

Master Inspection Report

(Powder Manufacturer)

Author: Powders WG

Document Code: F-MIR-Powd

QQM Section: 9.4.3.2

Date Approved: 14.03.2025

Approved by: EC

Valid from: 14.03.2025

Version: 07

No. Pages: 11

COMPANY

Name

Phone

E-mail

Contact person

Address Production Sites

INSPECTION POWDER MANUFACTURER PLANT

Date of Inspection

Report No.:

Type of Inspection

Granting ☐Renewal ☐Repetition ☐

Date of last Inspection

Issues during last inspection

Testing Laboratory

Name of inspector

1.

2.

LABORATORY EQUIPMENT (QCT Specifications Vol. 3, Ch. 3)

1 APPARATUS FOR MEASURING THICKNESS AND GLOSS

1.1 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 : $< 60 \pm 1$				
- Set-up III : $\geq 60 \pm 2$				
Function	☐ correct	☐ incorrect	☐ correct	☐ incorrect
Remarks				

1.2 Specular glossmeter (ISO 2813)

Verify the calibration of the instrument

Make		Model		No	
Function	☐ correct	☐ incorrect	(± 2 units)		
Remarks					

2 APPARATUS FOR MECHANICAL TESTS

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

2.1 Apparatus for bend test (ISO 1519)

Make		Model		No	
Visual assessment	☐ good	☐ not good			
Function	☐ correct	☐ incorrect			
Remarks					

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

Make		Model		No	
Visual assessment	☐ good	☐ not good			
Function	☐ correct	☐ incorrect			
Adhesive tape available	Yes	No			
	☐	☐			
Distances between cuts		mm			
Remarks					

2.3 Indenter (ISO 2815)

Make		Model		No	
Visual assessment	☐ good	☐ not good			
Function	☐ correct	☐ incorrect			
Remarks					

2.4 Cupping tester (ISO 1520)

Make

Model

No

Visual
assessment☐

good

☐

not good

Function

☐

correct

☐

incorrect

Remarks

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

Make

Model

No

Visual
assessment☐

good

☐

not good

Function

☐

correct

☐

incorrect

Remarks

2.6 Apparatus for T bend test (EN 13523-7) only for postforming

Make

Model

No

Visual
assessment☐

good

☐

not good

Function

☐

correct

☐

incorrect

Remarks

3 OTHER APPARATUS

3.1 Recorder for stoving temperature

Make		Model		No	
Function	☐ correct	☐ incorrect	Last service / calibration dates		
Remarks					

3.2 Apparatus for the accelerated weathering test with Xenon-arc lamps (ISO 16474-2)

This test can be outsourced to another production site or to a QUALICOAT accredited and approved laboratory that has the apparatus.

Make		Model		No	
Function	☐ correct	☐ incorrect	Calibration of radiometer		
Remarks					

3.3 Spectrophotometer (ISO 11664-4)

Make		Model		No	
Function	☐ correct	☐ incorrect	Calibration date		
Remarks					

3.4 Light cabinet

Make		Model		No	
Light type	(D65/A/F2)				
Function	☐ correct	☐ incorrect			
Remarks					

3.5 RAL Cards

GL
(mandatory) ☐ Yes ☐ No

HR ☐ Yes ☐ No

Expiration dates (of 5 randomly chosen samples)

Remarks

--

3.6 Apparatus for Measuring the Particle Size

Make

--

Model

--

No

--

ISO norm used

--

Function

☐ correct ☐ incorrect

Remarks

--

3.7 System for checking Polymerisation (Optional)

- Is there a system for checking polymerisation?

☐ Yes ☐ No

- If yes, which method is used?

Specify:

--

PRODUCTS

4 TESTING OF PRODUCTS DURING PRODUCTION

At least once per pre-mix (can be done before or after the milling, depending on the test)

Tests	QCT Specifications	Yes	No
Gloss	Vol. 3, Ch. 4 (3.B)	☐	☐
Coating thickness	Vol. 3, Ch. 4 (3.C)	☐	☐
Bend test	Vol. 3, Ch. 4 (3.G)	☐	☐
T Bend test (for postforming)	Vol. 3, Ch. 4 (3.H)	☐	☐
Impact test	Vol. 3, Ch. 4 (3.I)	☐	☐
Colour	Vol. 3, Ch. 4 (3.A)	☐	☐
Particle size		☐	☐

Remarks

TECHNICAL (QCT Specifications Vol. 3 Ch. 6)

5 TECHNICAL INFORMATION

5.1 Technical data sheet (TDS)

If the powder manufacturer has more than 5 approved systems, the inspector shall select 5 TDS from different P-No's or PF-No's.

Does the TDS contain the following information?

P-No. / PF-No										
Issue Date TDS										
Requirement	YES	NO	YES	NO	YES	NO	YES	NO	YES	NO
The P-No. or PF-No. in combination with the word QUALICOAT	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐
Product description	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐
Curing conditions (<i>min. two different temperatures with min. and max. curing time for each temperature</i>)	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐
Shelf life and maximum storage temperature	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐
T Bend value and max. impact value (<i>only for postforming</i>)	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐

Remarks

5.2 Powder box label

If the powder manufacturer has more than 5 approved systems, the inspector shall select **5 labels** from different P-No's or PF-No's.

Does the label contain the following information?

P-No. / PF-No										
Requirement	YES	NO	YES	NO	YES	NO	YES	NO	YES	NO
The P-No. or PF-No. in combination with the word QUALICOAT	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐
Colour description and product code	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐
Curing conditions (<i>min. two different temperatures with min. and max. curing time for each temperature</i>)	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐
Expiry date / Best before date at <YY°C	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐
Gloss value	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐
Batch number	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐

Remarks

5.3 Use of the logo on labels and TDS

Does the powder manufacturer use the QUALICOAT logo in accordance with QUALICOAT Specifications, Vol. 3, Ch. 7?

☐ Yes ☐ No

Remarks

SUMMARY

6 Summarizing sheet

Form to be completed at the end of an inspection

SUMMARY OF INSPECTION	ISSUES AND/OR NON-CONFORMITIES	POWDER MANUFACTURER'S REMARKS
LABORATORY EQUIPMENT (MIR-Powd Section 1-3)		
PRODUCTS (MIR-Powd Section 4)		
TECHNICAL (MIR-Powd Section 5)		

Date

Signature of the powder manufacturer's
representative (e-signature or original signature)

Date

Inspector's signature
(e-signature or original signature)

General licensee's recommendation to QUALICOAT

☐ Result satisfactory ☐ Result unsatisfactoryReason for
unsatisfactory
result

Date

General Licensee
(e-signature or original signature)