COATER
Master Inspection Report

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Report no.

COMPANY

Name					
Plant Address					
Phone		email			
Responsible person(s) (contact)					
Licence number		(leave blank for GR1/GR2)	Number of coating lines[2]		SEASIDE endorsement holder YES ☐ NO ☐

COATING LINE INSPECTION [1]

DATE OF INSPECTION
(use dropdown calendar)

DESIGNATION [2] OF THE COATING LINE

INSPECTION NO.

-

TYPE OF INSPECTION

PHYSICAL

Granting	-
Renewal	-
Repetition	-

SEASIDE:

Select **ONLY** if FFC test is performed (ANNEX I or ANNEX II)

Granting	☐
Renewal (During RN1)	☐
Repetition	☐

DATE OF LAST INSPECTION
(use dropdown calendar)

Has anything changed in the plant since the last inspection? YES ☐ NO ☐ If YES what?

Testing laboratory

Name of inspector 1: 2:

Is the inspection unannounced? YES ☐ NO ☐ If NO why?

Is an inspection possible? YES ☐ NO ☐ If NO why?

Remarks

1 Annex I = SEASIDE , Annex II = Anodic pretreatment, Annex III = Supplement for off-site anodic pretreatment, Annex IV = Batch pretreatment inspection
2 A coating line is a production line used for coating aluminium for architectural applications that includes **a single pretreatment cycle**.

Report no.

IDENTIFICATION OF QUALICOAT APPROVED COATING SYSTEMS USED BY THE COATER (STORAGE)

Verify that the powders (including colours) that the coater uses for external architectural applications during the inspection are approved by QUALICOAT. (fill in three random powders in stock)

Coating systems (type and brand name)	Producer	Approval NO.*	Banned colours*

*** As shown on the current list of approved coating systems published on the website (www.qualicoat.net)**

Does the coating plant have only approved powders in stock? YES ☐ NO ☐ If NO why?

Do the coating materials comply with the packaging rules prescribed by QUALICOAT? YES ☐ NO ☐
(see paragraph 4.1.1 and Appendix A1 of the Specifications)

Remarks

Optional picture upload

Report no.

STORAGE CONDITIONS AND LAYOUT OF EQUIPMENT

PARTS TO BE TREATED

Are the parts to be treated stored in accordance with section 3.1.1 of the Specifications? YES ☐ NO ☐

Remarks

CHEMICAL PRODUCTS

Do the storage conditions comply with the chemical manufacturer's requirements? YES ☐ NO ☐

Remarks

POWDER AND LIQUID COATING PRODUCTS

Do the storage conditions comply with the powder manufacturer's requirements? YES ☐ NO ☐

Remarks

LAYOUT OF EQUIPMENT

Does the layout of equipment comply with section 3.1.2 of the Specifications? YES ☐ NO ☐

Remarks

1. INSPECTION OF LABORATORY AND APPARATUS

1.1 LABORATORY

APPEARANCE CORRECT YES ☐ NO ☐

Remarks

Report no.

APPARATUS FOR MEASURING THICKNESS AND GLOSS

1.2 Instruments for measuring coating thickness (ISO 2360)

Verify the calibration of the instrument using **two** suitable standards according to the thickness to be measured

	Instrument A		Instrument B	
MAKE				
MODEL				
No.				
Deviation from the standard value	REQUIRED	MEASURED	REQUIRED	MEASURED
- Set-up I : 0 ± 0.5				
- Set-up II: < 60 ± 1				
- Set-up III: ≥ 60 ± 2				
Function	-		-	

Calibration standards/ foils available	YES ☐ NO ☐	Remarks
Data sheet with identification no. and calibration records available	YES ☐ NO ☐	Remarks

1.3 Specular glossmeter (ISO 2813)

Verify the calibration of the instrument

Make		Model		No	
Required		Measured			
Function	-	(± 2 units)	Data sheet with identification no. and calibration records available	YES ☐	NO ☐
Remarks					

1.4 Analytical balance (sensitivity not less than 0.1 mg)

Make | Model | No

Data sheet with identification no. and calibration records available: YES ☐ NO ☐

Last calibrated on

TEST WITH CALIBRATED WEIGHTS (10-50g)

