



Update of QUALICOAT Specifications 2022 Update Sheet No. 09 (V02) applicable from 1 July 2023

Subject: Coating Line Inspection Process

Proposals/Requests: **Ad-hoc Coating Lines WG** (9 March, 11 & 27 April and 6 May 2022)

- To eliminate ambiguities in the inspection process and standardize terminology

Resolution No. 11/ TC 2022-05-19

The TC approved the proposals of the Coating Lines Ad-hoc WG.

Resolution No. 6/TC 16.11.22

QUALICOAT Resolution: The TC approved update sheet No. 9 -Coating Lines Inspection Process, as amended at the meeting. The date of implementation will be 1 July 2023. The current rule concerning negative inspection on one of the lines in a multi coating lines company shall be addressed by the ad-hoc Coating Lines WG before the next TC meeting.

Amendment to the Specifications:

- Throughout the Specifications:
 - 'Coating applicator' shall be replaced by 'Licensee'
 - 'Plant installation' shall be replaced by 'Production site'
- Chapter 1: Terminology updates on 'licence' and 'licensee' with new terminologies added i.e., 'pretreatment cycle' and 'production site'.
- Chapter 5:
 - Update in licence granting procedures, with requisite for annual submission of the 'General Data of Licensee' form
 - Procedure to verify and inspect all coating lines operated at the production site (a licence is valid for the production site inspected)
 - Procedure in case a coating line is out of operation
- Appendix A1: Paraphrasing of '5.2. Use of the logo by coaters'

REMARKS:

Following amendments were made for the sake of clarity after EC ratification. (March 2023) - Verified by MKR:

- Introduction of new subtitles with reordering of selected passages.
- Paragraphs are numbered or renumbered for alignment.

No amendments were made to the content.

Author: QCT Specifications WG
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<p>1. General Information</p>	<p>Scope of the Specifications</p> <p>[...]</p> <p>The aim of these Specifications is to establish minimum requirements that plant installations production sites, coating lines, organic coating materials, chemical conversion materials, processes and finished products shall meet.</p> <p>These Specifications form the basis for granting and renewing the quality label. All requirements in these Specifications shall be met before a quality label can be granted. In case of ambiguities or uncertainties in any part of the Specifications, clarification shall be requested from QUALICOAT.</p> <p>The Specifications for plant installations production sites and coating lines are the minimum requirements for producing good quality. Other methods may only be used if they have been previously approved by QUALICOAT.</p> <p>Release and revision of the Specifications</p> <p>[...]</p> <p>The Specifications and update sheets are published on the Internet (www.qualicoat.net). They shall also be communicated to all licensed coating applicators licensees and to holders of an approval.</p> <p>[...]</p> <p>Coating and pretreatment materials</p> <p>Coating applicators Licensees holding the quality label shall treat all products intended for architectural applications in accordance with these Specifications and shall only use organic coating materials and chemical conversion materials approved by QUALICOAT for such products. For external architectural applications, other materials may be used only at the customer's written request and only if there are technical reasons for doing so. It is not permitted to use unapproved materials for commercial reasons.</p>	<p>---</p>

Reference (SPEC 2022 – V02)	Amendments	Remarks
<p>1. Terminology</p>	<p>Approval: Confirmation that a specific material (coating or chemical conversion) meets the requirements of the QUALICOAT Specifications.</p> <p>Coating applicator: Company that has one or several plant installations.</p> <p>Plant installation: A production site with one or more coating lines used for coating aluminium for architectural applications.</p> <p>Coating line: A production line used for coating aluminium for architectural applications that includes a single pretreatment cycle (surface preparation, conversion coating and drying) and a coating cycle (one or more spraying booths and ovens).</p> <p>Continuous line: A production line where parts are pretreated, coated and cured without intermediate handling.</p> <p>Curing index: A numerical index of cure value that quantifies directly from the curing graph the total coating cure experienced against the coating supplier's paint cure schedule</p> <p>Licence/Sub-licence: Permission to use the quality label in accordance with the QUALICOAT Specifications for all coatings on aluminium for architectural applications produced on the coating line(s) at the production site inspected.</p> <p>Licensee/Sub-licensee: Holder of the licence. The legal entity operating the inspected production site, holding the QUALICOAT licence for this specific production site and acting as this specific licensee on the market. This means marketing all coatings on architectural aluminium produced at this production site using the QUALICOAT label in accordance with the Specifications. The same legal entity may also operate other production sites and hold separate QUALICOAT licences for these.</p> <p>General licence: Permission to grant licences and approvals in a certain territory.</p> <p>General Licensee (GL): National or international association holding the QUALICOAT general licence for a defined territory.</p> <p>Pretreatment cycle: A system of tanks for spray or dipping application of chemicals, rinses and/or electrochemical processes, creating a process sequence for pretreating the workpieces to be coated. A single pretreatment cycle comprises one specific chemical conversion coating step or — in the case of pre-anodising — the pre-anodising bath.</p>	<p>Terminologies reordered by alpha</p>

