



Procedure for evaluating inspection results

Author: EC
Pascale Bellot
Tiffany Maechler

Document Code: P-EVA
QQM Section: 7.4.10, 9.5.1
Date Approved: 17.05.2023
Approved by: Executive Committee
Valid from: 01.07.2023
Version: 04
No. Pages: 5



1. Scope

This procedure sets out the criteria applied by QUALICOAT for the assessment of inspection reports for granting and renewing a licence to a coater's production site.

2. Reference standards

- QUALICOAT Specifications (latest edition)
- EN ISO / IEC 17000: Conformity assessment - Vocabulary and general principles
- EN ISO / IEC 17065
- EN ISO / IEC 17067: Conformity assessment — Fundamentals of product certification and guidelines for product certification schemes

3. Terminology

Non-conformity: failure to comply with a requirement leading to a repetition of the inspection.

Issue: Refusal or failure to comply with a requirement not included in the list of non-conformities defined by QUALICOAT.

Correction (remedy of a non-conformity): action taken to eliminate a detected non-conformity.

Corrective action: action taken to eliminate the cause of a detected non-conformity or other undesirable situation in order to prevent recurrence.

Preventive action: action taken to eliminate the cause of a potential non-conformity or other undesirable potential situation.

GL: General Licensee i.e. a national or an international association holding the QUALICOAT general licence for a defined territory.

Testing laboratory: Independent quality testing and/or inspection bodies duly authorised by the General Licensee or QUALICOAT.

4. Handling and assessment of inspection reports

The first granting inspection will be conducted by appointment, whereas all subsequent ones have to be carried out unannounced. Every coating line shall be inspected twice a year, in order for a QUALICOAT licence to be renewed. An inspection may only be carried out on parts coated with QUALICOAT approved organic coating materials.

The **inspector** shall complete one inspection report per coating line and record the findings on the appropriate summarizing sheet. The inspector shall then submit the inspection report to the **testing laboratory** via the web inspections interface.

If the **inspector** detects one or more non-conformities during his production site inspection, he shall immediately notify both the **GL** (or QUALICOAT Certification Body in countries without GL) and the **testing laboratory** and submit reports with the detected non-conformity to the GL (or QUALICOAT Certification Body in countries without GL) within one week after the inspection, via the web inspections interface. The **GL** (or the testing laboratory in countries without GL) shall immediately notify the licensee about the non-conformities detected and submit reports with a detected non-conformity to QUALICOAT Certification Body within one month after the inspection, via the web inspections interface.



If the inspection results of one or more coating line(s) do not meet the requirements and the inspection has been rated unsatisfactory by QUALICOAT Certification Body, a repeat inspection on the coating line(s) rated unsatisfactory shall be made within one month (allowing for holiday periods) after the **Licensee** has received notification of an unsatisfactory inspection.

If the repeat inspection again produces unsatisfactory results, the licence to use the quality label for the licensee's production site will be withdrawn immediately. (The coater shall wait at least three months before making a new application for a licence to use the quality label.)

For lines where no non-conformities have been detected during the inspection, the **testing laboratory** shall perform the laboratory tests, add its results to the inspection report and submit it to the **GL** (or to QUALICOAT Certification Body in countries without GL) via the web inspections interface.

The **GL** shall review the inspection report, add his comments and result recommendation and submit it to QUALICOAT Certification Body via the web inspections interface.

QUALICOAT Certification Body shall assess the inspection report, issue a commented confirmation letter stating the final inspection result and send it to the **GL**.

If the **GL** and/or QUALICOAT Certification Body detect one or more non-conformities during the report assessment or decide that an issue needs to be changed to a non-conformity the inspection of the coating line(s) concerned is being rated unsatisfactory by QUALICOAT Certification Body and a repeat inspection on the coating line(s) rated unsatisfactory shall be made within one month (allowing for holiday periods) after the **Licensee** has received notification of an unsatisfactory inspection.

If the repeat inspection again produces unsatisfactory results, the licence to use the quality label for the Licensee's production site will be withdrawn immediately. (The coater shall wait at least three months before making a new application for a licence to use the quality label.)

In any case, the **GL** (or QUALICOAT Certification Body in countries without GL) shall send the complete inspection report to the **Licensee**, highlighting issues and findings that must be solved. The **GL** (or QUALICOAT Certification Body in countries without GL) shall inform the **testing laboratory** and **inspector** about these issues and findings.

The subsequent inspection should only be carried out after these steps have been completed; the **inspector** shall check whether all failures have been remedied through preventive or corrective actions in the meantime.

5. Failures to be considered NON-CONFORMITIES ¹

- Failure to admit an inspector to carry out an inspection
- Use of organic coating materials for external architectural applications that have not been approved by QUALICOAT except for technical reasons justified by a customer's written request
- No apparatus available for measuring coating thickness
- Delay of more than 16 hours between pretreatment and coating, if the storage prescribed in Section 3. of the Specifications is poor (or 72 hours for anodic pretreatment)
- Curing parameters below the powder manufacturer's minimum requirements
- Etching degree less than the minimum specified
- Conversion coating weight lower than the minimum prescribed
- Conversion coating weight higher than the maximum prescribed
- Conductivity of the final rinse exceeding the acceptable value
- Coating thickness less than the minimum specified
- Rejected pieces more than the minimum prescribed for coating thickness
- No in-house control results recorded for more than one week
- Failure to comply with the rule stipulated for coaters that the additional samples for the AASS test must be sent every two months
- Unsatisfactory result in the Machu test
- Unsatisfactory result in the acetic acid salt spray test (rating D)
- Unsatisfactory result in the wet adhesion test

All other failures shall be considered issues to be followed up by the GL (or QUALICOAT in countries without GL). When an issue recurs the GL and QUALICOAT shall decide whether the status of this issue needs to be changed to a "non-conformity" or whether it can remain classified as an "issue" for a longer period. In case of ambiguities or uncertainties in any part of the Specifications, clarification shall be requested from the QUALICOAT Certification Body.

¹ All requirements refer to the current edition of the QUALICOAT Specifications

6. Flow chart

