Minutes of the QUALANOD Technical Committee meeting held on 24 November 2004 (8h30 – 12h00) in Zurich (Hotel Sofitel)

TC members :	**ESTAL**	**EAA**
	J. Bettencourt (Chairman) R. Boi P. LLoret S. Meirsschaut T. Ulucak J. van den Heuvel R. Wunderlin	Å. Andersson E. Arnoux R. Furneaux W. Mader
Secretariat:	J. Schoppig P. Bellot (Minutes)	
Guests:	C. Baroni (EC) H. Sips	
Apologies:	------	

A G E N D A

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2. **Secretariat's report**
3. **Review of the QUALANOD Specifications**
4. **Coil anodizing**
5. **Assessment of new alternative systems for sealing anodized aluminium**
6. **Modification of anodizing parameters**
7. **QUALISURFAL – Meeting of the Anodizing Section held on 28.10.2004**
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The Chairman of the Technical Committee, Mr. Bettencourt, welcomed the delegates and guests.

In September, Mr. Buchholz had written to Mr. Schoppig to say he had resigned from the German association and therefore would not participate in the QUALANOD committees any more. Those present deeply regretted not having the opportunity to thank Mr. Buchholz for his long-time cooperation in QUALANOD. Mr. Bettencourt asked Mr. Schoppig to write a letter to Mr. Buchholz expressing the sentiments of the QUALANOD Committee members.

1. Minutes of the meeting held on 17 June 2004

Mr. Bettencourt said that the conclusion of item 7 regarding coil anodizing needed to be clarified. Those present agreed to amend the last paragraph as follows:

> *The Technical Committee finally approved the working group's proposal that a provisional approval could be granted after positive laboratory tests. Concurrently, a new specification would be prepared following the instructions given by the working group.*

Mr. Boi pointed out that, after publication of the Minutes, the text in paragraph 3.1.d regarding the life and pH correction of solutions for the dye spot test had been amended by the Specifications working group in accordance with Clariant's instructions. The new text had been included in the official edition dated 15.09.04, effective as from 1 January 2005.

With these corrections and remarks, the Minutes of the previous meeting were finally approved. A revised issue would be distributed together with the Minutes of this meeting.

2. Statistical report

Mr. Schoppig commented on the list of unsatisfactory inspections based on the reports received between 1 June and 31 October 2004. Four inspections out of 116 (3.4%) had been negative, three due to the weight loss test. In the previous period (01.11.03.–31.05.04), six inspections out of 187 (3.2%) had been negative, five due to the weight loss test.

QUALANOD's Secretariat had compiled a list of all the weight loss values reported by the testing laboratories between 1 June and 31 October 2004. This list had been distributed to those present at the beginning of the session and an illustrative chart was shown to the Technical Committee. During this period, there had been no extremely poor result, and the tendency remained quite positive.

Those present agreed with the Secretariat that the WLT statistics needed to be revised. They thought that it was sufficient to distinguish between natural and coloured production without mentioning the type of colour. Additionally, some delegates suggested including information about the type of sealing.

The Technical Committee instructed the Secretariat to reorganize the weight loss test statistics. The summary would be split into two parts: results by type of colouring (natural/coloured) and results by type of sealing (hot sealing/medium temperature sealing/cold sealing).

3. Review of the Specifications

At the previous QUALANOD meeting in June, a working group consisting of Messrs. Arnoux, Bettencourt, Boi and LLoret had been set up to discuss ADAL's proposal for an in-depth review of the Specifications and inspection report. The working group had met in Valencia on 15 September 2004, the day before the ESTAL congress. Mr. LLoret had not been able to attend the working group meeting due to other commitments in the Spanish association.

On this occasion, the working group had made the last corrections to the second draft approved in June. The amended draft (showing the latest changes) and the final document had then been published in the "Members only" area of the QUALANOD website at the beginning of October 2004.

Mr. Bettencourt confirmed that the final version was the edition dated 15.09.04. The master version (hard copy of the English Specifications signed by the General Secretary) had already been distributed to the national associations, Committee members, direct members and testing laboratories.

In Valencia, the working group members had also embarked on an initial revision of the inspection report, adapting it to the new Specifications (see item 8). For the detailed review of the Specifications, Mr. Arnoux agreed to ask some French anodizers to work on this matter and submit some concrete proposals to QUALANOD.

The working group questioned the use of the weight loss test after immersion in nitric acid for assessing new products and processes (Appendix VI of the new Specifications and § 2.7) because no limit was fixed for this test.

Mr. van den Heuvel suggested comparing the long time nitric acid test with the test described in ISO 2932. Other delegates thought it was worth using the information obtained by testing and exposing new products.

Finally, the Technical Committee agreed to keep the nitric acid test for assessing new products and processes for the time being and to collect figures over a three-year period to enable the Technical Committee to verify the purpose of this test and decide whether a limit should be set.

Mr. Bettencourt told the Technical Committee members that the Secretariat had received some comments and questions from ESTAL Belgium regarding the new edition of the Specifications and its consistency with the EN standards.

As ESTAL Belgium's message had arrived very late and most questions needed to be reviewed in detail, the Technical Committee would try to give some answers at the next meeting. However, the Chairman of the Technical Committee made a point of voicing his disagreement with the Belgian association's comment concerning the working procedure followed by the Specifications working group. He emphasized that every draft prepared by the working group had been sent to the national associations in due time and that every change had been submitted and discussed at the Technical Committee meetings. Consequently, it was really unfair to accuse the working group of having worked independently of the Technical Committee.

The Secretariat would inform the Belgian association accordingly.

4. Coil anodizing

The "Coil anodizing" working group had defined some specifications in a paper distributed to the Technical Committee members at the beginning of the meeting. As some of the tests defined in the QUALANOD Specifications could not be used in a coil anodizing plant, some alterations were necessary.