Reference (SPEC 2022 – V02)	Amendments	Remarks																	
<p>(continued)</p> <p>1. Terminology</p>	<p>Production site A production facility for coating materials, chemicals, or coatings. In the case of a coating facility, the licensee may operate one or several coating lines in a production site. A production site shall have a distinct postal address.</p> <p>Testing laboratories: Independent quality testing and/or inspection bodies duly authorised by the General Licensee or QUALICOAT.</p>	<p>---</p>																	
<p>2. Test Methods and Requirements</p>	<p>[...]</p> <p>For the corrosion tests (§ 2.10 and 2.11), the test samples shall be made of AA 6060 or AA 6063. If the main production in the plant on a coating line is on sheets or alloys other than AA6060 or AA6063, the corrosion tests will be carried out on the material actually used.</p>	<p>---</p>																	
<p>2.19. Filiform corrosion test</p>	<p>[...]</p> <p>Final assessment of the FFC test:</p> <table border="1" data-bbox="336 860 1214 1469"> <thead> <tr> <th rowspan="2">RATING</th> <th colspan="2">GRANTING / RENEWAL OF</th> </tr> <tr> <th>APPROVAL OF PRETREATMENT SYSTEMS</th> <th>SEASIDE ENDORSEMENT</th> </tr> </thead> <tbody> <tr> <td>A</td> <td>Satisfactory</td> <td>Satisfactory</td> </tr> <tr> <td>B</td> <td>Satisfactory</td> <td>Satisfactory with a comment to the coating applicator licensee</td> </tr> <tr> <td>C</td> <td> Unsatisfactory <ul style="list-style-type: none"> ▶ Repetition of the filiform corrosion test. ▶ If the result of this second test is C or D, all tests shall be repeated. </td> <td> Unsatisfactory <ul style="list-style-type: none"> ▶ Repetition of the filiform corrosion test ▶ If the result of this second test is C or D, the inspection shall be repeated. </td> </tr> <tr> <td>D</td> <td> Unsatisfactory <ul style="list-style-type: none"> ▶ All laboratory tests shall be repeated. </td> <td> Unsatisfactory <ul style="list-style-type: none"> ▶ Another complete and unannounced inspection including SEASIDE shall be conducted. </td> </tr> </tbody> </table>	RATING	GRANTING / RENEWAL OF		APPROVAL OF PRETREATMENT SYSTEMS	SEASIDE ENDORSEMENT	A	Satisfactory	Satisfactory	B	Satisfactory	Satisfactory with a comment to the coating applicator licensee	C	Unsatisfactory <ul style="list-style-type: none"> ▶ Repetition of the filiform corrosion test. ▶ If the result of this second test is C or D, all tests shall be repeated. 	Unsatisfactory <ul style="list-style-type: none"> ▶ Repetition of the filiform corrosion test ▶ If the result of this second test is C or D, the inspection shall be repeated. 	D	Unsatisfactory <ul style="list-style-type: none"> ▶ All laboratory tests shall be repeated. 	Unsatisfactory <ul style="list-style-type: none"> ▶ Another complete and unannounced inspection including SEASIDE shall be conducted. 	<p>---</p>
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<p>3.2.1 Etching stage</p>	<p>[...]</p> <p>The etching degree is measured by taking the weight of a test sample before and after etching. If a sample cannot be taken, the method used to measure the etching degree shall be defined in agreement with the General Licensee or directly with QUALICOAT in countries without a General Licensee. Any new plant installation coating line shall be designed to allow sampling after each stage of the chemical treatment.</p> <p>The etching degree is measured on extruded sections of alloy AA6060 or AA6063. If the main production in the plants on a coating line is on sheets or alloys other than AA6060 or AA6063 the inspector should also check the etching degree with the material actually used.</p> <p>[...]</p> <p>Coating applicators Licensees who wish to have the endorsement SEASIDE on their licence certificate shall apply to their General Licensee or directly to QUALICOAT in countries without a General Licensee.</p>	<p>---</p>																	

