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**Anodizing of aluminium and its  
alloys — Instrumental determination  
of image clarity of anodic oxidation  
coatings — Instrumental method**

*Anodisation de l'aluminium et de ses alliages — Détermination de la  
netteté d'image sur couches anodiques — Méthode instrumentale*

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ISO copyright office  
Ch. de Blandonnet 8 • CP 401  
CH-1214 Vernier, Geneva, Switzerland  
Tel. +41 22 749 01 11  
Fax +41 22 749 09 47  
copyright@iso.org  
www.iso.org

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## Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see [www.iso.org/directives](http://www.iso.org/directives)).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see [www.iso.org/patents](http://www.iso.org/patents)).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation on the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see the following URL: [www.iso.org/iso/foreword.html](http://www.iso.org/iso/foreword.html).

This document was prepared by Technical Committee ISO/TC 79, *Light metals and their alloys*, Subcommittee SC 2, *Organic and anodic oxidation coatings on aluminium*.

This third edition cancels and replaces the second edition (ISO 10216:2010), which has been technically revised.

The main changes compared to the previous edition are as follows:

- the tolerance of the width of the slit has been revised;
- the figures have been revised;
- a combed sliding shutter figure has been added;
- information about the test specimen has been added.

## Introduction

Estimation of the image clarity of anodic oxidation coatings on aluminium and its alloys is normally carried out visually by observing the clearness of an image on the surface. However, the image can be observed at various angles and be confused with the gloss level of a surface, and while the degree of image clarity is mainly influenced by the clearness of the coating, it is also affected by image distortion caused by surface irregularities and the haziness of the coating layer. Standardized methods of determining image clarity are therefore required.

This document specifies the use of an instrumental method for measuring image clarity using an optical comb. A related document, ISO 10215, specifies the use of a chart scale also based on an optical comb together with a lightness scale to rank image clarity.

NOTE This instrumental method provides more accurate measurements of image clarity than visual evaluation and can be used in cases of dispute.

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# Anodizing of aluminium and its alloys — Instrumental determination of image clarity of anodic oxidation coatings — Instrumental method

## 1 Scope

This document specifies an instrumental method for determining the image clarity of anodic oxidation coatings on aluminium and its alloys by measuring reflection from the surface with the help of a sliding combed shutter.

The test can only be applied to a flat surface which can reflect the image onto the limited combed shutter and photo-receiver. This method can also be used to measure the optical evenness of anodic oxidation coatings on aluminium and its alloys.

## 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.

ISO 7583, *Anodizing of aluminium and its alloys — Terms and definitions*

ISO 7668, *Anodizing of aluminium and its alloys — Measurement of specular reflectance and specular gloss of anodic oxidation coatings at angles of 20°, 45°, 60° or 85°*

## 3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 7583 and the following apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <http://www.iso.org/obp>
- IEC Electropedia: available at <http://www.electropedia.org/>

### 3.1

#### image clarity

$C_n$

ability of the surface of an anodic oxidation coating to produce a clear image of an object facing the surface

Note 1 to entry: Image clarity is expressed as a percentage.

### 3.2

#### optical evenness

$E$

degree of evenness (surface irregularities) given by the ratio of the longitudinal and transverse values of the *image clarity* (3.1)

