



SPECIFICATIONS FOR A QUALITY LABEL FOR LIQUID AND POWDER ORGANIC COATINGS ON ALUMINIUM FOR ARCHITECTURAL APPLICATIONS

👉 13th Edition 👉

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This edition supersedes the previous edition. It may be supplemented with new update sheets.

Appendices A7 and A9 are continuously updated.

All current update sheets are published on Internet: www.qualicoat.net

MAIN CHANGES COMPARED WITH THE 12TH EDITION ISSUED IN SEPTEMBER 2009

UPDATE SHEETS OF THE 12TH EDITION:

1. VISUAL ASSESSMENT AFTER ARTIFICIAL AND NATURAL WEATHERING
2. DETAILED INFORMATION ON CURING CONDITIONS
3. NEW RULES FOR BANNED COLOURS
4. CLARIFICATION OF UNCERTAINTIES IN THE SPECIFICATIONS
5. EXTENSION OF POWDER SUPPLIERS' LABORATORY EQUIPMENT
6. CLARIFICATION REGARDING FLORIDA SUBMISSION
7. DRIPPING WATER VALUE FOR ANODIC PRETREATMENT
8. DISTINCTION BETWEEN DRYING AND STOVING CHAMBERS
9. PREPARATION OF TEST PANELS
10. CLARIFICATION REGARDING STRUCTURED POWDERS
11. REFERENCE TO APPENDICES A5 AND A9
12. DAILY CONTROL OF ETCHING DEGREE DURING SEASIDE PRODUCTION
13. SUMMARY OF REQUIREMENTS FOR THE APPROVAL OF POWDER COATING MATERIALS
14. THICKNESS REQUIREMENTS FOR 3 TESTS (IMPACT, BENDING AND CUPPING)
15. RENEWAL OF METALLIC COLOURS
16. EQUIPMENT OF INSPECTORS
17. PROCEDURE TO BE FOLLOWED IN CASE OF NON-CONFORMITIES
18. CLARIFICATION FOR GRANTING THE LICENCE
19. PREPARATION OF TEST PANELS
20. CLARIFICATION REGARDING ETCHING DEGREE SPECIFICATION

PROPOSALS APPROVED BY THE COMMITTEES ON 23-24 NOVEMBER 2011:

- No 1: Reference to the QUALIDECO Specifications in chapters 1 and 5
- No 2: Clarification regarding the execution of mechanical and corrosion tests (Chapter 2)
- No 3: Clarification regarding the final assessment of the acetic acid salt spray (§ 2.10.)
- No 4: Reorganisation of paragraphs 3.2 to 3.4 (chemical pretreatments)
- No 5: Revised Chapter 4 (Approval of Organic Coatings) including the following proposals:
 - Reference to extensions and to approvals for decoration
 - Distinction between standard approvals and special approvals
 - Introduction of the concept of "extension"
 - Introduction of the concept of "suspended colour"
- No 6: Clarifications to be made in chapter 5 regarding preliminary inspections and inspections sequences
- No 7: Amended table summarising the specifications for in-house control – including clarification regarding the minimum frequency for etching degree measurement (Resolution No 5/TC 23.11.11)
- Amended procedure for evaluating alternative chemical pretreatment materials - Revised appendix A6
- Suspension of inspections in case of political unrest - new paragraph in chapter 5 (Resolution No 5/EC 24.11.11)

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Chapter 1

General Information

1. General Information

These Specifications apply to the QUALICOAT quality label, which is a registered trademark. The regulations for use of the quality label are set out in Appendix A1.

The aim of these Specifications is to establish minimum requirements which plant installations, organic coating materials, chemical conversion materials, processes and finished products shall meet.

These Specifications are designed to ensure high-quality of coated products for use in architectural applications, whatever kind of coating process is used. Any after treatment not stipulated in these Specifications may affect the quality of an organic coated product and is the responsibility of whoever applies it.

The Specifications for plant installations are the minimum requirements for producing good quality. Other methods may only be used if they have been previously approved by QUALICOAT.

The aluminium or aluminium alloy material shall be suitable for the coating processes specified in this document. It shall be free from corrosion and shall not have any anodic or organic coating (except anodic pre-treatment as described in these Specifications). It shall also be free from all contaminants, especially silicone lubricants. The edge radii shall be as large as possible.

Coating applicators holding the quality label shall treat all products intended for architectural applications in accordance with these Specifications and shall only use organic coating materials and chemical conversion materials approved by QUALICOAT for such products. For external architectural applications, other materials may be used only at the customer's written request and only if there are technical reasons for doing so. It is not permitted to use unapproved materials for commercial reasons.

These Specifications form the basis for granting and renewing the quality label. All requirements in these Specifications shall be met before a quality label can be granted. In case of ambiguities or uncertainties in any part of the Specifications, clarification shall be requested from QUALICOAT.

The quality assurance representative in the company holding the label shall always have the latest version of the Specifications.

The Specifications may be supplemented or amended with update sheets that set out and incorporate the QUALICOAT's resolutions until new edition is issued. These numbered sheets will state the subject of the resolution, the date when QUALICOAT passed the resolution, the effective date and the details of the resolution.

The Specifications and update sheets are published on Internet (www.qualicoat.net). They shall also be communicated to all licensed coating applicators and to holders of an approval.

These Specifications do not apply to coil coating.

The procedures for granting and renewing a licence for decoration are set out in a separate document available on both QUALICOAT (www.qualicoat.net) and QUALIDECO (www.qualideco.eu) websites.

TERMINOLOGY

Approval:	Confirmation that a specific material (coating or chemical conversion) meets the requirements of the QUALICOAT Specifications.
Coating applicator:	Company that has one or several plant installations.
Plant installation:	A production site with one or more coating lines used for coating aluminium for architectural applications.
Coating line:	A production line including surface preparation, conversion coating and drying, used for coating aluminium for architectural applications.
Licence:	Permission to use the quality label in accordance with the QUALICOAT Specifications.
Licensee:	Holder of the licence.
General licence:	Permission to grant licences and approvals in a certain territory.
General licensee (GL):	National or international association holding the QUALICOAT general licence for a defined territory.
Testing laboratories:	Independent quality testing and inspection bodies duly authorised by the General Licensee or QUALICOAT.

Chapter 2

Test Methods and Requirements

2. Test Methods and Requirements

The test methods described below are used to test finished products, organic coating materials and chemical conversion materials for approval (see chapters 4 and 5).

The test methods are based on international standards, where they exist, listed in appendix A9. The requirements are specified by QUALICOAT on the basis of practical experience and/or testing programs organized by QUALICOAT.

For the mechanical tests stipulated in § 2.6, 2.7 and 2.8, the test panels shall be made of the alloy AA 5005-H24 or -H14 (AlMg 1 - semihard) with a thickness of 0.8 or 1 mm, unless otherwise approved by QUALICOAT. These mechanical tests shall be carried out on the reverse side of the significant surface.

For the corrosion tests (§ 2.10 and 2.11), the test samples shall be made of AA 6060 or AA 6063. If the main production in the plant is on sheets or alloys other than AA6060 or AA6063 the corrosion tests will be carried out on the material actually used.

2.1. Appearance

The appearance will be evaluated on the **significant surface**.

The significant surface shall be defined by the customer and is the part of the total surface which is essential to the appearance and serviceability of the item. Edges, deep recesses and secondary surfaces are not included in the significant surface. The organic coating on the significant surface shall not have any scratches through to the base metal. When the organic coating on the significant surface is viewed at an oblique angle of about 60° to the upper surface, none of the defects listed below shall be visible from a distance of 3 metres: excessive roughness, runs, blisters, inclusions, craters, dull spots, pinholes, pits, scratches or any other unacceptable flaws.

The organic coating shall be of even colour and gloss with good hiding power. When viewed on site, these criteria shall be fulfilled as follows:

- for parts used outside: viewed at a distance of 5 m
- for parts used inside: viewed at a distance of 3 m

2.2. Gloss

EN ISO 2813 - using incident light at 60° to the normal.

Note: if the significant surface is too small or unsuitable for the gloss to be measured with the glossmeter, the gloss should be compared visually with the reference sample (from the same viewing angle).

REQUIREMENTS:

Gloss category	Gloss range			Acceptable variation		
1 (matt)	0	-	30	+/-	5	units
2 (semi-matt or semi-gloss)	31	-	70	+/-	7	units
3 (gloss)	71	-	100	+/-	10	units

(permissible variation from the nominal value specified by the coating supplier)

2.3. Coating thickness

EN ISO 2360

The thickness of the organic coating on each part to be tested shall be measured on the significant surface at not less than *five measuring areas* (appr.1 cm²) with *3 to 5 separate readings* taken at each area. The average of the separate readings taken at one measuring area gives a *measured value* to be recorded in the inspection reports. None of the measured values may be less than 80% of the specified minimum value otherwise the thickness test as a whole will be considered unsatisfactory.

REQUIREMENTS:

Powder coating:

Class 1 ¹	:	60 µm
Class 2	:	60 µm
Class 3	:	50 µm
Two-coat powder coating (classes 1 et 2)	:	110 µm
Two-coat PVDF powder coating	:	80 µm

Liquid coating

Two-coat PVDF liquid coating	:	35 µm
Three-coat metallized PVDF liquid coating	:	45 µm
Silicon polyester without primer (minimum 20% silicon resin)	:	30 µm
Water-thinnable liquid coating	:	30 µm
Other thermosetting liquid coating	:	50 µm
Two-component liquid coating	:	50 µm
<u>Electrophoretic coating</u>	:	25 µm

Other organic coatings may require different thicknesses, but they may only be applied with the approval of the Executive Committee.

The results shall be assessed as shown by **four typical examples** (minimum thickness for coatings of 60 µm):

Example 1:

Measured values in µm : 82, 68, 75, 93, 86 average: 81

Rating:

This sample is satisfactory.

¹ There are three different classes of coating powders that meet different requirements. The particular class is stated in the approval.

Example 2:

Measured values in μm : 75, 68, 63, 66, 56 average: 66

Rating:

This sample is good because the average thickness is more than 60 μm and because no value measured is less than 48 μm (80% of 60 μm).

Example 3:

Measured values in μm : 57, 60, 59, 62, 53 average: 58

Rating:

This sample is unsatisfactory and comes under the heading "rejected samples" in table 5.1.5.

Example 4:

Measured values in μm : 85, 67, 71, 64, 44 average: 66

Rating:

This sample is unsatisfactory although the average thickness is more than 60 μm . The inspection is unsatisfactory because the measured value of 44 μm is below the tolerance limit of 80% (48 μm).

2.4. Adhesion

EN ISO 2409

The adhesive tape is prescribed by the standard. The spacing of the cuts shall be 1 mm for organic coating thicknesses of up to 60 μm , 2 mm for thicknesses between 60 μm and 120 μm , and 3 mm for thickness over 120 μm .

REQUIREMENTS:

The result shall be 0.

2.5. Indentation

EN ISO 2815

REQUIREMENTS:

Minimum 80 at the required thickness.

2.6. Cupping test

All organic coatings except class 2 and 3 powder coatings²: **EN ISO 1520**

² See previous footnote.

Class 2 and 3 powder coatings:

EN ISO 1520 followed by a tape pull adhesion test as specified below:

Apply an adhesive tape (see § 2.4) to the significant surface of the test panel following the mechanical deformation. Cover the area by pressing down firmly against the coating to eliminate voids or air pockets. Pull the tape off sharply at right angles to the plane of the panel after 1 minute.

REQUIREMENTS:

Minimum 5 mm for powder coatings (classes 1, 2 and 3)

Minimum 5 mm for liquid coatings except

- two-component liquid coatings: minimum 3 mm
- water-thinnable liquid coatings: minimum 3 mm

Minimum 5 mm for electrophoretic coatings

The test shall be performed on an organic coating with a thickness approximating the minimum required.

In case of a negative result, the test shall be repeated on a panel coated with a thickness of

- Class 1 and 2: 60 to 70 µm
- Class 3: 50 to 60 µm

Using normal corrected vision, the organic coating shall not show any sign of cracking or detachment, except for class 2 and 3 powder coatings.

Class 2 and 3 powders coatings:

Using normal corrected vision, the organic coating shall not show any sign of detachment following the tape pull adhesion test.

2.7. Bend test

All organic coatings except class 2 and 3 powder coatings³: **EN ISO 1519**

Class 2 and 3 powder coatings:

EN ISO 1519 followed by a tape pull adhesion test as specified below:

Apply an adhesive tape (see § 2.4) to the significant surface of the test panel following the mechanical deformation. Cover the area by pressing down firmly against the coating to eliminate voids or air pockets. Pull the tape off sharply at right angles to the plane of the panel after 1 minute.

The test shall be performed on an organic coating with a thickness approximating the minimum required.

In case of a negative result, the test shall be repeated on a panel coated with a thickness of

- Class 1 and 2: 60 to 70 µm
- Class 3: 50 to 60 µm

³ See previous footnote.

REQUIREMENTS:

Bending around a 5 mm mandrel for all organic coatings except for two-component and water-thinnable liquid coatings. For these, use an 8 mm mandrel.

Using normal corrected vision, the coating shall not show any sign of cracking or detachment, except for class 2 and 3 powders coatings.