	WEIGHTS USED		WEIGHTS MEASURED
Weight 1	g	=	g
Weight 2	g	=	g

Function: -

Two calibrated weights for in-house adjustment available: YES ☐ NO ☐

Remarks

APPARATUS FOR MECHANICAL TESTS

When verifying that the apparatus is functioning properly, it is necessary to check the visual appearance of the apparatus

1.5 Cutting tool (for cross-cut adhesion test ISO 2409)

Make | Model | No

Visual assessment: -

If not good, indicate the reasons

Function: -

Adhesive tape available: YES ☐ NO ☐

Available distances between cuts: mm

Remarks

Report no.

1.6 Impact tester (ISO 6272-1, ISO 6272-2 and ASTM D 2794)

Make		Model		No	
Visual assessment	-				
If not good, indicate the reasons					
Function	-				
Remarks					

1.7 Apparatus for bend test (ISO 1519)

Make		Model		No	
Visual assessment	-				
If not good, indicate the reasons					
Function	-				
Remarks					

OTHER APPARATUS

1.8 Recorder for stoving temperature

Make		Model		No			
Minimum number of sensors	3 on the parts	YES ☐	NO ☐	1 to measure the air	YES ☐	NO ☐	
Method used by the inspector for checking that the apparatus is functioning (for example, by comparing it with certified apparatus)							
Function	-			Last checked on			
Data sheet with identification no. and calibration records available		YES ☐	NO ☐				
Remarks							

1.9 Conductivity meter

Make | Model | No

Reference test solution | µS/cm | Temperature | °C

Measured | µS/cm | Temperature | °C

Function (≤ 2 µS/cm) | - | Calibration solution ≤ 100 µS/cm available | YES ☐ NO ☐

Data sheet with identification no. and calibration records available | YES ☐ NO ☐

Remarks

1.10 pH meter

Make | Model | No

Test of the electrodes with two standard test solutions | Solution 1 | pH | Measured | pH

Solution 2 | pH | Measured | pH

Function (± 0.1) | -

Remarks

1.11 Apparatus for boiling water test

Make | Model | No

Function | - | Pressure cooker | YES ☐ NO ☐

Remarks

1.12 Device for the analytical coating weight determination (Chemical pretreatment only)

Make | Model | No

Function | - | Data sheet with identification no. and calibration records available | YES ☐ NO ☐

Test method

Remarks

Report no.

2. INSPECTION OF PLANT AND EQUIPMENT

SURFACE PRETREATMENT

2.1 Type of pretreatment

☐ Chromate pretreatment

☐ Chemical pretreatment (Chrome VI-free)

QUALICOAT approval NO. (Example: A-003 / A-074 / A-132)

Rinse pretreatment ☐

No-rinse pretreatment ☐

☐ In-house Anodic pretreatment (please complete ANNEX II)

☐ Off-site Anodic pretreatment (please complete ANNEX III)

Remarks

2.2 Specific requirements

Interruption in treatment? YES ☐ NO ☐

If YES, how much time between the pretreatment and coating

Hours (max. 16 hours)

If YES, Are the pretreated parts handled with clean textile gloves? YES ☐ NO ☐

Remarks

Report no.

3. PROCESS INSPECTION

Installation

Horizontal ☐
Vertical ☐

System used

Spray ☐
Immersion ☐
Cascade ☐

Process

Continuous ☐
Batch with basket ☐
Batch (jig) ☐

} In the case of batch pretreatment using a basket, please complete ANNEX IV

SEASIDE pretreatment (For endorsement holders)

The SEASIDE inspection shall be conducted during the first annual licence renewal inspection using ANNEX I (or ANNEX II for in-house Anodic pretreatment and Annex III for Off-site Anodic pretreatment)

SEASIDE production on the inspection day	YES	NO	Remarks
	☐	☐	

3.1 PRETREATMENT

Etching type

(Optional for Anodic pretreatment, see ANNEX II)

A1 ☐ (simple acid etching)
A2 ☐ (acid etching + acid etching)
AA1 ☐ (alkaline etching and acid etching)
AA2 ☐ (acid etching + alkaline etching + acid etching)

