



# BS 3987:1991 Assessment Report.

Alumet B.V.

Report  
Author

**Hans Breuker**

Visit Start Date

23/01/2015

Page 1 of 6

...making excellence a habit.™

## Introduction.

This report has been compiled by Hans Breuker and relates to the assessment activity detailed below:

Visit ref/Type/Date/Duration	Certificate/Standard	Site address
8257581 23/01/2015 1.5 day(s) No. Employees: 60	623762 Second Party (Generic) BS 3987:1991	Alumet B.V. Nieuwe Donk 7 Etten-Leur 4879 AC Netherlands

The objective of the assessment was to conduct a certification assessment to ensure the elements of the proposed scope of registration and the requirements of the management standard are effectively addressed by the organisation's management system and to confirm the forward strategic plan.

### Proposed scope of registration 623762 (Second Party (Generic))

Location	Scope
Alumet B.V. Nieuwe Donk 7 Etten-Leur 4879 AC Netherlands	Anodic oxidation coatings on wrought aluminium for external architectural applications.  Colour anodized aluminium and electrolytically coloured anodized aluminium

## Management Summary.

### Overall Conclusion

We are pleased to recommend that the scope of activities detailed in this report meet the requirements of the BSI 3987:1991 standard. BSI has assessed the implementation of the BSI 3987:1991 requirements in the documentation and adherence to the procedures in the production process. Compliance with the requirements of the BSI 3987:1991 was demonstrated by Alumet. The company has made the mentioned procedures part of its certified management system which was not assessed by BSI at the occasion of this visit, this report covers the outcome of a standalone visit for which periodic re-assessment was not concluded as at the moment of this visit.

The objectives of this assessment have been achieved. I would like to thank all the audit participants for their assistance and co-operation which enabled the audit to run smoothly and to schedule. Based on the objective evidence detailed within this report, the areas assessed during the course of the visit were found to be effective.

There were no outstanding nonconformities to review from previous assessment. No new nonconformities were identified during the assessment. Enhanced detail relating to the overall assessment findings is contained within subsequent sections of the report.

## Areas Assessed & Findings.

### Compliance to BS 3987:1991.

Alumet has requested BSI management System BV to perform an assessment on the business and production process against the requirements of the BS 3987:1991 standard with the scope : Anodic oxidation coatings on wrought aluminium for external architectural applications. Alumet is registered for ISO 9001:2008 by LRQA, reg. RQA664947 and the registration is valid till October 2016. All relevant quality control and assurance procedures and methodologies comply with the requirements of that standard. All reports from LRQA from the last recertification and surveillance audits have been discussed, there are no pending non conformity or corrective action issues. The quality management system has not been assessed in detail at the occasion of this visit. Additional the company keeps a valid Qualanod registration nr 820 valid till and with December 2015 from the European Aluminium and Anodising Association, the audits are done by IFO Netherlands. There are no pending non conformities and or corrective actions, the last inspections for 2012 and 2013 and 2014 have been discussed.

The management of Alumet had prepared for this assessment against the requirements of the BSI 3987:1991 standard access to all relevant documents and records. In this document it is explained what is in place in the company for every clause of the BS 3987:1991 standard. Alumet staff was very supportive which resulted in a very effective and transparent approach which is appreciated by the BSI auditor.

It can be confirmed that the the documentation as established by Alumet gives adequate justification and explanation for all clauses of the BS 3987:1991 standard.

Chapter of the BS 3987:1991	Audit result
1 Scope	✓
2 Definitions	✓
3 Visual inspection after anodizing	✓
4 Colour	✓
5 Thickness	✓
6 Sealing	✓
7 Cold impregnation	✓
8 Surface abrasion resistance	✓
Appendix A Guidance on information to be supplied	✓
Appendix B Guidance on properties affecting coating performance 5	✓
Appendix C Choice of aluminium for anodizing	✓
Appendix D Handling and temporary protection during transportation and installation	✓
Appendix E Maintenance of anodized aluminium	✓
Appendix F Surface texture	✓
Appendix G Visual inspection after anodizing	✓

Appendix H Colour	✓
Appendix J Examples of average and local thickness requirements	✓
Appendix K: Sealing quality: production control methods	✓
Appendix L Guidance on sampling	✓
Application in the production process	✓
✓ Means no non compliance identified , exclusions well explained.	