Class 2 and 3 powders coatings:

Using normal corrected vision, the organic coating shall not show any sign of detachment following the tape pull adhesion test.

2.8. Impact test

(for powder coatings only)

The impact shall be carried out on the reverse side, whereas the results shall be assessed on the coated side.

- Class 1 powder coatings (one- and two-coat), energy: 2.5 Nm: EN ISO 6272- 2 (indenter diameter: 15.9 mm)
- Two-coat PVDF powder coatings, energy: 1.5 Nm: **EN ISO 6272-1 or EN ISO 6272-2 / ASTM D 2794** (indenter diameter: 15.9 mm)
- Class 2 and 3 powder coatings, energy: 2.5 Nm: **EN ISO 6272-1 or EN ISO 6272-2 / ASTM D 2794** (indenter diameter: 15.9 mm) followed by a tape pull adhesion test as specified below.

Apply an adhesive tape (see § 2.4) to the significant surface of the test panel following the mechanical deformation. Cover the area by pressing down firmly against the organic coating to eliminate voids or air pockets. Pull the tape off sharply at right angles to the plane of the panel after 1 minute.

The test shall be performed on an organic coating with a thickness approximating the minimum required.

In case of a negative result, the test shall be repeated on a panel coated with a thickness of

- Class 1 and 2: 60 to 70 µm
- Class 3: 50 to 60 µm

REQUIREMENTS:

Using normal corrected vision, the organic coating shall not show any sign of cracking or detachment, except for class 2 and 3 powder coatings.

Class 2 and 3 powder coatings:

Using normal corrected vision, the organic coating shall not show any sign of detachment following the tape pull adhesion test.

2.9. Resistance to humid atmospheres containing sulphur dioxide

EN ISO 3231 (0,2 l SO₂ - 24 cycles). A cross-cut incision with a width of 1 mm shall be made to cut the organic coating down to the metal.

REQUIREMENTS:

No infiltration exceeding 1 mm on both sides of the scratch, and no change in colour or blisters in excess of 2 (S2) according to ISO 4628-2.

2.10. Acetic acid salt spray resistance

ISO 9227. A cross-cut incision with a width of 1 mm shall be made to cut the organic coating down to the metal. The test shall be carried out on three test pieces of AA 6060 or AA 6063.

For all organic coatings except class 3 powder coatings: testing time: 1000 hours

For class 3 powder coatings: testing time: 2000 hours

REQUIREMENTS:

No blistering in excess of 2 (S2) according to ISO 4628-2. An infiltration of maximum 16 mm² is allowed over a scratch length of 10 cm but the length of any single infiltration shall not exceed 4 mm.

The inspector takes three test pieces from different lots. The results are classified according to the scale below:

A.	3 samples satisfactory	=	0 sample unsatisfactory
B.	2 samples satisfactory	=	1 sample unsatisfactory
C.	1 sample satisfactory	=	2 samples unsatisfactory
D.	0 sample satisfactory	=	3 samples unsatisfactory

Final assessment of the AASS test:

RATING	GRANTING/RENEWAL OF APPROVAL	GRANTING/RENEWAL OF LICENCES
A	Satisfactory	Satisfactory
B	Satisfactory	Satisfactory with a comment to the coating applicator
C	Unsatisfactory Repetition of the acetic acid salt spray resistance test. If the result of this second test is C or D, all tests shall be repeated.	Unsatisfactory Repetition of the acetic acid salt spray resistance test. If the result of this second test is C or D, the inspection shall be repeated.
D	Unsatisfactory All laboratory tests shall be repeated.	Unsatisfactory The inspection shall be repeated.

2.11. Machu test

(Accelerated corrosion test, on extruded sections of AA 6060 or AA 6063 only)

Before immersion, a cross-cut incision with a width of 1 mm shall be made on the significant surface with a special tool to cut the coating down to the metal.

Test solution:

NaCl	:	50 ± 1 g/l
CH ₃ COOH (Glacial)	:	10 ± 1 ml/l
H ₂ O ₂ (30%)	:	5 ± 1 ml/l
Temperature	:	37 ± 1 °C
Testing time	:	48 ± 0.5 hours

The pH of this solution is 3.0 - 3.3. After 24 hours, another 5 ml/l of hydrogen peroxide (H₂O₂ 30%) shall be added and the pH adjusted with glacial acetic acid or caustic soda. A new solution shall be prepared for each test.

REQUIREMENTS:

No infiltration exceeding 0.5 mm on both sides of the scratch.

2.12. Accelerated weathering test

EN ISO 11341

Luminous intensity: 550 ± 20 W/m² (290 - 800 nm)

Black standard temperature: 65 ± 5°C

Demineralised water: maximum 10 µS

Special UV filter (290 nm)

Cycles of 18 minutes in a wet medium and 102 minutes in a dry medium

After 1000 hours exposure (2000 hours for class 3), the test panels should be rinsed with demineralised water and checked for:

- Gloss variation: EN ISO 2813
angle of incidence 60°
- Colour change: ΔE CIELAB formula according to ISO 7724/3, measurement including specular reflection.

3 colour measurements are to be made on the test panels before and after the accelerated weathering test.

For class 3 powder coatings gloss and colour variation shall be checked every 500 hours.

REQUIREMENTS:

Gloss retention: the loss of gloss after the accelerated weathering test shall not be greater than 50% of the initial value, or 10% for class 2 and class 3 powder coatings.

An additional visual assessment will be carried out for

- organic coatings with an original gloss value of less than 20 units;
- organic coatings with structured appearance in all gloss categories;
- organic coatings with a metallic or metallised effect (see appendix A4).

Colour change: according to the ΔE values stipulated in the annexed table. For class 2 and class 3 powders, the colour change ΔE shall not be greater than 50% of the limits prescribed in the annexed table (see appendix A7).

2.13. Natural weathering test

Exposure in Florida according to ISO 2810

The test should start in April.

Class 1 organic coatings

Samples shall be exposed facing 5° south to the horizontal and facing toward the equator for **1 year**.

4 test panels per colour shade are required (3 for weathering and 1 reference panel)

Class 2 organic coatings

Samples shall be exposed facing 5° south for **3 years with an annual evaluation**.

10 test panels per colour shade are required (3 per year for weathering and 1 reference panel).

Class 3 organic coatings

Samples shall be exposed facing 45° south for **10 years**.

All the test panels shall be cleaned and measured annually by the laboratory in Florida.

After 1, 4 and 7 years, 3 test panels will be sent back to the QUALICOAT laboratory in charge for evaluation. The remaining 3 test panels will finally be sent back to the laboratory in charge at the end of the 10-year exposure period.

For all organic coatings:

Dimensions of the test panels: approx. 100 x 305 x 0.8 - 1 mm

After exposure, the exposed panels shall be cleaned using the following method:

Immersion in demineralised water with a 1% surface-active agent for 24 hours, then cleaned by wiping with a soft sponge with tap water applying gentle pressure, or using any other method approved by the Technical Committee. This process shall not scratch the surface.

The gloss shall be measured according to EN ISO 2813, at an angle of 60°.

The average is taken from the colorimetric measurements. The conditions for measurement and colorimetric evaluation are:

Colour variation: ΔE CIELAB formula according to ISO 7724/3, measurement including specular reflection.

The colorimetric evaluation shall be made for the standard illuminant D65 and the ten-degree normal observer.

To determine the gloss and colour, three measurements will be made on the cleaned panels before and after the weathering test. These measurements shall be made at different points at least 50 mm apart.

REQUIREMENTS:

Gloss

The residual gloss shall be at least 50% of the original gloss for class 1 organic coatings.

The following values apply to class 2 organic coatings:

- After 1 year in Florida : at least 75%
- After 2 years in Florida : at least 65%
- After 3 years in Florida : at least 50%

The following values apply to class 3 organic coatings:

- After 1 year in Florida : at least 90%
- After 4 years in Florida : at least 70%
- After 7 years in Florida : at least 55%
- After 10 years in Florida : at least 50%

An additional visual assessment will be carried out for

- organic coatings with an original gloss value of less than 20 units;
- organic coatings with structured appearance in all gloss categories;
- organic coatings with a metallic or metallised effect (see appendix A4).

Colour change

For class 1 organic coatings the ΔE values shall not exceed the maximum values prescribed in the annexed table (see Appendix A7).

The following values apply to class 2 organic coatings:

- After 1 year in Florida: not greater than 65% of the limits prescribed in the table
- After 2 years in Florida: not greater than 75% of the limits prescribed in the table
- After 3 years in Florida: within the limits prescribed in the table

For class 3 organic coatings, the ΔE value after 10 years in Florida shall not exceed the limits prescribed in the table (Appendix A7).

2.14. Polymerisation test

Prescribed solvent for liquid coatings: MEK or as specified by the liquid coating material's manufacturer and approved by the Technical Committee.

Prescribed solvent for powder coatings: xylene or as specified by the powder coating material's manufacturer and approved by the Technical Committee.

Saturate a swab of cotton wool with solvent. Within 30 seconds, rub it lightly back and forth 30 times in each direction over the part to be tested. Wait 30 minutes before making the assessment.

The polymerisation quality is assessed according to the following ratings:

1. The coating is very dull and quite soft.
2. The coating is very dull and can be scratched with a finger-nail.
3. Slight loss of gloss (less than 5 units)
4. No perceptible change. Cannot be scratched with a finger-nail.

REQUIREMENTS:

Ratings 3 and 4 are satisfactory.

Ratings 1 and 2 are unsatisfactory.

For powder coatings, this test is optional in in-house control; it is merely indicative and cannot alone cast doubt upon the quality of the coating.

2.15. Resistance to mortar

The test shall be performed according to the **EN 12206-1** (paragraph 5.9) standard.

REQUIREMENTS:

The mortar shall be easy to remove without leaving any residues. Any mechanical damage to the organic coating caused by grains of sand should be disregarded.

Any change in the appearance/colour of organic coatings with metallic or metallized effect shall not exceed 1 on the reference scale (see Appendix A4). All other colours shall not show any change.

2.16. Resistance to boiling water

Method 1 with boiling water:

2 hours immersion in boiling demineralised water (maximum 10 μ S at 20°C). Remove the test sample and allow it to cool down to room temperature. Apply an adhesive tape (see § 2.4) to the surface, ensuring that no air is trapped. After one minute, remove the tape at an angle of 45° with a sharp even pull.

Method 2 with a pressure cooker:

(to be used for powder and electrophoretic coatings only)

Add demineralised water (maximum 10 μ S at 20°C) to a pressure cooker with an internal diameter of about 200 mm to a depth of 25 mm and place a test panel measuring 50 mm in it.

Place the lid in position and heat the pressure cooker until steam escapes from the valve. The weighted needle valve shall be adjusted to produce an internal pressure of 100 +/- 10 kPa (1 bar). Continue heating for 1 hour, timing from the moment when steam first escapes from the valve. Cool the pressure cooker, remove the sample and allow it to cool down to room temperature.

Apply an adhesive tape (see § 2.4) to the surface, ensuring that no air is trapped. After one minute, remove the tape at any angle of 45° with a sharp even pull.

REQUIREMENTS:

No blistering in excess of 2 (S2) according to ISO 4628-2. There shall not be any defects or detachment. Some colour change is acceptable.

2.17. Constant climate condensation water test

EN ISO 6270-2

A cross-cut incision with a width of at least 1 mm shall be made to score the organic coating down to the metal.

The test duration is 1000 hours for all organic coatings except class 3 and 2000 hours for class 3 organic coatings.

REQUIREMENTS:

No blistering in excess of 2 (S2) according to ISO 4628-2; the maximum infiltration at the cross is 1 mm.

2.18. Sawing, milling and drilling

The good quality of the organic coating is tested using sharpened tools suitable for aluminium.

REQUIREMENTS:

The coating shall not crack or chip when sharp tools are used.

Chapter 3

Work Specifications

3. Work Specifications

3.1. Storage of the products to be treated and layout of equipment

3.1.1 Storage

Aluminium

The products to be treated shall either be stored in a separate room or at least a good distance away from the processing baths. They shall also be protected against condensation and dirt.

Powder and liquid coating materials

Coating materials shall be stored in accordance with the specifications of the coating material's manufacturer.

Chemical products

Chemical products shall be stored in accordance with the specifications of the chemical material's manufacturer.

3.1.2 Layout of equipment

The layout of the equipment should be designed to avoid any form of contamination.

3.2. Surface preparation

The surfaces of the parts to be treated shall be clean and free of any oxidation, scale or soils, oil, grease, lubricants, handsweat or any other contamination that may be detrimental to the final finish. The parts shall therefore be etched before conversion coating. Two preliminary pretreatments are defined: **standard** (compulsory) and **enhanced** (voluntary, for SEASIDE endorsement).

The products to be treated shall either be attached to the jig individually or placed in a basket as stipulated in the appendix A8. Each product shall be treated fully in one pass, at each stage.

Cast accessories have special requirements (see Appendix A5 – Special specifications for coatings on aluminium accessories for architectural applications under the QUALICOAT quality label).

3.2.1 Etching Degree

All chemical pretreatments for powder and liquid organic coatings shall include an aluminium etching stage.

This etching stage consists of one or more steps, the last step preceding chemical conversion coating always being an acid step.

