Information About Drum Anodic Oxidation/Anodising in Bulk

1. General information
– The drum process is particularly suitable for large quantities.
– As a rule, the workpieces should not exceed the mass of 2–8 mm in diameter and 2–65 mm in length.
– All aluminium alloys that can be anodised are suitable.
– The minimum quantity that can be drum anodised is approx. 2 cubic decimetres volume.

2. Anodising
– Anodising is carried out in the GS process (direct current sulphuric acid process).
– The layer thicknesses vary between 5–15 µm
– The layer thickness can be measured and recorded if required.
– The layer can be dyed in almost all colours.
– Fine colour nuances must be accepted.
– Small contact points must be accepted.

3. Contact points
– Due to the process, there are always contact points during the barrel process, as the workpieces are contact each other. Depending on the size, geometry and position of the workpieces in relation to each other smaller or larger contact points.
– A certain reject rate can therefore be expected.
– The reject rate is influenced by various factors such as colour, position of the workpieces in relation to each other, size, geometry, customer requirements etc.

4. Sorting
– Depending on the size of the quantities, sorting is carried out manually or by means of fully automatic testing and sorting machines.

5. Special
– Drum anodising is a special process from Stalder Finish. All data are approximate values to consider.
– Each workpiece has to be checked individually and needs its own „recipe“.
– A 100% statement about the feasibility can only be made after sampling.

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