For every clause of the BSI 3987:1991 standard Alumet has clearly investigated and recorded to which extend the already implemented processes meet the requirements of the BSI 3987:1991 standard. Only in the area of sampling there is some difference but in a way that the BS 3987:1991 requirements are less stringent compared to the Qualanod requirements. The BSI auditor verified this comparison and did not notice any anomalies or shortcomings. Alumet has developed specific documents and records for orders manufactured under BSI 3987 standard. Order numbers 1500383 and 1500249 have been selected for in detail assessment against the BSI 3987 standard, full compliance was demonstrated to the auditor.

**Audit trail.**

After review of the documentation against all clauses of the BS 3987;1991 standard the complete process has been assessed.

1. Contracting, order intake. On the order and related drawings all the required specific information is available.
2. The incoming material is duly identified as BS order and staff is familiar with specific details (if any) required by the customer.
3. Cleaning and or pre-treatment of the aluminium products complies with the standard.
4. The Anodic Oxidation process in highly automated (current, time) and process control e.g. electrolyte flow and gas off let are closely monitored.
5. The laboratory is well manned and equipped, the control of concentration of substances in the electrolyte and other liquids is closely sampled and monitored. Good process control was demonstrated.
6. All test required by the BS 3987;1991 are available, well understood and results can be related back to appropriate sampling and testing standards.
- 7 Records management complies with ISO 9001;2008.
- 8 Calibration is well implemented.
9. Overall in the production process no anomalies or shortcomings have been sighted.

During the course of the visit logos were found to be used correctly.

## Assessment Participants.

On behalf of the organisation:

Name	Position
F. Tijs	Production manager
Several	Operational staff

The assessment was conducted on behalf of BSI by:

Name	Position
Hans Breuker	Team Leader

## Next Visit Plan.

This report contains the outcome of a standalone visit for which periodic re-assessment was not concluded as at the moment of this visit.

## Notes.

The assessment was based on sampling and therefore nonconformities may exist which have not been identified.

If you wish to distribute copies of this report external to your organisation, then all pages must be included.

BSI, its staff and agents shall keep confidential all information relating to your organisation and shall not disclose any such information to any third party, except that in the public domain or required by law or relevant accreditation bodies. BSI staff, agents and accreditation bodies have signed individual confidentiality undertakings and will only receive confidential information on a 'need to know' basis.

'Just for Customers' is the website that we are pleased to offer our clients following successful registration, designed to support you in maximising the benefits of your BSI registration - please go to [www.bsigroup.com/j4c](http://www.bsigroup.com/j4c) to register. When registering for the first time you will need your client reference number and your certificate number (47543475/ 623762).

This report and related documents is prepared for and only for BSI's client and for no other purpose. As such, BSI does not accept or assume any responsibility (legal or otherwise) or accept any liability for or in connection with any other purpose for which the Report may be used, or to any other person to whom the Report is shown or in to whose hands it may come, and no other persons shall be entitled to rely on the Report.

Should you wish to speak with BSI in relation to your registration, please contact our Customer Engagement and Planning:

Customer Services  
 BSI  
 Kitemark Court,  
 Davy Avenue, Knowlhill  
 Milton Keynes  
 MK5 8PP

Tel: +44 (0)845 080 9000 Fax +44 (0)1908 228123

**Report Author** Hans Breuker  
 Visit Start Date 23/01/2015

Email: [MK.CustomerServices@bsigroup.com](mailto:MK.CustomerServices@bsigroup.com)