

Assessment Report

Alumet B.V.

Assessment dates	20/02/2025
Assessment Location(s)	Etten-Leur (000)
Report Author	Okke Jansma
Assessment Standard(s)	Second Party (Generic)



Assessment Details

Location reference	0047543475-000
Assessed Location Name/ Address	Alumet B.V. Mon Plaisier 32 Etten-Leur 4879 AN The Netherlands
Visit type	Supplier Audit - Client Programme
Assessment number	30384430
Assessment dates	20/02/2025
Assessment duration	1 day(s)

Assessment Team

Name	Position
Okke Jansma	Team Leader

Assessment Participants

Name	Position	Opening Meeting	Closing Meeting	Interviewed (processes)
Remco Baartmans	Director	X		X
Frans Thijs	Senior Q&S Auditor	X	X	X
Masoud Kheirollahi	Process manager	X	X	X
Coskun Gueney	Production manager			X
Michaela Güney	Hoofd Customer Service			
Chananja Verhoog	Commercieel manager			
Marjolein Oomen	Customer Service			
Leon van der Kubbe	Planning			
Erham Aksoy	teamleader Anodising			
Gabriel Miha	Operator (early shift)			X
Ehsan	Operator			X
Florin Ababei	Operator (Quality Check)			X
Sevket Kurt	Teamleader Rack & Unpack			X
Muhamer Erdogan	Lab Technician			X

Site/ Facility Overview

Alumet B.V. is located at Mon Plaisier 32 Etten-Leur 4879 AN The Netherlands. The facility specializes in anodizing aluminium constructions (plating and profiles). The main production processes include: unpacking, polishing, grinding, brushing, anodizing, inspection and shipping. The facility consists of one production building.

Production workers have different nationality (Dutch, German, Turkish, Polish, Rumanian, Iranian)

The facility is opened from Monday to Friday, 24 hours. Incidentally Saturday is used for extra production or for maintenance.

Assessment Objective, Scope and Criteria

This is a verification/ witness audit for the BS 3987:1991, on-site o at Etten-Leur on an announced basis according to the contract.

Audit methodology included witness of the production (anodizing process), inspection, interviews with workers, document/record review, observations and management interviews. Findings were raised based on a limited, yet thorough sampling and collaborated from different information sources.

Findings from this assessment

Implementation of the BS 3987:1991

BSI has witnessed the new production facility during the commissioning process with regards to the requirements of the BS 3987:1991 and has seen no deviations. Compliance of the production facility with the requirements of the BSI 3987:1991 was demonstrated.

Process control:

Witnessed batches:

Batch 31: E6 Nature (E6-Alunature-20) – Workorders 2501829 – 2501830 2501835 – 2501840 – 2501841 – 2501842 – client: Hydro Building Systems – France

Batch 18: E6 Nature (E6-Alunature-20) – Workorders 2501832 – 2501834 – 2501835 – 2501846 – client: ALUK Belgium NV.

Process conditions:

Position 4: Alkaline degreasing – 53 °C - pH 9.3 - Time performance: 605 secs (Recipe secs: 600)

Position 5: Rinse – Time performance: 126 secs (Recipe secs: 120)

Position 7: Etching – 62 °C - NaOH: 52.7 - Al: 164.4 - Time performance: 808 secs (Recipe secs: 720)

Position 8: Semi static - warm rinsing - 26 °C - Time performance: 153 secs (Recipe secs: 150)

Position 9: Rinsing - Time performance: 11 secs (Recipe secs: 1) (extra rinsing)

Position 17: Cascade rinsing

Position 15: Neutralization

Position 17: Cascade rinsing

Position 20: Anodising – 16.2 °C - 18.1 V - current: 21.60 kA - Time performance: 3,653 (Recipe secs: 3600) - H2SO4: 182.3, Al: 11.9 - 12.2

Position 19: Rinsing – Time performance: 51(Recipe secs: 60)

Position 22: Rinsing – Time performance: 411 (Recipe secs: 1)

Position 27: Rinsing – Time performance: 9 (Recipe secs: 1)

Position 28: Demi Rinsing – Time performance: 51 (Recipe secs: 1) - pH: 6.4

Position 36: Demi rinsing – Time performance: 9 (Recipe secs: 1) - pH: 6.4 - conductivity: 117 µS

Position 39: Hot seal – 96 °C Time performance: 3627 (Recipe time: 3600) - pH: 6.0 - conductivity: 632 µS

Test Results:

Thickness measures:

batch 18: between 27.7 µm and 31.3 µm. All measured thicknesses above 25 µm.

batch 31: between 25.9 µm and 32.0 µm. All measured thicknesses above 25 µm.

Visual inspection: okay

Sanding test performed on edges of profiles:

batch 18: 10 times sanding: no visible degradation of surface, sanding paper not colored (OK)

batch 31: 10 times sanding: no visible degradation of surface, sanding paper not colored (OK)

batch 18: 50 times sanding: from 28.2 to 27.9 µm - loss of thickness 0.3 µm (OK)

batch 31: 50 times sanding: from 30.4 to 29.5 µm - loss of thickness 1.1 µm (OK)

Ultrasonic measurements calibrated with Anotest reference

Surface abrasion resistance

Batch 31: Total load 18.8

Batch 31: Total load 18.3

(Afdrachtstesten)

Summary of Findings / Audit Conclusion

BSI has witnessed the new production facility during the commissioning process with regards to the requirements of the BS 3987:1991 and has seen no deviations. Compliance of the production facility with the requirements of the BSI 3987:1991 was demonstrated.

How to contact BSI

Should you wish to speak with BSI in relation to your assessment report, please contact your local BSI office – contact details available from the BSI website:

<https://www.bsigroup.com/nl-NL/neem-contact-met-ons-op/>

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