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3.3.2 Chemical pretreatments	<p>[...]</p> <p>The coating applicators licensees shall use the products as described in the technical data sheet and in the instructions provided for the specific plant coating line by the chemical manufacturer(s) concerning the methods for assessing the quality of the chrome VI-free conversion coating, the device prescribed for analytically determining the coating weight, and the in-house control frequencies. These specific instructions shall be accessible to the inspector.</p>	---
3.4. Anodic pretreatment (automatic SEASIDE endorsement)	<p>Record of test results</p> <p>Coating applicators Licensees using this type of anodic pretreatment shall perform and record the following additional tests: [...]</p> <p>[...]</p> <p>Coating applicators Licensees using anodic pretreatment, as specified above, shall ask their coating suppliers to confirm in writing the compatibility of their coating system with this type of pretreatment.</p>	---
3.6. Drying	<p>After chemical pretreatment and before the application of organic coating, the products shall be dried thoroughly in an oven. For this purpose, a drying oven shall be installed in each plant prior to the coating cycle.</p>	---
3.7.1. Coating	<p>For architectural applications the coating plant installation licensee shall use only organic coatings approved by QUALICOAT in accordance with <u>Chapter 4</u> “Approval of Organic Coatings”.</p> <p><u>Best before date expiry</u></p> <p>At the coating applicator's licensee's request, permission to extend the use of expired powders may be given by the powder manufacturer. It is the powder manufacturer's responsibility to stipulate which additional tests need to be carried out either by themselves or by the coating applicator licensee. Following satisfactory results, the powder manufacturer shall give written permission to the coater indicating the new “best before” date.</p>	---
3.8. Laboratory	<p>The coating plant installation production site shall have laboratory facilities which are separate from the production facilities. The laboratory shall have the apparatus and chemicals necessary for testing and controlling the process solutions and finished products. The laboratory shall at least be equipped with the following apparatus and equipment: [...]</p>	---
3.9. In-house control	<p>Coating plant installations Licensees holding the quality label shall monitor their production processes and inspect their finished products in accordance with <u>Chapter 6</u>.</p>	---
3.10. Operation Instructions	<p>For every test the coating plant installation licensee shall have the relevant standards or operating instructions based on these standards. These standards or operating instructions shall be available to all operators carrying out the tests.</p>	---
3.11. Registers	<p>The coating plant installation licensee shall maintain registers for: [...]</p>	---
4. Approval of Organic Coatings	<p>[...]</p> <p>When a two-coat organic coating material (primer and coloured topcoat) approved by QUALICOAT is used, the coating plant licensee may apply either a class 1, 1.5 or class 2 topcoat on the approved primer provided that the powder supplier gives written authorisation for it. It is not necessary to have an approval for each combination. However the organic coating material (primer and coloured topcoat) used by the coating plant installation licensee shall originate from the same manufacturer.</p>	---