### 3.3

#### dispersion of light

$D$

degree of dispersion of reflected light by the test specimen

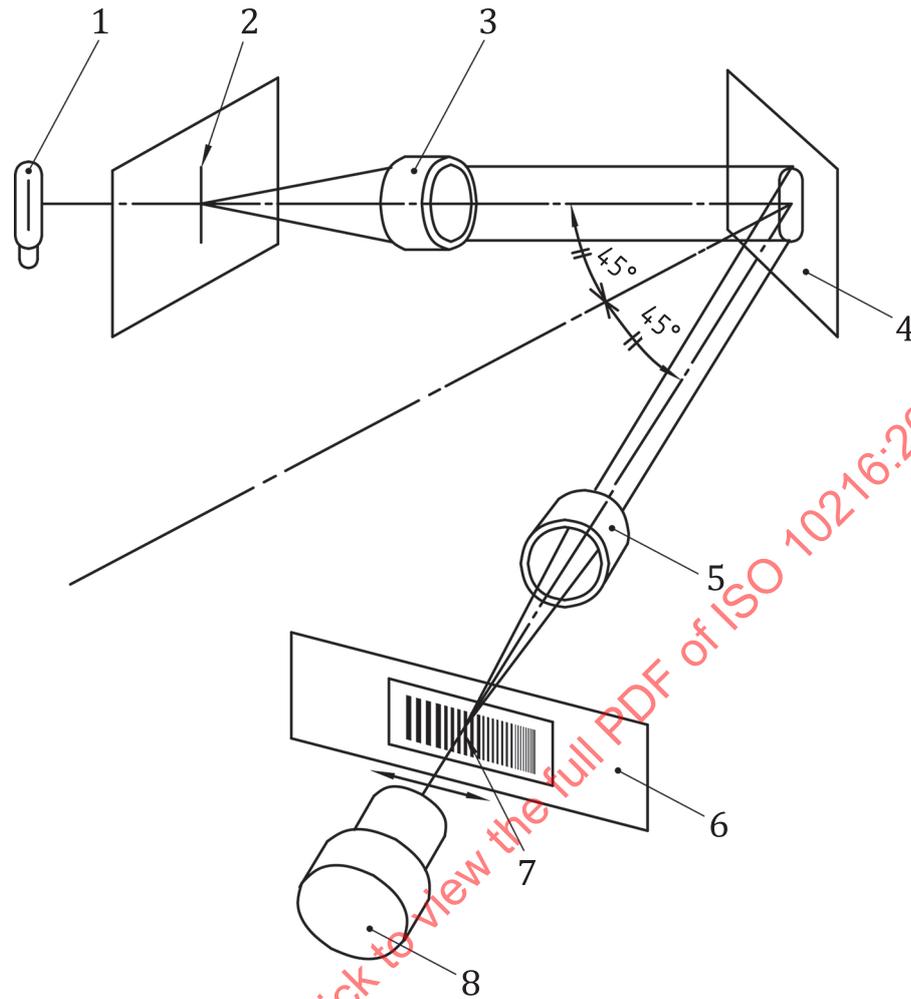
## 4 Principle

A light source illuminates the slit and is converted to parallel light through a collimating lens. It is reflected at the surface of the test specimen, which is set at 45° to the incident light, and is then focused on a combed sliding shutter through a de-collimating lens. In cases where the test specimen has a completely flat and smooth surface, the reflected light is concentrated as a sharp image of the slit at the combed sliding shutter. The shutter is slid laterally. When the transparent portion of the combed sliding shutter coincides with the reflected slit image, the reflected light passes completely and the maximum light intensity is received by the photo-receiver. In cases where the test specimen has a matt surface, the reflected light passes partially through the transparent portion of the combed sliding shutter and a lower light intensity is received, depending on the degree of dispersion by the test specimen. This difference corresponds to the image clarity. Optical evenness is shown by the ratio of the longitudinal and transverse values (see [8.4](#)).

## 5 Apparatus

An example of the apparatus is shown in [Figure 1](#).

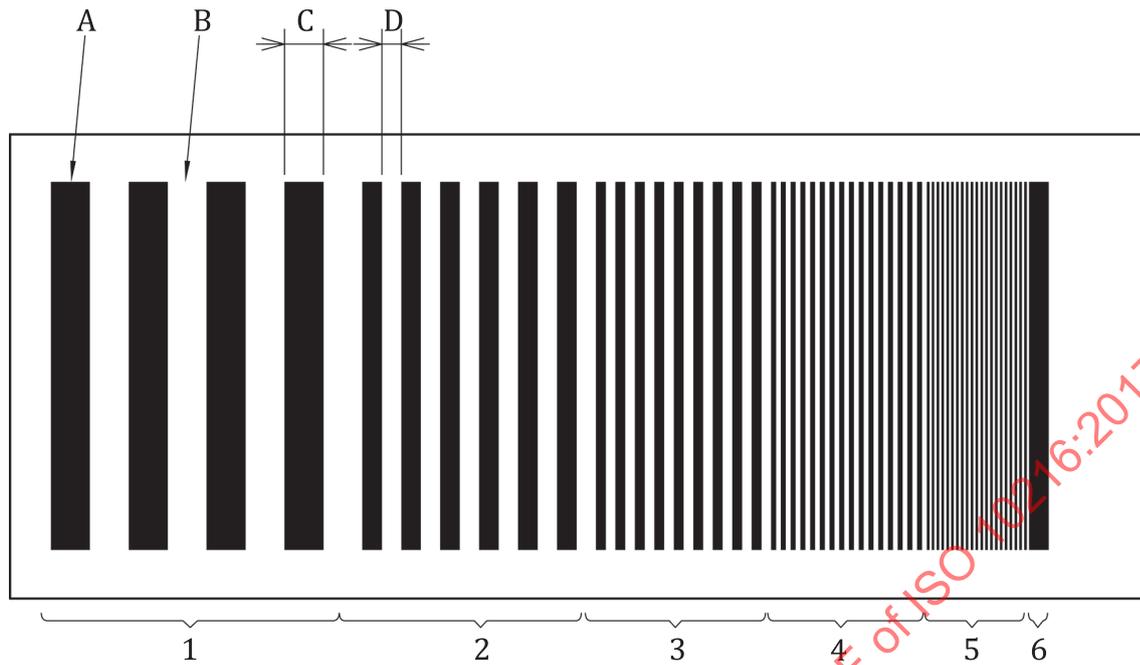
- 5.1 **Flat surface of the test specimen**, set at 45° to the incident light and with the reflected image measured at 45° in the specular direction.
- 5.2 **Lenses**, focal length of 130 mm.
- 5.3 **Light source**, filament not larger than 0,05 mm and capable of providing a constant light intensity during measurement.
- 5.4 **Slit**, 0,02 mm ± 0,01 mm in width and about 20 mm in length.
- 5.5 **Combed sliding shutter** (see [Figure 2](#)), thin sheet with optical slits having a ratio of width of transparent portion to opaque portion of 1:1. Five different widths of 0,125 mm, 0,25 mm, 0,5 mm, 1,0 mm and 2,0 mm are incorporated.
- 5.6 **Photo-receiver**, adjustable to the received light intensity.
- 5.7 **Black glass**, which shall conform to ISO 7668.



