

COATER

Master Inspection Report

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Report no. _____

COMPANY

Name					
Plant Address					
Phone		email			
Responsible person(s) (contact)					
Licence number		(leave blank for GR1/GR2)	Number of coating lines ²		SEASIDE endorsement holder YES NO

COATING LINE INSPECTION¹

DATE OF INSPECTION (use dropdown calendar)	DESIGNATION ² OF THE COATING LINE				
INSPECTION NO.	Granting			SEASIDE:	Granting
TYPE OF INSPECTION	Renewal		Select ONLY if FFC test is performed (ANNEX I or ANNEX II)	Renewal (During RN1)	
	Repetition			Repetition	
DATE OF LAST INSPECTION (use dropdown calendar)	Has anything changed in the plant since the last inspection?	YES	NO	If YES what?	
Testing laboratory					
Name of inspector	1:		2:		
Is the inspection unannounced?	YES	NO	If NO why?		
Is an inspection possible?	YES	NO	If NO why?		
Remarks					

¹ Annex I = SEASIDE, Annex II = Anodic pretreatment, Annex III = Supplement for off-site anodic pretreatment, Annex IV = Batch pretreatment inspection² A coating line is a production line used for coating aluminium for architectural applications that includes a **single pretreatment cycle**.

Report no. _____

IDENTIFICATION OF QUALICOAT APPROVED
COATING SYSTEMS USED BY THE COATER (STORAGE)

Verify that the powders (including colours) that the coater uses for external architectural applications during the inspection are approved by QUALICOAT. (fill in three random powders in stock)

Coating systems (type and brand name)	Producer	Approval NO.*	Banned colours*

* As shown on the current list of approved coating systems published on the website (www.qualicoat.net)

Does the coating plant
have only approved
powders in stock?

YESNO

If NO why?

Do the coating materials comply with the packaging rules
prescribed by QUALICOAT?
(see paragraph 4.1.1 and Appendix A1 of the Specifications)

YESNO

Remarks

Optional picture upload

Report no. _____

STORAGE CONDITIONS
AND LAYOUT OF EQUIPMENT

PARTS TO BE TREATED YES NO

Are the parts to be treated stored in accordance with section 3.1.1 of the Specifications?

Remarks

CHEMICAL PRODUCTS YES NO

Do the storage conditions comply with the chemical manufacturer's requirements?

Remarks

POWDER AND LIQUID COATING PRODUCTS YES NO

Do the storage conditions comply with the powder manufacturer's requirements?

Remarks

LAYOUT OF EQUIPMENT YES NO

Does the layout of equipment comply with section 3.1.2 of the Specifications?

Remarks

1. INSPECTION OF LABORATORY
AND APPARATUS

1.1 LABORATORY

YES NO

APPEARANCE CORRECT

Remarks

Report no. _____

APPARATUS FOR MEASURING THICKNESS AND GLOSS

1.2 Instruments for measuring coating thickness (ISO 2360)

Verify the calibration of the instrument using two suitable standards according to the thickness to be measured

	Instrument A		Instrument B	
	MAKE		MAKE	
	MODEL		MODEL	
	No.		No.	
Deviation from the standard value	REQUIRED	MEASURED	REQUIRED	MEASURED
- Set-up I : 0 ± 0.5				
- Set-up II: < 60 ± 1				
- Set-up III: ≥ 60 ± 2				
Function				
Calibration standards/ foils available	YES	NO	Remarks	
Data sheet with identification no. and calibration records available	YES	NO	Remarks	

1.3 Specular glossmeter (ISO 2813)

Verify the calibration of the instrument

Make		Model		No	
Required		Measured			
Function		(± 2 units)	Data sheet with identification no. and calibration records available	YES	NO
Remarks					

Report no. _____

1.4 Analytical balance (sensitivity not less than 0.1 mg)

Make		Model		No	
Data sheet with identification no. and calibration records available	YES	NO	Last calibrated on		

TEST WITH CALIBRATED WEIGHTS (10-50g)

	WEIGHTS USED		WEIGHTS MEASURED
Weight 1	g	=	g
Weight 2	g	=	g

Function

Two calibrated weights for in-house adjustment available

YES NO

Remarks

APPARATUS FOR MECHANICAL TESTS

When verifying that the apparatus is functioning properly, it is necessary to check the visual appearance of the apparatus