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<p>4.1.7. Assessment of test results</p>	<p>[...]</p> <p>The table below shows the different deadlines until when the powder manufacturer may still produce and sell the different colours and until when a coating-applicator licensee may use them.</p> <table border="1" data-bbox="336 450 1217 768"> <thead> <tr> <th colspan="6">DEADLINES</th> </tr> <tr> <th colspan="2">Production of QUALICOAT approved products</th> <th colspan="2">Sale of QUALICOAT approved products</th> <th colspan="2">Use of QUALICOAT approved products by coating-applicator licensee</th> </tr> <tr> <th>Single failed basic colour</th> <th>Remaining colours</th> <th>Single failed basic colour</th> <th>Remaining colours</th> <th>Single failed basic colour</th> <th>Remaining colours</th> </tr> </thead> <tbody> <tr> <td>30.09.xx</td> <td>31.12.xx</td> <td>30.03.yy</td> <td>30.03.yy</td> <td colspan="2">End of original shelf life</td> </tr> </tbody> </table> <p>xx = current year yy = following year</p>	DEADLINES						Production of QUALICOAT approved products		Sale of QUALICOAT approved products		Use of QUALICOAT approved products by coating-applicator licensee		Single failed basic colour	Remaining colours	Single failed basic colour	Remaining colours	Single failed basic colour	Remaining colours	30.09.xx	31.12.xx	30.03.yy	30.03.yy	End of original shelf life		<p>---</p>																								
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<p>4.2.2. Sampling</p>	<p>[...]</p> <p>There are three options for sampling systems to be tested for renewal of approvals:</p> <ul style="list-style-type: none"> - The inspector takes samples of the required colours during routine inspections at the coating-plants coaters' production sites. <p>[...]</p> <p>The coating material may be applied to the test panels in the testing laboratory, at a local licensed coater's plant production site or at the coating manufacturer's premises under the auspices of the inspector according to § 4.1.6.</p>	<p>---</p>																																																
<p>4.2.5 Banned colours</p>	<p>[...]</p> <p>The tables below show the different deadlines until when the powder manufacturer may still produce and sell a single failed colour or a banned colour family and until when a coating-applicator licensee may use it.</p> <p><u>For all classes</u></p> <table border="1" data-bbox="336 1252 1217 1570"> <thead> <tr> <th colspan="6">DEADLINES</th> </tr> <tr> <th colspan="2">Production of QUALICOAT approved products</th> <th colspan="2">Sale of QUALICOAT approved products</th> <th colspan="2">Use of QUALICOAT approved products by coating-applicator licensee</th> </tr> <tr> <th>Single failed colour</th> <th>Remaining colours</th> <th>Single failed colour</th> <th>Remaining colours</th> <th>Single failed colour</th> <th>Remaining colours</th> </tr> </thead> <tbody> <tr> <td>30.09.xx</td> <td>----</td> <td>30.03.yy</td> <td>---</td> <td>End of original shelf life</td> <td>---</td> </tr> </tbody> </table> <p>xx = current year yy = following year</p> <p><u>For a class 2 or 3 banned colour family</u></p> <table border="1" data-bbox="336 1655 1217 1973"> <thead> <tr> <th colspan="6">DEADLINES</th> </tr> <tr> <th colspan="2">Production of QUALICOAT approved products</th> <th colspan="2">Sale of QUALICOAT approved products</th> <th colspan="2">Use of QUALICOAT approved products by coating-applicator licensee</th> </tr> <tr> <th>Single failed colour</th> <th>Remaining colours of the banned family</th> <th>Single failed colour</th> <th>Remaining colours of the banned family</th> <th>Single failed colour</th> <th>Remaining colours of the banned family</th> </tr> </thead> <tbody> <tr> <td>30.09.xx</td> <td>31.12.xx</td> <td>30.03.yy</td> <td>30.03.yy</td> <td colspan="2">End of original shelf life</td> </tr> </tbody> </table> <p>xx = current year yy = following year</p>	DEADLINES						Production of QUALICOAT approved products		Sale of QUALICOAT approved products		Use of QUALICOAT approved products by coating-applicator licensee		Single failed colour	Remaining colours	Single failed colour	Remaining colours	Single failed colour	Remaining colours	30.09.xx	----	30.03.yy	---	End of original shelf life	---	DEADLINES						Production of QUALICOAT approved products		Sale of QUALICOAT approved products		Use of QUALICOAT approved products by coating-applicator licensee		Single failed colour	Remaining colours of the banned family	Single failed colour	Remaining colours of the banned family	Single failed colour	Remaining colours of the banned family	30.09.xx	31.12.xx	30.03.yy	30.03.yy	End of original shelf life		<p>---</p>
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<p>4.2.7.1. Withdrawal by QUALICOAT</p>	<p>[...] The table below shows the different deadlines until when the powder manufacturer may still produce and sell a single failed colour and until when a coating-applicator licensee may use it.</p> <table border="1" data-bbox="336 456 1217 719"> <thead> <tr> <th colspan="6" data-bbox="336 456 1217 495">DEADLINES</th> </tr> <tr> <th colspan="2" data-bbox="336 495 619 577">Production of QUALICOAT approved products</th> <th colspan="2" data-bbox="619 495 901 577">Sale of QUALICOAT approved products</th> <th colspan="2" data-bbox="901 495 1217 577">Use of QUALICOAT approved products by coating-applicator licensee</th> </tr> <tr> <th data-bbox="336 577 464 660">Single failed colour</th> <th data-bbox="464 577 619 660">Remaining colours</th> <th data-bbox="619 577 746 660">Single failed colour</th> <th data-bbox="746 577 901 660">Remaining colours</th> <th data-bbox="901 577 1061 660">Single failed colour</th> <th data-bbox="1061 577 1217 660">Remaining colours</th> </tr> </thead> <tbody> <tr> <td data-bbox="336 660 464 719">30.09.xx</td> <td data-bbox="464 660 619 719">31.12.xx</td> <td data-bbox="619 660 746 719">30.03.yy</td> <td data-bbox="746 660 901 719">30.03.yy</td> <td colspan="2" data-bbox="901 660 1217 719">End of original shelf life</td> </tr> </tbody> </table>	DEADLINES						Production of QUALICOAT approved products		Sale of QUALICOAT approved products		Use of QUALICOAT approved products by coating-applicator licensee		Single failed colour	Remaining colours	Single failed colour	Remaining colours	Single failed colour	Remaining colours	30.09.xx	31.12.xx	30.03.yy	30.03.yy	End of original shelf life		<p>---</p>
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<p>4.2.7.2. Voluntary withdrawal</p>	<p>[...] The table below depicts the different deadlines that determine until when a powder manufacturer may still produce and sell a withdrawn product, and until when a coating-applicator licensee may use it:</p> <table border="1" data-bbox="336 882 1217 1050"> <thead> <tr> <th data-bbox="336 882 624 965">Withdrawal request</th> <th data-bbox="624 882 820 965">Deadline for stopping production</th> <th data-bbox="820 882 997 965">Deadline for stopping sale</th> <th data-bbox="997 882 1217 965">Use of product by coating-applicator licensee</th> </tr> </thead> <tbody> <tr> <td data-bbox="336 965 624 1050">January – December XX</td> <td data-bbox="624 965 820 1050">Date of withdrawal request</td> <td data-bbox="820 965 997 1050">30.03.YY</td> <td data-bbox="997 965 1217 1050">End of original shelf life</td> </tr> </tbody> </table>	Withdrawal request	Deadline for stopping production	Deadline for stopping sale	Use of product by coating-applicator licensee	January – December XX	Date of withdrawal request	30.03.YY	End of original shelf life	<p>---</p>																
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<p>Chapter 5 (Cover page header)</p>	<p>Chapter 5 Licensing of Coating Applicators Coaters' Production Sites</p>	<p>---</p>																								
<p>5. Licensing of Coating Applicators</p>	<p>5. Licensing of Coating Applicators Coaters' Production Sites</p> <p>This chapter specifies the procedure for granting a licence to a coater for one production site.</p> <p>The procedures for granting and renewing a licence to coating-applicators coaters applying decoration are set out in a separate document available on the QUALICOAT Website.</p> <p>General data on production site</p> <p>Prior to the first inspection in the granting process, the applicant shall fill in the form 'General Data of Licensee' providing detailed information about the production site that the licence is being applied for. The applicant shall submit the form to the General Licensee, or to QUALICOAT in countries without GL.</p> <p>The same obligation applies to licensees, who shall fill out the form and submit it as described above by the end of each calendar year. Having received such information, the General Licensee shall forward this document to QUALICOAT. The General Licensee, or QUALICOAT in countries without GL, shall forward the information about the production site to the inspector, and also to the testing institute commissioned with carrying out the inspections.</p> <p>The licensee shall mark all coating lines used for the coating of aluminium for architectural applications with their respective designation as listed in the form 'General Data of Licensee' so that the lines are clearly identifiable for the inspector.</p> <p>The licensee shall immediately inform the General Licensee (respectively QUALICOAT in countries where there is no General Licensee) about any changes relevant for the 'General Data of Licensees', e.g., in the event that a coating line is no longer used for coating of aluminium for architectural applications or if an additional coating line is used for coating of aluminium for architectural applications.</p>	<p>Subtitle added:</p> <ul style="list-style-type: none"> • General data on production site <p>Two sentences of the former introduction text were removed to:</p> <p>'5.1 Granting of a licence (quality label) <i>A preliminary inspection can be requested by the applicant but in this case the results cannot be used for granting the licence.'</i></p> <p>'5.7 Training of Licensees <i>Training for staff of licensed coating plants is mandatory in all countries. This training shall be organised regularly by the General Licensees or QUALICOAT.'</i></p>																								

