



16th Edition of the QUALICOAT Specifications – Update Sheet – SPEC-US04

Subject: Colour deviation

Proposal/Request: Powders WG

Resolution No. 10/TC 22.11.17

QUALICOAT resolution: The TC asked the Powders WG to decide where acceptable tolerances should be published and to start working on a concept of RAL tolerances for coaters.

Valid from: 1 JANUARY 2020

Amendment to the Specifications: Amendments in § 2.1.

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2.1 Appearance

The appearance shall be evaluated on the **significant surface**.

The significant surface shall be defined by the customer and is the part of the total surface which is essential to the appearance and serviceability of the item. Edges, deep recesses and secondary surfaces are not included in the significant surface. The organic coating on the significant surface shall not have any scratches through to the base metal. When the organic coating on the significant surface is viewed at an oblique angle of about 60° to the upper surface, none of the defects listed below shall be visible from a distance of 3 metres: excessive roughness, runs, blisters, inclusions, craters, dull spots, pinholes, pits, scratches or any other unacceptable flaws.

The organic coating shall be of even colour and gloss with good hiding power. When viewed on site, these criteria shall be fulfilled as follows:

- for parts used outside: viewed at a distance of 5 m
- for parts used inside: viewed at a distance of 3 m

Specific requirements for testing and approving coating materials (laboratories):

The colour of the organic coating shall be measured on the significant surface.

The colour deviation (ISO 11664-4) from the certified RAL GL card shall not be greater than the limit prescribed in Appendix A8.*

* List of colour tolerances before granting or renewing an approval (for QUALICOAT laboratories)