The etching degree is measured by taking the weight of a test sample before and after etching. If a sample cannot be taken, the method used to measure the etching degree shall be defined in agreement with the General Licensee or directly with QUALICOAT

in countries without a General Licensee. Any new plant installation shall be designed to allow sampling after each stage of the chemical treatment.

The etching degree is measured on extruded sections of alloy AA6060 or AA6063. If the main production in the plants is on sheets or alloys other than AA6060 or AA6063 the inspector should also check the etching degree with the material actually used.

An etching degree is not specified for rolled products or cast accessories. Etching is optional for such products.

Two preliminary pretreatments are defined:

a) Standard pretreatment (compulsory)

The total etching degree shall be at least 1.0 g/m².

b) Enhanced pretreatment (voluntary, for SEASIDE endorsement)

- **Type A : simple acid etching**

The total etching degree shall be at least 2.0 g/m².

- **Type AA : dual etching (alkaline etching and acid etching)**

The total etching degree shall be at least 2.0 g/m². Each etching degree shall be at least 0.5 g/m².

Coating applicators who wish to have the endorsement SEASIDE on their licence certificate shall apply to their General Licensee or directly to QUALICOAT in countries without a General Licensee.

3.3. Chemical conversion coatings

After conversion coating pre-treated aluminium shall not be stored for more than 16 hours. As a rule, they should be coated immediately after pre-treatment. The risk of insufficient adhesion increases the longer the products are stored.

Pre-treated aluminium shall never be stored in an atmosphere that is dusty and detrimental to them. Good atmospheric conditions shall always be maintained in the storage area. All workers handling pre-treated aluminium shall wear clean textile gloves to avoid contamination of the surface.

3.3.1 Chromate conversion coatings

This chemical chromate or chromate-phosphate conversion shall be carried out according to **ISO 10546**.

The conductivity of the final rinse preceding chemical chromate conversion's step shall comply with the manufacturer's specifications and be checked by the inspector.

Demineralised water shall be used for the final rinse after chemical chromate conversion before drying. The conductivity of the dripping water shall not exceed a maximum of 30 µS/cm at 20°C. The conductivity should only be measured for open sections and not for hollow sections.

The weight of the chromate conversion coating shall be between 0.6 and 1.2 g/m² for chemical chromate conversion (yellow coating) and between 0.6 and 1.5 g/m² for chemical chromate-phosphate conversion (green coating).

3.3.2 Alternative Conversion Coatings

Alternative chemical pre-treatments are treatments other than the pre-treatments described above.

Such alternative chemical pre-treatments may not be used until they have been approved by QUALICOAT, following a test programme.

Coating plant installations which decide to use such treatments shall inform their General Licensee or QUALICOAT if there is not a General Licensee. The coating plant installations and manufacturers shall comply with the special specifications set out in Appendix A6.

3.4. Anodic pre-treatment (automatic SEASIDE endorsement)

The aluminium surface shall be treated to eliminate all impurities that could pose problems in the anodic pre-treatment.

The anodic pre-treatment shall be chosen so as to produce an anodic coating with a thickness of at least 3 µm (not more than 8 µm) without powdering and without surface flaws.

The anodic pre-treatment parameters can be as follows:

- Acid concentration (sulphuric acid) : 180-220 g/l
- Aluminium content : 5-15 g/l
- Temperature : 20-30°C (± 1°C of the temperature chosen by the coater)
- Current density : 0.8-2.0 A/dm²
- Agitation of the electrolyte

After anodic pre-treatment, the aluminium shall be rinsed with demineralised water for as long and at such a temperature (less than 60°C) as is required to remove the acid from the pores. The conductivity of the dripping water of the last rinse shall not exceed a maximum of 30 µS/cm at 20°C. The conductivity should only be measured for open sections and not for hollow sections.

Plant installations using this type of anodic pre-treatment shall perform the following additional tests:

Anodising bath:

- the acid concentration and aluminium content shall be analysed every 24 hours of operation
- the temperature shall be checked 1 hour after anodising starts, then every 8 hours.

Testing of the coated finished products:

- Before application, each coating (of a system and/or a manufacturer) shall be tested for resistance to boiling water, followed by an adhesion test (see § 2.4).
- During application, resistance to boiling water should be tested, followed by an adhesion test every 4 hours.

Coating plant installations which decide to use such treatments shall inform their General Licensee, or QUALICOAT if there is not a General Licensee.

3.5. Electrophoretic coatings

All products to be coated shall be cleaned by adapted chemical treatment in an alkaline or acid solution. The cleaned surfaces shall be rinsed in demineralised water with a maximum conductivity of 30 $\mu\text{S}/\text{cm}$ at 20°C prior to coating. The surfaces should be wettable with water.

The products shall be coated immediately.

All workers handling pre-treated parts shall wear clean textile gloves to avoid contamination of the surface.

3.6. Drying

After chemical pretreatment and before the application of organic coating, the products shall be dried thoroughly in an oven. For this purpose, a drying oven shall be installed in each plant.

For continuous treatment the maximum drying temperature allowed is 100°C.

For discontinuous treatment the products shall be dried at the following temperatures:

- chemical chromate conversion (yellow coating): maximum 65°C
- chemical chromate-phosphate conversion (green coating): maximum 85°C

The specified temperatures apply to the temperature of the metallic parts and not to the air temperature. The products shall be dried thoroughly before the coating is applied, irrespective of the production method (continuous/discontinuous).

For anodic pre-treatment, the drying temperature should be less than 80°C to prevent the anodic coating from being sealed.

Alternative chemical pre-treatment systems should be dried following the manufacturer's specifications.

3.7. Coating and stoving

3.7.1 Coating

For architectural applications the coating plant installation shall use only coatings approved by QUALICOAT. If the approval for an organic coating system is withdrawn, the coating plant installation is allowed to continue using it for a maximum of three months in order to complete unfinished work. However if a colour is banned the coating plant installation shall immediately stop using this colour.

3.7.2 Stoving

The coating line shall have an oven for drying and one for curing; in cases where the oven is combined (performing both functions), an efficient control system for temperature and time shall be in place to ensure that suppliers' recommended conditions can be followed.

The conditions between the spray booth and the oven shall be absolutely free of dust and contamination.

All organic coatings shall be stoved immediately after application. The oven shall bring the products to the required temperature and maintain them at that temperature for the whole length of the prescribed time.

The temperatures of the products and the stoving times shall match the values recommended in the manufacturer's technical specifications.

It is recommended to keep the difference in metal temperature during polymerisation phase below 20°C.

It should be possible to measure the temperature over the whole length of the oven.

The oven shall be fitted with an alarm system which operates as soon as the temperature moves outside the prescribed temperature range.

3.8. Laboratory

The coating plant installation shall have laboratory facilities which are separate from the production facilities. The laboratory shall have the apparatus and chemicals necessary for testing and controlling the process solutions and finished products. The laboratory shall at least be equipped with the following apparatus:

- 1) Specular glossmeter
- 2) 2 instruments for measuring coating thickness
- 3) 1 analytical balance (precision 0.1 mg)
- 4) Cutting tools and instruments necessary for performing the adhesion test
- 5) Instrument for measuring indentation hardness
- 6) Apparatus for testing adhesion and elasticity (cupping test)
- 7) Impact tester
- 8) Recorder for stoving temperature and time with four different measuring points, three on the parts and one to measure the air temperature.
- 9) Conductivity meter
- 10) Apparatus for testing resistance to cracking on bending
- 11) Test solution, material and special cutting tool for the Machu test
- 12) Test solutions for the polymerisation test
- 13) pH-meter

Each piece of apparatus shall have a data sheet showing the apparatus identification number and calibration checks.

The oven temperature recorder shall be checked and the results shall be registered at least twice per year.

The laboratory conditions may differ from those prescribed by ISO standards for mechanical tests.

3.9. In-house control

Coating plant installations holding the quality label shall monitor their production processes and inspect their finished products in accordance with chapter 6.

3.10. Operating Instructions

For every test the coating plant installation shall have the relevant standards or operating instructions based on these standards. These standards or operating instructions shall be available to all operators carrying out the tests.

3.11. Registers

The coating plant installation shall maintain registers for:

- production of QUALICOAT products
- in-house control
- customers' complaints.

Chapter 4

Approval of Organic Coatings

4. Approval of Organic Coatings

The organic coatings used in quality label coating shall be approved before they may be used. It is not permissible to apply a second coat for organic coating materials that are intended and approved for the application of a single coat.

When a two-coat organic coating material (primer and coloured topcoat) approved by QUALICOAT is used, the coating plant installation may apply either a class 1 or class 2 topcoat on the approved primer. It is not necessary to have an approval for each combination. However the organic coating material (primer and coloured topcoat) used by the coating plant installation shall originate from the same manufacturer.

Any modification of the chemical properties of the binder (resin(s) and/or hardening agent(s) is tantamount to a new product and absolutely requires a new QUALICOAT approval. Furthermore, if the physical appearance of the final coating is modified, a new specific QUALICOAT approval shall be required (see Appendix A3).

Special approvals or extensions of existing approvals may be granted for specific colours or applications such as decoration.

4.1. Granting of an approval

Organic coating materials have a reference identifying a specific chemical formulation. Every organic coating material can have a variety of gloss levels (matt, satin or gloss) and appearances (see Appendix A3).

Approvals are granted for each organic coating material, gloss level and appearance.

Approvals are usually requested by the manufacturers themselves, but any third party interested may apply for approval of an organic coating material he wishes to sell under his own brand name provided that he clearly informs the General Licensee and QUALICOAT of the sources used. An approval is granted for one single production site. If an approval holder changes his source, he shall advise the General Licensee and QUALICOAT and have such new organic coating materials approved.

In order for an approval to be granted, the following conditions shall be met:

4.1.1 Minimum laboratory equipment

- 1) Specular glossmeter
- 2) Instruments for measuring coating thickness
- 3) Apparatus for testing resistance to cracking on bending
- 4) Cutting tools and instruments necessary for performing the adhesion test
- 5) Instrument for measuring indentation hardness
- 6) Apparatus for cupping test
- 7) Impact tester
- 8) Apparatus for controlling stoving temperature and time
- 9) System for checking polymerisation
- 10) Spectrophotometer
- 11) Apparatus for accelerated weathering test⁴

⁴ The accelerated weathering test can be outsourced and carried out by a QUALICOAT approved laboratory or another laboratory accredited for this specific test according to ISO 17025.

Each piece of apparatus shall have a data sheet showing the apparatus identification number and calibration checks.

4.1.2 Tests for granting an approval⁵

The following tests shall be made:

- 1) Gloss (2.2)
- 2) Coating thickness (2.3)
- 3) Adhesion (2.4)
- 4) Indentation (2.5)
- 5) Cupping test (2.6)
- 6) Bend test (2.7)
- 7) Impact test (2.8)
- 8) Resistance to humid atmospheres (2.9)
- 9) Acetic acid salt spray resistance (2.10)
- 10) Accelerated weathering test (2.12)
- 11) Polymerisation test (2.14)
- 12) Resistance to mortar (2.15)
- 13) Resistance to boiling water (2.16)
- 14) Condensation water test (2.17)
- 15) Natural weathering (Florida) (2.13)

The tests shall be made on three test panels (for mechanical tests) and on three test samples (for corrosion tests) coated by a laboratory approved by QUALICOAT.

4.1.3 Basic colours to be tested for standard approvals

Class 1 and class 2

The following colours shall be tested (independently of gloss category or appearance):

- white RAL 9010
- blue RAL 5010
- red RAL 3005

plus a metallic or metalised effect colour if an extension to metallic colours is requested (see Appendix A4)

Class 3

The following colours shall be tested:

- blue
- light grey
- metallic or metalised effect

Not all the colours are suitable for use for class 3. Therefore it is the responsibility of the manufacturer to indicate the critical colours.

⁵ A summary of tests and requirements for powder coatings is given in Appendix A10.

4.1.4 Basic colours to be tested for special approvals or extensions

4.1.4.1 Special approvals valid for single colours

If a coating material is produced for a single colour, tests shall be carried out only on the colour mentioned in the system name. The tests are the same as those specified in § 4.1.2.

No other colours may be produced under the same approval number.

4.1.4.2 Special approvals valid for sublimation only⁶

If a coating material is produced exclusively for the application in sublimation, tests shall be carried out only on the following colours:

- BEIGE
- BROWN

The tests are the same as those specified in § 4.1.2.

Other colours may be produced under the same approval only for sublimation.

4.1.4.3 Extension for powder on powder technology

If a manufacturer wishes to have an approval extended for powder on powder (main coating and non-continuous top coating having the same QUALICOAT approval), tests shall be carried out for checking the compatibility of two colours on the decoration WALNUT following QUALIDECO criteria.

The following tests shall be carried out on decorated samples prepared by the laboratory:

- Resistance to humid atmospheres
- Resistance to boiling water (pressure cooker)
- Accelerated weathering test
- Natural weathering (Florida)

4.1.4.4 Extension for sublimation technology

If a manufacturer wishes to have a standard approval extended for sublimation, tests shall be carried out on the following colours:

- BEIGE
- BROWN

The tests are the same as those specified in § 4.1.2.