Reference (SPEC 2022 – V02)	Amendments	Remarks
5.1. Granting of a licence (quality label)	<p>5.1. Granting of a licence (quality label)</p> <p>A preliminary inspection can be requested by the applicant but in this case the results cannot be used for granting the licence.</p> <p>Every coating line as defined in these Specifications shall be checked inspected in order for a QUALICOAT licence to be granted.</p> <p>Two inspections shall be satisfactory before a licence is granted. These inspections will be made at the coating applicator's coater's request. The first inspection will be conducted by appointment. The second will be unannounced and will only take place once all the results of the first inspection (including the acetic acid salt spray resistance test) have been found satisfactory.</p> <p>The inspectors shall take along the following equipment:</p> <ul style="list-style-type: none"> - Thickness meter - Conductivity meter - Calibration tools for the other tests stipulated <p>5.1.1. Verification of the data concerning the coating lines</p> <p>The inspector shall verify the plausibility of the data provided by the applicant regarding the coating lines operated at the production site and their use for coatings on aluminium for architectural applications. He shall produce a separate inspection report for each coating line inspected and shall indicate the designation of the respective coating line as marked on site.</p> <p>The inspector shall visually check what kind of parts are produced on the coating lines, especially on those that are not listed for inspection. If these lines produce coatings on typical architectural products like extrusions or sheets, the inspector shall ask for an explanation why these products are not to be considered architectural. If no sufficient explanation can be given by the coater, the inspector shall make a remark in the inspection report.</p> <p>The inspector shall check the following using the inspection form approved by QUALICOAT.</p>	<p>Following sentence taken from the former introduction:</p> <p><i>'A preliminary inspection can be requested by the applicant but in this case the results cannot be used for granting the licence'</i></p> <p>Subtitle added:</p> <ul style="list-style-type: none"> • 5.1.1. Verification of the data concerning the coating lines
5.1.1. Inspection of materials	<p>5.1.1. 5.1.2. Inspection of materials</p> <p>The inspector will check that for outside architectural applications the coating plant installation coater uses organic coating materials approved by QUALICOAT. If chemical materials other than the chromate conversion coating described in 3.3.1 are used, he shall also check that these chemical materials are approved by QUALICOAT.</p>	<p>---</p>
5.1.5. Inspection of finished products	<p>5.1.5. 5.1.6. Inspection of finished products</p> <p>Only finished products which have been released by the coating applicator coater are to be tested (all parts ready for dispatch are deemed to have been released by the coating applicator coater). [...]</p> <p>[...]</p> <p>(¹) Lot: 1 lot represents a customer's complete order in one colour or that part of the order which is in the coating plant installation production site.</p>	<p>---</p>
5.1.7. Review of in-house control and registers	<p>5.1.7. 5.1.8. Review of in-house control and registers</p> <p>The inspector will check that in-house control has been carried out in accordance with § 3.9 and that the coating plant installation coater maintains registers according to § 3.11.</p>	<p>---</p>
5.1.8. Final assessment for granting the licence	<p>5.1.8. 5.1.9. Final assessment for granting the licence</p> <p>[...]</p> <ul style="list-style-type: none"> • If the results of one of the two inspections do not meet the requirements, the coating applicator coater will be informed that the licence to use the quality label cannot be granted for the time being, stating reasons. The coating applicator coater shall wait at least three months before making a new application for a licence. 	<p>---</p>