1.5 Cutting tool (for cross-cut adhesion test ISO 2409)

Make		Model		No	
Visual assessment					
If not good, indicate the reasons					
Function					
Adhesive tape available	YES	NO			
Available distances between cuts		mm			
Remarks					

Report no. _____

1.6 Impact tester (ISO 6272-1, ISO 6272-2 and ASTM D 2794)

Make		Model		No	
Visual assessment					
If not good, indicate the reasons					
Function					
Remarks					

1.7 Apparatus for bend test (ISO 1519)

Make		Model		No	
Visual assessment					
If not good, indicate the reasons					
Function					
Remarks					

OTHER APPARATUS

1.8 Recorder for stoving temperature

Make		Model		No		
Minimum number of sensors	3 on the parts	YES	NO	1 to measure the air	YES	NO
Method used by the inspector for checking that the apparatus is functioning (for example, by comparing it with certified apparatus)						
Function		Last checked on				
		YES NO				
Data sheet with identification no. and calibration records available						
Remarks						

Report no. _____

1.9 Conductivity meter

Make		Model		No	
Reference test solution		μS/cm	Temperature		°C
Measured		μS/cm	Temperature		°C
Function (≤ 2 μS/cm)		Calibration solution ≤ 100 μS/cm available	YES	NO	
Data sheet with identification no. and calibration records available	YES	NO			
Remarks					

1.10 pH meter

Make		Model		No		
Test of the electrodes with two standard test solutions	Solution 1		pH	Measured		pH
	Solution 2		pH	Measured		pH
Function (± 0.1)						
Remarks						

1.11 Apparatus for boiling water test

Make		Model		No	
Function		Pressure cooker	YES	NO	
Remarks					

1.12 Device for the analytical coating weight determination (Chemical pretreatment only)

Make		Model		No	
Function		Data sheet with identification no. and calibration records available	YES	NO	
Test method					
Remarks					

Report no. _____

2. INSPECTION OF PLANT
AND EQUIPMENT

SURFACE PRETREATMENT

2.1 Type of pretreatment

Chromate
pretreatment

Chemical
pretreatment
(Chrome VI-free)

QUALICOAT approval NO.
(Example: A-003 / A-074 / A-132)

Rinse
pretreatment
No-rinse
pretreatment

In-house Anodic pretreatment
(please complete ANNEX II)

Off-site Anodic pretreatment
(please complete ANNEX III)

Remarks

2.2 Specific requirements

Interruption
in treatment?

YES NO

If YES, how much time between the
pretreatment and coating

Hours
(max. 16 hours)

If YES, Are the pretreated parts handled with
clean textile gloves?

YES NO

Remarks

3. PROCESS INSPECTION

Installation	System used	Process	
Horizontal	Spray	Continuous	
Vertical	Immersion	Batch with basket	} In the case of batch pretreatment using a basket, please complete ANNEX IV
	Cascade	Batch (jig)	

SEASIDE pretreatment (For endorsement holders)

The SEASIDE inspection shall be conducted during the first annual licence renewal inspection using ANNEX I (or ANNEX II for in-house Anodic pretreatment and Annex III for Off-site Anodic pretreatment)

SEASIDE production on the inspection day	YES	NO	Remarks	
--	-----	----	---------	--

3.1 PRETREATMENT

Etching type
(Optional for Anodic pretreatment, see ANNEX II)

A1 (simple acid etching)		A2 (acid etching + acid etching)	AA1 (alkaline etching and acid etching)	AA2 (acid etching + alkaline etching + acid etching)	
			STEP 1	STEP 2	STEP 3
INDICATE THE STEP (DEGREASING, ETCHING OR DEOXIDATION)					
pH					
Temperature (°C)	required				
	measured				
Concentration	required				
	measured				
Immersion/spray time (min)	required				
	measured				
Aluminium removed	(g/m²)				
Remarks					
Total aluminium removed				≥ 1 g/m² / (≥ 2g/m² for SEASIDE)	

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3.1.1 Conversion treatment

Supplier

Product

	REQUIRED		MEASURED	
Temperature		°C		°C
Concentration / extinction				
Conductivity		µS/cm		µS/cm
Immersion/spray time				
pH value				
Remarks				

3.1.2 Chromate conversion coating

	WEIGHT RANGE REQUIRED		WEIGHT MEASURED	
YELLOW		g/m²		g/m²
GREEN		g/m²		g/m²
Remarks				

