



UPDATE SHEET N° 1

Surface abrasion resistance test

*Effective from 1st October 2026,
this Update Sheet serves as a supplement to the:*

Specifications for the Qualanod Quality Label for Sulfuric Acid-Based Anodizing of Aluminium

Edition
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MODIFICATION OF SECTIONS 12.11.2, 12.11.4 and 8.3.8	
QUALANOD resolutions:	TC Res. 6 / 11.05.2026 Surface abrasion test EC Res. 4 / 12.05.2026 TC Resolutions
Effective from:	1st October 2026

1. Note:

This Update Sheet is valid only in connection with the Qualanod Specifications Edition 01.07.2026, it details **in red** the modifications in the Qualanod Specifications (QS) which are put into force by this Update Sheet valid from the date indicated above. This Update Sheet leaves all other provisions in the Qualanod Specifications Edition 01.07.2026 unaffected.

2. Objective:

The TC decided that the 20 µm threshold for surface abrasion resistance testing be removed from the QS and that coils shall be subject to surface abrasion resistance testing as well.

The EC confirmed this decision and decided that the 12 months transition period be specified by a date (i.e. 30th June 2027).

In the implementation of TC Res. 6 / 11.05.2026 and EC Res. 4 / 12.05.2026, it was overlooked that the sections QS 12.11.2 and QS 12.11.4 should have been modified accordingly. This is remedied by the modifications detailed below. QS 8.3.8 is adapted to avoid ambiguities.

3. Modifications:

12.11.2 Nonconformities

The following is a list of nonconformities for architectural anodizing. These are the criteria for a negative inspection. Note that if an issue has not been remedied by the time of the next inspection, then the issue may be treated as a nonconformity which means a negative inspection.

	Nonconformities for the anodizing type: architectural anodizing	References
5	The inspection for architectural anodizing is negative - if a coil or a lot of anodized material where all the pieces tested have an average coating thickness of 20 µm or greater gives a negative result from the surface abrasion resistance test. <u>For inspections conducted until 30th June 2027, a negative result on a coil or lot of anodized material where pieces tested have an average coating thickness of below 20 µm constitutes an issue as defined in section 6.1.3.</u> - or if the anodizer uses a process for anodizing or for a subsequent process such as sealing that is not well-established for architectural anodizing or does not have current approval from Qualanod.	12.11.4, 8.3.8 12.8.1

12.11.4 The product tests of an inspection

The inspection can include the following product tests.

- Coating thickness
- Mass loss
- Dye spot or admittance (admittance tests are carried out within 48 h after sealing)
- Surface abrasion resistance

Average and local coating thicknesses are measured on products using the eddy current method specified in ISO 2360 (see 9.2). These shall not be lower than the minimum values for the specified thickness class on more parts than allowed by the statistical sampling of 8.3.6.

The inspection is negative for a licensed anodizing type if the result of the thickness tests for that type is negative. This is a criterion for a negative inspection.

Products are assessed using the mass loss test method of 9.3.1. The mass loss shall not exceed 30 mg/dm². It is an issue if the test solution in use based on phosphoric acid contains more than 0,5 g of anodic oxidation coating and aluminium per litre of solution.

It is a non-conformity if the amount in the test solution based on phosphoric acid exceeds 2,0 g per litre as specified in ISO 3210. This is a criterion for a negative inspection.

The inspection visit is negative for all licensed anodizing types except hard anodizing if a mass loss test gives a negative result or if the mass loss test is to be performed at the licensee's plant and it is not possible to do so. This is a criterion for a negative inspection.

Products are assessed using the dye spot test method of 9.3.3.

Products are assessed using the admittance test method of 9.3.4.

Anodized aluminium test specimens ~~and coils with an average coating thickness of 20 µm or greater for exterior application~~ are assessed for surface abrasion resistance using the method of 9.6.1 or of 9.6.2. After applying the method of 9.6.1, the abrasive paper shall not exhibit a dense deposit of chalky white powder. After applying the method of 9.6.2, the coating shall have a wear index less than 1.4. If, after carrying out the method of 9.6.1, the result is disputed, then the dispute is resolved by applying the method of 9.6.2.

The inspection for architectural anodizing is negative, if a ~~coil or a~~ lot of anodized material ~~where all the pieces tested have an average coating thickness of 20 µm or greater~~ gives a negative result from the surface abrasion resistance test. This is a criterion for a negative inspection.

For inspections conducted until 30th June 2027, a negative result on a coil or lot of anodized material where pieces tested have an average coating thickness of below 20 µm constitutes an issue as defined in section 6.1.3.

8.3.8 Surface abrasion resistance test

The inspector carries out the surface abrasion resistance test as described in the subclauses "Product tests carried out during an inspection" in the appendices.

The inspector applies the surface abrasion test to each lot or coil of architectural anodizing for exterior application selected for thickness measurement (see Table 1). He performs the surface abrasion test on the sample with the highest thickness.

The inspection for architectural anodizing is negative, if a coil or a lot of anodized material ~~where all the pieces tested have an average coating thickness of 20 µm or greater~~ gives a negative result from the surface abrasion resistance test. This is a criterion for a negative inspection.

For inspections conducted until 30th June 2027, a negative result on a coil or lot of anodized material where pieces tested have an average coating thickness of below 20 µm constitutes an issue as defined in section 6.1.3.