



# Update of QUALICOAT Specifications 2021

## Update Sheet No. 06

applicable from 1 January 2022

**Subject:** Requirements for the laboratory equipment at the coating applicator

**Proposal/Request:** Laboratories WG/2021-04-13 (item 8)

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**QUALICOAT Resolution:** Resolution No. 3/TC 2021-06-11  
The TC instructed the Specifications WG to prepare an update sheet to clarify the coaters' laboratory equipment in Section 3.8, as proposed by the Laboratories WG.

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**Amendment to the Specifications:** § 3.8 Laboratory

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### 3.8. Laboratory

The coating plant installation 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:

- 1) Specular glossmeter suitable to measure in 60° incident light mode
- 2) 2 instruments for measuring coating thickness according to **ISO 2360** (corresponding calibration standards <60 µm and >60 µm)
- 3) 1 analytical balance with precision 0.1 mg (2 calibrated weights for in-house adjustment)
- 4) Cutting tools and instruments necessary for performing the adhesion test
- 5) Impact tester
- 6) Recorder for stoving temperature and time with four different measuring points, three on the parts and one to measure the air temperature
- 7) Conductivity meter (calibration solution ≤ 100 µS/cm)
- 8) Apparatus for testing resistance to cracking on bending for bending radius 5 mm
- 9) Test solutions for the polymerisation test
- 10) pH-meter (calibration solution corresponding to the pH value of the coating line)
- 11) Device prescribed for the analytical coating weight determination (only for chemical pretreatment according to [§ 3.3.2](#))

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

The oven temperature recorder shall be checked, and the results shall be registered at least twice per year.

The laboratory conditions may differ from those prescribed by ISO standards for mechanical tests.