		STEP 1	STEP 2	STEP 3
INDICATE THE STEP (DEGREASING, ETCHING OR DEOXIDATION)				
pH		-	-	-
Temperature (°C)	required			
	measured			
Concentration	required			
	measured			
Immersion/spray time (min)	required			
	measured			
Aluminium removed	(g/m²)			
Remarks				

Total aluminium removed ≥ 1 g/m² / (≥ 2g/m² for SEASIDE)

3.1.1 Conversion treatment

Supplier | Product

	REQUIRED		MEASURED	
Temperature		°C		°C
Concentration / extinction		-		-
Conductivity		µS/cm		µS/cm
Immersion/spray time		-		-
pH value				

Remarks

3.1.2 Chromate conversion coating

	WEIGHT RANGE REQUIRED		WEIGHT MEASURED	
YELLOW	0.6 - 1.2	g/m²		g/m²
GREEN	0.6 - 1.5	g/m²		g/m²

Remarks

3.1.3 Chemical chrome VI-free conversion coating

	METHOD	WEIGHT RANGE REQUIRED	WEIGHT MEASURED	UNIT
COATER				
CHEMICAL MANUFACTURER (last available result)				

Remarks

3.2 COOPERATION WITH THE CHEMICAL MANUFACTURER

Does the coater send a production sample to the chemical manufacturer every 2 months according to the QUALICOAT Specifications? YES ☐ NO ☐

If YES fill in the following table:

NUMBER OF SAMPLES TESTED BY THE CHEMICAL MANUFACTURER SINCE THE LAST INSPECTION		QUANTITY
AASS Test	for Chemical (Chrome VI-free) **and** Chromate treatment	
Coating weight measurement	for Chemical (Chrome VI-free) treatment	

Remarks

Are the chemical manufacturers test results recorded? YES ☐ NO ☐ If NO why?

Are the sample details (shipping dates, chemical manufacturers confirmation receipts) recorded? YES ☐ NO ☐ If NO why?

3.3 TECHNICAL INFORMATION

General technical data sheet YES ☐ NO ☐ Specific instructions for the plant YES ☐ NO ☐

Remarks

3.4 FINAL RINSE

CONDUCTIVITY [µS/cm] *		REQUIRED	MEASURED
Rinse before conversion treatment	Rinsing Water		
	Dripping Water		
Rinse after conversion treatment (if used)	Rinsing Water		
	Dripping Water		

* Limit values see QUALICOAT Specifications: 3.3.1 Chromate, 3.3.2 Chemical, 3.4 Anodic

Satisfactory YES ☐ NO ☐

Remarks/Reason for missing drip water measurement

Report no.

3.5 DRYING

Maximum temperature allowed °C

Maximum temperature measured on the parts °C

Production method -

Satisfactory YES NO

Remarks

3.6 STOVING CONDITIONS

In the table below, the inspector must record the progressive temperature measured on the coldest part, the pertinent time measured and the stoving times specified by the powder manufacturer.

Powder manufacturer

Powder approval (P-No.)

Product name

STOVING CONDITIONS SPECIFIED BY THE POWDER MANUFACTURER		MEASURED		STOVING INSTALLATION	
Time in minutes	Temp. of parts °C	Time in minutes	Temp. of parts °C	Duration in minutes	Set value °C

Alarm system available YES NO

A calculation of the CURING INDEX is used YES NO

If YES, does the value meet the manufacturer's recommendations YES NO

Condition acceptable YES NO

Remarks/ Reference to additional file uploads

4. INSPECTION OF FINISHED PRODUCTS

4.1 INSPECTION OF COATED PARTS (Which have been released by the coater)

Appearance

Conforms to section 2.1 of the QUALICOAT Specifications YES NO

If NO why?

Type of production

Sections Sheets Small parts Others

Remarks

Report no.

