Update of QUALICOAT Specifications 2024

Update Sheet No. 02

applicable from 01.07.2024

Subject:	Reference Temperature
Proposal / Requests:	**QUALISURFAL / 2023.09.18** With consideration that all test instruments were globally calibrated at 25°C; the QUALISURFAL Committee requested for an Update Sheet to specify the reference temperature as 25°C (instead of from 20°C). This reference temperature shall be harmonised throughout the Specification and for all inspection reports. **Pretreatment WG / 2024.01.17** The Pretreatment WG agreed that the reference temperature shall be specified as 25°C (instead of from 20°C) throughout the Specifications and an Update Sheet shall be prepared for TC's resolution in May 2024.
QUALICOAT Resolution:	**Resolution No. 11/TC 2023.11.15** The TC tasked the Pretreatment WG to create an update sheet to specify the reference temperature as 25°C (instead of from 20°C). **Resolution No. 1/TC 2024.05.16** The TC approved the following update sheets with implementation date 1st July 2024: 2. SPEC 2024-US02 - Reference Temperature (as amended in the meeting)
Amendment to the Specifications:	Updates in: • §3.3.1, §3.3.2, §3.4.1.4, §3.4.2.2, §3.4.2.3 & §3.5 • Appendix A15, 1.4 & 1.6

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Document Code:	SPEC 2024 – US02
QQM Section:	7.8.2
Date Approved:	17.05.2024
Approved by:	Executive Committee
Valid from:	01.07.2024
Version:	02
No. of Pages:	3

3.3 Chemical conversion coatings

[…]

3.3.1 Chromate conversion coatings

[…]

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 µS/cm at ~~20°C~~ 25°C.

[…]

In the event that it is not possible to measure the conductivity of the dripping water for immersion installation, the conductivity of the rinse water in the process tank shall be measured with a maximum conductivity of 15 µS/cm at ~~20°C~~ 25°C before immersion starts.

[…]

3.3.2 Chemical pretreatments

[…]

a) Rinse system

There is a final rinse after the conversion coating stage.

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~~ 25°C.

[…]

In the event that it is not possible to measure the conductivity of the dripping water for immersion installation, the conductivity of the rinse water in the process tank shall be measured with a maximum conductivity of 15 µS/cm at ~~20°C~~ 25°C before immersion starts.

b) No-rinse system

There is no final rinse after the conversion stage (a spray mist step after the conversion stage is not considered as final rinse).

The conductivity of the dripping water of the last rinse before the conversion stage shall not exceed a maximum conductivity as prescribed by the chemical supplier in the manual adapted to the coating line, which shall not be higher than 100 µS/cm at ~~20°C~~ 25°C.

[…]

3.4 Anodic pretreatment (automatic SEASIDE endorsement)

[…]

3.4.1.4 Post-treatment and rinsing after pre-anodising

[…]

The conductivity of the dripping water of the final rinse prior to coating shall not exceed a maximum of 30 µS/cm at ~~20°C~~ 25°C. The final rinse prior to the coating shall be performed in either the anodising or coating line.

[…]

In the event that it is not possible to measure the conductivity of the dripping water for immersion installation, the conductivity of the rinse water in the tank shall be measured with a maximum conductivity of 15 µS/cm at ~~20°C~~ 25°C before immersion starts.

3.4.2.2 Storage time and transportation

Pre-anodised parts shall not be stored for more than 16 hours. However, the parts may be stored (including transportation, where applicable) for up to 72 hours provided that additional rinsing has occurred with demineralised water with a conductivity of maximum 30 µS/cm at ~~20°C~~ 25°C and drying has taken place prior to coating (no etching allowed). The risk of insufficient adhesion increases the longer the parts are stored.

3.4.2.3 Pretreatment and rinsing prior to coating

[…]

The conductivity of the dripping water of the final rinse prior to coating shall not exceed a maximum of 30 µS/cm at ~~20°C~~ 25°C. The conductivity of the dripping water should only be measured for open sections and not for hollow sections.

[…]

3.5 Electrophoretic coatings

All electrocoated products shall be cleaned by adapted chemical treatment in an alkaline or acid solution before the topcoat is applied. The cleaned surfaces shall be rinsed in demineralised water with a maximum conductivity of 30 µS/cm at ~~20°C~~ 25°C prior to coating. The surfaces should be wettable with water.

[…]

A15 – Specifications for off-site anodisers

[…]

1.4. Post-treatment and Rinsing after Pre-anodising

[…]

The conductivity of the dripping water of the final rinse prior to coating shall not exceed a maximum of 30 µS/cm at ~~20°C~~ 25°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 be measured for open sections and not for hollow sections.

In the event that it is not possible to measure the conductivity of the dripping water for immersion installation, the conductivity of the rinse water in the tank shall be measured with a maximum conductivity of 15 µS/cm at ~~20°C~~ 25°C before immersion starts.

[…]

1.6. Storage time and transportation

Pre-anodised parts shall not be stored for more than 16 hours. However, the parts may be stored (including transportation, where applicable) for up to 72 hours, provided that additional rinsing has occurred with demineralised water with a conductivity of maximum 30 µS/cm at ~~20°C~~ 25°C and drying has taken place prior to coating (no etching allowed). The risk of insufficient adhesion increases the longer the parts are stored.