3.1.3 Chemical chrome VI-free conversion coating

	METHOD	WEIGHT RANGE REQUIRED	WEIGHT MEASURED	UNIT
COATER				
CHEMICAL MANUFACTURER (last available result)				
Remarks				

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3.2 COOPERATION WITH THE CHEMICAL MANUFACTURER

Does the coater send a production sample to the chemical manufacturer every 2 months according to the QUALICOAT Specifications? YES NO

If YES fill in the following table:

NUMBER OF SAMPLES TESTED BY THE CHEMICAL MANUFACTURER SINCE THE LAST INSPECTION		QUANTITY
AASS Test	for Chemical (Chrome VI-free) <u>and</u> Chromate treatment	
Coating weight measurement	for Chemical (Chrome VI-free) treatment	

Remarks

Are the chemical manufacturers test results recorded? YES NO If NO why?

Are the sample details (shipping dates, chemical manufacturers confirmation receipts) recorded? YES NO If NO why?

3.3 TECHNICAL INFORMATION

General technical data sheet YES NO Specific instructions for the plant YES NO

Remarks

3.4 FINAL RINSE

CONDUCTIVITY [μ S/cm] *		REQUIRED	MEASURED
Rinse before conversion treatment	Rinsing Water		
	Dripping Water		
Rinse after conversion treatment (if used)	Rinsing Water		
	Dripping Water		

* Limit values see QUALICOAT Specifications: 3.3.1 Chromate, 3.3.2 Chemical, 3.4 Anodic

YES NO
Satisfactory

Remarks/Reason for missing drip water measurement

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3.5 DRYING

Maximum temperature allowed
°C

Maximum temperature measured on the parts
°C

Production method

YES

NO

Satisfactory

Remarks

3.6 STOVING CONDITIONS

In the table below, the inspector must record the progressive temperature measured on the coldest part, the pertinent time measured and the stoving times specified by the powder manufacturer.

Powder manufacturer

Powder approval (P-No.)

Product name

STOVING CONDITIONS SPECIFIED BY THE POWDER MANUFACTURER		MEASURED		STOVING INSTALLATION	
Time in minutes	Temp. of parts °C	Time in minutes	Temp. of parts °C	Duration in minutes	Set value °C

Alarm system available

YES

NO

A calculation of the CURING INDEX is used

YES

NO

If YES, does the value meet the manufacturer's recommendations

YES

NO

Condition acceptable

YES

NO

Remarks/Reference to additional file uploads

4. INSPECTION OF FINISHED PRODUCTS

4.1 INSPECTION OF COATED PARTS (Which have been released by the coater)

Appearance

Conforms to section 2.1 of the QUALICOAT Specifications

YES

NO

If NO why?

Type of production

Sections

Sheets

Small parts

Others

Remarks

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4.2 COATING THICKNESS (Minimum thickness measured)

Powder (P-No)		Order No		Number of pieces tested	
Colour		Lot size		Minimum thickness measured	

No.	Measured coating thickness results(µm)					Average in µm	Remark
	1	2	3	4	5		
1							
2							
3							
4							
5							
6							
7							
8							
9							
10							

Powder (P-No)		Order No		Number of pieces tested	
Colour		Lot size		Minimum thickness measured	

No.	Measured coating thickness results(µm)					Average in µm	Remark
	1	2	3	4	5		
1							
2							
3							
4							
5							
6							
7							
8							
9							
10							

Powder (P-No)		Order No		Number of pieces tested	
Colour		Lot size		Minimum thickness measured	

No.	Measured coating thickness results(µm)					Average in µm	Remark
	1	2	3	4	5		
1							
2							
3							
4							
5							
6							
7							
8							
9							
10							

Number of rejected pieces		Satisfactory	YES	NO	Remarks	
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4.3 Sawing test

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

YESNO

Satisfactory

Remarks

4.4 Dry adhesion (ISO 2409)

Test on finished product. The result shall be 0.

SAMPLE No.	COATING THICKNESS	SPACING OF THE CUTS BY COATING THICKNESS			ASSESSMENT (0 REQUIRED)
		up to 60 µm 1mm	60 - 120 µm 2mm	Over 120 µm 3mm	
	µm				

YESNO

Satisfactory

Remarks

4.5 Wet Adhesion test

3 samples of finished product taken during the inspection. On visual inspection, there shall be no sign of detachment or blistering. Colour change is acceptable.