4.1.5 Sampling

The manufacturer shall send coating materials and coated samples to the laboratory in charge, together with the relevant technical data sheet for each colour. The data sheet

⁶ Systems designated as “1s” in the column “Coating materials” of the list of approved systems published on the Internet

should include at least the following information: colour, gloss value and curing conditions (including range of times and temperatures).

The inspector prepares the test samples in the testing laboratory using approved alternative chemical pretreatment and the coating materials supplied by the manufacturer. The test samples may also be coated elsewhere provided that the inspector is present during the whole time of treatment.

The inspector shall always select the minimum stoving time and temperature specified by the manufacturer. After checking the colour and gloss, he shall perform the above mentioned tests on the samples.

4.1.6 Assessment of test results

The inspector submits the test report to the General Licensee or to QUALICOAT in countries where there is no General Licensee.

The inspection reports are assessed by the General Licensee. Under the supervision of QUALICOAT, the General Licensee decides whether or not to grant an approval or an extension.

- If the results of tests 1 to 14 meet the requirements for all basic colours the approval or the extension will be granted.
- If the results of tests 1 to 14 meet the requirements for the basic colours but not for the metallic one, an approval will be granted for all colours excluding the metallic ones.⁷
- If the results of any of the tests 1 to 14 on a basic colour do not meet the requirements, the manufacturer of the organic coating material tested will be informed that no approval or extension can be granted for the time being, stating the details and reasons.
- If the results of tests 1 to 14 are satisfactory for the metallic colour but not for the basic colours, the manufacturer of the organic coating material tested will be informed that no approval can be granted for the time being, stating the details and reasons.

The manufacturer shall wait at least three months to have tests 1 to 14 repeated.

The approval shall be confirmed if the results of test 15 (natural weathering test in Florida) are satisfactory for all basic colours.

If the result is unsatisfactory for the metallic colour alone, the approval shall be maintained for all colours except metallic ones.

In all other cases, the approval shall be withdrawn.

4.1.7 Inspection of coating manufacturer's plant

A visit shall be required for new applicants in order to check the laboratory equipment of the coating manufacturer's plant. The costs of such a visit will be paid by the applicant. If a visit is considered unsatisfactory, the General Licensee (or QUALICOAT) retains the right not to grant the approval.

⁷ This rule is not valid for class 3 where metallic colour is one of the basic colours.

4.2. Renewal of approved systems

After an approval has been granted to a coating material, laboratory tests and Florida exposure shall be performed annually and an inspection of the coating manufacturer's plant shall be carried out every five years.

4.2.1 Laboratory tests and Florida exposure

Consistent quality of approved organic coating materials is monitored with tests 1 to 15 (see § 4.1.2) being performed on two colours chosen from the three colours specified by QUALICOAT each year. One metallic colour specified by QUALICOAT shall also be tested every year if there is an extension for metallic colours.

Renewal of special approvals and extensions

For the renewal of special approvals and extensions the same colours as for the granting shall be tested every year in the laboratory and in Florida.

Renewal of class 3 approvals

For class 3 organic coatings, two colours selected by QUALICOAT shall be tested in a laboratory every year. One of these two colours shall be metallic.

Two colours shall also be sent to Florida every five years. QUALICOAT shall indicate the two colours for the renewal.

4.2.2 Sampling

There are three options for sampling systems to be tested for renewal of approvals:

- The inspector takes samples of the required colours during routine inspections at the coating plants.
- The inspector takes samples directly at the system manufacturer's premises.
- The manufacturer sends organic coating materials and coated panels to the laboratory in charge preferably by June, together with the relevant technical data sheet for each colour. The data sheet should include at least the following information: colour, gloss value and curing conditions (including range of times and temperatures). In countries where there is neither a General Licensee nor a testing laboratory, the coating manufacturer sends the selected colours to a laboratory approved by QUALICOAT.

The coating material may be applied to the test panels in the testing laboratory, at a local licensed coater's plant or at the coating manufacturer's premises under the auspices of the inspector according to § 4.1.5.

4.2.3 Assessment of laboratory test results

The testing laboratory shall submit the test report to the General Licensee who will assess the results. Under the supervision of QUALICOAT, the General Licensee decides whether to renew or withdraw the approval or to ban colours as follows:

- If the results of any of the laboratory test(s) do not meet the requirements for a colour, all of the tests shall be repeated within one month, using new samples.
- If the results of this second series of tests are again unsatisfactory, the colour shall be banned.

For class 3 organic coatings, if the residual gloss after the accelerated weathering test is between 85 and 90%, the system shall remain approved and the colour which produced unsatisfactory results shall be sent to Florida.

4.2.4 Assessment of the Florida test results

The Florida Working Group shall submit the test results to QUALICOAT.

- The approval shall be renewed if the result of the natural weathering test in Florida test (test 15) is satisfactory.
- If the result is unsatisfactory for one colour, the colour shall be banned.

If a manufacturer has failed for any reason to submit the required colours to the laboratory on time and if no samples were sent to Florida as a result, two renewal colours specified by the Florida Working Group and one metallic colour (if there is an extension to metallic colours) shall be banned.

4.2.5 Procedure regarding banned colours

The manufacturers shall have banned colours tested again as soon as possible after having received notification.

Banned colours that are under repetition shall be considered as suspended.

QUALICOAT shall publish a list of all colours (currently) banned including suspended colours.

4.2.6 Withdrawal of an approval

Class 1 and 2

The approval shall be withdrawn as soon as four non-metallic colours are banned. In applying this rule suspended colours will not be considered.

Class 3

The approval shall be withdrawn as soon as three non-metallic colours are banned.

As soon as an approval is cancelled, the supplier shall stop using any reference to the approval when selling the coating material concerned.

4.3. Use of the logo by coating manufacturers

The use of the logo shall comply with the Regulations for use of the QUALICOAT quality label (Appendix A1).

Chapter 5

Licensing of Coating Applicators

5. Licensing of Coating Applicators

This chapter specifies the procedure for granting a licence to a coater for one production site.

A preliminary inspection can be requested by the applicant but in this case the results cannot be used for granting the licence.

The procedures for granting and renewing a licence to coating applicators applying decoration are set out in a separate document available on QUALIDECO website (www.qualideco.eu).

5.1. Granting of a licence (quality label)

Two inspections shall be satisfactory before a licence is granted. These inspections will be made at the coating applicator's request. The first inspection will be conducted by appointment. The second will be unannounced and will only take place once all the results of the first inspection (including the acetic acid salt spray resistance test) have been found satisfactory.

The inspectors shall take along the following equipment:

- Thickness meter
- Conductivity meter
- Calibration tools for the other tests stipulated

The inspector shall check the following using the inspection form approved by QUALICOAT.

5.1.1 Inspection of materials

The inspector will check that for outside architectural applications the coating plant installation uses organic coating materials approved by QUALICOAT. If alternative chemical materials are used, he will also check that these chemical materials are approved by QUALICOAT.

5.1.2 Inspection of laboratory equipment

As specified in § 3.8 to ensure that the equipment is available, functional and properly used. The inspector will also verify whether there are relevant standards or written operating instructions according to § 3.9.

5.1.3 Inspection of production process and equipment

According to § 3.1, 3.6 and 3.7.

5.1.4 Inspection of chemical pre-treatment

According to § 3.2, 3.3 or 3.5

5.1.5 Inspection of finished products

Certain tests may be carried out on the finished products themselves but the full range of tests shall be performed on test panels processed concurrently with a production lot (see § 5.1.6).

Only finished products which have been released by the coating applicator are to be tested (all parts ready for dispatch are deemed to have been released by the coating applicator).

The number of pieces on which film thickness measurements shall be made is shown in the table below (subject to a minimum of 30 pieces).

Lot size (')	Number of pieces (random selection)	Acceptance limit for rejected pieces
1 - 10	All	0
11 - 200	10	1
201 - 300	15	1
301 - 500	20	2
501 - 800	30	3
801 - 1'300	40	3
1'301 - 3'200	55	4
3'201 - 8'000	75	6
8'001 - 22'000	115	8
22'001 - 110'000	150	11

(') Lot: 1 lot represents a customer's complete order in one colour or that part of the order which is in the coating plant installation.

The inspector shall perform the following tests on the finished products:

- Appearance (to test the uniformity of production) (2.1)
- Thickness (2.3)
- Adhesion (2.4)
- Indentation (2.5)
- Acetic acid salt spray (2.10)
- Machu (2.11)
- Polymerisation (2.14)
- Sawing (2.18)

During the first inspection, the Machu test is carried out prior to the acetic acid salt spray test. If the result of the Machu test is satisfactory, the acetic acid salt spray test will then be performed. However, if the result of the Machu test is unsatisfactory, the first inspection will be considered unsatisfactory and shall be repeated. The inspection is satisfactory when all tests are satisfactory including the acetic acid salt spray test.

In the second inspection, only the Machu test will be carried out. If the result of the Machu test is unsatisfactory, the second inspection shall be repeated.

5.1.6 Inspection of the test panels

The following tests shall be performed on test panels processed concurrently with a production lot:

- Gloss (2.2)
- Thickness (2.3)
- Adhesion (2.4)
- Indentation (2.5)
- Cupping (2.6)

- Bend (2.7)
- Impact (2.8)

5.1.7 Review of in-house control and registers

The inspector will check that in-house control has been carried out in accordance with § 3.9 and that the coating plant installation maintains registers according to § 3.11.

In the in-house control register he will check that the results recorded in the register coincide with the results of the test panels. For this reason, all test panels shall be kept and held at the inspector's disposal for one year.

5.1.8 Final assessment for granting the licence

The inspector submits the inspection reports to the General Licensee for the evaluation.

Under the supervision of QUALICOAT, the procedure below is to be followed by the General Licensee:

- If the results of both inspections meet the requirements, a licence to use the quality label shall be granted.
- If the results of one of the two inspections do not meet the requirements, the coating applicator will be informed that the licence to use the quality label cannot be granted for the time being, stating reasons. The coating applicator shall wait at least three months before making a new application for a licence.

Licences with the endorsement «SEASIDE»

If the coating applicator has applied for the endorsement SEASIDE an inspection shall be carried out following the specifications as set out in § 3.2.1 or 3.4.

If the results of the inspection meet the requirements, the "SEASIDE" endorsement shall be granted. The QUALICOAT certificate will state that the coating plant installation is able to produce finished products that meet the SEASIDE requirements.

If the results of the inspection do not meet the requirements, the coating applicator shall wait at least three months before making a new application for a "SEASIDE" endorsement.

5.2. Routine inspections of licensees

After a coating applicator has been granted a licence to use the quality label, this licence shall be renewed if the results of at least two inspections per year meet the requirements.

Routine inspections shall be made without prior notice. The inspectors shall take along the following equipment:

- Thickness meter
- Conductivity meter
- Calibration tools for the other tests stipulated

The inspector shall check the following using the inspection form approved by QUALICOAT:

- an inspection of materials according to § 5.1.1
- an inspection of laboratory equipment according to § 5.1.2
- an inspection of production process and equipment according to § 5.1.3
- an inspection of chemical pre-treatment according to § 5.1.4
- an inspection of finished products and test panels according to § 5.1.5 and 5.1.6
- an acetic acid salt spray test to be carried out at least once per year according to § 2.10
- a review of the registers according to § 5.1.7

The inspector submits the inspection reports to the General Licensee for the evaluation.

Under the supervision of QUALICOAT, the procedure below is to be followed by the General Licensee:

- If the results of the inspection meet the requirements, authorisation to use the quality label will continue.
- If the results of the inspection do not meet the requirements another inspection shall be made within one month (allowing for holiday periods) after the coater has received notification of an unsatisfactory inspection from the General Licensee and/or QUALICOAT. In the meantime, the licensee should rectify non-conformities and inform the General Licensee or QUALICOAT immediately.

If the second inspection again produces unsatisfactory results, the licence to use the quality label will be withdrawn immediately. The coating applicator shall wait at least three months before making a new application for a licence to use the quality label.

Licences with the endorsement «SEASIDE»

Routine SEASIDE inspections are carried out as set out in § 3.2.1 or § 3.4 during QUALICOAT inspections. At least one SEASIDE inspection shall be possible and satisfactory during the year. If no SEASIDE inspection is possible during QUALICOAT visits, an additional announced inspection shall be carried out.

If the results of the inspection meet the requirements, the “SEASIDE” endorsement shall be confirmed.

If the results of the inspection do not meet the requirements, another (announced) SEASIDE inspection shall be made within one month (allowing for holiday periods).

If the second inspection again produces unsatisfactory results, the “SEASIDE” endorsement shall be withdrawn immediately. The coating applicator shall wait at least three months before making a new application for a “SEASIDE” endorsement.

Suspension of an inspection

In case of political unrest or unforeseen circumstances and after consultation with the testing laboratory responsible the inspection can be suspended for a maximum period of 12 months by the General Licensee or by QUALICOAT. After this period, the licence will be cancelled.

5.3. Use of the logo by coating applicators

The use of the logo shall comply with the Regulations for use of the QUALICOAT quality label (Appendix A1).

Chapter 6

Specifications for In-House Control

6. Specifications for In-House Control

6.1. Controlling the production process parameters

6.1.1 Chemical pre-treatment baths

The chemical parameters defined by the manufacturer of the chemical pre-treatment materials shall be analysed **at least**:

once per day (24 hours) per bath.