4.2 COATING THICKNESS (Minimum thickness measured)

Powder (P-No)		Order No		Number of pieces tested	
Colour		Lot size		Minimum thickness measured	

No.	Measured coating thickness results(µm) 1	2	3	4	5	Average in µm	Remark
1						0	
2						0	
3						0	
4						0	
5						0	
6						0	
7						0	
8						0	
9						0	
10						0	

Powder (P-No)		Order No		Number of pieces tested	
Colour		Lot size		Minimum thickness measured	

No.	Measured coating thickness results(µm) 1	2	3	4	5	Average in µm	Remark
1						0	
2						0	
3						0	
4						0	
5						0	
6						0	
7						0	
8						0	
9						0	
10						0	

Powder (P-No)		Order No		Number of pieces tested	
Colour		Lot size		Minimum thickness measured	

No.	Measured coating thickness results(µm) 1	2	3	4	5	Average in µm	Remark
1						0	
2						0	
3						0	
4						0	
5						0	
6						0	
7						0	
8						0	
9						0	
10						0	

Number of rejected pieces		Satisfactory	YES ☐ NO ☐	Remarks	

4.3 Sawing test

The coating shall not crack or chip when sharp tools are used

Satisfactory YES ☐ NO ☐

Remarks

4.4 Dry adhesion (ISO 2409)

Test on finished product. The result shall be 0.

SAMPLE No.	COATING THICKNESS	SPACING OF THE CUTS BY COATING THICKNESS			ASSESSMENT (0 REQUIRED)
		up to 60 µm 1mm	60 - 120 µm 2mm	Over 120 µm 3mm	
	µm	☐	☐	☐	

Satisfactory YES ☐ NO ☐

Remarks

4.5 Wet Adhesion test

3 samples of finished product taken during the inspection. On visual inspection, there shall be no sign of detachment or blistering. Colour change is acceptable.

SAMPLE No.	COATING THICKNESS	SPACING OF THE CUTS BY COATING THICKNESS			VISUAL INSPECTION SATISFACTORY
		up to 60 µm 1mm	60 - 120 µm 2mm	Over 120 µm 3mm	
	µm	☐	☐	☐	YES ☐ NO ☐
	µm	☐	☐	☐	YES ☐ NO ☐
	µm	☐	☐	☐	YES ☐ NO ☐

Satisfactory YES ☐ NO ☐

Remarks

Report no.

4.6 Machu test

No infiltration exceeding 0.5 mm on both sides of the scratch on 3 test pieces from different lots taken during the inspection. The results should be classified according to the rating scale below:

A.	3 samples satisfactory	0 samples unsatisfactory
B.	2 samples satisfactory	1 samples unsatisfactory
C.	1 samples satisfactory	2 samples unsatisfactory
D.	0 samples satisfactory	3 samples unsatisfactory

SAMPLE LOT NO.	RESULTS			SATISFACTORY
	Length of infiltration		mm	YES ☐ NO ☐
	Length of infiltration		mm	YES ☐ NO ☐
	Length of infiltration		mm	YES ☐ NO ☐

Classification [-] Remarks

4.7 Acetic acid salt spray test (ISO 9227)

The inspector must take 3 samples (sections) from different lots, during first inspection of the year. The results should be classified according to the rating scale below:

A.	3 samples satisfactory	0 samples unsatisfactory
B.	2 samples satisfactory	1 samples unsatisfactory
C.	1 samples satisfactory	2 samples unsatisfactory
D.	0 samples satisfactory	3 samples unsatisfactory

SAMPLE LOT NO.	RESULTS				SATISFACTORY
	Length of infiltration		mm		YES ☐ NO ☐
	Surface corroded		mm²/10 cm		
	Blistering		S		
	Length of infiltration		mm		YES ☐ NO ☐
	Surface corroded		mm²/10 cm		
	Blistering		S		
	Length of infiltration		mm		YES ☐ NO ☐
	Surface corroded		mm²/10 cm		
	Blistering		S		

AASS Classification [-] Remarks

4.8 Polymerisation test as prescribed (optional for powder coatings)

Assessment rating:

1	Coating is very dull and quite soft	☐	3	Slight loss of gloss (less than 5 units)	☐
2	Coating is very dull and can be scratched with a finger-nail	☐	4	No perceptible change Cannot be scratched with a finger-nail	☐

Requirements:

1 and 2 = unsatisfactory
3 and 4 = satisfactory

Solvent used

Remarks

5. INSPECTION OF THE TEST PANELS

Tests performed on test panels processed concurrently with a production lot

Processed during the visit: YES ☐ NO ☐

POWDER APPROVAL (P-No.)	TYPE AND BRAND NAME	PRODUCER	GLOSS CATEGORY 1/2/3	COLOUR SHADE

Remarks

5.1 COATING THICKNESS (ISO 2360)

SAMPLE REFERENCE	REQUIRED	MEASURED	SATISFACTORY YES ☐ NO ☐

Remarks

5.2 GLOSS MEASUREMENT (ISO 2813)

SAMPLE REFERENCE	REQUIRED GLOSS RANGE	MEASURED	SATISFACTORY YES ☐ NO ☐

Remarks

5.3 DRY ADHESION (ISO 2409)

SAMPLE REFERENCE	COATING THICKNESS	SPACING OF THE CUTS BY COATING THICKNESS			Assessment (0 required)
		up to 60 µm 1mm	60 µm - 120 µm 2mm	Over 120 µm 3mm	
	µm	☐	☐	☐	

Satisfactory YES ☐ NO ☐

Remarks

5.4 BEND TEST (ISO 1519)

SAMPLE REFERENCE	COATING THICKNESS according to 2.7 of the Specifications	COATING THICKNESS of the sample	CLASS 1: NO cracking or detachment CLASS 1.5; 2 AND 3: NO detachment	
	µm	µm	Satisfactory	YES ☐ NO ☐

Remarks

5.5 IMPACT TEST (ASTM D 2794 AND ISO 6272-1 OR-2) – for powder coatings only

SAMPLE REFERENCE	COATING THICKNESS according to 2.8 of the Specifications	COATING THICKNESS of the sample	CLASS 1: NO cracking or detachment CLASS 1.5; 2 AND 3: NO detachment	
	µm	µm	Satisfactory	YES ☐ NO ☐

Remarks

Report no.

6. IN-HOUSE CONTROL

	CATEGORY OF TEST	CONFORMITY: Minimum frequency required	Recorded
TESTING OF FINISHED PRODUCTS	APPEARANCE	According to the lot size of the order	☐
	COATING THICKNESS (ISO 2360)	According to the lot size of the order	☐
	GLOSS (ISO 2813)	Once in every working shift for each shade and manufacturer	☐
	WET ADHESION	Once in every working shift All samples from one day may be tested together	☐
PANEL TESTING	DRY ADHESION (ISO 2409)	Minimum of 1 x sample* for every two production hours	☐
	POLYMERISATION TEST (OPTIONAL FOR POWDER COATINGS)	Once in every working shift for each colour shade and gloss category and for each manufacturer	☐
	BEND TEST (ISO 1519)	Minimum of 1 x sample* for every two production hours	☐
	IMPACT TEST (ASTM D 2794 and ISO 6272)	Minimum of 1 x sample* for every two production hours	☐
PROCESS TESTING	CHEMICAL PRETREATMENT BATHS	Once per bath in every working shift, or according to the chemical supplier's advice, that shall be at least once per day (24 hours)	☐
	CONDUCTIVITY OF DEMINERALISED RINSING WATER	Once per bath in every working shift, or according to the chemical supplier's advice, that shall be at least once per day (24 hours)	☐
	TEMPERATURE OF PRETREATMENT BATHS AND HOT WATER RINSE	Once per bath in every working shift, or according to the chemical supplier's advice, that shall be at least once per day (24 hours)	☐
	DRYING CONDITIONS	Drying temperature recording: once in every working shift Measurement on parts: once a week	☐
	WEIGHT OF CONVERSION COATING (CHROMATE/CHEMICAL PRETREATMENT)	Once in every working shift, or according to the chemical supplier's advice, that shall be at least once per day (24 hours)	☐
	WEIGHT OF ALUMINIUM REMOVED (etching degree)	Once in every working shift, or according to the chemical supplier's advice, that shall be at least once per day (24 hours)	☐
	STOVING CONDITIONS	Displayed temperature recording: once in every working shift Stoving curve: twice a week on profiles	☐

* The same panel to be chosen for DRY ADHESION, BEND TEST and IMPACT TEST

RECORDS AND REGISTERS

	YES	NO
up to date	☐	☐

PRODUCTION CONTROL REGISTER

	YES	NO
up to date	☐	☐

STANDARDS OR OPERATING INSTRUCTIONS BASED ON THE STANDARDS

	YES	NO
are available for all tests	☐	☐

Remarks

Report no.