Reference (SPEC 2022 – V02)	Amendments	Remarks
<p>5.1.9. “SEASIDE” endorsement</p>	<p>5.1.9. 5.1.10. “SEASIDE” endorsement</p> <p>If the coating applicator coater has applied for the endorsement SEASIDE an inspection shall be carried out following the specifications as set out in § 3.2.1 or § 3.4., and a filiform corrosion test(s) shall be carried out on finished products (§ 2.19) with every type of pretreatment the coater wishes to use for SEASIDE.</p> <p>If the results of the inspection meet the requirements, the “SEASIDE” endorsement shall be granted. A specific QUALICOAT SEASIDE certificate shall be issued stating that the coating plant installation licensee is able to produce finished products that meet the SEASIDE requirements.</p> <p>If the results of the inspection do not meet the requirements, the coater shall wait at least three months before making a new application for a “SEASIDE” endorsement.</p>	
<p>5.2. Routine inspections of licensees</p>	<p>After a coating applicator coater has been granted a licence to use the quality label, this licence shall be renewed if the results of at least two inspections per year meet the requirements.</p> <p>Every coating line shall be checked inspected twice a year in order for a QUALICOAT licence to be renewed.</p> <p>Routine inspections shall be made without prior notice. Inspectors will only be authorised by the GL or QUALICOAT Secretariat to announce an inspection in the case of travel safety issues or visa problems.</p> <p>Licensees shall immediately inform the General Licensee, or QUALICOAT in countries without GL, in case a coating line is out of operation, regardless of whether planned or due to a technical failure.</p> <p>5.2.1. Verification of the data concerning the coating lines</p> <p>The inspector shall verify the plausibility of the data provided by the licensee regarding the coating lines operated at the production site and their use for coatings on aluminium for architectural applications.</p> <p>He shall produce a separate inspection report for each coating line inspected and indicate the designation of the respective coating line as marked on site.</p> <p>The inspector shall visually check what kind of parts are produced on the coating lines, especially on those coating lines that are not listed for inspection.</p> <p>In case these lines produce coatings on typical architectural products like extrusions or sheets, the inspector shall ask for an explanation why these products are not to be considered architectural. If no sufficient explanation can be given by the coater, the inspector shall make a remark in the inspection report.</p> <p>5.2.2. Inspectors’ equipment and checklists</p> <p>The inspectors shall take along the following equipment:</p> <p>[...]</p> <p>The inspector shall check the following using the inspection form approved by QUALICOAT:</p> <p>[...]</p> <p>5.2.3. Corrosion tests</p> <p>5.2.3.1. Machu test</p> <p>During the first inspection of the year, the Machu test is carried out prior to the acetic acid salt spray test.</p> <p>[...]</p> <p>5.2.3.2. Acetic salt spray test and Filiform corrosion test</p> <p>Samples for the acetic acid salt spray test and the filiform corrosion test (in the case of SEASIDE) shall be taken during the first inspection of the year.</p> <p>5.2.3.3. Special cases</p> <p>Unforeseen problems during renewal inspections</p> <p>In cases of unforeseen problems arising at short notice, or in the case that a pretreatment cycle is not in use on the day of the inspection when AASS, FFC, and/or Machu test samples are to be taken, the following rule shall apply:</p>	<p>Subtitles added:</p> <ul style="list-style-type: none"> • 5.2.1. Verification of the data concerning the coating lines • 5.2.2. Inspectors’ equipment and checklists • 5.2.3. Corrosion tests • 5.2.3.2. Acetic salt spray test and Filiform corrosion test • 5.2.3.3. Special cases <ul style="list-style-type: none"> - Unforeseen problems - Anodic pretreatment

Reference (SPEC 2022 – V02)	Amendments	Remarks
<p>(continued)</p> <p>5.2. Routine inspections of licensees</p>	<ul style="list-style-type: none"> The inspector shall fill in the inspection report on the basis of the documentation of the in-house control and shall take the samples for corrosion tests from finished products. If such samples are not available on the day of the inspection, the licensee shall send such samples to the testing institute within one month from the inspection date. If the licensee fails to do so, the inspection shall be evaluated as 'not satisfactory'. <p>Anodic pretreatment</p> <p>For lines where parts with chemical conversion as well as parts with anodic pretreatment are coated, the following rule shall apply:</p> <ul style="list-style-type: none"> During the first inspection of the year, samples for the acetic acid salt spray test and the filiform corrosion test (if the licensee uses chemical conversion for SEASIDE as well) shall be taken on parts with chemical conversion and a separate report shall be filled in. Also during the first inspection of the year, samples for the acetic acid salt spray test and the filiform corrosion test shall be taken on parts with anodic pretreatment and a separate report shall be filled in. During the second inspection of the year, also two reports will be filled in but the samples shall only be taken from the pretreatment that is in use on the day of the inspection. <p>The inspector shall submit the inspection reports to the General Licensee for the evaluation.</p> <p>5.2.4. Final assessment for renewing the licence</p> <p>[...]</p> <p>If the second inspection again produces unsatisfactory results, the licence to use the quality label will be withdrawn immediately. The coating-applicator coater shall wait at least three months before making a new application for a licence to use the quality label.</p> <p>5.2.5. Licences with the endorsement «SEASIDE»</p> <p>[...]</p> <p>If the second inspection again produces unsatisfactory results, the "SEASIDE" endorsement shall be withdrawn immediately. The coating-applicator coater shall wait at least three months before making a new application for a "SEASIDE" endorsement.</p> <p>5.2.6. Suspension of an inspection</p> <p>[...]</p>	<p>---</p>
<p>5.3. Coating applicator's right of appeal</p>	<p>5.3. Coating-applicator's Licensee's right of appeal</p> <p>The coating-plant licensee shall receive a copy of each inspection report. If the results do not meet the requirements, full details and reasons shall be given. The plant licensee shall be entitled to appeal within 10 days.</p>	<p>---</p>
<p>5.5. Deadline for submission of inspection reports</p>	<p>[...]</p> <p>If a plant production site inspection was unsatisfactory, the General Licensees shall send the report to QUALICOAT's Secretariat within one month after the inspection.</p>	<p>---</p>
<p>5.6. Use of the logo by coating applicators</p>	<p>5.6. Use of the logo by coating-applicators licensees</p> <p>The use of the logo shall comply with the Regulations for use of the QUALICOAT quality label (Appendix A1).</p>	<p>---</p>
<p>---</p>	<p>5.7. Training of licensees</p> <p>Training for staff of licensed coating-plants production sites is mandatory in all countries. This training shall be organised regularly by the General Licensees or QUALICOAT.</p>	<p>New section and subtitle added:</p> <ul style="list-style-type: none"> 5.7. Training of licensees