The coating applicator shall increase the frequency of the analyses if necessary.

The results of these analyses shall be entered in charts or some other record (register) readily accessible to the inspector. They shall show the nominal values, maximum values not to be exceeded, actual values recorded and the number of shifts worked. A separate record shall be kept for each bath.

If corrective measures are necessary, they shall be recorded.

6.1.2 Water quality

The conductivity of the final rinsing preceding chromate bath and of the demineralised rinsing water shall be measured **at least**:

once per day (24 hours)

The coating applicator shall increase the frequency of the analyses if necessary.

The results of these analyses shall be entered in charts or some other record (register) readily accessible to the inspector. They shall show the nominal values, maximum values not to be exceeded, actual values recorded and the number of shifts worked.

6.1.3 Measuring the temperature of chemical pre-treatment and rinsing baths

The temperature of the pre-treatment baths and the final rinse, if a hot water rinse, shall be measured **at least**:

once per day (24 hours) per bath

The results of these measurements shall be entered in charts or some other record (register) readily accessible to the inspector. They shall show the nominal values, maximum values not to be exceeded, actual values recorded and the number of shifts worked.

6.1.4 Measuring the drying temperature

The drying temperature shall be measured **at least**:

once per week

The temperature on the products and the temperature displayed on the visual display unit shall be read and recorded.

The temperature should be measured using a recording instrument or some other means such as thermochromic pencils or tablets.

The results of these measurements should be recorded and the drying curves classified on some record (register) readily accessible to the inspector.

6.1.5 Measuring the stoving conditions

The stoving conditions according to § 3.7 shall be tested **at least**:

- twice per 24 hours: the displayed temperature shall be recorded
- once per week: a stoving curve shall be made on profiles

The results of these tests should be recorded and the stoving curves classified on some record (register) readily accessible to the inspector.

6.2. Quality control of the chemical pretreatment

6.2.1 Testing the etching degree

The degree of aluminium removal shall be measured **at least** once per day using the method described in § 3.2.1.

If a licence has the endorsement «SEASIDE», the coating applicator shall check the etching degree at least once per day during SEASIDE production.

6.2.2 Testing the weight of the conversion coating

The weight of chromate conversion coating shall be tested **at least** once per day (24 hours) in accordance with **EN ISO 3892** and that of other conversion coatings following the chemical manufacturer's instructions (see Appendix A6).

6.3. Quality control of the finished products

During the production, test panels shall be prepared **at least** once in every 8-hour work shift for each colour and approved coating material.

6.3.1 Gloss test (EN ISO 2813)

The gloss of the organic coating on finished products shall be tested **at least** once in every 8-hour work shift for each colour shade and each manufacturer.

The results of these analyses shall be entered in some record (register) readily accessible to the inspector, showing the nominal values, maximum values not to be exceeded, the actual values recorded and the number of work shifts.

6.3.2 Coating thickness test (EN ISO 2360)

The coating thickness shall be measured on pieces as specified below:

Lot size (')	Number of pieces (random selection)	Acceptance limit for rejected pieces
1 - 10	All	0
11 - 200	10	1
201 - 300	15	1
301 - 500	20	2
501 - 800	30	3
801 - 1'300	40	3
1'301 - 3'200	55	4
3'201 - 8'000	75	6
8'001 - 22'000	115	8
22'001 - 110'000	150	11

* lot : a customer's complete order in one colour or the part of the order that has already been coated.

The results of these measurements (minimum and maximum values) shall be entered on some record readily accessible to the inspector.

6.3.3 Appearance test

The appearance shall be controlled on pieces as specified below:

Lot size (')	Number of pieces (random selection)	Acceptance limit for rejected pieces
1 - 10	All	0
11 - 200	10	0
201 - 300	15	0
301 - 500	20	0
501 - 800	30	0
801 - 1'300	40	0
1'301 - 3'200	55	0
3'201 - 8'000	75	0
8'001 - 22'000	115	0
22'001 - 110'000	150	0

* lot : a customer's complete order in one colour or the part of the order that has already been coated

The results of these measurements shall be entered on some record readily accessible to the inspector.

6.3.4 Adhesion test (EN ISO 2409)

The adhesion shall be tested on test panels.

The results shall be entered on some record readily accessible to the inspector.

6.3.5 Indentation (EN ISO 2815)

The indentation test shall be carried out on test panels.

The results shall be entered on some record readily accessible to the inspector.

6.3.6 Polymerisation test

This test is used to check that the organic coating polymerisation is good. In in-house control, this test is **optional for powder coatings**.

The polymerisation test shall be carried out on test panels.

The results shall be entered on some record readily accessible to the inspector.

6.3.7 Cupping test (EN ISO 1520)

The cupping test shall be carried out on test panels.

The results shall be entered on some record readily accessible to the inspector.

6.3.8 Bend test (EN ISO 1519)

The resistance to cracking on bending shall be tested on test panels.

The results shall be entered on some record readily accessible to the inspector.

6.3.9 Impact test (EN ISO 6272 / ASTM D 2794)

The impact test shall be carried out on test panels.

The results shall be entered on some record readily accessible to the inspector.

6.3.10 Machu test

The Machu test shall be carried out **at least** once per week on production pieces.

The results shall be entered on some record readily accessible to the inspector.

6.4. Quality control registers

6.4.1 Control register for the production process

This control register is either a bound register with numbered pages, or a computer listing.

It shall show the following information:

- the temperature of the baths,

- the chemical parameters specified by the manufacturers,
- the results of the etching degree test,
- the results of the tests of the conversion coating weight,
- the results of the water conductivity tests,
- the results of the tests of the drying and stoving conditions.
- the drying and stoving temperature curves

6.4.2 Control register for test panels

This control register is either a bound register (not a spiral binding) with numbered pages, or a computer listing.

It shall show the following information:

- the production date
- the references of the organic coating material used: RAL or some other reference for identification, lot number, manufacturer's name
- the following results:
 - gloss test,
 - thickness test,
 - adhesion test,
 - indentation test,
 - polymerisation test (optional for powder coatings),
 - cupping test,
 - bend test,
 - impact test,
 - Machu test,
 - colour shade inspection (visual inspection to compare colour with the colour shade required by the customer).

6.4.3 Control register for finished products

This register is to be kept at the end of the production line.

It is either a bound register (not a spiral binding) with numbered pages, or a computer listing.

It shall show the following information

- the customer's name and the order or lot identification data,
- the production date,
- the reference of the organic coating material used,
- the following results:
 - coating thickness test
 - inspection of the colour shade and its gloss
 - appearance

6.5. Table summarising the specifications for In-House Control

CONTROL	OBJECT TESTED		MINIMUM FREQUENCY	RESULTS TO BE RECORDED IN
Process	Chemical pre-treatment baths, degreasing, pickling, chromating, rinsing	Chem. Parameters	Once per day (24 hours) per bath	Chart or register
	Conductivity of the water		Once per day (24 hours)	Chart or register
	Temperature of chemical pre-treatment and rinsing baths		Once per day (24 hours) per bath	Chart or register
	Drying temperature		Once per week	Chart or register
	Stoving conditions		Twice a day: record the displayed temperature Once a week: make 1 stoving curve on profiles	Chart or register
Conversion coating	Etching degree		Once per day (24 hours)	Chart or register
	Weight of the conversion coating ⁸		Once per day (24 hours)	Chart or register
Finished products	Gloss		Once in every 8-hour work shift for each shade and manufacturer	Chart or register
	Coating thickness		According to the lot size of the order	Chart or register
	Appearance		According to the lot size of the order	Chart or register
	Machu test		Once per week	Chart or register
Panels	Adhesion		Once in every 8-hour work shift for each shade and manufacturer	Chart or register
	Indentation		Once in every 8-hour work shift for each shade and manufacturer	Chart or register
	Polymerisation (optional for powder coatings)		Once in every 8-hour work shift for each shade and manufacturer	Chart or register
	Cupping test		Once in every 8-hour work shift for each shade and manufacturer	Chart or register
	Bend test		Once in every 8-hour work shift for each shade and manufacturer	Chart or register
	Impact test		Once in every 8-hour work shift for each shade and manufacturer	Chart or register

⁸ Only for chromate conversion layer

Appendices

Appendices

A1 – Regulations for use of the QUALICOAT quality label for liquid and powder organic coatings on aluminium for architectural applications

1. Definitions

For the purposes of these regulations, the QUALICOAT "Quality Label" denotes the trademark registered by the Association for Quality Control in the Lacquering, Painting and Coating Industry (QUALICOAT), Zurich, with the Federal Patent and Trademark Office on 8 May 1987 under trademark no. 352 316 and in the International Trademark Register on 14 August 1987 under no. 513 227 and published in the Swiss Official Gazette of Commerce on 5 May 1987.

"QUALICOAT" means the Association for Quality Control in the Lacquering, Painting and Coating Industry, Zurich.

"GL" means a General Licensee i.e. a national or an international association holding the QUALICOAT general licence for a defined territory.

"Licence" is a statement issued by or on behalf of the Association authorising the holder to use the Quality Label in accordance with these regulations.

"Approval" is a confirmation that a specific material (coating or chemical conversion) meets the requirements of the Specifications.

"Specifications" are the "Specifications for a Quality Label for liquid and powder organic coatings on Aluminium for Architectural Applications".

"Holder" is the company authorised to use the Quality label.

2. Ownership of the Quality Label

The Quality Label is owned by QUALICOAT and may not be used by anyone unless authorised to do so by QUALICOAT.

QUALICOAT has granted to the GL a general licence in respect of the Quality Label for (country) with powers to authorise the use of the Quality Label in accordance with these regulations.

3. Qualifications of applicant

Authorisation to use the Quality Label may be granted on condition that the applicant operates in accordance with the Specifications. This authorisation is governed by a contract.

The granting of a licence or approval entitles the Holder to use the Quality Label for the products specified. The licence or approval may not be transferred.

4. Register of holders

QUALICOAT shall keep a register showing (in addition to other details which may be resolved upon now or later) the name, address and trade description of each Holder, the date on which the licence or approval was granted to the Holder, the number assigned to each Holder, the date of withdrawal of the licence or approval and any other details which QUALICOAT may deem necessary.

The Holder shall notify the GL forthwith of any changes in name or address and the GL shall in turn inform QUALICOAT in order for the change to be recorded in the register.

5. Use of the logo by coating applicators and manufacturers

5.1 Use in general

The logo exists in black and white, in white and blue (PANTONE Reflex Blue CV; RGB: 14-27-141; CMYK: 100-72-0-6) and in blue and silver (PANTONE Silver 877u; RGB: 205-211-215; CMYK: 8-3-3-9).

The words "Quality Label for Architectural Coating on Aluminium" (or a text appropriate to national legal requirements) may be added in the space to the right.



The Holder may not make any alteration or addition to the logo when using it. In the event that the Holder's own brands or trademarks are used separately on or in connection with his products, these regulations may not be infringed in any manner whatsoever. Holders of an approval or licence shall at any time provide the GL with all information required as to the use of the logo.

Improper use of the logo may lead to the sanctions stipulated in § 9.

5.2 Use of the logo by coating applicators

By applying the logo to a product, the coating applicator guarantees that the quality of the finished product supplied meets all the requirements of the Specifications.

For applicators who have more than one production site, the quality label shall only be used for the coating plant installation for which the applicator is holding the licence.

The logo may be used on the products themselves, business stationery, quotations or invoices, price lists, cards, display boxes and on all company literature and brochures or in catalogues and newspaper advertisements.

Whenever a coating applicator makes mention or reference to QUALICOAT, it shall systematically indicate its licence number. This shall apply both to the use of the logo and in texts.



Licence n° xxxx

5.3 Use of the logo by manufacturers (coating manufacturers and manufacturers of alternative pre-treatment systems)

The QUALICOAT logo shall not appear on packaging or labels. They may only show the name "QUALICOAT" followed by the approval number (P-XXXX or A-XXXX) of the packed product.

In their business literature and documents, the coating manufacturers may only use the logo for products approved by QUALICOAT, stating: «Product approved by QUALICOAT». Wherever the logo is used, the phrase «QUALICOAT is a quality label for licensed coaters» should also appear in the document.

For any other use of the logo, the coating manufacturers are required to submit all new documents mentioning QUALICOAT to their national association. In countries without a General Licensee, these documents should be submitted directly to the QUALICOAT Secretariat before publication.

6. Other conditions for use of the logo

6.1 Use of the logo by General Licensees (national or international associations)

General Licensees are authorised to use the logo in the stipulated colours but always together with their respective logos or the legal designation of the national or international associations. The logo may also be used in conjunction with a national flag and by adding the name of the country. When the QUALICOAT logo or name is used on licensees' stationery or in correspondence, the national association's name should always be predominant to avoid any confusion between the licensee and QUALICOAT. Wherever the logo is used, the phrase «X⁹ is the QUALICOAT General Licensee for Y¹⁰» should also appear in the document. The size of the logo may be altered provided that the geometrical proportions are maintained.

6.2 Use of the logo by the QUALICOAT Secretariat

Only the Secretariat and the Technical Director are authorised to use the logo without any further designation. The logo should be used in black/white for internal communications, such as circular letters, notices of meetings and minutes. For external use, the stipulated colours are to be used. The logo shall always be placed on the first page of the respective documents, but not necessarily on the following pages. The logo shall be included in the letterhead.

6.3 Use of the logo by QUALICOAT officers

The President of QUALICOAT and the Chairman of the Technical Committee are also authorised to use the logo on business cards prepared by QUALICOAT if such cards are needed for representation purposes. Other members of the Committees (Executive and Technical Committees, Working Groups) are neither allowed to use the logo nor to make any reference to QUALICOAT unless authorised to do so by the Executive Committee.

6.4 Use of the logo by interested third parties

Some businesses using QUALICOAT coated products may wish to use the logo on the products they manufacture or in their business literature.

They shall request written authorisation which may be granted on condition that they:

9 X = name of the national association

10 Y = country

- undertake to use solely aluminium products coated by licensed coating plants;
- undertake to submit all documents that refer to QUALICOAT to the GL for approval or directly to QUALICOAT in countries where there is no GL;
- undertake to undergo inspections and controls by the GL or QUALICOAT.
- Such authorisation may require payment of an annual fee.

7. Conditions for granting and renewing approvals and licenses

As stipulated in chapter 4 for coating manufacturers.

As stipulated in chapter 5 for coating plant installation.

As stipulated in Appendix A6 for manufacturers of alternative chemical pretreatment materials

The granting of an approval or licence shall require payment of an annual fee.

8. Withdrawal of approvals and licences

8.1 Failure to comply with the Regulations

The GL shall withdraw the approval or licence if the Holder ceases to comply with these regulations and in particular if the Holder is guilty of any improper use of the Quality Label or has failed to pay the annual fee.

In the event of withdrawal of an approval or licence, the Holder shall be given notice in writing by the GL and such notice shall be effective immediately. In such event, all tags, labels, bands, stencils, stamps, wrappers, containers, price lists, business notices, business cards and any other objects in or upon which the Quality Label is affixed shall either be delivered to the GL or, upon the GL's instructions, kept at the disposal of the GL until a new approval or licence is granted.

8.2 Significant changes in a company

In the case of any significant event (change in shareholders or key personnel, new lines), the company shall notify the GL immediately. The GL shall be authorised to make a supplementary visit in order to ensure that the Holder continues to satisfy all the conditions stipulated in the Specifications.

If the Holder ceases to trade, all tags, labels, bands, stencils, stamps, wrappers, containers, price lists, business notices, business cards and any other objects in or upon which the Quality Label is affixed shall either be delivered to the GL or, upon the GL's instructions, kept at the disposal of the GL until a new approval or licence is granted.

8.3 Voluntary withdrawal

In the event of voluntary withdrawal of an approval or licence, all tags, labels, bands, stencils, stamps, wrappers, containers, price lists, business notices, business cards and any other objects in or upon which the Quality Label is affixed shall either be delivered to the GL or, upon the GL's instructions, kept at the disposal of the GL until a new approval or licence is granted.

9. Sanctions

In the event of improper use of the Quality Label or of any behaviour or action which could impair the image of the Quality Label, the following sanctions may be imposed either by the GL or by QUALICOAT in countries without a GL:

- official statement
- reprimand
- withdrawal of the label

The party concerned shall have the right to appeal first at the GL's level and finally at the QUALICOAT Executive Committee's level whose decision is final.

10. Amendments to the Regulations

These Regulations may be amended if and when necessary. However, the Holder of the label shall be allowed 4 months from the date of publication in which to comply with any such amendment.

11. Notices

Any notice required to be given to or by the Holder under these regulations shall be effective if sent by correctly stamped and addressed letter.

A2 – Not used (former QUALIDECO Specifications)

A3 – Compulsory declaration of changes in formulation for organic coating materials approved by QUALICOAT

Organic coating materials essentially consist of 4 kinds of components:

- binder
- pigments
- extenders
- additives

These are the organic coating material's components that determine the organic coating's characteristics.

1. BINDER

The binder consists of resin(s) + hardening agent together; it imparts the principal characteristics to the organic coating material (reactivity, application properties, mechanical properties etc.). The main types of resins used in Europe are:

- saturated carboxylated polyester
- saturated hydroxylated polyester
- epoxy
- acrylic

These different types of resins can be used with several different kinds of hardeners.

It is quite obvious that variations in the chemical composition of the different resins or changes in the chemical molecular structure of the hardening agent can bring about modifications in the properties or characteristics of the organic coating and require a new QUALICOAT approval.

2. PIGMENTS

Pigments can be organic, inorganic or metallic; they impart colour, appearance and opacity to the organic coating

3. EXTENDERS

Extenders improve the rheological or chemical properties of the organic coating.

4. ADDITIVES

These are substances added to the organic coating material in small quantities to improve certain characteristics of the organic coating (vapour relief, gloss etc.).

These other components (pigments, extenders or additives) of organic coating material can also have some influence on the film properties and characteristics controlled within the QUALICOAT label. Nevertheless, as these constituents can be numerous and varied, it is up to the organic coating manufacturers to control their formulations so that they comply with the QUALICOAT label.

5. APPEARANCE OF THE FINAL ORGANIC COATING

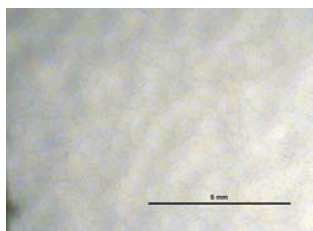
Like all other coatings, organic coating materials – after curing – can give the final organic coating different appearances, for example a smooth appearance or a structured appearance.

A structured appearance cannot be treated like a smooth appearance. Even if the change in formulation is based on special additives, an organic coating imparting an uneven appearance, which does not involve colour gloss or metallic effect, needs a special QUALICOAT approval in a different category from the approvals granted for smooth organic coatings.

Definition criteria for structured surfaces

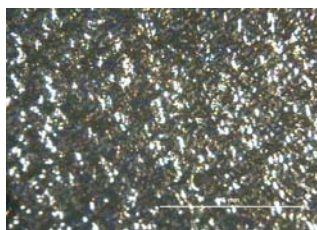
These finishes can be split into the following three families. An approval is necessary for each family.

a) **Leathered (or orange peel)**, where the production technology generally takes advantage of the phenomenon of incompatibility between some components in the coating product formulation. The surface has an orange peel appearance. The effect, called antiqued metallised, falls within the “leathered” category with the addition of the metallic effect pigments. Both this last finish and “hammered” finish shall be carefully monitored and approved, in particular for external use.



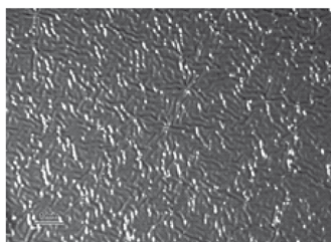
Leathered appearance

b) **Textured (or sandpaper)**, where the production technology generally makes use of the effect of adding particular substances (e.g. Teflon based waxes, fillers with a high oil content, etc.) to the formulation of coating products. The surface has an appearance resembling sandpaper.



Textured (or sand paper) appearance

c) **Wrinkled**, where the technology generally derives from the reactivity between hydroxylated resins and melamine resins.



Wrinkled appearance

A4 – Metallic organic coating

1. DEFINITION

Metallic organic coating materials are organic coatings with a metallic or metallized effect. A metallic organic coating is a "normal" organic coating, the difference is the pigmentation. Manufacturers achieve this special effect by incorporating metal (for example: leafing or non-leafing aluminium) or other materials (for example: mica) in the formulation of the organic coating.

We can separate metallic organic coatings into two categories:

- One-coat systems with a metallized appearance (no clear coat is needed for good outdoor durability and resistance). **The current approvals are sufficient.**
- Two-coat systems: metallic powder coatings that need a clear coat in order to have acceptable weathering resistance. **These specific two-coat systems shall be approved separately by QUALICOAT.**

The manufacturers are responsible for advising their customers whether they need to use a two-coat system or not.

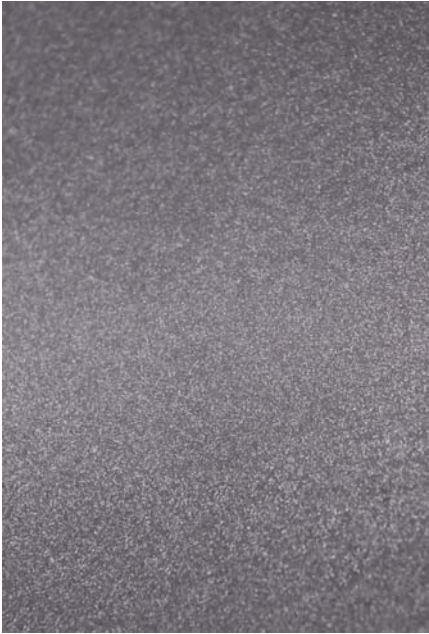
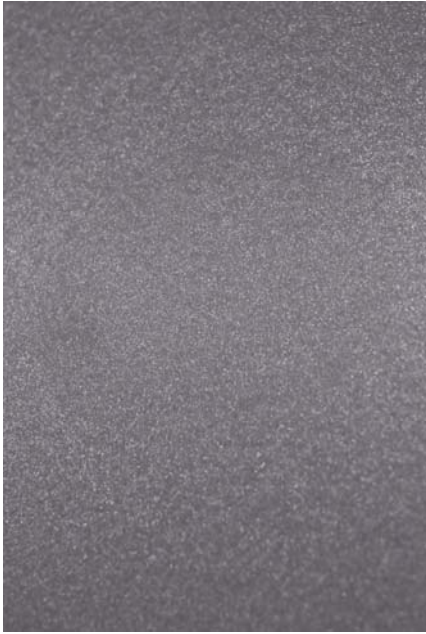


2. REFERENCE SCALE

Some metallic colours, especially those based on aluminium, may show variations in colour during tests that affect the surface of the coating. In this case, QUALICOAT accepts a slight variation in colour. In the case of metallic colours, the colour variations may differ depending on the angle of observation. This makes it difficult to perform a reliable measurement using any of the apparatus defined in the standard mentioned in § 2.12 of the Specifications.

For this reason, a reference scale for the laboratories has been defined using panels coated in an aluminium-based metallic colour (RAL 9006). The stains are obtained by applying an alkaline solution to the surface for different lengths of time. These different panels produced by an approved laboratory are approved and distributed by QUALICOAT. Each approved laboratory shall have these reference panels.

For information, the following photographs show values 1 and 2 on the reference scale.

REFERENCE FOR EVALUATING MORTAR TEST RESULTS
(FOR INFORMATION)

 <p>Acceptable value 1</p>	 <p>Acceptable value 1</p>
 <p>Unacceptable value 2</p>	 <p>Unacceptable value 2</p>

A5 – Special specifications for coatings on aluminium accessories for architectural applications under the QUALICOAT quality label

1. Introduction

Cast accessories may be made of different alloys whose chemical composition is specified in the **EN 1706** standard.

The nature of the alloy and production method determine the final quality of the coated accessory. Some alloys – especially those based on silicone and copper – are the cause of unsatisfactory resistance to corrosion.

The chemical pretreatment cycle shall be tailored to the alloy and the quality of the castings. For outdoor architectural applications, it is necessary to use special alloys which have good resistance to corrosion as indicated in EN 1706.

It is the responsibility of the customer to define the alloy.

2. Work Specifications

All the requirements set out in Chapter 3 of the Specifications are applicable to the treatment of accessories, **with the exception of the etching degree** which is not specified for castings (see Specifications, § 3.2.1).

3. Testing

3.1 Inspection of finished products

Certain tests may be carried out on the finished products themselves but the full range of tests shall be performed on test panels processed concurrently with a production lot.

The inspector shall perform the following tests on the coated accessories:

- Appearance (Specifications § 2.1)
- Polymerisation (Specifications § 2.14)

and if the geometry of the parts permits:

- Coating thickness (Specifications § 2.3)
- Adhesion (Specifications § 2.4)
- Indentation (Specifications § 2.5)

The following tests shall be performed on extruded sections only:

- Acetic acid salt spray test (Specifications § 2.10)
- Machu test (Specifications § 2.11)

3.2 Inspection of test panels

The full range of tests shall be performed on test panels processed concurrently with a production lot.

- Gloss (Specifications § 2.2)
- Coating thickness (Specifications § 2.3)
- Adhesion (Specifications § 2.4)
- Indentation (Specifications § 2.5)
- Cupping test (Specifications § 2.6)
- Bend test (Specifications § 2.7)
- Impact test (Specifications § 2.8)

Apart from the restrictions above, please refer to the QUALICOAT Specifications.

A6 – Procedure for evaluating alternative chemical pretreatment materials

1. INTRODUCTION

This Appendix specifies the procedure for granting an approval for new alternative pretreatment systems. It also describes the testing programme to be followed by the laboratories involved and the requirements for every test. S

2. FORMAL APPLICATION PRIOR TO TESTING

Chemical manufacturers who plan to submit a new alternative pretreatment system for testing shall send a formal request to the General Licensee or to QUALICOAT in countries without a national association.

If the pretreatment system is manufactured at several production plants, the applicant shall name the main production site and/or technical service centre and indicate all other production sites.

Basic documentation (TDS), a safety data sheet and detailed instructions on treatment cycles shall be submitted to an approved QUALICOAT laboratory selected in agreement with the General Licensee and/or QUALICOAT.

