



Update of QUALICOAT Specifications 2024

Update Sheet No. 03

applicable from 01.07.2024

Subject: Various adjustments

Proposals/Requests: Adjustments and corrections are requested/proposed by the WGs and/or QUALICOAT

QUALICOAT Resolutions: **Resolution No. 1/TC 2024.05.16**
The TC approved the following update sheets with implementation date 1st July 2024:
3. SPEC 2024-US03 - Various adjustments

Amendment to the Specifications:

- **3.4.1.4 Post-treatment and rinsing after pre-anodising**
Additional text for more clarity
- **2.20 Scratch and mar resistance test (Martindale)**
Deletion of footnote regarding data collection period
- **Chapter 3 – Work Specifications and Appendix A15 – Specifications for off-site anodisers**
Clarification of wording in sections:
 - 3.3.1 Chromate conversion coatings
 - 3.3.2 Chemical pretreatments, sub-section a) Rinse systems
 - 3.4.1.4 Post-treatment and rinsing after pre-anodising
 - 3.4.2.3 Pretreatment and rinsing prior to coating
 - APPENDIX A15 – Specifications for off-site anodisers (§1.4)

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No.	Background/Source	Amendments
1	<p><u>Pre-anodising WG / 17.01.2024 – Item 3</u></p> <p><i>For clarity, the Pre-anodising WG agreed that an update sheet shall be prepared to include the additional text 'before coating' in §3.4.1.4</i></p>	<p>3.4.1.4 Post-treatment and rinsing after pre-anodising</p> <p>After anodic pretreatment, the aluminium shall be rinsed for such a time and at such a temperature as is required to remove the acid from the pores and to fulfil the requirements of the wet adhesion test.</p> <p>Enhancing rinsing with a hot sealing step and/or a passivation step with a QUALICOAT approved chemical pretreatment system or chromate conversion coating is permitted. The rinsing process shall not produce a sealed surface, as this increases the risk of adhesion failure. No-rinse passivation is not permitted when a period of 16 hours has passed before coating.</p> <p>[...]</p>
2	<p><u>Powders WG / 14-15.02.2024 – Item 12</u></p> <p><i>Powders WG agreed that Martindale test is mandatory for any new approvals and renewals 2024 without any changes in the current requirement. The test should also be included in P-TAC (Procedure for testing and approving coating materials).</i></p>	<p>2.20 Scratch and mar resistance test (Martindale)⁷</p> <p>[...]</p> <hr/> <p>⁷Implementation for data collection with real application by the laboratories from 2020 renewals (Florida exposure 2021–2022/3/4). No consequence on test results in case of failure until 2022 renewals.</p>
3	<p><u>24.04.2024</u></p> <p><i>Clarification of wording in Chapter 3 – Work Specifications and Appendix A15 – Specifications for off-site anodisers, in consultation with JS, MKR, MP & RH</i></p> <p>Sections</p> <ul style="list-style-type: none"> • 3.3.1 Chromate conversion coatings • 3.3.2 Chemical pretreatments, sub-section a) Rinse systems • 3.4.1.4 Post-treatment and rinsing after pre-anodising • 3.4.2.3 Pretreatment and rinsing prior to coating • APPENDIX A15 – Specifications for off-site anodisers (§1.4) 	<p>3.3.1 Chromate conversion coatings</p> <p>[...]</p> <p>Demineralised water shall be used for the final rinse after chemical chromate conversion before drying. When measured on open sections, the conductivity of the dripping water shall not exceed a maximum of 30 µS/cm at 20°C.</p> <p>Any spray and cascade installation shall be designed (or retrofitted) to allow sampling for measuring the conductivity as described above. The conductivity of the dripping water should only shall be measured for on open sections and not for can also be measured on hollow sections.</p> <p>[...]</p> <p>3.3.2 Chemical pretreatments</p> <p>[...]</p> <p>a) Rinse system</p> <p>[...]</p> <p>When measured on open sections, the conductivity of the dripping water of all chemical pretreatment systems with a final rinse shall not exceed a maximum of 30 µS/cm at 20°C.</p> <p>Any spray and cascade installation shall be designed (or retrofitted) to allow sampling for measuring the conductivity as described above. The conductivity of the dripping water should only shall be measured for on open sections and not for can also be measured on hollow sections.</p> <p>[...]</p>

3.4.1.4 Post-treatment and rinsing after pre-anodising

[...]

When measured on open sections, the conductivity of the dripping water of the final rinse prior to coating shall not exceed a maximum of 30 $\mu\text{S}/\text{cm}$ at 20°C. The final rinse prior to the coating shall be performed in either the anodising or coating line.

Any spray and cascade installation shall be designed (or retrofitted) to allow sampling for measuring the conductivity as described above. The conductivity of the dripping water ~~should-only~~ shall be measured ~~for~~ on open sections and ~~not-for~~ can also be measured on hollow sections.

[...]

3.4.2.3 Pretreatment and rinsing prior to coating

[...]

When measured on open sections, the conductivity of the dripping water of the final rinse prior to coating shall not exceed a maximum of 30 $\mu\text{S}/\text{cm}$ at 20°C. The conductivity of the dripping water ~~should-only~~ shall be measured ~~for~~ on open sections and ~~not-for~~ can also be measured on hollow sections.

[...]

A15 – Specifications for off-site anodisers

[...]

1.4 Post-treatment and rinsing after pre-anodising

[...]

When measured on open sections, the conductivity of the dripping water of the final rinse prior to coating shall not exceed a maximum of 30 $\mu\text{S}/\text{cm}$ at 20°C. The final rinse prior to the coating shall be performed in either the anodising or coating line. The conductivity of the dripping water ~~should-only~~ shall be measured ~~for~~ on open sections and ~~not-for~~ can also be measured on hollow sections.

[...]
