STN

**Letectvo a kozmonautika
Anodizácia hliníka a zliatin hliníka bez obsahu
šesťmocného chrómu**

**STN
EN 4827**

31 2382

Aerospace series - Hexavalent chromium free anodizing of aluminium and aluminium alloys

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

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EUROPEAN STANDARD

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English Version

Aerospace series - Hexavalent chromium free anodizing of aluminium and aluminium alloys

Série aérospatiale - Anodisation sans chrome
hexavalent de l'aluminium et des alliages d'aluminium

Luft- und Raumfahrt - Anodisieren von Aluminium und
Aluminiumlegierungen ohne hexavalentem Chrom

This European Standard was approved by CEN on 14 July 2019.

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EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels

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European foreword

This document (EN 4827:2019) 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 document 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 document 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of an identical text or by endorsement, at the latest by March 2020, and conflicting national standards shall be withdrawn at the latest by March 2020.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 4827:2019 (E)

1 Scope

This document defines the requirements for hexavalent chromium free anodizing of aluminium and aluminium alloys for corrosion protection, bonding and painting.

Hard anodizing and plasma electrolytic anodizing (micro-arc oxidation) are not covered by this document.

The purpose of this document is to give design, quality and manufacturing requirements. It does not give complete in-house process instructions; these are given in the processors 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 2284, *Aerospace series — Sulphuric acid anodizing of aluminium and wrought aluminium alloys*

EN 3665, *Aerospace series — Test methods for paints and varnishes — Filiform corrosion resistance test on aluminium alloys*

EN 4704, *Aerospace series — Tartaric-Sulphuric-Acid anodizing of aluminium and aluminium wrought alloys for corrosion protection and paint pre-treatment (TSA)*

EN 4707, *Aerospace series — Acid pickling of aluminium and aluminium alloy without hexavalent chromium*[1])

EN 6072, *Aerospace series — Metallic materials — Test methods — Constant amplitude fatigue testing*

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

EN ISO 2085, *Anodizing of aluminium and its alloys — Check for continuity of thin anodic oxidation coatings — Copper sulfate test*

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

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

EN ISO 10289, *Methods for corrosion testing of metallic and other inorganic coatings on metallic substrates — Rating of test specimens and manufactured articles subjected to corrosion tests*

koniec náhľadu – text ďalej pokračuje v platenej verzii STN

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1) Published as ASD-STAN Prestandard at the date of publication of this standard by AeroSpace and Defence industries Association of Europe - Standardization (ASD-STAN), http://www.asd-stan.org/