**Key**

- |                    |                          |
|--------------------|--------------------------|
| 1 light source     | 5 de-collimating lens    |
| 2 slit             | 6 combed sliding shutter |
| 3 collimating lens | 7 reflected slit image   |
| 4 test specimen    | 8 photo-receiver         |

**Figure 1 — Example of apparatus for image clarity measurement**



**Key**

- |   |                              |   |  |
|---|------------------------------|---|--|
| A | opaque portion               | 1 | transparent and opaque portions each 2,0 mm in width   |
| B | transparent portion          | 2 | transparent and opaque portions each 1,0 mm in width   |
| C | width of opaque portion      | 3 | transparent and opaque portions each 0,5 mm in width   |
| D | width of transparent portion | 4 | transparent and opaque portions each 0,25 mm in width  |
|   |                              | 5 | transparent and opaque portions each 0,125 mm in width |
|   |                              | 6 | opaque portion   |

**Figure 2 — Example of combed sliding shutter**

**6 Test specimen**

**6.1 Sampling**

The test specimen shall be taken from a significant flat surface of the product and shall not be taken from part of the edge because of possible distortion and/or non-uniformity.

Where it is impossible to test the product itself, a test specimen may be used. However, in this case, the test specimen used shall be one which is representative of the product and it shall be made from the same material and prepared under the same conditions of finishing as those used for the preparation of the product.

The aluminium alloy, the manufacturing conditions (kind and temper of the material) and the surface condition before treatment shall be the same as those of the product.

Pretreatment, anodizing and sealing shall be performed in the same baths and under the same conditions as the treatment of the product.

**6.2 Size**

The standard size of the test specimen should be about 50 mm × 50 mm.

### 6.3 Treatment before measurement

The test specimen shall be clean, free from dirt, stains and other foreign matter. Any deposits or stains shall be removed with a clean, soft cloth or similar material which is wetted by water or an appropriate organic solvent such as ethanol. Organic solvent which can corrode the test specimens or generate protective films on the test specimens shall not be used.

## 7 Procedure

### 7.1 Measurement of black glass

Set the black glass on the holder and measure the received light intensity by moving the combed sliding shutter. Adjust the minimum light intensity to zero.

### 7.2 Sensitivity adjustment by test specimen

Set the test specimen on the holder and measure the received light intensity by moving the combed sliding shutter, in order not to saturate the photo-receiver. In case the test specimen has directionality, measure in both longitudinal and transverse directions. Use the higher light intensity as the maximum light intensity. Adjust the full scale standardization sensitivity so that the maximum light intensity is not saturating.

### 7.3 Measurement of test specimen

Measure the test specimen by moving the combed sliding shutter. Two different points are measured. If there is a large difference between those values, make an additional measurement and use the two largest values. In case the test specimen has directionality, measure in both longitudinal and transverse directions.

NOTE 1 The combed sliding shutter, 0,125 mm, is suitable for mirror finished specimens.

NOTE 2 The combed sliding shutter, 0,5 mm, is suitable for general use.

