



# Update of QUALICOAT Specifications 2021 Update Sheet No. 08

applicable from 1 January 2022

**Subject:** Use of modal verbs in the QCT Specifications

**Proposal/Request:** VOA / Ad-hoc Specifications WG

**Resolution No. 5/TC 2021-06-11**

**QUALICOAT Resolution:** The TC created an ad-hoc WG (AG, MKR, MP, SL) to clarify the wording issues of the Specifications raised in VOA's request I/2021.

**Amendment to the Specifications:**

- Insertion of a "Language" section to explain the use of modal verbs in Chapter 1 – General Information
- Replacement of “should” and “may” in various parts of the Specifications according to the definitions stated in Chapter 1, Language

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**Approved by:** Executive Committee

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## 1. General Information

[...]

### Training

The licensees shall attend training programmes organised regularly by the General Licensee or QUALICOAT.

### Language

The official version of these Specifications are derived from the English language version.

In the English language version, certain verbal forms have meanings which correspond to the requirements of the ISO/IEC Directives, Part 2, Clause 7.

The following verbal forms indicate strict requirements to be followed to comply with these Specifications and from which no deviation is permitted:

- Shall.
- Shall not.

The following verbal forms indicate that among several possibilities, one is recommended as particularly suitable, without mentioning or excluding others, or that a certain course of action is preferred but not necessarily required. Additionally, in the negative form, a certain possibility or course of action is deprecated but not prohibited:

- Should.
- Should not.

The following verbal forms indicate a course of action permissible within the limits of these Specifications:

- May.
- Need not.

The following verbal forms are used for statements of possibility and capability—whether material, physical, or causal:

- Can.
- Cannot.

### Terminology

[...]

Reference (SPEC 2021 – V02)	Amendments: “SHOULD” or “MAY” replaced by “SHALL” (or vice versa)
<p><b>2.2 Gloss</b></p>	<p>Note: if the significant surface is too small or the finish of the coating (structured finish type a , highly metallic finishes) unsuitable for the gloss to be measured with the glossmeter, the gloss <del>should</del> shall be compared visually with the reference sample provided by the powder coating supplier (from the same viewing angle).</p>
<p><b>2.3 Coating thickness</b></p>	<p><u>Liquid coating</u> To be defined by the liquid coating supplier and documented within a technical data sheet with the approval of the Executive Committee.</p> <p>Other organic coatings may require different thicknesses, but they <del>may</del> shall only be applied with the approval of the Executive Committee.</p> <p><b><u>Final assessment</u></b> None of the measured values <del>may</del> shall be less than 80% of the specified minimum value otherwise the thickness test as a whole will be considered unsatisfactory.</p>
<p><b>2.13 Natural weathering test</b></p>	<p><b>Exposure in Florida according to ISO 2810</b> The test <del>should</del> shall start in April.</p>
<p><b>2.15 Resistance to mortar</b></p>	<p><b>REQUIREMENTS:</b> The mortar shall be easy to remove without leaving any residues. Any mechanical damage to the organic coating caused by grains of sand <del>should</del> shall be disregarded.</p>
<p><b>3.3.2 Chemical pretreatments</b></p>	<p>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. The conductivity <del>shall</del> should only be measured for open sections and not for hollow sections.</p>
<p><b>3.6 Drying</b></p>	<p>For anodic pretreatment, the drying temperature <del>should</del> shall be less than 80°C to prevent the anodic coating from being sealed.</p> <p>Chemical pretreatment systems other than chromate conversion coatings <del>should</del> shall be dried following the manufacturer’s specifications.</p>
<p><b>4.1.1 Technical information</b></p>	<p><u>Technical Data Sheet</u> The manufacturer shall provide the coaters and the laboratory in charge with the relevant technical data sheet. It <del>should</del> shall include at least the following information: [...]</p> <p><u>Label</u> Labels <del>should</del> shall include at least the following information: [...]</p>