Reference (SPEC 2022 – V02)	Amendments	Remarks
6. Specifications for In-House Control	The aim of in-house control is to give the coating-plant licensee a tool to keep control over its own production process. The number of shifts worked, the requirements, the results of the analyses and corrective actions shall be entered in charts or some other records/registration systems readily accessible to the inspector.	---
6.2.1. Testing the etching degree	[...] If a licence has the SEASIDE endorsement, the coating-applicator licensee shall check the etching degree at least once in every working shift during SEASIDE production.	---
Appendix A1 5. Use of the logo by coating applicators and manufacturers	5. Use of the logo by coating-applicators coaters and manufacturers	---
Appendix A1 5.2. Use of the logo by coating applicators	5.2. Use of the logo by coating-applicators coaters By applying the logo to a product, the coating applicator guarantees that the quality of the finished product supplied Unless explicitly stated otherwise in individual cases, the licensee assures, by using the logo, that the quality of the entirety of coatings on aluminium for architectural applications produced at the licenced production site meets all the requirements of the Specifications. For applicators licensees that have more than one production site, the quality label shall only be used for the coating-plant installation production site for which the applicator licensee is holding the licence. The logo may be used on the products themselves, business stationery, quotations or invoices, price lists, cards, display boxes and on all company literature and brochures or in catalogues and newspaper advertisements. Whenever a coating-applicator licensee makes mention or reference to QUALICOAT, it shall systematically indicate its licence number. This shall apply both to the use of the logo and in texts.  Licence n° xxxx	---
Appendix A1 6.4. Use of the logo by interested third parties	[...] They shall request written authorisation which may be granted on condition that they: <ul style="list-style-type: none"> • undertake to use solely aluminium products coated by licensed-coating-plants licensees • undertake to submit all documents that refer to QUALICOAT to the GL for approval or directly to QUALICOAT in countries where there is no GL • undertake to undergo inspections and controls by the GL or QUALICOAT • Such authorisation may require payment of an annual fee 	---
Appendix A1 7. Conditions for granting and renewing approvals and licenses	As stipulated in <u>chapter 4</u> for coating manufacturers. As stipulated in <u>chapter 5</u> for coating-plant installation coaters' production sites. As stipulated in <u>Appendix A6</u> for manufacturers of chemical pretreatment materials The granting of an approval or licence shall require payment of an annual fee.	---

