

# ISO 8078:2025-05 (E)

## Aerospace process - Anodic treatment of aluminium alloys - Sulfuric acid process, undyed coating

---

<b>Contents</b>		<b>Page</b>
Foreword .....		iv
<b>1</b>	<b>Scope .....</b>	<b>1</b>
<b>2</b>	<b>Normative references .....</b>	<b>1</b>
<b>3</b>	<b>Terms and definitions .....</b>	<b>1</b>
<b>4</b>	<b>Technical requirements .....</b>	<b>2</b>
4.1	Materials to be anodized .....	2
4.2	Process requirements .....	2
4.3	Process details .....	2
4.3.1	General rules .....	2
4.3.2	Water quality .....	2
4.3.3	Racking of parts .....	2
4.3.4	Cleaning requirement .....	3
4.3.5	Deoxidizing .....	3
4.3.6	Anodizing procedure .....	3
4.3.7	Sealing .....	3
4.3.8	Drying .....	3
4.3.9	Rework .....	4
4.3.10	Temperature control .....	4
<b>5</b>	<b>Quality assurance provisions .....</b>	<b>4</b>
5.1	Responsibility for inspection .....	4
5.2	Lot acceptance tests .....	4
5.3	Process control tests .....	4
5.4	Process qualification tests .....	4
5.5	Solution control .....	5
5.5.1	Surface preparation and anodizing baths .....	5
5.5.2	Sealing bath .....	5
5.6	Inspection and testing of coatings .....	5
5.6.1	Visual examination .....	5
5.6.2	Coating mass per unit area .....	5
5.6.3	Thickness of coating .....	5
5.6.4	Corrosion resistance .....	6
5.6.5	Effectiveness of sealing .....	6
5.7	Approval .....	6
<b>6</b>	<b>Packaging and delivery .....</b>	<b>6</b>
6.1	Packaging .....	6
6.2	Delivery .....	6
Bibliography .....		8