SAMPLE No.	COATING THICKNESS	SPACING OF THE CUTS BY COATING THICKNESS			VISUAL INSPECTION SATISFACTORY	
		up to 60 µm 1mm	60 - 120 µm 2mm	Over 120 µm 3mm	YES	NO
	µm					
	µm					
	µm					

YESNO

Satisfactory

Remarks

Report no. _____

4.6 Machu test

No infiltration exceeding 0.5 mm on both sides of the scratch on 3 test pieces from different lots taken during the inspection. The results should be classified according to the rating scale below:

- | | |
|---------------------------|--------------------------|
| A. 3 samples satisfactory | 0 samples unsatisfactory |
| B. 2 samples satisfactory | 1 samples unsatisfactory |
| C. 1 samples satisfactory | 2 samples unsatisfactory |
| D. 0 samples satisfactory | 3 samples unsatisfactory |

SAMPLE LOT NO.	RESULTS		SATISFACTORY	
	Length of infiltration		YES	NO
	Length of infiltration		YES	NO
	Length of infiltration		YES	NO

Classification		Remarks	
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4.7 Acetic acid salt spray test (ISO 9227)

The inspector must take 3 samples (sections) from different lots, during first inspection of the year. The results should be classified according to the rating scale below:

- | | |
|---------------------------|--------------------------|
| A. 3 samples satisfactory | 0 samples unsatisfactory |
| B. 2 samples satisfactory | 1 samples unsatisfactory |
| C. 1 samples satisfactory | 2 samples unsatisfactory |
| D. 0 samples satisfactory | 3 samples unsatisfactory |

SAMPLE LOT NO.	RESULTS			SATISFACTORY	
	Length of infiltration		mm	YES	NO
	Surface corroded		mm ² /10 cm		
	Blistering		S		
	Length of infiltration		mm	YES	NO
	Surface corroded		mm ² /10 cm		
	Blistering		S		
	Length of infiltration		mm	YES	NO
	Surface corroded		mm ² /10 cm		
	Blistering		S		

AASS Classification		Remarks	
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4.8 Polymerisation test as prescribed (optional for powder coatings)

Assessment rating:

- | | |
|--|---|
| <p>1 Coating is very dull and quite soft</p> <p>2 Coating is very dull and can be scratched with a finger-nail</p> | <p>3 Slight loss of gloss (less than 5 units)</p> <p>4 No perceptible change
Cannot be scratched with a finger-nail</p> |
|--|---|

Requirements:

1 and 2 = unsatisfactory
3 and 4 = satisfactory

Solvent used

Remarks

5. INSPECTION OF THE TEST PANELS

Tests performed on test panels processed concurrently with a production lot

Processed during the visit YES NO

POWDER APPROVAL (P-No.)	TYPE AND BRAND NAME	PRODUCER	GLOSS CATEGORY 1/2/3	COLOUR SHADE

Remarks

5.1 COATING THICKNESS (ISO 2360)

SAMPLE REFERENCE	REQUIRED	MEASURED	SATISFACTORY
			YES NO

Remarks

5.2 GLOSS MEASUREMENT (ISO 2813)

SAMPLE REFERENCE	REQUIRED GLOSS RANGE	MEASURED	SATISFACTORY
			YES NO

Remarks

Report no. _____

5.3 DRY ADHESION (ISO 2409)

SAMPLE REFERENCE	COATING THICKNESS	SPACING OF THE CUTS BY COATING THICKNESS			Assessment (0 required)
		up to 60 µm 1mm	60 µm - 120 µm 2mm	Over 120 µm 3mm	
	µm				
		YES NO			
Satisfactory					
Remarks					

5.4 BEND TEST (ISO 1519)

SAMPLE REFERENCE	COATING THICKNESS according to 2.7 of the Specifications	COATING THICKNESS of the sample	CLASS 1: NO cracking or detachment	
			CLASS 1.5; 2 AND 3: NO detachment	
			YES	NO
	µm	µm	Satisfactory	
Remarks				

5.5 IMPACT TEST (ASTM D 2794 AND ISO 6272-1 OR-2) – for powder coatings only

SAMPLE REFERENCE	COATING THICKNESS according to 2.8 of the Specifications	COATING THICKNESS of the sample	CLASS 1: NO cracking or detachment	
			CLASS 1.5; 2 AND 3: NO detachment	
			YES	NO
	µm	µm	Satisfactory	
Remarks				

