



Update of QUALICOAT Specifications 2023

Update Sheet No. 11

applicable from 01.01.2024

Subject: APPENDIX A6 – Various adjustments

Proposals/Requests: Several adjustments are requested/proposed by the Pretreatment WG, Laboratories WG and/or the Secretariat.

QUALICOAT Resolution: See Background/Source column on the following pages

Amendment to the Specifications:

- Section 3 - PRELIMINARY CONDITIONS
- Section 5a - PANEL PREPARATION
- Section 8c - AASS test '10+2' rule and FFC test '15+3' rule

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S/No.	Background/Source	Amendments
1.	<p><u>Resolution No. 14 / TC 2023.05.16</u> The TC agreed that Appendix A6 should be updated to allow the 'constant climate condensation water' and 'resistance to humid atmospheres containing sulphur dioxide' corrosion tests to be outsourced and carried out by a QCT-approved laboratory.</p>	<p>A6 – Approval of chemical pretreatments [...]</p> <p>3. PRELIMINARY CONDITIONS (minimum equipment) <u>THE CHEMICAL MANUFACTURER SHALL HAVE THE FOLLOWING MINIMUM EQUIPMENT AVAILABLE AT LEAST AT ONE LOCATION</u> (main production site and/or technical service centre):</p> <ul style="list-style-type: none"> • analytical instruments for testing the quality of the conversion coating; • cutting tools and instruments necessary for performing the adhesion test; • apparatus for testing dry and wet adhesion and elasticity (cupping test); • impact tester (ISO 6272); • apparatus for testing resistance to cracking on bending; • analytical balance for determining weight loss (precision 0.1 mg); • apparatus to carry out the following corrosion tests: <ul style="list-style-type: none"> ○ constant climate condensation water²¹ ○ resistance to humid atmospheres containing sulphur dioxide²¹ ○ acetic acid salt spray resistance ○ resistance to boiling water ○ filiform corrosion test²¹ <p>[...]</p> <p>²¹ This test may be outsourced and carried out by a QUALICOAT approved laboratory or another laboratory accredited for this specific test according to ISO 17025.</p>
2.	<p><u>Resolution No. 16 / TC 2023.05.16</u> The TC approved the lower and upper limits set by the Laboratories WG for the panel preparation following the Pretreatment WG's recommendation. An update sheet shall be prepared.</p>	<p>A6 – Approval of chemical pretreatments [...]</p> <p>5. TESTING PROGRAMME Approval is based on the following testing programme to ensure conformity with the requirements prescribed by QUALICOAT.</p> <p>a) PANEL PREPARATION [...]</p> <p><u>Pretreatment</u> The laboratory in charge of preparing the samples shall take into account the following parameters:</p> <ul style="list-style-type: none"> • Etching degree The total etching degree shall be between 1.0 g/m² and 2.0 g/m² on samples for all tests. • Weight of the conversion coating <ul style="list-style-type: none"> ○ close to the system's lower limit value specified by the chemical manufacturer, which means in the range of the lower limit value up to +33.33% of the upper limit value for corrosion test samples; ○ close to the system's upper limit value specified by the chemical manufacturer, which means in the range of the upper limit value down to -33,33% of the upper limit value for mechanical test samples, especially for the adhesion test. <p>[...]</p>

S/No.	Background/Source	Amendments
3.	<p>Resolution No. 17 / TC 2023.05.16</p> <p>The TC agreed that the 15+3 rule for the FFC tests (including sanctions) should be included in Appendix A6 and implemented from the renewals 2024. An update sheet shall be prepared.</p>	<p>A6 – Approval of chemical pretreatments</p> <p>[...]</p> <p>8. RENEWAL OF PRETREATMENT SYSTEM APPROVALS</p> <p>a) Renewing pretreatment system approvals</p> <p>[...]</p> <p>b) Repetition of unsatisfactory laboratory tests</p> <p>[...]</p> <p>c) AASS test '10+2' rule and FFC test '15+3' rule</p> <p>10% of failures in the AASS test and at least two C+D values classified as unsatisfactory shall lead to an unsatisfactory assessment. If only one C+D AASS test result is obtained, the pretreatment system shall be considered satisfactory.</p> <p>15% of failures in the FFC test and at least three C+D values classified as unsatisfactory shall lead to an unsatisfactory assessment. If only two C+D FFC test result is obtained, the pretreatment system shall be considered satisfactory.</p> <p>Evaluation</p> <p>The QUALICOAT Secretariat shall determine all the chemical pretreatment systems falling under the AASS test '10+2' rule and FFC test '15+3' rule by evaluating the previous year's AASS and FFC test results from samples taken during the annual inspections at the licensees' production sites.</p> <p>Information</p> <p>By the end of June, at the latest, the chemical manufacturers concerned shall be informed by the General Licensee (or directly by QUALICOAT in countries without a General Licensee) that their chemical pretreatment system is being placed 'under observation' for exceeding the AASS test '10+2' rule and/or FFC test '15+3' rule.</p> <p>All 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>Observation period</p> <p>The one-year observation period of the chemical pretreatment system shall start with the written notification of the chemical manufacturer by the end of June. If the chemical pretreatment system does not fall under the AASS test '10+2' rule and/or FFC test '15+3' rule again in the subsequent calendar year, the status shall be reset, and the chemical manufacturer shall be informed by the General Licensee (or directly by QUALICOAT in countries without a General Licensee).</p> <p>Withdrawal</p> <p>If a system fails over two consecutive calendar years, it shall be cancelled by 30 June of the second year and the chemical manufacturer shall be notified by the General Licensee (or directly by QUALICOAT in countries without a General Licensee) that the chemical pretreatment system will be cancelled within 30 days from the notification date.</p> <p>d) Deadline for the licensee to use the product</p> <p>All licensees using the chemical pretreatment system cancelled due to the AASS test '10+2' rule and/or FFC test '15+3' 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>