## 8 Expression of results

### 8.1 Calculation of image clarity, $C_n$

Calculate the image clarity using [Formula \(1\)](#); see [Figure 3](#) and [Figure 4](#):

$$C_n = \frac{M - m}{M + m} \times 100 \quad (1)$$

where

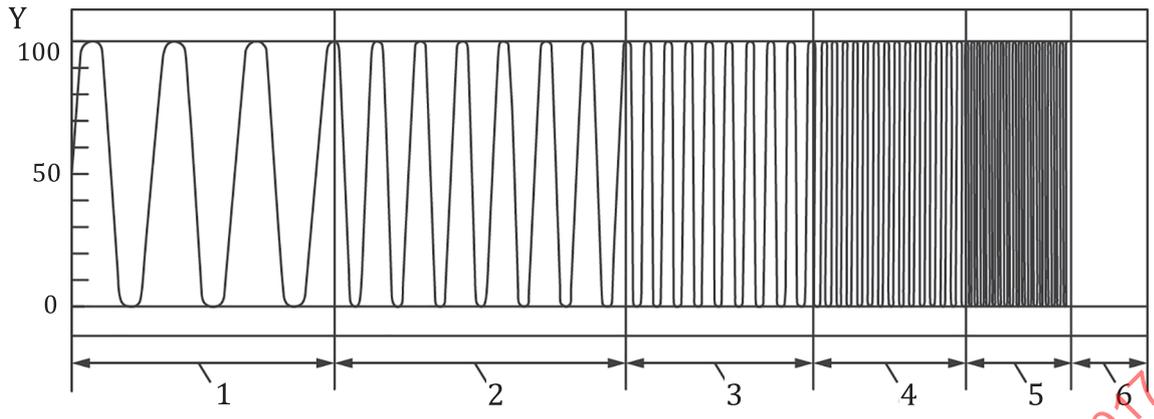
$C_n$  is the image clarity;

$M$  is the maximum light intensity;

$m$  is the minimum light intensity;

$n$  is the width of the combed sliding shutter.

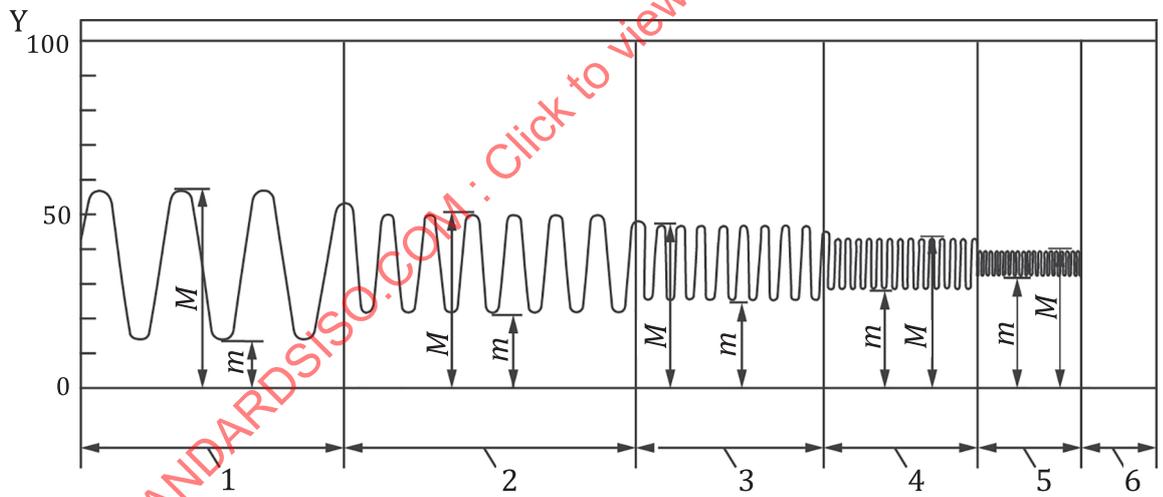
NOTE When the image clarity is high, the image can be seen clearly. On the contrary, when the image clarity is low, the image is distorted.



**Key**

- Y relative light intensity
- 1 transparent and opaque portions each 2,0 mm in width
- 2 transparent and opaque portions each 1,0 mm in width
- 3 transparent and opaque portions each 0,5 mm in width
- 4 transparent and opaque portions each 0,25 mm in width
- 5 transparent and opaque portions each 0,125 mm in width
- 6 opaque portion

**Figure 3 — Example of received light intensity from black glass**



**Key**

- Y relative light intensity
- M maximum light intensity
- m minimum light intensity
- 1 transparent and opaque portions each 2,0 mm in width
- 2 transparent and opaque portions each 1,0 mm in width
- 3 transparent and opaque portions each 0,5 mm in width
- 4 transparent and opaque portions each 0,25 mm in width
- 5 transparent and opaque portions each 0,125 mm in width
- 6 opaque portion

**Figure 4 — Example of received light intensity from test specimen**