Report no. _____

6. IN-HOUSE CONTROL

CATEGORY OF TEST		CONFORMITY	
		Minimum frequency required	Recorded
TESTING OF FINISHED PRODUCTS	APPEARANCE	According to the lot size of the order	
	COATING THICKNESS (ISO 2360)	According to the lot size of the order	
	GLOSS (ISO 2813)	Once in every working shift for each shade and manufacturer	
	WET ADHESION	Once in every working shift All samples from one day may be tested together	
PANEL TESTING	DRY ADHESION (ISO 2409)	Minimum of 1 x sample* for every two production hours	
	POLYMERISATION TEST (OPTIONAL FOR POWDER COATINGS)	Once in every working shift for each colour shade and gloss category and for each manufacturer	
	BEND TEST (ISO 1519)	Minimum of 1 x sample* for every two production hours	
	IMPACT TEST (ASTM D 2794 and ISO 6272)	Minimum of 1 x sample* for every two production hours	
PROCESS TESTING	CHEMICAL PRETREATMENT BATHS	Once per bath in every working shift, or according to the chemical supplier's advice, that shall be at least once per day (24 hours)	
	CONDUCTIVITY OF DEMINERALISED RINSING WATER	Once per bath in every working shift, or according to the chemical supplier's advice, that shall be at least once per day (24 hours)	
	TEMPERATURE OF PRETREATMENT BATHS AND HOT WATER RINSE	Once per bath in every working shift, or according to the chemical supplier's advice, that shall be at least once per day (24 hours)	
	DRYING CONDITIONS	Drying temperature recording: once in every working shift Measurement on parts: once a week	
	WEIGHT OF CONVERSION COATING (CHROMATE/CHEMICAL PRETREATMENT)	Once in every working shift, or according to the chemical supplier's advice, that shall be at least once per day (24 hours)	
	WEIGHT OF ALUMINIUM REMOVED (etching degree)	Once in every working shift, or according to the chemical supplier's advice, that shall be at least once per day (24 hours)	
	STOVING CONDITIONS	Displayed temperature recording: once in every working shift Stoving curve: twice a week on profiles	

* The same panel to be chosen for DRY ADHESION, BEND TEST and IMPACT TEST

RECORDS AND
REGISTERS

YES NO

up to date

PRODUCTION CONTROL
REGISTER

YES NO

up to date

STANDARDS OR OPERATING INSTRUCTIONS
BASED ON THE STANDARDS

YES NO

are available for all tests

Remarks

Report no. _____

7. OTHERS

Specifications

Is the latest edition of the QUALICOAT Specifications (including current Update Sheets) available to the person(s) responsible?

YES NO

Complaint book

Is a register for customer's complaints available?

YES NO

Use of the label (see Appendix A1 of the QUALICOAT Specifications)

Does the use of the logo comply with the regulations for use of the QUALICOAT quality label?

YES NO

Training attendance

Do employees participate in the trainings provided by the General Licensee?

YES NO

If Not, why?

INSPECTION BODY

DATE

INSPECTOR'S SIGNATURE

DATE

LABORATORY'S SIGNATURE

GENERAL LICENSEE

DATE

RESULT RECOMMENDATION TO QUALICOAT*

SATISFACTORY

NOT SATISFACTORY

REMARKS GL

* The final assessment is made by **QUALICOAT**

Report no. _____

SUMMARIZING SHEET

Form to be completed at the end of an inspection

COATER

LICENCE NUMBER

DATE OF INSPECTION

COATING LINE DESIGNATION

NAME OF INSPECTOR

INSPECTION NO.

Granting

Renewal

Repetition

RESOLUTION OF PREVIOUS ISSUES AND NONCONFORMITIES:

1

2

3

4

RESULTS

SUMMARY OF TESTS AND INSPECTION	ISSUES AND/OR NONCONFORMITIES	COATER'S REMARKS
INSPECTION OF MATERIALS (5.1.1.)		
INSPECTION OF LABORATORY EQUIPMENT (5.1.2)		

Report no. _____

SUMMARY OF TESTS AND INSPECTION	ISSUES AND/OR NONCONFORMITIES	COATER'S REMARKS
INSPECTION OF PRODUCTION PROCESS AND EQUIPMENT (5.1.3) + INSPECTION OF PRETREATMENT (5.1.4)		
INSPECTION OF FINISHED PRODUCTS EXCLUDING LABORATORY TEST RESULTS (5.1.5) + PANELS (5.1.6)		
REVIEW OF IN-HOUSE CONTROL AND REGISTERS (5.1.7)		
OTHERS (CLAIMS REGISTER, USE OF THE LABEL, ETC.)		

