

STN	Letectvo a kozmonautika Anodické elektrolytické nanášanie základnej vrstvy bez obsahu šesťmocného chrómu	STN EN 4868 31 7929
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Aerospace series - Anodic electrodeposition of hexavalent chromium free primer

Táto norma obsahuje anglickú verziu európskej normy.
This standard includes the English version of the European Standard.

Táto norma bola oznámená vo Vestníku ÚNMS SR č. 03/20

Obsahuje: EN 4868:2019

130536

EUROPEAN STANDARD

EN 4868

NORME EUROPÉENNE

EUROPÄISCHE NORM

September 2019

ICS 49.040

English Version

Aerospace series - Anodic electrodeposition of hexavalent chromium free primer

Série aérospatiale - Electrodeposition anodique d'un primaire sans chrome hexavalent

Luft- und Raumfahrt - Anodische Elektrotauchlackierung von sechswertigem chromfreiem Grundierung

This European Standard was approved by CEN on 5 May 2019.

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This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the CEN-CENELEC Management Centre has the same status as the official versions.

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European foreword

This document (EN 4868:2019) has been prepared by the Aerospace and Defence Industries Association of Europe - Standardization (ASD-STAN).

After enquiries and votes carried out in accordance with the rules of this Association, this Standard has received the approval of the National Associations and the Official Services of the member countries of ASD, prior to its presentation to CEN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by March 2020, and conflicting national standards shall be withdrawn at the latest by March 2020.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

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EN 4868:2019 (E)**1 Scope**

This document defines the requirements for hexavalent chromium free anodic electrodeposition of organic coatings on aluminium and aluminium alloys for corrosion protection of parts.

The purpose of this standard is to give design, quality and manufacturing requirements. It doesn't give complete in-house process instructions; these shall be given in the processor detailed process instructions.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 3840, *Aerospace series — Paints and varnishes — Technical specification*

EN ISO 1463, *Metallic and oxide coatings — Measurement of coating thickness — Microscopical method*

EN ISO 1518-1, *Paints and varnishes — Determination of scratch resistance — Part 1: Constant-loading method*

EN ISO 1519, *Paints and varnishes — Bend test (cylindrical mandrel)*

EN ISO 2360, *Non-conductive coatings on non-magnetic electrically conductive base metals — Measurement of coating thickness — Amplitude-sensitive eddy-current method*

EN ISO 2409, *Paints and varnishes — Cross-cut test*

EN ISO 2812-1, *Paints and varnishes — Determination of resistance to liquids — Part 1: Immersion in liquids other than water*

EN ISO 2812-2, *Paints and varnishes — Determination of resistance to liquids — Part 2: Water immersion method*

EN ISO 4623-2, *Paints and varnishes — Determination of resistance to filiform corrosion — Part 2: Aluminium substrates*

EN ISO 4628-8, *Paints and varnishes — Evaluation of degradation of coatings — Designation of quantity and size of defects, and of intensity of uniform changes in appearance — Part 8: Assessment of degree of delamination and corrosion around a scribe or other artificial defect*

EN ISO 4628-10, *Paints and varnishes — Evaluation of degradation of coatings — Designation of quantity and size of defects, and of intensity of uniform changes in appearance — Part 10: Assessment of degree of filiform corrosion*

EN ISO 9220, *Metallic coatings — Measurement of coating thickness — Scanning electron microscope method*

EN ISO 9227, *Corrosion tests in artificial atmospheres — Salt spray tests*

EN ISO 17872, *Paints and varnishes — Guidelines for the introduction of scribe marks through coatings on metallic panels for corrosion testing*

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