

Update sheet No. 2022/001 to the Technical Specifications Version 4.2. – July 2021

Applicable from the 1st of January 2023

Subject

CONTROL OF CONVERSION LAYER

Proposal/Request

Revision of table in § 3.5.3. concerning the control of the conversion layer.

Qualisteelcoat resolution

No. 38/10.06.2020: The TC decided that the required tests “assessment of conversion layer” and “weight of the conversion layer” will be assembled as “control of conversion layer” in the specifications 3.5.3 and the test report and shall be done according to the chemical supplier’s regulations.

Approved

05.10.2022 by Executive Committee

Amendments to the specifications

Amendments in

§3.5.3 Quality control for chemical pre-treatment
and § 6.6. Assessment of the conversion layer

3.5.3 Quality control for chemical pre-treatment process

The coater must check his production methods and products **per the chemical supplier's recommendations** but at least per the following frequency.

required test	C1 – C2	C3 – C5
coatability of parts	every lot	
concentration of pre-treatment process baths per the supplier's instructions		once per day
assessment of pH value of baths per the supplier's instructions	once per day	once per shift
conductivity of rinsing water (last rinse)		once per shift
temperature of pre-treatment process baths	once per day	
content of Zn and Al with a method according to the supplier's recommendations		once per day
drying temperature		once per day
assessment of the zinc layer thickness after pickling (only for hot-dip galvanized steel)		once per shift
assessment-control of conversion coatinglayer		visual once per shift, and chrome-free once per month specified by regulations of the supplier of the chemical conversion products
weight of the conversion layer		once per month
surface preparation		visual

6.6 Assessment of the conversion coating

The assessment for quality control of conversion coatings varies a lot for each system and different suppliers. ~~The minimum requirements are defined in chapter 3.5.3~~ The supplier of the chemical products for the conversion layer provides the necessary test methods and frequency of testing.

Requirements:

The chemical supplier's ~~specifications~~recommendations about the test method and, frequency ~~and the minimum requirements of this specification.~~

The licence holder records the test results and the corrective actions of the pre-treatment line in order to meet the required result.