Reference (SPEC 2021 – V02)	Amendments: “SHOULD” or “MAY” replaced by “SHALL” (or vice versa)
<p><b>4.1.5.1</b> <b>Special approvals valid for single colours</b></p>	<p>If a coating material is produced for a single colour, tests shall be carried out only on the colour mentioned in the system name. The tests are the same as those specified in § 4.1.3.</p> <p>No other colours <del>may shall</del> be produced under the same approval number.</p>
<p><b>4.2.2</b> <b>Sampling</b></p>	<p>There are three options for sampling systems to be tested for renewal of approvals:</p> <ul style="list-style-type: none"> <li>- The inspector takes samples of the required colours during routine inspections at the coating plants.</li> <li>- The inspector takes samples directly at the system manufacturer's premises.</li> <li>- The manufacturer sends organic coating materials and coated panels to the laboratory in charge preferably by June, together with the relevant technical data sheet for each colour. The data sheet <del>should shall</del> include at least the following information: colour, gloss value and curing conditions (including range of times and temperatures). In countries where there is neither a General Licensee nor a testing laboratory, the coating manufacturer sends the selected colours to a laboratory approved by QUALICOAT.</li> </ul>
<p><b>6.1.4</b> <b>Recording and measuring the drying temperature</b></p>	<p>The drying temperature displayed shall be recorded at least once in every working shift.</p> <p>The temperature <del>should shall</del> be measured on parts at least once a week using a recording instrument or some other means such as thermochromic pencils or tablets.</p>
<p><b>Appendix A1</b> <b>Section 2.</b></p>	<p><b>2. Ownership of the Quality Label</b> The Quality Label is owned by QUALICOAT and <del>may shall</del> not be used by anyone unless authorised to do so by QUALICOAT.</p>
<p><b>Appendix A1</b> <b>Section 3.</b></p>	<p><b>3. Qualifications of applicant</b> Authorisation to use the Quality Label may be granted on condition that the applicant operates in accordance with the Specifications. This authorisation is governed by a contract. The granting of a licence or approval entitles the Holder to use the Quality Label for the products specified. The licence or approval <del>may shall</del> not be transferred.</p>
<p><b>Appendix A1</b> <b>Section 5.1</b></p>	<p><b>5.1. Use in general</b> The Holder <del>may shall</del> not make any alteration or addition to the logo when using it. In the event that the Holder's own brands or trademarks are used separately on or in connection with his products, these regulations <del>may shall</del> not be infringed in any manner whatsoever. Holders of an approval or licence shall at any time provide the GL with all information required as to the use of the logo.</p>
<p><b>Appendix A1</b> <b>Section 5.3</b></p>	<p><b>5.3 Use of the logo by manufacturers (coating manufacturers and manufacturers of pretreatment systems)</b> The QUALICOAT logo shall not appear on packaging or labels. In their business literature and documents, the coating manufacturers <del>may shall</del> only use the logo for products approved by QUALICOAT, stating: «Product approved by QUALICOAT». Wherever the logo is used, the phrase «QUALICOAT is a quality label for licensed coaters» should also appear in the document. For any other use of the logo, the coating manufacturers are required to submit all new documents mentioning QUALICOAT to their national association. In countries without a General Licensee, these documents <del>should shall</del> be submitted directly to the QUALICOAT Secretariat before publication.</p>

Reference (SPEC 2021 – V02)	Amendments: “SHOULD” or “MAY” replaced by “SHALL” (or vice versa)						
<p><b>Appendix A1</b> Section 6.1</p>	<p><b>6.1 Use of the logo by General Licensees (national or international associations)</b></p> <p>General Licensees are authorised to use the logo in the stipulated colours but always together with their respective logos or the legal designation of the national or international associations. The logo may also be used in conjunction with a national flag and by adding the name of the country. When the QUALICOAT logo or name is used on licensees' stationery or in correspondence, the national association's name <del>should</del> shall always be predominant to avoid any confusion between the licensee and QUALICOAT. Wherever the logo is used, the phrase «X<sup>18</sup> is the QUALICOAT General Licensee for Y<sup>19</sup>» should also appear in the document. The size of the logo may be altered provided that the geometrical proportions are maintained.</p>						
<p><b>Appendix A7</b> Section 3</p>	<p><b>A7 - – Specifications for batch treatment</b> [...]</p> <p><b>3. Testing method to evaluate contact mark areas</b></p> <p>Use a piece of a pretreated aluminium extrusion that has been marked by a separator. The area on the bar with the marks <del>should</del> shall be identified.</p>						
<p><b>Appendix A10</b></p>	<p><b>A10 – Summary of requirements for the approval of organic coating materials (all classes)</b></p> <table border="1" data-bbox="440 1041 1524 1209"> <tr> <td data-bbox="440 1041 539 1209"> <p>COATING THICKNESS 2.3</p> </td> <td data-bbox="539 1041 596 1209"> <p>ISO 2360</p> </td> <td data-bbox="596 1041 944 1209"> <p>Minimum thickness = 60 µm None of the values measured <del>may</del> shall be less than 80% of the specified minimum value</p> </td> <td data-bbox="944 1041 1125 1209"> <p>Same as class 1</p> </td> <td data-bbox="1125 1041 1294 1209"> <p>Same as class 1</p> </td> <td data-bbox="1294 1041 1524 1209"> <p>Minimum thickness= 50 None of the values measured <del>may</del> shall be than 80% of the specif minimum value.</p> </td> </tr> </table>	<p>COATING THICKNESS 2.3</p>	<p>ISO 2360</p>	<p>Minimum thickness = 60 µm None of the values measured <del>may</del> shall be less than 80% of the specified minimum value</p>	<p>Same as class 1</p>	<p>Same as class 1</p>	<p>Minimum thickness= 50 None of the values measured <del>may</del> shall be than 80% of the specif minimum value.</p>
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Reference (SPEC 2021 – V02)	Other amendments
<p><b>Appendix A6</b> Section 8.</p>	<p><b>9. RESPONSIBILITY AND COOPERATION WITH THE COATING APPLICATOR</b></p> <p>Manufacturers and coating applicators shall cooperate closely (see Chapter 3, <a href="#">§ 3.2.2</a>).</p> <p>[...]</p> <p>The methods for assessing the conversion coating may differ from one system to the next since there is not a pertinent standard. The manufacturer <del>shall</del> indicates how the coating applicator <del>should</del> has to monitor the quality of the chrome VI-free conversion coating during in-house control. A device to check the coating weight analytically shall be prescribed. QUALICOAT recommends the coating weight to be measured in every working shift, or according to the chemical manufacturer’s advice, which shall be at least once per day (see table in section <a href="#">6.5</a>).</p>