



Update of QUALICOAT Specifications 2022

Update Sheet No. 03

applicable from 1 January 2023

Subject: Cooperation between coater and manufacturer of chemical chromate pretreatment

Proposals/Requests: Pretreatment WG (25 January 2022)

QUALICOAT Resolution: **Resolution No. 1/ TC 2022-05-19**
The TC agreed that the requirements for chromate conversion coatings should be aligned with those for chemical pretreatment in terms of the requested cooperation with the pretreatment manufacturer (as described in Appendix A6, Section 9). The Specifications WG should prepare a draft update sheet.

Amendment to the Specifications: Additional text in § 3.3.1 Chromate conversion coatings and § 3.11 Registers

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3.3.1 Chromate conversion coatings

This chemical chromate or chromate-phosphate conversion shall be carried out according to **ISO 10546**.

The conductivity of the final rinse preceding chemical chromate conversion's step shall comply with the manufacturer's specifications and be checked by the inspector.

Demineralised water shall be used for the final rinse after chemical chromate conversion before drying. The conductivity of the dripping water shall not exceed a maximum of 30 $\mu\text{S}/\text{cm}$ at 20°C. The conductivity should only be measured for open sections and not for hollow sections.

The weight of the chromate conversion coating shall be between 0.6 and 1.2 g/m² for chemical chromate conversion (yellow coating) and between 0.6 and 1.5 g/m² for chemical chromate-phosphate conversion (green coating).

Every two months a production sample shall be sent to the chemical chromate conversion manufacturer who shall carry out an acetic acid salt spray resistance test. The test results shall be communicated to the coater within a period of maximum four months.

The results and any corrective actions communicated by the chemical chromate conversion manufacturer shall be entered and retained along with the related shipping details in records readily accessible to the inspector. Unsatisfactory values shall have no influence on the result of a QUALICOAT inspection.

3.11 Registers

The coating plant installation shall maintain registers for:

- production of QUALICOAT products
- in-house control
- tests carried out by the chemical manufacturers (as defined in [3.3.1](#), [3.3.2](#) and Appendix A6)
- customers' complaints