

QUALIDECO - Master Inspection Form Decorator

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Report no. _____

Type of inspection:

- ☐ **Grant**
☐ **Renewal**
☐ **Repetition**

Company

Name, address,
phone and e-mail

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Licence number:

Technology: ☐ **Sublimation** ☐ **Powder on Powder** ☐ **Other:**

Person responsible:
(contact person)

Date of inspection:

Name of inspector:

Date of last inspection:

Has anything changed in the plant since the last inspection? YES ☐ NO ☐

If yes, what?

Is an inspection possible? YES ☐ NO ☐

If not, why?

Testing laboratory:

Report no. _____

A) INSPECTION OF DECORATIVE FINISHES

A.1) CLASS 1

SUBLIMATION								
DECORATION		BASE COATING			FILM		SELECTED FROM	
		Supplier (PS No.)	Product code of the powder coating	DP-No.	Supplier (FS No.)	Product code of the film	Suppliers' list of self-tested decorations	Decorator's list of approved decorations
1							<input type="checkbox"/> FS <input type="checkbox"/> PS	<input type="checkbox"/>
2							<input type="checkbox"/> FS <input type="checkbox"/> PS	<input type="checkbox"/>
3							<input type="checkbox"/> FS <input type="checkbox"/> PS	<input type="checkbox"/>
4							<input type="checkbox"/> FS <input type="checkbox"/> PS	<input type="checkbox"/>

SUBLIMATION (NOT APPROVED DECORATIONS)					
DECORATION		BASE COATING			FILM
		Supplier (PS No.)	Product code of the powder coating ¹	DP-No.	Supplier (FS No.)
1					
2					

POWDER ON POWDER						
DECORATION		Powder supplier (name)	BASE COATNG		TOP COATING	
			Product code of the powder coating ¹	P-No.	Product code of the powder coating ¹	P-No.
1						
2						

Remarks:

A.2) CLASS 2

SUBLIMATION							
DECORATION		BASE COATING			FILM		SELECTED FROM
		Supplier (PS No.)	Product code of the powder coating ¹	DP-No.	Supplier (FS No.)	Product code of the film	Suppliers' list of class 2 approved decorations
1							<input type="checkbox"/>
2							<input type="checkbox"/>

POWDER ON POWDER						
DECORATION		Powder supplier (name)	BASE COATNG		TOP COATING	
			Product code of the powder coating ¹	P-No.	Product code of the powder coating ¹	P-No.
1						
2						

Remarks:

¹ Identification of the powder coating (including colour) as indicated on the product package.

Report no. _____

B) COATER

NAME OF COATING PLANT	COUNTRY	CITY	QUALICOAT Licence No.

C) INSPECTION OF LABORATORY EQUIPMENT

Specular glossmeter (ISO 2813)

Make: _____ Model: _____ No.: _____
 Function: correct (± 2 units) ☐ incorrect ☐

Remarks:

Instrument for measuring coating thickness (ISO 2360)

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

Deviation from the standard value

- Set-up I : 0 ± 0.5
- Set-up II: $< 60 \pm 1$
- Set-up III: $\geq 60 \pm 2$

Function

Remarks

Make: Model: No.:	
Required	Measured
Correct <input type="checkbox"/>	Incorrect <input type="checkbox"/>
Remarks	

D) PROCESS INSPECTION

D.1) PROCESS INSPECTION FOR THE SUBLIMATION PROCESS

SUBLIMATION TEMPERATURE (at least 3 points to check uniformity of the sublimation oven)				
Position 1 (upper extremity):				
Position 2 (centre):				
Position 3 (lower extremity):				
Oven temperature:	Set up value:		Read value:	
PARAMETERS FOR SUBLIMATION PROCESS (prescribed by the Film Supplier)				
Sublimation temperature				
Prescribed	Measured			

EVALUATION: ☐ SATISFACTORY ☐ UNSATISFACTORY

Remarks:

Report no. _____

D.2) PROCESS INSPECTION FOR THE POWDER ON POWDER PROCESS

UNIFORMITY OF STOVING (at least 3 points to check uniformity of stoving)

