

**EUROPEAN PATENT APPLICATION**

(2<sup>1</sup>) Application number: **86106391.5**

(5<sup>1</sup>) Int. Cl.4: **C25D 11/04**

(2<sup>2</sup>) Date of filing: **12.05.86**

(3<sup>0</sup>) Priority: **17.06.85 IT 2117785**

(4<sup>3</sup>) Date of publication of application:  
**21.01.87 Bulletin 87/04**

(8<sup>4</sup>) Designated Contracting States:  
**CH DE FR GB LI**

(8<sup>6</sup>) Date of deferred publication of the search report:  
**04.11.87 Bulletin 87/45**

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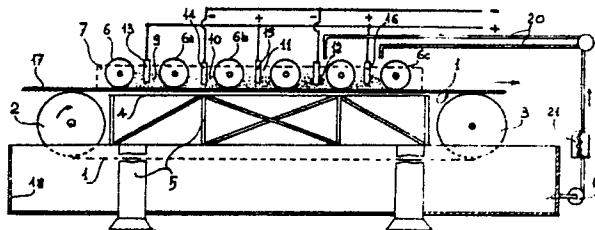
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(5<sup>4</sup>) **Process for the anodic oxidation of metals as sheets, tapes and the like, particularly suitable for aluminium and its alloys, and related equipment.**

(5<sup>7</sup>) Process for the anodic oxidation of the metals, in particular of aluminium and its alloys, consisting in making a metal plate or strip (17) advance, by a conveyor means, through a plurality of electrolytic cells, containing the same anodizing bath, and positioned in a sequential approached arrangement; each cell is provided with an electrode (13, 14, 15, 16 etc.) having alternately opposite polarity relatively to the polarity of the electrodes of the adjacent cells, so as to create oxidating anodic cells alternated to reducing cathodic cells, able to cause the formation on the metal plate of an oxide layer having increasing thickness, as the plate is conveyed through the sequential oxidating cells; and then in extracting, from the last cell, which is preferably an oxidating cell, the plate thus anodized.

An equipment having the purpose of accomplishing such a process, in which an endless belt conveyor (1), taut between end rollers (2, 3), on which a plurality of rollers (6, 6a, 6b, 6c), positioned equally spaced from each other, and closed at their ends by staunch containment side walls, are mounted, each adjacent couple of said rollers (6-6a; 6a-6b) constituting, together with its respective side walls (7, 8), a cell, under each of which cells a plate to be anodized being advanced; to each cell an

electrode (13, 14, 15, 16 etc.) is associated, alternately having opposite polarity relatively to the polarity of the electrodes of adjacent cells, all the cells being fed with the same anodizing bath, said plurality of adjacent cells defining oxidating anodic chambers alternated to reducing cathodic chambers, able to form a layer of oxide by sequential steps of anodic oxidation. Furthermore, means for the recovery of the solution leakages, as well as means for the recycle to the individual cells of said leaked solution are provided.



**Fig. 1**



DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl. 4)
X, P	DE-A-3 447 575 (FUNAKOSHI) * Page 5, lines 27-36; page 6, lines 1-26 *	1, 2, 7, 8	C 25 D 11/04
A	FR-A-2 192 873 (KALLE)		
A	EP-A-0 032 530 (GEBR. SCHMID GmbH & CO.)		
A	GB-A-1 407 947 (FROMSON)		
A	US-A-3 799 848 (KOLIC) * Column 17, lines 6-20, 44-45 *	5, 6	
			TECHNICAL FIELDS SEARCHED (Int. Cl. 4)
			C 25 D 11/02 C 25 D 11/04 C 25 D 7/06
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 17-08-1987	Examiner VAN LEEUWEN R.H.
<p><b>CATEGORY OF CITED DOCUMENTS</b></p> <p>X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document</p> <p>T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons &amp; : member of the same patent family, corresponding document</p>			