INSPECTOR'S SIGNATURE

PLANT MANAGER'S SIGNATURE

Report no. _____

ANNEX I

ANNEX I
SUPPLEMENT FOR MONITORING SEASIDE

1. SEASIDE PRETREATMENT TYPE

A1 (simple acid etching)	A2 (acid etching + acid etching)	AA1 (alkaline etching and acid etching)	AA2 (acid etching + alkaline etching + acid etching)
SAMPLE	Initial weight	P1 [g]	MEASURED
	Surface area	S [m²]	
ACID ETCHING	Weight after Weight after acid	P2 [g]	
	Weight loss	D1 = (P1-P2)/S [g/m²]	
ALKALINE ETCHING	Weight after alkaline etching	P3 [g]	
	Weight loss	D2 [g/m²]	
ACID ETCHING	Weight after acid etching	P4 [g]	
	Weight loss	D3 [g/m²]	
Total Weight loss		D = D1 + D2 + D3 [g/m²]	
Remarks			

2. FILIFORM CORROSION TEST

The inspector takes three samples (sections) from different lots.
The results should be classified according to the rating scale below:

- A. 3 samples satisfactory0 samples unsatisfactory
- B. 2 samples satisfactory1 samples unsatisfactory
- C. 1 samples satisfactory2 samples unsatisfactory
- D. 0 samples satisfactory3 samples unsatisfactory

SAMPLE No.	RESULTS			SATISFACTORY	
	Longest filament	≤ 4 mm	L:	YES	NO
	Average length of filaments	≤ 2 mm	M:		
	Longest filament	≤ 4 mm	L:	YES	NO
	Average length of filaments	≤ 2 mm	M:		
	Longest filament	≤ 4 mm	L:	YES	NO
	Average length of filaments	≤ 2 mm	M:		

FFC Classification		Remarks	
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ANNEX II
SUPPLEMENT FOR ANODIC PRETREATMENT

1. DEGREASING - ETCHING - DESMUTTING

		DEGREASING	ETCHING	DESMUTTING*
SUPPLIER				
PRODUCT				
Temperature (°C)	required			
	measured			
Concentration	required			
	measured			
Immersion/spray time (min)	required			
	measured			

* mandatory for Alkaline etching

Total etching rate g/m²

(≥ 2g/m2 requested)

Remarks

2. ANODISING

	RECOMMENDED	MEASURED	INHOUSE CONTROL FREQUENCY	RECORDED
Temperature of anodising bath	20 - 30 °C		Every 8 hours	
Acid concentration	180 – 220 g/l		Once per day	
Aluminium content	5 – 15 g/l		Once per day	

Remarks

3. CONVERSION TREATMENT

	REQUIRED		MEASURED	
Temperature		°C		°C
Concentration/ extinction				
Conductivity		µS/cm		µS/cm
Immersion/spray time				
pH value				

Remarks

4. RINSING

	REQUIRED	MEASURED	INHOUSE CONTROL FREQUENCY	RECORDED
Conductivity of the final rinse	30 µS/cm at 20 °C		Minimum once per day	
Conductivity of dripping water	30 µS/cm at 20 °C		Minimum once per day	

Remarks

5. PROCESS REQUIREMENTS

Passivation after pre-anodising with QUALICOAT AP-No. _____

Is there a written confirmation from the powder manufacturer on the compatibility with this type of pretreatment? YES NO

Remarks _____

Is each coating material (i.e., each colour shade, gloss category, and manufacturer) tested for boiling water resistance prior to coating, followed by an adhesion test (see § 2.4)? YES NO

Remarks _____

Is a wet adhesion test carried out every 4 hours during the application? YES NO

Remarks _____

Is the etching rate checked once per day? YES NO

Remarks _____

Is the thickness of the anodic coating checked with every load? YES NO

Remarks _____

Are the pre-anodised parts stored for longer than 16 hours? YES NO

Is an additional rinsing done? YES NO

Is the total time between pre-anodising and coating less than 72 hours? YES NO

Remarks _____

6. THICKNESS OF ANODIC FILM (Anodic coating without powdering and surface flaws)

ORDER NO. _____ LOT SIZE _____

Section	1	2	3	4	5	6	7	8	9	10
Thickness in [µm]										

ORDER NO. _____ LOT SIZE _____

Section	1	2	3	4	5	6	7	8	9	10
Thickness in [µm]										

ORDER NO. _____ LOT SIZE _____

Section	1	2	3	4	5	6	7	8	9	10
Thickness in [µm]										

Remarks _____

7. FILIFORM CORROSION TEST

The inspector takes three pre-anodised sections from different lots.
The results should be classified according to the rating scale below:

- A. 3 samples satisfactory 0 samples unsatisfactory

B. 2 samples satisfactory 1 samples unsatisfactory
- C. 1 samples satisfactory 2 samples unsatisfactory

D. 0 samples satisfactory 3 samples unsatisfactory

SAMPLE No.	RESULTS			SATISFACTORY	
	Longest filament	≤ 4 mm	L:	YES	NO
	Average length of filaments	≤ 2 mm	M:		
	Longest filament	≤ 4 mm	L:	YES	NO
	Average length of filaments	≤ 2 mm	M:		
	Longest filament	≤ 4 mm	L:	YES	NO
	Average length of filaments	≤ 2 mm	M:		

FFC Classification _____ Remarks _____

Report no. _____

ANNEX III

ANNEX III
SUPPLEMENT FOR OFF-SITE ANODIC PRETREATMENT

1. QUALANOD
licence no.
of anodiser

QUALICOAT
licence no.
of anodiser

2. Checklist outsourced work (off-site anodiser)

Date order
is given

Unique
reference

Type of
product

Profiles
Sheets
Others

(e.g. order no. / job card no. / process no. for reference)

Bill of material
includes

Numbers
YES NO

Lengths
YES NO

Perimeter
YES NO

m²
YES NO

Drawings
YES NO

If NO
specify

Alloy

Requested
treatment

PreOx

Declared layer thickness
4-10µm

Remark

Delivery
of treated
parts

From Extruder/
Trader

From Powder
Coater

Complete
delivery

Partial
delivery

Exit control
by anodiser

YES NO

Visual
check

OK NOT OK

Remark

Extra
samples
provided

YES NO

Are the extra samples
declared to be made
of the same material
as the delivery?

YES NO

If not
specify

Date of Anodising production (A)

(use dropdown calendar)

Time of Anodising production (A)

Date of Sample production

(use dropdown calendar)

Time of Sample production

3. Delivery appointments between sender and recipient
(storage period in accordance with 3.4 of the QUALICOAT Specifications)

(use dropdown calendars)

Date of material receipt		(effective goods receipt date)
Delivery material latest		(date of the final delivery completion)
Desired pick up date		(originally requested pick up date)

Remarks

4. Preliminary in-house control of pre-Ox by the coater
(incoming goods inspection before production)

Checks packaging at receipt	OK	Are the extra samples made of the same material as the delivery?	YES	NO				
Film thickness check	OK	Measurements		Average of 10 measurements µm				
Visual check of products satisfactory	YES	NO	Remarks					
Rinsed upon arrival (<30µS)	YES	NO	Specify					
Additional wet adhesion test for powders used for the first time on pre-Ox (NO = to be carried out on a preproduction sample)	YES	NO	Feedback In-House Control Anodiser of process / parameters	YES	NO	Receipt of suitability of powder coating from coating supplier	YES	NO

5. Coating production
(incoming goods inspection before production)

Date of coating production (B)		Time of coating production (B)						
Elapsing time between Anodising (A) and Coating (B) less than 72h?	YES	NO	Are the pre-treated parts handled with clean textile gloves?	YES	NO	Is the resistance to boiling water, followed by an adhesion test carried out every 4 hours during application?	YES	NO
Remarks								

ANNEX IV
BATCH PRETREATMENT INSPECTION

PROCESS INSPECTION (see section 3)

1. Material and separators

Aluminium	Stainless steel
Others	Specify

2. Shape and number of separators

Shape		Number	
Contact width: (maximum 2 mm)		(The maximum contact widths must be effective and not nominal)	
Remarks			

3. Flow of liquid

Distance between the section		Correct (minimum 1 cm)	YES	NO
Remarks				

4. Hooping

MATERIAL USED

Aluminium	Stainless steel
Others	Specify

MAXIMUM CONTACT WIDTHS

	YES	NO
Correct (maximum 2 mm)		
Remarks		

5. Boiling water test (only for granting a licence)

	YES	NO
Satisfactory		
Remarks		

Report no. _____

ADDITIONAL FILES
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