PARTIAL CURING			
Position 1 (upper extremity):			
Position 2 (centre):			
Position 3 (lower extremity):			
Stoving conditions specified by the manufacturer		Measured	
Time (min.)	Temperature of parts (°C)	Time (min.)	Temperature of parts (°C)

CURING			
Position 1 (upper extremity):			
Position 2 (centre):			
Position 3 (lower extremity):			
Stoving conditions specified by the manufacturer		Measured	
Time (min.)	Temperature of parts (°C)	Time (min.)	Temperature of parts (°C)

EVALUATION: ☐ SATISFACTORY ☐ UNSATISFACTORY

Remarks:

E) IN-HOUSE CONTROL

CATEGORY OF CONTROL	CONFORMITY	
	Minimum frequency prescribed	Recorded
Sublimation process (oven)	Once per day (1 point) Once per week (3 points)	
Curing conditions (powder coatings)	Once per week (3 points)	
Gloss (ISO 2813)	Once per lot	
Coating thickness (ISO 2360)	According to the lot size of the order	
Appearance	According to the lot size of the order	
Records and registers	updated daily	
Production control register	updated daily	

Remarks:

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Report no. _____

F) SAMPLING (samples taken by the inspector for laboratory tests)

F.1) SAMPLING FOR THE SUBLIMATION PROCESS

As prescribed in Section 4.2 of the Specifications

SUBLIMATION (CLASS 1)								
DECORATION		BASE COATING			FILM		SELECTED FROM	
		Supplier (PS No.)	Product code of the powder coating	DP-No.	Supplier (FS No.)	Product code of the film	Suppliers' list of self-tested decorations	Decorator's list of approved decorations
1							<input type="checkbox"/> FS <input type="checkbox"/> PS	<input type="checkbox"/>
2							<input type="checkbox"/> FS <input type="checkbox"/> PS	<input type="checkbox"/>

Remarks:.....

SUBLIMATION – CLASS 2								
DECORATION		BASE COATING			FILM		SELECTED FROM	
		Supplier (PS No.)	Product code of the powder coating ²	DP-No.	Supplier (FS No.)	Product code of the film	Suppliers' list of class 2 approved decorations	Decorator's list of class 2 approved decorations
1							<input type="checkbox"/>	<input type="checkbox"/>
2							<input type="checkbox"/>	<input type="checkbox"/>

Remarks:.....

F.2) SAMPLING FOR THE POWDER ON POWDER PROCESS

As prescribed in Section 6.3.2 of the Specifications

POWDER ON POWDER - CLASS 1						
DECORATION		Powder supplier (name)	BASE COATING		TOP COATING	
			Product code of the powder coating ²	P-No.	Product code of the powder coating ²	P-No.
1						
2						

Remarks:.....

POWDER ON POWDER – CLASS 2						
DECORATION		Powder supplier (name)	BASE COATING		TOP COATING	
			Product code of the powder coating ²	P-No.	Product code of the powder coating ²	P-No.
1						
2						

Remarks:.....

² Identification of the powder coating (including colour) as indicated on the product package.

Report no. _____

G) OTHERS

► **Technical data sheets**

SUBLIMATION		
	FILM	POWDER COATING
Date of the latest version		
Is all the information necessary for correct application of the products available?	YES <input type="checkbox"/> NO <input type="checkbox"/>	YES <input type="checkbox"/> NO <input type="checkbox"/>

POWDER ON POWDER		
	BASE COATING	TOP COATING
Date of the latest version		
Is all the information necessary for correct application of the products available?	YES <input type="checkbox"/> NO <input type="checkbox"/>	YES <input type="checkbox"/> NO <input type="checkbox"/>

► **Storage as specified in the film and powder coating manufacturers' instructions?**

YES ☐ NO ☐

► **Complaint book available?**

YES ☐ NO ☐

► **Relevant standards or written instructions to carry out the tests available?**

YES ☐ NO ☐

► **Use of the label**

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

YES ☐ NO ☐

If not, why? :

Inspector's signature

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Date :

Enclosures :

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General Licensee's recommendation to QUALICOAT

☐ Result satisfactory

☐ Result unsatisfactory (specify)

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Date:

Signature: