



Update of QUALIDECO Specifications - Appendix to the QUALICOAT Specifications 2020 QDC-SPEC-US05 applicable from 1 January 2021

Subject: Licensing of film suppliers

**QUALICOAT/QUALIDECO
Resolution:**

None (alignment with Update Sheets Nos. 1 and 2)

**Amendment to the
Specifications:**

§ 3.1.

Author: QDC Specifications WG
Pascale Bellot

Document Code: QDC-SPEC-US05

QQM Section: 7.8.2

Date Approved: 18.11.2020

Approved by: EC

Valid from: 01.01.2021

Version: 01

No. of Pages: 7

3.1. Licensing of film suppliers

3.1.1 Work specifications for film suppliers (REQUIREMENTS)

3.1.1.1 Traceability

The film supplier shall have a procedure for monitoring and documenting all manufacturing steps in order to ensure traceability in the production chain. The results of these measures shall be entered in some record (register) readily accessible to the inspector.

The film supplier shall comply with the procedure for film coding described in [Appendix II-1](#).

3.1.1.2 Laboratory and in-house control

In this context, the finished product is understood to be the film used for sublimation.

The film shall be tested after being applied to panels coated with ~~a powder approved for QUALIDECO applications~~—an approved organic coating material (DP-approval).

The film supplier shall have laboratory facilities that are separate from the production facilities. This laboratory shall have all the apparatus and chemicals necessary for testing the manufacturing process and finished products.

It shall at least be equipped with the following apparatus and reference material:

- ◆ a specular glossmeter
- ◆ an instrument for measuring coating thickness
- ◆ a recorder for stoving temperature and time with four different measuring points
- ◆ apparatus for testing accelerated weathering resistance and for measuring colour change and gloss retention
- ◆ an application booth
- ◆ transfer equipment
- ◆ a grey scale reference (ISO 105-A02).

Each piece of apparatus shall have a data sheet showing the apparatus identification number and calibration checks.

The film supplier shall use the following procedure to monitor its manufacturing process and test its finished products:

- A sample of each roll (every 1000 metres) shall be printed on the coated surface to check the visual appearance. The results shall be recorded and at least two samples, taken from the beginning and end of each roll, shall be stored.
- The film supplier shall provide the decorator with a **system data sheet** for the decoration approved for exterior applications (in particular indicating maximum temperatures and times and the reference to the film and powder codes). A copy shall be available to the inspector during his visit.
- The film supplier shall test every single new decoration in its laboratory and shall include every satisfactory decoration in a list of self-tested decorations which shall be shown to the ~~QUALIDECO~~ inspector upon request.

3.1.2 Granting a licence to a film supplier¹

The film supplier shall submit to the General Licensee (or QUALICOAT in countries where there is no GL) a written application for inspection and testing, using the official form available on the QUALICOAT website (<https://www.qualicoat.net/main/about-us/assured-quality/how-to-apply.html>).

A licence shall be granted subject to the following conditions:

3.1.2.1 Plant inspection

An inspection of the film supplier's facility shall be carried out to check that the laboratory is equipped with the minimum apparatus prescribed and that its in-house control meets the requirements specified in § 3.1.1.2.

3.1.2.2 Testing and approval for class 1 (decoration systems)

- a) Following acceptance of the film supplier's application, the laboratory responsible for testing shall ask the film supplier to send a roll of film (film coding according to [Appendix II-1](#)) for the following **four basic decorations**:
 - WALNUT and OAK to be applied on a brown base
 - PINE and OAK to be applied on a beige base.
- b) Samples of film shall be taken from that part of the roll where the pattern and printing marks appear.
- c) The laboratory shall apply the approved powder coating (DP-approval according to Appendix VI) and the film and perform the following tests:
 - Accelerated weathering test (see [§ 2.4.](#))
 - Resistance to humid atmospheres containing sulphur dioxide (see [§ 2.3.](#)).
- d) If the laboratory test results are satisfactory, the decoration system(s) tested shall be approved and a natural weathering test shall be carried out in Florida (see [§ 2.5.](#)).

3.1.2.3 Testing and approval for class 2 (single decorations)

- a) Following acceptance of the film supplier's application, the laboratory responsible for testing shall ask the powder supplier(s) to send a sample of organic coating material from a class 2 DP-approval for the **two basic class 2 decorations** clearly identified by the film supplier on the application form.
- b) The laboratory shall apply the powder coating and the film and perform the following tests:
 - Accelerated weathering test (see [§ 2.4.](#))
 - Resistance to humid atmospheres containing sulphur dioxide (see [§ 2.3.](#)).

¹ See flow chart No. 1 at the end of § 3.1.

- c) If the laboratory test results are satisfactory for both decorations, these class 2 basic decorations shall be approved, and a natural weathering test shall be carried out in Florida (see § 2.5.).

3.1.2.4 Conformity assessment

A licence shall be granted if the inspection and at least one decoration system (class 1) or both class 2 basic decorations are satisfactory.

TABLE 1: PROCEDURE FOR GRANTING A LICENCE TO A FILM SUPPLIER

INSPECTION RESULT	ACTIONS			
SATISFACTORY	► LABORATORY TESTS for approval of a decoration system (class 1) or two basic class 2 decorations	TEST RESULTS SATISFACTORY	LICENCE GRANTED for the tested decoration system(s) (class 1) or the tested basic class 2 decorations	► FLORIDA TEST
		TEST RESULTS UNSATISFACTORY	LICENCE NOT GRANTED ⁽¹⁾	
UNSATISFACTORY	LICENCE NOT GRANTED ⁽¹⁾			

FLORIDA TEST RESULTS	FINAL ASSESSMENT
ALL DECORATIONS SATISFACTORY	LICENCE CONFIRMED – DECORATION SYSTEM APPROVAL CONFIRMED
1 OR MORE BASIC CLASS 1 DECORATION(S) UNSATISFACTORY	LICENCE CONFIRMED – DECORATION SYSTEM APPROVAL WITHDRAWN ⁽²⁾
1 OR 2 CLASS 2 BASIC DECORATIONS UNSATISFACTORY	LICENCE WITHDRAWN FOR THE BASIC CLASS 2 DECORATIONS ⁽³⁾

⁽¹⁾ A new application may be made only when the company has given notification that it has rectified the deficiencies recorded.

⁽²⁾ If the film supplier has only one decoration system approved, the FS-licence itself shall be cancelled.

⁽³⁾ If the film supplier has no approved decoration system and no other approved class 2 decoration, the FS-licence itself shall be cancelled.

3.1.3 Renewing a film supplier's licence

After a film supplier has been granted a licence to use the quality label, its plant shall be inspected every three years.

The routine inspection shall include the following aspects:

- a) **LABORATORY EQUIPMENT** in accordance with § 3.1.1.2
- b) **DECORATED SAMPLES** tested during in-house control
- c) **IN-HOUSE CONTROL AND REGISTERS**
- d) **SAMPLING**
 - **CLASS 1:** Two different decorations from the film supplier's list of self-tested decorations² shall be taken by the inspector for testing according to § 3.1.2.2 c) and d).
 - **CLASS 2:** Two decorations from the list of the film supplier's approved class 2 decorations shall be taken by the inspector for testing according to § 3.1.2.3 b) and c).

² See Appendix II-2.

In years without a plant inspection, the testing laboratory shall perform the tests on samples of two decorations selected from the film supplier's list of self-tested decorations in accordance with § 3.1.2.2 c) and d) and/or from the list of the supplier's approved class 2 decorations in accordance with § 3.1.2.3 b) and c).

TABLE 5: PROCEDURE FOR RENEWING A FILMSUPPLIER'S QUALIDECO LICENCE

INSPECTION	INSPECTION RESULT	ACTIONS	REPETITION OF INSPECTION		
	SATISFACTORY	▶ LABORATORY TESTS			
	UNSATISFACTORY	▶ REPEAT INSPECTION		SATISFACTORY	▶ LABORATORY TESTS
				UNSATISFACTORY	LICENCE WITHDRAWN

LABORATORY TESTS	LABORATORY TEST RESULTS	ACTIONS	REPETITION OF LABORATORY TESTS		
	BOTH DECORATIONS SATISFACTORY	LICENCE RENEWED ▶ FLORIDA TEST			
	1 DECORATION UNSATISFACTORY	▶ REPEAT LABORATORY TESTS ON THE DECORATION THAT FAILED ⁽¹⁾		SATISFACTORY	▶ FLORIDA TEST
				UNSATISFACTORY	DECORATION BANNED ⁽²⁾
	BOTH DECORATIONS UNSATISFACTORY	▶ REPEAT LABORATORY TESTS ON BOTH DECORATIONS ⁽¹⁾		BOTH DECORATIONS SATISFACTORY	▶ FLORIDA TEST
			1 DECORATION SATISFACTORY		
			1 DECORATION UNSATISFACTORY	1 DECORATION BANNED ⁽²⁾	
			BOTH DECORATIONS UNSATISFACTORY	▶ REPEAT INSPECTION	

FLORIDA TEST	FLORIDA TEST RESULTS	FINAL ASSESSMENT
	BOTH DECORATIONS SATISFACTORY	LICENCE RENEWED – DECORATION SYSTEM APPROVAL RENEWED BOTH DECORATIONS APPROVED
	1 DECORATION SATISFACTORY	LICENCE RENEWED – DECORATION SYSTEM APPROVAL RENEWED SATISFACTORY DECORATION APPROVED
	1 DECORATION UNSATISFACTORY	LICENCE RENEWED – DECORATION SYSTEM APPROVAL RENEWED 1 DECORATION BANNED ⁽²⁾
	BOTH DECORATIONS UNSATISFACTORY	LICENCE RENEWED – DECORATION SYSTEM APPROVAL RENEWED 2 DECORATIONS BANNED ⁽²⁾

- After receiving notification of the unsatisfactory results, the supplier shall submit a new powder sample, with the same reference code as the material used for preparing the unsatisfactory decoration(s). The laboratory shall then use this sample to prepare new decorated samples for repeating the tests.
- Every banned decoration shall be recorded in a list of banned decorations appended to the powder supplier's certificate. The powder supplier shall have banned decorations tested again as soon as possible after receiving notification. Banned decorations subject to repeat testing shall be considered suspended.

3.1.4 Approval of a new decoration system

After a film supplier has been granted an FS-licence, new decoration systems shall be approved as prescribed in § 3.1.2.2.

3.1.5 Approval of new class 2 decorations

After a film supplier has been granted an FS-licence, class 2 decorations shall be approved subject to the following conditions:

- The film supplier shall submit to the laboratory responsible for testing a written application identifying the decoration(s) to be tested (reference codes of both the film and the base coating). The powder supplier shall be notified of this written application.

- b) All data pertaining to the named decoration shall be available to allow correct application of the powder and film:
 - Designation
 - Decoration reference code
 - DP-XXXX approval for class 2 and reference code of the powder coating
 - Film reference complying with the procedure for film coding described in Appendix II-1
 - Technical data sheets for the film and powder coating
- c) The laboratory shall perform the tests prescribed in § 3.1.2.3
- d) An approval shall be granted for every single decoration if all the laboratory tests are satisfactory. A list of approved class 2 decorations shall be appended to the film supplier's certificate.
- e) If one or more tests are unsatisfactory, the laboratory shall inform both the film supplier and the powder supplier of the unsatisfactory results.
- f) The approval shall be confirmed if the result of the natural weathering test (Florida exposure) is satisfactory.

3.1.6 Withdrawal of a decoration system

The approval of a decoration system (base coating + film) shall be withdrawn if

- one or more basic decoration(s) do not meet the requirements after the Florida test;
- the DP-XXXX approval related to the decoration system approval is cancelled;
- as soon as four decorations are banned.

3.1.7 Withdrawal of a class 2 decoration

Every decoration that does not meet the requirements after two consecutive unsatisfactory laboratory test results or after the natural weathering test shall have its approval withdrawn and shall be included in a list published on the QUALICOAT website along with the film supplier's certificate.

3.1.8 Withdrawal of a film supplier's licence

A film supplier's licence shall be cancelled if two consecutive inspections are unsatisfactory.

A film supplier's licence covering only one decoration system (class 1) shall be cancelled if the approval of that decoration system is withdrawn as stipulated in § 3.1.6.

A film supplier's licence covering only two class 2 decorations shall be cancelled if the approval of those class 2 decorations has to be withdrawn as stipulated in § 3.1.7.

FLOW CHART No. 1 – GRANT OF A LICENCE TO A FILM SUPPLIER

