



# Update of QUALICOAT Specifications 2021 Update Sheet No. 09 applicable from 1 January 2022

**Subject:** Wording clarifications in sections 3.4 and 3.5

**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:**

- **Section 3.4** - Anodic pretreatment (automatic SEASIDE endorsement)
- **Section 3.5** - Electrophoretic coatings

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### 3.4 Anodic pretreatment (automatic SEASIDE endorsement)

[...]

#### Rinsing

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.

Enhancing rinsing with a hot sealing step or a passivation step (~~QUALICOAT approved~~) ~~alternative system step~~ with a QUALICOAT-approved chemical pretreatment system is permitted. The conductivity of the dripping water of the last rinse shall not exceed a maximum of 30  $\mu\text{S}/\text{cm}$  at 20°C. The conductivity shall only be measured for open sections and not for hollow sections.

[...]

#### Record of test results

[...]

- Anodising bath

[...]

- The thickness of the anodic coating shall be checked (every ~~lead~~ flight bar).

- Testing of the coated finished products

- Before application, each coating material (~~of a system and/or a manufacturer~~) (i.e., each colour shade, gloss category, and manufacturer) shall be tested for resistance to boiling water, followed by an adhesion test (see § [2.4](#)).

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### 3.5 Electrophoretic coatings

All electrocoated Pproducts ~~to be coated~~ shall be cleaned by an 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  $\mu\text{S}/\text{cm}$  at 20°C prior to topcoating. The surfaces should be wettable with water.

The products shall be ~~top~~ coated immediately.

All workers handling pre-treated parts shall wear clean textile gloves to avoid contamination of the surface.