Mr. Ulucak wondered why no plant and process inspection had been stipulated. He felt that it should not be too easy for coil anodizers to obtain the quality label and that it would be unfair to batch anodizers who had to fulfil many other requirements.

Mr. Furneaux explained that it was impossible for QUALANOD to fix parameters. It would have been easy to adopt the applicant company's own specifications, but the working group had preferred not to do so because such specifications would probably not be suitable for other potential applicants since each coil anodizing plant developed its own technology.

Mr. Arnoux explained some details concerning sampling and commented on the table summarizing the test method for measuring weight loss. There would be one weight loss test during each inspection, with 48 measuring points on the running coil and at least 3 coils on stock (9 measurements per coil).

The Technical Committee members agreed to carefully review the appendix prepared by the working group. The draft would also be submitted to the national associations, and a final decision would be taken at the next QUALANOD meeting in June 2005. In the meantime, the testing programme would be started provided that Coil accepted it. An additional requirement would be the use of alloy 5005A.

5. Assessment of new alternative systems for sealing anodized aluminium

By e-mail, the Secretariat had distributed the test report and the technical data sheet for two alternative sealing systems that one producer had submitted for approval.

As the procedure described in Appendix VI had been followed and the test results for both products were satisfactory, the Technical Committee members agreed to proceed with outdoor exposure.

Mr. Bettencourt and Mr. Boi considered that the procedure for assessing new products and processes needed some revision. They particularly felt that QUALANOD should already grant a provisional approval after one year of satisfactory outdoor exposure.

Mr. Meierschaut thought it was important to determine whether QUALANOD approved the principle of medium sealing in general or simply individual products. He recommended that systems already approved be submitted again for testing.

Mr. Boi agreed that in future QUALANOD could establish some kind of certification which would imply regular testing. However, it was clear that QUALANOD had to lay down the rules before asking for more samples.

The Technical Committee agreed to recommend to the Executive Committee that Appendix VI of the new Specifications should be revised and an update sheet published.

6. Modification of anodizing parameters

Those present had received a copy of a fax Mr. Brodalla had sent out a few days before the meeting. In this letter, Mr. Brodalla informed the Technical Committee that a Co-operative Research Project entitled “Modification of Anodizing Parameters for Increased Productivity and Energy Savings” had been submitted to the EU. The full proposal had been sent to Brussels and acceptance was expected. SAPA had offered to act as supervisor.

Mr. Andersson confirmed that the parameters chosen were very interesting. He was convinced that it was a valuable programme. However, the project was only one out of many others and it was not certain to be accepted.

7. QUALISURFAL – Meeting of the Anodizing Section held on 28.10.04

As Chairman of the QUALISURFAL Anodizing Section, Mr. Boi summarized the meeting which had been held in Nieuwegein (Netherlands).

The most important items discussed at the meeting had been the new Specifications presented by the Secretariat, the adaptation of the inspection report (see item 8) and various questions raised by the inspectors.

Another issue had been the Portuguese laboratory’s proposal to organize round robin tests for the thickness measurement.

8. Inspection report

Mr. Boi and Mr. Schoppig commented on the inspection form which had been updated by the Specifications working group in Valencia on 15 September 2004 and reviewed by the inspectors on 28 October 2004.

At the QUALISURFAL meeting, most of the inspectors had confirmed that they were satisfied with the combined report for plant and finished product inspections. They had recommended adding the date of the last plant inspection on the first page of the report in order to get better control over the rule stipulated in § 5.2.2 of the new Specifications.

Rather than deleting the whole "Busbars and contacts" paragraph of section 1.3 as proposed by the working group, the inspectors had suggested dropping only the first sentence *"The voltage drop between busbar to flightbar contact must not be more than 0.3 volts".*

Mr. van den Heuvel strongly disagreed with this amendment.

The majority of the Technical Committee members finally approved the revised inspection form submitted by the Secretariat. The master version would be finalized and distributed to the national associations and testing laboratories by e-mail. The revised inspection form (24.11.04 edition) would then become effective in January 2005.

9. Report on CEN TC 132/WG 15

Mr. Boi reported that CEN TC 132 had asked him to organize a meeting in order to prepare a new standard for architectural applications. The following gentlemen had been nominated to participate in this new work: Messrs. E. Arnoux (France), J. Bettencourt (Portugal), R. Boi (Italy), G. Borst (Germany), J.F. Del Rio Martin (Spain), R. Furneaux (United Kingdom) and W. Mader (Germany).

Mr. Arnoux explained that he had only accepted this nomination in order to be informed. He was not at all convinced of the purpose of such a standard which would essentially promote QUALANOD quality as almost all the people nominated were QUALANOD members. He was in favour of simply not starting the work. Mr. Mader also shared this opinion and felt that a good European standard could be dangerous for QUALANOD. Mr. van den Heuvel feared that, if the QUALANOD experts did not do the job, a group of architects could decide to do so instead.

Mr. Boi thought that setting a European standard for architectural applications was a crucial issue because there were currently some national standards which were more important than the European ones. He insisted that the working group should meet and make at least a recommendation to CEN.

A meeting of the working group would be organized in Zurich on the day before the next June meetings.

10. Any other business

The Dutch testing laboratory, Adviescentrum VOM, had asked what kind of testing had to be carried out by an anodizing company using medium temperature sealing.

The Technical Committee answered that, like for cold sealing, the dye spot test was sufficient. It was not compulsory to use the admittance test.

11. Next meetings

Technical and Executive Committees:

Wednesday, 22 June 2005

and

Thursday, 24 November 2005

in Zurich (Hotel SOFITEL)