7. OTHERS

Specifications

Is the latest edition of the QUALICOAT Specifications (including current Update Sheets) available to the person(s) responsible? YES ☐ NO ☐

Complaint book

Is a register for customer's complaints available? YES ☐ NO ☐

Use of the label (see Appendix A1 of the QUALICOAT Specifications)

Does the use of the logo comply with the regulations for use of the QUALICOAT quality label? YES ☐ NO ☐

Training attendance

Do employees participate in the trainings provided by the General Licensee? YES ☐ NO ☐

If Not, why?

INSPECTION BODY

DATE

INSPECTOR'S SIGNATURE

DATE

LABORATORY'S SIGNATURE

GENERAL LICENSEE

DATE

RESULT RECOMMENDATION TO QUALICOAT*

SATISFACTORY ☐

NOT SATISFACTORY ☐

REMARKS GL

* The final assessment is made by **QUALICOAT**

Report no.

SUMMARIZING SHEET

Form to be completed at the end of an inspection

COATER

LICENCE NUMBER

DATE OF INSPECTION

COATING LINE DESIGNATION

NAME OF INSPECTOR

INSPECTION NO.

-

Granting -

Renewal -

Repetition -

RESOLUTION OF PREVIOUS ISSUES AND NONCONFORMITIES:

1

2

3

4

RESULTS

SUMMARY OF TESTS AND INSPECTION	ISSUES AND/OR NONCONFORMITIES	COATER'S REMARKS
INSPECTION OF MATERIALS (5.1.1.)		
INSPECTION OF LABORATORY EQUIPMENT (5.1.2)		

Report no. _____

SUMMARY OF TESTS AND INSPECTION	ISSUES AND/OR NONCONFORMITIES	COATER'S REMARKS
INSPECTION OF PRODUCTION PROCESS AND EQUIPMENT (5.1.3) + INSPECTION OF PRETREATMENT (5.1.4)		
INSPECTION OF FINISHED PRODUCTS EXCLUDING LABORATORY TEST RESULTS (5.1.5) + PANELS (5.1.6)		
REVIEW OF IN-HOUSE CONTROL AND REGISTERS (5.1.7)		
OTHERS (CLAIMS REGISTER, USE OF THE LABEL, ETC.)		

INSPECTOR'S SIGNATURE

PLANT MANAGER'S SIGNATURE

ANNEX I
SUPPLEMENT FOR MONITORING SEASIDE

1. SEASIDE **PRETREATMENT** TYPE

A1 ☐ (simple acid etching)

A2 ☐ (acid etching + acid etching)

AA1 ☐ (alkaline etching and acid etching)

AA2 ☐ (acid etching + alkaline etching + acid etching)

			MEASURED	
SAMPLE	Initial weight	P1 [g]		g
	Surface area	S [m²]		m²
ACID ETCHING	Weight after Weight after acid	P2 [g]		g
	Weight loss	D1 = (P1-P2)/S [g/m²]		g/m²
ALKALINE ETCHING	Weight after alkaline etching	P3 [g]		g
	Weight loss	D2 [g/m²]		g/m²
ACID ETCHING	Weight after acid etching	P4 [g]		g
	Weight loss	D3 [g/m²]		g/m²
Total Weight loss		D = D1 + D2 + D3 [g/m²]		g/m²

Remarks

2. **FILIFORM** CORROSION TEST

The inspector takes three samples (sections) from different lots.
The results should be classified according to the rating scale below:

A. 3 samples satisfactory 0 samples unsatisfactory
B. 2 samples satisfactory 1 samples unsatisfactory
C. 1 samples satisfactory 2 samples unsatisfactory
D. 0 samples satisfactory 3 samples unsatisfactory

