

QUALICOAT SPECIFICATIONS

25th Edition

**Appendix B – Specifications for
Cast Accessories**

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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 the 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 2 of Volume 2: Specifications for Coaters are applicable to the treatment of accessories, with the exception of the etching degree which is not specified for castings.

3. Testing

a) 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
- Polymerisation

and if the geometry of the parts permits:

- Coating thickness
- Adhesion

The following test shall be performed on extruded sections only:

- Acetic acid salt spray test
- Machu test

b) Inspection of test panels

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

- Gloss
- Coating thickness
- Adhesion
- Bend test
- Impact test

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