Reference (SPEC 2022 – V02)	Amendments	Remarks																		
<p>Appendix A2 List of currently approved procedures²⁰</p>	<table border="1"> <thead> <tr> <th data-bbox="331 322 469 398">CODE</th> <th data-bbox="469 322 1062 398">PROCEDURE</th> <th data-bbox="1062 322 1214 398">INTENDED FOR</th> </tr> </thead> <tbody> <tr> <td data-bbox="331 398 469 474">P-EVA</td> <td data-bbox="469 398 1062 474"> Procedure for evaluating inspection results List of failures to be considered nonconformities </td> <td data-bbox="1062 398 1214 474">General Licensees</td> </tr> <tr> <td data-bbox="331 474 469 551">P-FFC</td> <td data-bbox="469 474 1062 551"> Procedure for the filiform corrosion test </td> <td data-bbox="1062 474 1214 551">Testing laboratories</td> </tr> <tr> <td data-bbox="331 551 469 627">P-TAC</td> <td data-bbox="469 551 1062 627"> Procedure for testing and approving coating materials </td> <td data-bbox="1062 551 1214 627">Testing laboratories</td> </tr> <tr> <td data-bbox="331 627 469 703">P-RLT</td> <td data-bbox="469 627 1062 703"> Procedure for the repetition of laboratory tests </td> <td data-bbox="1062 627 1214 703">Testing laboratories</td> </tr> <tr> <td data-bbox="331 703 469 831">P-SAMP</td> <td data-bbox="469 703 1062 831"> Procedure for sampling (coating plant inspections coaters' production sites and laboratory tests) - including classification of tests </td> <td data-bbox="1062 703 1214 831">Testing laboratories</td> </tr> </tbody> </table>	CODE	PROCEDURE	INTENDED FOR	P-EVA	Procedure for evaluating inspection results List of failures to be considered nonconformities	General Licensees	P-FFC	Procedure for the filiform corrosion test	Testing laboratories	P-TAC	Procedure for testing and approving coating materials	Testing laboratories	P-RLT	Procedure for the repetition of laboratory tests	Testing laboratories	P-SAMP	Procedure for sampling (coating plant inspections coaters' production sites and laboratory tests) - including classification of tests	Testing laboratories	---
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<p>Appendix A6 2. Formal application prior to testing</p>	<p>On the application form and in the TDS, the applicant shall specify whether the product is a rinse or a no-rinse system, or whether it is suitable for dual use depending on the coating applicator's licensee's pretreatment line set-up. Products intended for dual use shall be tested both ways.</p> <p>The following minimum technical information shall also be provided to the QUALICOAT laboratory in charge on a separate sheet (General Technical Information):</p> <table border="1"> <tbody> <tr><td>APPLICATION METHOD (1) (2)</td><td></td></tr> <tr><td>PROCESS CYCLE (2)</td><td></td></tr> <tr><td>FINAL RINSE (YES/NO/DUAL USE)</td><td></td></tr> <tr><td>ANALYTICAL METHODS FOR BATH</td><td></td></tr> <tr><td>FILM WEIGHT (3)</td><td></td></tr> <tr><td>OTHER ANALYSES</td><td></td></tr> <tr><td>OTHER RECOMMENDATIONS (EQUIPMENT, HANDLING, STORAGE ETC.) (4)</td><td></td></tr> <tr><td>COLOURLESS CONVERSION COATING?</td><td></td></tr> <tr><td>DRYING CONDITIONS</td><td></td></tr> </tbody> </table> <p>(1) Spraying and/or immersion. (2) The manufacturer is responsible for ensuring that the cycle used by the coating applicator licensee is suitable for obtaining a coated product conforming to the QUALICOAT Specifications. What are the limits for demineralised water before conversion coating? (3) Method for in-house control and laboratory tests (limits and frequency). (4) The technical specifications shall make it clear which items are compulsory, for instance does "recommended" mean compulsory or not?</p>	APPLICATION METHOD (1) (2)		PROCESS CYCLE (2)		FINAL RINSE (YES/NO/DUAL USE)		ANALYTICAL METHODS FOR BATH		FILM WEIGHT (3)		OTHER ANALYSES		OTHER RECOMMENDATIONS (EQUIPMENT, HANDLING, STORAGE ETC.) (4)		COLOURLESS CONVERSION COATING?		DRYING CONDITIONS		---
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<p>Appendix A6 8. Renewal of pretreatment system approvals</p>	<p>c) '10+2' rule [...] [...] Evaluation The QUALICOAT Secretariat shall determine all the chemical pretreatment systems falling under the '10+2 rule' by evaluating the previous year's AASS test results from samples taken during the annual inspections at the licensed coating applicators licensees' production sites.</p>	---																		

Reference (SPEC 2022 – V02)	Amendments	Remarks
<p>(continued)</p> <p>Appendix A6</p> <p>8. Renewal of pretreatment system approvals</p>	<p>Information</p> <p>[...]</p> <p>All licensed coating applicators licensees using the chemical pretreatment system placed 'under observation' shall be informed by the General Licensee (or directly by QUALICOAT in countries without a General Licensee) by the end of July. They shall be made aware that they must continue to fully comply with the requirements of the QUALICOAT Specifications.</p> <p>[...]</p> <p>d) Deadline for the coating applicator licensee to use the product</p> <p>All licensed coating applicators licensees using the chemical pretreatment system cancelled due to the '10+2 rule', may continue to use it until end of the year of cancellation. They shall be made aware that they must continue to fully comply with the requirements of the QUALICOAT Specifications</p>	<p>---</p>
<p>Appendix A6</p> <p>9. Responsibility and cooperation with the coating applicator</p>	<p>9. Responsibility an cooperation with the coating applicator licensee</p> <p>Manufacturers and coating applicators licensees shall cooperate closely (see Chapter 3, § 3.2.2).</p> <p>For all systems, there shall be technical data sheets, also giving information about other products with which a system may or may not be used.</p> <p>To take into account the particular conditions in each plant, specific instructions to be followed by the persons in charge shall be provided to the coating applicator licensee and shall specify that the conductivity of the dripping water of all chemical pretreatment systems with a final rinse shall not exceed a maximum of 30 µS/cm at 20°C (the conductivity only being measured on open sections and not on hollow sections). The instructions for the specific plant shall also specify whether the product is to be used as a rinse or no-rinse system, or whether it is suitable for dual use, depending on the coating applicator's licensee's pretreatment line set-up.</p> <p>The methods for assessing the conversion coating may differ from one system to the next since there is not a pertinent standard. . The manufacturer indicates how the coating applicator licensee has to monitor the quality of the chrome VI-free conversion coating during in-house control. A device to check the coating weight analytically shall be prescribed. QUALICOAT recommends the coating weight to be measured in every working shift, or according to the chemical manufacturer's advice, which shall be at least once per day (see table in section 6.5).</p> <p>[...]</p> <p>Receipt of the samples shall be confirmed to the coating applicator licensee immediately. Detailed results and any corrective actions shall be entered and retained along with the related shipping details in records readily accessible to the inspector and communicated to the coating applicator licensee within a period of maximum four months.</p> <p>If the chemical manufacturer fails to cooperate with the coating applicator licensee within the specified deadlines, the following sanction procedure shall be followed:</p> <p>[...]</p>	<p>---</p>