

**Subject:**

Revised APPENDIX A5

**Proposal**

«Cast accessories» WG

**QUALICOAT resolution:**

Meeting on 21.06.07  
(ratified on 21.11.07)

**Date of application:**

January 2008

**Amendments to the Specifications:**

Appendix A5

Application Suspended  
UNDER STUDY

**See following pages**

## **A5 – Special specifications for coatings on aluminium accessories for architectural applications under the QUALICOAT quality label**

### **1. Introduction**

Accessories may be made of different alloys:

- Alloys conforming to **EN 1706** must be used for castings.
- EN AW 6060 or 6063 alloys conforming to **EN 573-3** must be used for extrusions.

The nature of the alloy and the production method determine the final quality of the coated accessory. Some cast alloys – especially those based on silicon and copper – are the cause of unsatisfactory resistance to corrosion.

The pretreatment cycle must be tailored to the alloy and the quality of the castings. Outdoor architectural applications require the use of special alloys which have good corrosion resistance classified as “A” in EN 1706 (see the table at the end of this Appendix).

It is the responsibility of the customer to define the alloy.

### **2. Work Specifications**

All the requirements set out in Chapter 3 of the Specifications are applicable to the treatment of accessories, **with the exception of the etching degree** which is not specified for castings (see Specifications, § 3.2.1).

### **3. Testing**

#### **3.1 Inspection of finished products**

The inspector must perform the following tests on the coated accessories:

- Appearance (Specifications § 2.1)
- Acetic acid salt spray test (Specifications § 2.10)
- Machu test (Specifications § 2.11)
- Polymerisation (Specifications § 2.14)

and if the geometry of the parts permits:

- Coating thickness (Specifications § 2.3)
- Adhesion (Specifications § 2.4)
- Indentation (Specifications § 2.5)

#### **3.2 Inspection of test panels**

Mechanical tests must be performed on test panels (as defined in Chapter 2) processed concurrently with a production lot.

- Gloss (Specifications § 2.2)
- Coating thickness (Specifications § 2.3)
- Adhesion (Specifications § 2.4)
- Indentation (Specifications § 2.5)
- Cupping test (Specifications § 2.6)

- Bend test (Specifications § 2.7)
- Impact test (Specifications § 2.8)

Apart from the restrictions above, please refer to the QUALICOAT Specifications.

**TABLE - Alloys for coating**

Alloy group	Alloy designation	Chemical symbols
AlMg	EN AC 51000	EN AC Mg3
	EN AC 51100	EN AC Mg3
	EN AC 51200	EN AC Mg9
	EN AC 51300	EN AC Mg5
	EN AC 51400	EN AC Mg5