The following minimum technical information shall also be provided to the QUALICOAT laboratory in charge on a separate sheet (General Technical Information):

APPLICATION METHOD (1) (2)	
PROCESS CYCLE (2)	
FINAL RINSE	
ANALYTICAL METHODS FOR BATH	
FILM WEIGHT (3)	
OTHER ANALYSES	
OTHER RECOMMENDATIONS (EQUIPMENT, HANDLING, STORAGE ETC.) (4)	
COLOURLESS CONVERSION COATING?	
DRYING CONDITIONS	
(1) Spraying and/or immersion. (2) The manufacturer is responsible for ensuring that the cycle used by the coating applicator is suitable for obtaining a coated product conforming to the QUALICOAT Specifications. What are the limits for demineralised water before conversion coating? (3) Method for in-house control and laboratory tests (limits and frequency). (4) The technical specifications shall make it clear which items are compulsory, for instance does “recommended” mean compulsory or not?	

3. PRELIMINARY CONDITIONS (minimum equipment)

The chemical manufacturer shall have the following minimum equipment available at **at least one location** (main production site and/or technical service centre):

- analytical instruments for testing the quality of the conversion coating;
- cutting tools and instruments necessary for performing the adhesion test;
- apparatus for testing adhesion and elasticity (cupping test);
- impact tester (EN ISO 6272);
- apparatus for testing resistance to cracking on bending;
- apparatus to carry out the following corrosion tests:
 - constant climate condensation water
 - resistance to humid atmospheres containing sulphur dioxide
 - acetic acid salt spray resistance
 - pressure cooker test
 - filiform corrosion test¹¹ - *Test method under discussion*

At **all other locations** (not being the main production site and/or technical service centre), the following requirements shall be met:

- A method for testing the quality of the conversion coating shall be available.
- Tests that cannot be carried out on-site shall be performed by the laboratory at the main production site and/or technical service centre or outsourced to any QUALICOAT approved laboratory.

4. QUALICOAT TESTING LABORATORIES

Before an approval is granted for a new pretreatment system, the laboratory in charge shall carry out the testing programme specified in the following section. Corrosion tests shall also be performed by a second laboratory under the responsibility of the laboratory in charge.

For renewal of an approval, the full testing programme shall be carried out only by the laboratory in charge.

5. TESTING PROGRAMME

Approval is based on the following testing programme to ensure conformity with the requirements prescribed by QUALICOAT.

¹¹ This test may be outsourced and carried out by a QUALICOAT approved laboratory or another laboratory accredited for this specific test according to ISO 17025.

a) PANEL PREPARATION

For every corrosion test, six extruded samples shall be evaluated (three samples in each of the two laboratories involved).

Special attention shall be paid to the preparation of samples. The final results of corrosion and exposure tests depend not only on the treatment but also on the aluminium composition and the reaction between the aluminium surface and chemical products.

The manufacturers shall indicate the complete pretreatment cycle to be used (degreasing etc.), and the laboratory responsible for preparing the samples shall strictly follow these instructions.

The samples may be prepared:

- either in the QUALICOAT approved laboratory under the supervision of a representative of the applicant company;
- or in the laboratory of the chemical manufacturer under the supervision of a representative of the laboratory in charge.

Samples

The following alloys shall be used:

- panels for mechanical tests (thickness of 0.8 or 1 mm): **AA 5005-H24 or -H14** (AlMg 1 - semihard);
- extruded samples for corrosion tests and outdoor exposure: **AA 6060 or 6063**.

The chemical composition of the samples has an influence on the final results, especially in corrosion tests. For this reason, all laboratories shall use an alloy from the same batch to prepare the samples.

QUALICOAT shall provide every laboratory with enough test samples having a chemical composition specified by the Technical Committee.

The laboratory's final report shall always indicate the chemical composition.

Pretreatment

The laboratory in charge of preparing the samples shall take into account the following parameters:

- **Etching degree**
The **total** etching degree shall be between 1.0 g/m² and 2.0 g/m² on samples for all tests.
- **Weight of the conversion coating**
 - close to the system's lower limit for corrosion test samples;
 - close to the upper limit for mechanical test samples, especially for the adhesion test.

Coating material to be applied

The coating system material shall have a QUALICOAT approval.

Each system shall be tested with the following organic coating materials:

- class 1 powder, metallic colour (RAL 9006 or RAL 9007)
- class 2 powder, category 1, RAL 9010
- class 3 powder (when requested by the supplier).
- liquid coating (when requested by the supplier)

b) LABORATORY TESTS

The following tests shall be performed:

- **Mechanical tests** (according to the QUALICOAT Specifications)
 - impact
 - wet adhesion (incision after immersion test) – *method under study*
 - bend
 - cupping.
- **Corrosion tests** (according to the QUALICOAT Specifications)
 - constant climate condensation water
 - resistance to humid atmospheres containing sulphur dioxide
 - acetic acid salt spray resistance
 - pressure cooker
 - filiform corrosion (*acceptable limits agreed by the Laboratories WG on 24 May 2011*).

The acceptable limits are the same as those prescribed in the QUALICOAT Specifications.

Evaluation of laboratory test results

The final evaluation shall be as follows:

- **Result of one laboratory**

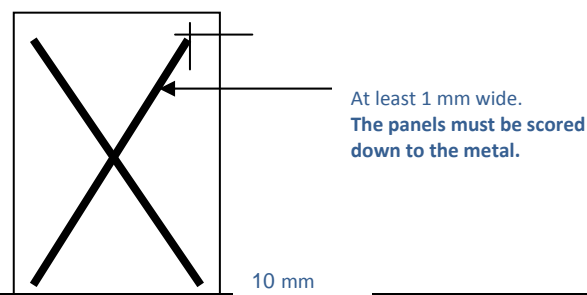
POSITIVE	0 or 1 unsatisfactory panel
NEGATIVE	2 or more unsatisfactory panels.
- **Results of two laboratories**
 - If the results in both laboratories are positive, the system is satisfactory.
 - If the results in both laboratories are negative, the system is unsatisfactory.
 - If the results are positive in one laboratory and negative in the other, the tests shall be repeated in a third laboratory.

c) OUTDOOR EXPOSURE

- **Exposure site**
2 years in Genoa starting in September.
- **Number of panels**
All tests shall be made in triplicate.

Fig. 1 Scratches for outdoor exposure

(panel dimensions: length 200 mm, width 70 – 100 mm)



Evaluation of exposure test results

After 2 years of exposure, a final evaluation shall be made, applying the following criteria:

POSITIVE	0 or 1 unsatisfactory panel
NEGATIVE	2 or more unsatisfactory panels.

6. CONFORMITY ASSESSMENT

A QUALICOAT working group shall evaluate the laboratories' test results and take a decision, also in writing.

If necessary, the chemical manufacturer of the system tested shall be invited to a meeting to discuss the results.

7. GRANTING OF AN APPROVAL

If all the results meet the requirements, QUALICOAT shall issue an approval number and a certificate signed by the President, which is valid for three years.

After the exposure tests, the working group shall evaluate the results and take a decision on confirmation of the approval. The manufacturer shall be informed of the results and decisions.

8. RENEWAL OF PRETREATMENT SYSTEM APPROVALS

Approvals shall be renewed every three years, with the full testing programme including outdoor exposure (see § 5 of this Appendix) carried out by one laboratory. Once a system has been approved for six consecutive years, the renewal interval shall be extended to five years.

If an approved system identified by a single approval number is manufactured at different production sites of the same company, the full testing programme (including the exposure test) shall be carried out for the main production site and/or technical service centre. At the other production sites indicated by the chemical manufacturer, the approved pretreatment system shall be checked only with corrosion tests.

An approval shall be renewed if the results of the laboratory and exposure tests conform to the Specifications.

If the laboratory test results are negative, all corrosion tests shall be repeated in two laboratories. Renewal shall be confirmed if the results are positive in both laboratories. If the results are negative in one of the two laboratories, the approval shall be cancelled. If the result of outdoor exposure is negative, the approval shall then be cancelled.

9. RESPONSIBILITY**a) MANUFACTURER'S RESPONSIBILITY**

The coating applicator is expected to use the products as instructed by his supplier. The manufacturers shall be responsible for all cycles used by coating applicators.

Manufacturers and customers (coating applicators) already cooperate closely. For all systems, there shall be technical data sheets, also giving information about other products

with which a system may or may not be used. System manufacturers shall send QUALICOAT a valid technical data sheet.

To take into account the particular conditions in each plant, the system manufacturer shall also provide specific instructions to be followed by the persons in charge of the plant. These instructions or requirements shall be consistent with the general technical data sheets. The QUALICOAT inspector may request these instructions to ensure that the coating applicator is using the correct method.

The manufacturer shall indicate how the quality of the chromium-free conversion coating should be monitored during in-house control. The methods for assessing the conversion coating may differ from one system to the next since there is not a pertinent standard. QUALICOAT shall send these data sheets to the General Licensees (national associations) and recognised testing laboratories.

These tests shall be performed with the following frequency:

- practical method in the coating plant: daily/shift
- analytical method in the manufacturer's facilities: once every two weeks.

The results shall be entered and retained in records readily accessible to the inspector.

Cooperation between the coating applicator and chemical manufacturer:

Every two months, the chemical manufacturer shall carry out the following tests on three production samples:

- acetic acid salt spray resistance
- wet adhesion test (*test method under study*)

If the results are unsatisfactory, the chemical manufacturer shall seek the causes and advise corrective action.

Details shall be entered and retained in records readily accessible to the inspector in the plant and in the chemical manufacturer's facilities.

b) Coating applicator's responsibility

The coating applicator shall be responsible for the quality of the coated products. Only the user is able to control all the parameters in his plant. However, the manufacturers shall be prepared to check more frequently whether their customers adhere to the specifications stipulated on the technical data sheets. During their regular visits, they shall also verify the values recorded by the licensed plants during their in-house control.

10. COMPULSORY DECLARATION OF CHANGES IN FORMULATION OF ALTERNATIVE PRETREATMENTS

In principle, if the chemical composition of the conversion coating remains the same, it shall not be necessary to apply for a new approval. In practice, this means accepting all the variations specified on the technical data sheet to adjust the system to a specific application line in order to achieve the specified coating weight. The chemical product may be supplied as a two-component or single-component system. The chemical manufacturers shall guarantee that the chemical composition of the working solution is essentially the same as that approved by QUALICOAT.

Any change in formula that can result in significant changes in the composition of the conversion coating represents a new product and requires a new QUALICOAT approval.

To give a few examples of such changes, we would like to mention some clear-cut cases:

- Any change in the metal content of the coating through substitution, addition, removal, etc. of the approved metal system when the products are based on transition metals replacing chrome.
- Any change in the polymer composition and, by extension, in the organic components through substitution, addition, removal etc. when they are present in the approved formula.
- Any change in the typical appearance of the conversion coating, for example from colourless to colour.