SAMPLE No.	RESULTS				SATISFACTORY
	Longest filament	≤ 4 mm	L:		YES ☐ NO ☐
	Average length of filaments	≤ 2 mm	M:		
	Longest filament	≤ 4 mm	L:		YES ☐ NO ☐
	Average length of filaments	≤ 2 mm	M:		
	Longest filament	≤ 4 mm	L:		YES ☐ NO ☐
	Average length of filaments	≤ 2 mm	M:		

FFC Classification -

Remarks

ANNEX II
SUPPLEMENT FOR ANODIC PRETREATMENT

1. DEGREASING - ETCHING - DESMUTTING

		DEGREASING	ETCHING	DESMUTTING*
SUPPLIER				
PRODUCT				
Temperature (°C)	required			
	measured			
Concentration	required			
	measured			
Immersion/spray time (min)	required			
	measured			

* mandatory for Alkaline etching

Total etching rate g/m² (≥ 2g/m2 requested) Remarks

2. ANODISING

	RECOMMENDED	MEASURED	INHOUSE CONTROL FREQUENCY	RECORDED
Temperature of anodising bath	20 - 30 °C		Every 8 hours	☐
Acid concentration	180 – 220 g/l		Once per day	☐
Aluminium content	5 – 15 g/l		Once per day	☐

Remarks

3. CONVERSION TREATMENT

	REQUIRED		MEASURED	
Temperature		°C		°C
Concentration/ extinction		-		-
Conductivity		µS/cm		µS/cm
Immersion/spray time		-		-
pH value				

Remarks

4. RINSING

	REQUIRED	MEASURED	INHOUSE CONTROL FREQUENCY	RECORDED
Conductivity of the final rinse	30 µS/cm at 20 °C		Minimum once per day	☐
Conductivity of dripping water	30 µS/cm at 20 °C		Minimum once per day	☐

Remarks

5. PROCESS REQUIREMENTS

Passivation after pre-anodising with QUALICOAT AP-No.

Is there a written confirmation from the powder manufacturer on the compatibility with this type of pretreatment? YES ☐ NO ☐

Remarks

Is each coating material (i.e., each colour shade, gloss category, and manufacturer) tested for boiling water resistance prior to coating, followed by an adhesion test (see § 2.4)? YES ☐ NO ☐

Remarks

Is a wet adhesion test carried out every 4 hours during the application? YES ☐ NO ☐

Remarks

Is the etching rate checked once per day? YES ☐ NO ☐

Remarks

Is the thickness of the anodic coating checked with every load? YES ☐ NO ☐

Remarks

Are the pre-anodised parts stored for longer than 16 hours? YES ☐ NO ☐

Is an additional rinsing done? YES ☐ NO ☐

Is the total time between pre-anodising and coating less than 72 hours? YES ☐ NO ☐

Remarks

6. THICKNESS OF ANODIC FILM (Anodic coating without powdering and surface flaws)

ORDER NO. | **LOT SIZE**

Section	1	2	3	4	5	6	7	8	9	10
Thickness in [µm]										

ORDER NO. | **LOT SIZE**

Section	1	2	3	4	5	6	7	8	9	10
Thickness in [µm]										

ORDER NO. | **LOT SIZE**

Section	1	2	3	4	5	6	7	8	9	10
Thickness in [µm]										

Remarks

7. FILIFORM CORROSION TEST

The inspector takes three pre-anodised sections from different lots.
The results should be classified according to the rating scale below:

A. 3 samples satisfactory 0 samples unsatisfactory
B. 2 samples satisfactory 1 samples unsatisfactory
C. 1 samples satisfactory 2 samples unsatisfactory
D. 0 samples satisfactory 3 samples unsatisfactory

SAMPLE No.	RESULTS				SATISFACTORY
	Longest filament	≤ 4 mm	L:		YES ☐ NO ☐
	Average length of filaments	≤ 2 mm	M:		
	Longest filament	≤ 4 mm	L:		YES ☐ NO ☐
	Average length of filaments	≤ 2 mm	M:		
	Longest filament	≤ 4 mm	L:		YES ☐ NO ☐
	Average length of filaments	≤ 2 mm	M:		