A7 - RAL / DELTA E Table¹²

RAL	DELTA E	RAL	DELTA E	RAL	DELTA E	RAL	DELTA E	RAL	DELTA E	RAL	DELTA E	RAL	DELTA E	RAL	DELTA E	RAL	DELTA E
1000	3.0	2000	6.0	<u>3000</u>	6.0	4001	4.0	5000	4.0	6000	5.0	7000	4.0	8000	4.0	<u>9001</u>	2.0
1001	3.0	<u>2001</u>	5.0	3001	6.0	4002	4.0	5001	4.0	6001	5.0	<u>7001</u>	3.0	<u>8001</u>	4.0	<u>9002</u>	2.0
1002	3.0	2002	8.0	<u>3002</u>	6.0	<u>4003</u>	5.0	<u>5002</u>	4.0	<u>6002</u>	4.0	7002	4.0	8003	4.0	<u>9003</u>	2.0
<u>1003</u>	4.0	2003	6.0	<u>3003</u>	4.0	4004	5.0	<u>5003</u>	5.0	6003	5.0	7003	4.0	8004	4.0	<u>9004</u>	5.0
<u>1004</u>	6.0	<u>2004</u>	4.0	3004	4.0	<u>4005</u>	4.0	5004	5.0	6004	5.0	<u>7004</u>	4.0	<u>8007</u>	4.0	<u>9005</u>	5.0
1005	6.0	2008	6.0	<u>3005</u>	4.0	4006	5.0	<u>5005</u>	4.0	<u>6005</u>	3.0	7005	4.0	8008	4.0	<u>9006</u>	2.0
1006	6.0	<u>2009</u>	4.0	3007	4.0	4007	5.0	<u>5007</u>	4.0	6006	4.0	7006	4.0	8011	4.0	<u>9007</u>	2.0
<u>1007</u>	6.0	2010	6.0	<u>3009</u>	4.0	4008	4.0	<u>5008</u>	5.0	6007	4.0	7008	4.0	8012	4.0	<u>9010</u>	2.0
<u>1011</u>	3.0	2011	6.0	<u>3011</u>	5.0	4009	4.0	5009	4.0	6008	5.0	7009	4.0	<u>8014</u>	3.0	<u>9011</u>	5.0
<u>1012</u>	3.0	2012	4.0	<u>3012</u>	2.0	4010	5.0	<u>5010</u>	4.0	6009	4.0	7010	4.0	8015	4.0	<u>9016</u>	2.0
<u>1013</u>	2.0			3013	6.0			<u>5011</u>	5.0	<u>6010</u>	5.0	7011	4.0	8016	4.0	9018	2.0
1014	3.0			3014	4.0			5012	4.0	<u>6011</u>	4.0	<u>7012</u>	4.0	<u>8017</u>	4.0	9022	2.0
<u>1015</u>	2.0			3015	3.0			5013	5.0	<u>6012</u>	4.0	7013	4.0	<u>8019</u>	3.0		
1016	6.0			<u>3016</u>	5.0			<u>5014</u>	4.0	<u>6013</u>	3.0	7015	4.0	8022	5.0		
1017	3.0			3017	8.0			<u>5015</u>	3.0	<u>6014</u>	4.0	<u>7016</u>	3.0	8024	4.0		
1018	6.0			<u>3018</u>	5.0			<u>5017</u>	5.0	6015	4.0	<u>7021</u>	4.0	8025	4.0		
<u>1019</u>	2.5			<u>3020</u>	4.0			5018	5.0	<u>6016</u>	5.0	<u>7022</u>	4.0	<u>8028</u>	3.0		
<u>1020</u>	6.0			<u>3022</u>	4.0			5019	4.0	<u>6017</u>	5.0	7023	3.0				
1021	6.0			3027	6.0			5020	5.0	<u>6018</u>	4.0	7024	4.0				
1023	3.0			3031	4.0			5021	4.0	6019	2.0	7026	4.0				
1024	3.0							5022	5.0	<u>6020</u>	2.0	7030	2.0				
1027	3.0							<u>5023</u>	4.0	6021	4.0	7031	4.0				
<u>1028</u>	8.0							5024	4.0	6022	4.0	<u>7032</u>	2.0				
1032	6.0									<u>6024</u>	3.0	7033	3.0				
1033	8.0									6025	5.0	7034	3.0				
1034	4.0									<u>6026</u>	5.0	<u>7035</u>	2.0				
1037	6.0									6027	2.0	7036	3.0				
<u>1038</u>	2.0									6028	5.0	<u>7037</u>	3.0				
										<u>6029</u>	4.0	<u>7038</u>	2.0				
										<u>6032</u>	3.0	<u>7039</u>	4.0				
										<u>6033</u>	2.0	<u>7040</u>	3.0				
										<u>6034</u>	2.0	<u>7042</u>	3.0				
												<u>7043</u>	3.0				
												<u>7044</u>	2.0				
												7045	3.0				
												7046	4.0				
												7047	2.0				

underlined = colours tested as of November 2011

¹² This table is continuously updated (www.qualicoat.net)

A8 - Specifications for batch treatment

1. Introduction

For batch treatment, the products to be treated are arranged in organised loads in baskets used for immersion.

2. Specifications

The material used for separators and hooping shall be compatible with the chemistry used as recommended by the chemical manufacturer.

The number of separators shall be chosen to minimise contacts. The products shall be arranged with sufficient space between them to allow the liquid to pass freely through the load.

It is important to avoid any surface scratching.

3. Testing method to evaluate contact mark areas

Use a piece of a pretreated aluminium extrusion that has been marked by a separator. The area on the bar with the marks should be identified.

The **boiling water test** (2.16 of the Specifications – Resistance to Boiling Water) shall be carried out on the coated samples.

Allow the test piece to cool after the test and examine it for any blistering on the identified area.

Requirements:

No blistering in excess of 2 (S2) according to ISO 4628-2.

Colour change is acceptable but there shall not be any defect or loss of adhesion.

This testing method shall be used by the inspectors whenever a licence is to be granted.

A9 – List of relevant standards¹³

Nº	YEAR	TITLE	SPECIFICATIONS
EN ISO 2813	1999	Paints and varnishes -- Determination of specular gloss of non-metallic paint films at 20 degrees, 60 degrees and 85 degrees	Gloss 2.2, 2.12, 2.13, 6.3.1
EN ISO 2360	2003	Non-conductive coatings on non-magnetic electrically conductive basis materials - Measurement of coating thickness - Amplitude-sensitive eddy current method	Coating thickness 2.3, 6.3.2
EN ISO 2409	2007	Paints and varnishes -- Cross-cut test	Adhesion 2.4, 6.3.4
EN ISO 2815	2003	Paints and varnishes -- Buchholz indentation test	Indentation 2.5, 6.3.5
EN ISO 1520	2006	Paints and varnishes -- Cupping test	Cupping test 2.6, 6.3.7
EN ISO 1519	2011	Paints and varnishes -- Bend test (cylindrical mandrel)	Bend test 2.7, 6.3.8
EN ISO 6272-1	2011	Paints and varnishes -- Rapid-deformation (impact resistance) tests -- Part 1: Falling-weight test, large-area indenter	Impact test 2.8
EN ISO 6272- 2	2011	Paints and varnishes -- Rapid-deformation (impact resistance) tests -- Part 2: Falling-weight test, small-area indenter	Impact test 2.8
ASTM D 2794	2004	Standard Test Method for Resistance of Organic Coatings to the Effects of Rapid Deformation (Impact)	Impact test 2.8
EN ISO 3231	1997	Paints and varnishes -- Determination of resistance to humid atmospheres containing sulphur dioxide	Resistance to humid atmospheres containing sulphur dioxide 2.9
EN ISO 4628-2	2003	Paints and varnishes -- Evaluation of degradation of coatings -- Designation of quantity and size of defects, and of intensity of uniform changes in appearance -- Part 2: Assessment of degree of blistering	Blistering 2.9 - 2.10 – 2.16

¹³ This list refers to EN standards and their relevant year of issue. It is continuously updated on Internet (www.qualicoat.net).

Nº	YEAR	TITLE	SPECIFICATIONS
EN ISO 9227	2012	Corrosion tests in artificial atmospheres -- Salt spray tests	Acetic acid salt spray resistance 2.10
EN ISO 11341	2004	Paints and varnishes -- Artificial weathering and exposure to artificial radiation -- Exposure to filtered xenon-arc radiation	Accelerated weathering test 2.12
ISO 7724-3	1988	Paints and varnishes -- Colorimetry -- Part 3: Calculation of colour differences	Colour variation 2.12 – 2.13
EN ISO 2810	2004	Paints and varnishes -- Natural weathering of coatings -- Exposure and assessment	Natural weathering test 2.13
EN 12206-1	2011	Paints and varnishes – Coating of aluminium and aluminium alloys for architectural purposes – Part 1: Coatings prepared from coating powder	Resistance to mortar 2.15
EN ISO 6270-2	2005	Paints and varnishes – Determination of resistance to humidity – Part 2: Procedure for exposing test specimens in condensation – water atmospheres	Constant climate condensation water test 2.17
ISO 10546	1993	Chemical conversion coatings – Rinsed and non rinsed chromate conversion coatings on aluminium and aluminium alloys	Chromate pretreatment 3.2.2
EN ISO 3892	2001	Conversion coatings on metallic materials -- Determination of coating mass per unit area - - Gravimetric methods	Chromate pretreatment 6.2.2
EN 1706	2010	Aluminium and aluminium alloys - Castings - Chemical composition and mechanical properties	Cast accessories Appendix A5

A10 –Summary of requirements for the approval of organic coating materials (classes 1, 2 and 3)

TESTS 1-15		STANDARDS	QUALICOAT SPECIFICATIONS		
			CLASS 1	CLASS 2	CLASS 3
1	GLOSS 2.2	EN ISO 2813	Permissible variation from the nominal value specified by the coating supplier: Gloss cat. 1: 0 – 30 +/- 5 units Gloss cat. 2: 31 - 70 +/- 7 units Gloss cat. 3: 71 – 100 +/- 10 units	Same as class 1	Same as class 1
2	COATING THICKNESS 2.3	EN ISO 2360	Minimum thickness = 60 µm None of the values measured may be less than 80% of the specified minimum value	Same as class 1	Minimum thickness= 50 µm None of the values measured may be less than 80% of the specified minimum value
3	ADHESION 2.4	EN ISO 2409	The result shall be 0.	Same as class 1	Same as class 1
4	INDENTATION 2.5	EN ISO 2815	Minimum 80 with the specified required coating thickness	Same as class 1	Same as class 1
5	CUPPING TEST 2.6	EN ISO 1520	Minimum 5 mm Using normal corrected vision, the coating shall not show any sign of cracking or detachment.	Minimum 5 mm Using normal corrected vision, the coating shall not show any sign of detachment following the <u>tape pull adhesion test</u> .	Same as class 2
6	BEND TEST 2.7	EN ISO 1519	Using normal corrected vision, the coating shall not show any sign of cracking or detachment.	Using normal corrected vision, the coating shall not show any sign of detachment following the <u>tape pull adhesion test</u> .	Same as class 2
7	IMPACT TEST 2.8	EN ISO 6272 ASTM D 2794	Using normal corrected vision, the coating shall not show any sign of cracking or detachment.	Using normal corrected vision, the coating shall not show any sign of detachment following the <u>tape pull adhesion test</u> .	Same as class 2
8	RESISTANCE TO HUMID ATMOSPHERES 2.9	EN ISO 3231	No infiltration exceeding 1 mm on both sides of the scratch, and no change in colour or blisters in excess of 2 (S2) according to ISO 4628-2.	Same as class 1	Same as class 1
9	ACETIC ACID SALT SPRAY RESISTANCE 2.10	EN ISO 9227	Testing time: 1000 hours RATING A = 3 samples ok, 0 not ok RATING B = 2 samples ok, 1 not ok RATING C = 1 sample ok, 2 not ok RATING D = 0 sample ok, 3 not ok Evaluation: A/B : test result satisfactory C : test result unsatisfactory (repetition of the AAST) D : test result unsatisfactory (repetition of all laboratory tests)	Same as class 1	Testing time: 2000 hours Evaluation: same as class 1

TESTS 1-15		STANDARDS	QUALICOAT SPECIFICATIONS		
			CLASS 1	CLASS 2	CLASS 3
10	ACCELERATED WEATHERING TEST 2.12	EN ISO 11341	<p>Exposure time: 1000 hours</p> <p>Gloss retention: the loss of gloss after the accelerated weathering test shall not be greater than 50% of the original value</p> <p>Colour change: according to the ΔE values stipulated in appendix A7.</p>	<p>Exposure time: 1000 hours</p> <p>Gloss retention: the loss of gloss after the accelerated weathering test shall not be greater than 10% of the original value</p> <p>Colour change: not greater than 50% of the limits prescribed in appendix A7</p>	<p>Exposure time: 2000 hours Every 500 hours: check gloss and colour</p> <p>Gloss retention: the loss of gloss after the accelerated weathering test shall not be greater than 10% of the original value</p> <p>Colour change: not greater than 50% of the limits prescribed in appendix A7</p>
11	POLYMERISATION TEST 2.14 OPTIONAL	----	<p>Ratings: 1: very dull and quite soft coating 2: very dull coating which can be scratched with a finger-nail. 3: slight loss of gloss i.e. less than 5 units 4: no perceptible change. Coating cannot be scratched with a finger-nail.</p> <p>Evaluation: 1/2: test result unsatisfactory 3/4: test result satisfactory</p>	Same as class 1	Same as class 1
12	RESISTANCE TO MORTAR 2.15	EN 12206-1 par. 5.9	There shall not be any change in appearance/colour after the mortar test.	Same as class 1	Same as class 1
13	RESISTANCE TO BOILING WATER 2.16	-----	No blistering in excess of 2 (S2) according to ISO 4628-2. There shall not be any defects or detachment. Some colour change is acceptable.	Same as class 1	Same as class 1
14	CONSTANT CLIMATE CONDENSATION WATER TEST 2.17	EN ISO 6270	<p>Testing time: 1000 hours</p> <p>No blistering in excess of 2 (S2) according to 4628-2; the maximum infiltration at the cross is 1 mm.</p>	Same as class 1	<p>Testing time: 2000 hours</p> <p>No blistering in excess of 2 (S2) according to 4628-2; the maximum infiltration at the cross is 1 mm.</p>
15	NATURAL WEATHERING TEST (FLORIDA) (2.13)	EN ISO 2810	<p>5° south 4 panels per colour shade</p> <p>Exposure time: 1 year</p> <p>Gloss retention: the loss of gloss after the natural weathering test must not be greater than 50% of the original value</p> <p>Colour change: according to the ΔE values stipulated in appendix A7.</p>	<p>5° south 10 panels per colour shade</p> <p>Exposure time: 3 years with an annual evaluation</p> <p>Gloss retention After 1 year : at least 75% of the original value After 2 years : at least 65% After 3 years : at least 50%</p> <p>Colour change: After 1 year: not greater than 65% of the limits prescribed in the table After 2 years: not greater than 75% of the limits prescribed in the table After 3 years: within the limits prescribed in the table</p>	<p>45° south 13 panels per colour shade</p> <p>Exposure time: 10 years with an evaluation after 1, 4 and 7 years</p> <p>Gloss retention After 1 year : at least 90% After 4 years : at least 70% After 7 years : at least 55% After 10 years : at least 50%</p> <p>Colour change: After 10 years, within the limits prescribed in the table</p>