FFC Classification -

Remarks

ANNEX III
SUPPLEMENT FOR OFF-SITE ANODIC PRETREATMENT

1. QUALANOD licence no. of anodiser

QUALICOAT licence no. of anodiser

2. Checklist outsourced work (off-site anodiser)

Date order is given

Unique reference

(e.g. order no. / job card no. / process no. for reference)

Type of product: Profiles ☐ Sheets ☐ Others ☐

Bill of material includes

Numbers		Lengths		Perimeter		m^2		Drawings	
YES	NO	YES	NO	YES	NO	YES	NO	YES	NO
☐	☐	☐	☐	☐	☐	☐	☐	☐	☐

If NO specify

Alloy

Requested treatment: PreOx ☐ | Declared layer thickness ☐ 4-10µm

Remark

Delivery of treated parts: From Extruder/ Trader ☐ From Powder Coater ☐ | Complete delivery ☐ Partial delivery ☐

Exit control by anodiser: YES ☐ NO ☐

Visual check: OK ☐ NOT OK ☐

Remark

Extra samples provided: YES ☐ NO ☐

Are the extra samples declared to be made of the same material as the delivery? YES ☐ NO ☐

If not specify

Date of Anodising production **(A)** (use dropdown calendar)

Time of Anodising production **(A)**

Date of Sample production (use dropdown calendar)

Time of Sample production

3. Delivery appointments between sender and recipient

(storage period in accordance with 3.4 of the QUALICOAT Specifications)

(use dropdown calendars)

Date of material receipt		(effective goods receipt date)
Delivery material latest		(date of the final delivery completion)
Desired pick up date		(originally requested pick up date)

Remarks

4. Preliminary in-house control of pre-Ox by the coater

(incoming goods inspection before production)

Checks packaging at receipt OK ☐

Are the extra samples made of the same material as the delivery? YES ☐ NO ☐

Film thickness check OK ☐

Measurements

Average of 10 measurements

µm

Visual check of products satisfactory YES ☐ NO ☐

Remarks

Rinsed upon arrival (<30µS) YES ☐ NO ☐

Specify

Additional wet adhesion test for powders used for the first time on pre-Ox YES ☐ NO ☐

(NO = to be carried out on a preproduction sample)

Feedback In-House Control Anodiser of process / parameters YES ☐ NO ☐

Receipt of suitability of powder coating from coating supplier YES ☐ NO ☐

5. Coating production

(incoming goods inspection before production)

Date of coating production (B)

Time of coating production (B)

Elapsing time between Anodising (A) and Coating (B) less than 72h? YES ☐ NO ☐

Are the pre-treated parts handled with clean textile gloves? YES ☐ NO ☐

Is the resistance to boiling water, followed by an adhesion test carried out every 4 hours during application? YES ☐ NO ☐

Remarks

ANNEX IV
BATCH PRETREATMENT INSPECTION

PROCESS INSPECTION (see section 3)

1. Material and separators

Aluminium ☐ Stainless steel ☐

Others ☐ Specify

2. Shape and number of separators

Shape | Number

Contact width: (maximum 2 mm) | (The maximum contact widths must be effective and not nominal)

Remarks

3. Flow of liquid

Distance between the section | Correct (minimum 1 cm) YES ☐ NO ☐

Remarks

4. Hooping

MATERIAL USED

Aluminium ☐ Stainless steel ☐

Others ☐ Specify

MAXIMUM CONTACT WIDTHS

	YES	NO
Correct (maximum 2 mm)	☐	☐

Remarks

5. Boiling water test (only for granting a licence)

	YES	NO
Satisfactory	☐	☐

Remarks

Report no.

ADDITIONAL FILES UPLOAD 1/4

INSTRUCTION: Click on the empty area to upload a document/image here

Report no.

ADDITIONAL FILES UPLOAD 2/4

INSTRUCTION: Click on the empty area to upload a document/image here

Report no.

ADDITIONAL FILES UPLOAD 3/4

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Report no.

ADDITIONAL FILES UPLOAD 4/4

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