

Siderise Mullion Cover paint inspection criteria

Siderise is the manufacturer and supplier of its patented mullion overcover system for both acoustic and fire applications.

The business sources fabricated metalwork that is powder coated and meets the standards set out in the **Qualicoat Specification 01/01/2021 REV 01** this covers the following:

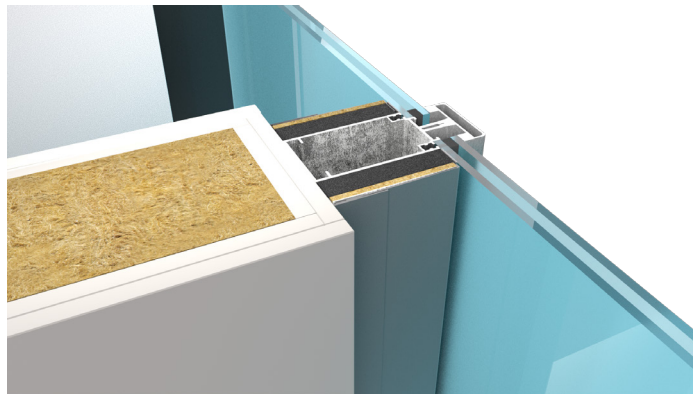
1. Gloss finish where applicable to ISO 2813, item 2.2.
2. Coating Thickness to ISO 2360, item 2.3.
3. Dry Paint adhesion to ISO 2409, item 2.4.
4. Wet Paint adhesion to ISO 2409, item 2.4.
5. Buchholz Indentation hardness testing to ISO 2815, item 2.5.
6. Cupping tests for the resistance of coating to cracking or detachment from the substrate, ISO 1520, item 2.6.
7. Bend Testing to ISO 1519, performed after mechanical deformation, item 2.7.
8. Impact Testing, that shall be carried out to the reverse side of the substrate as defined by ISO 6272 indent diameter 15.9mm followed by a tape pull test, item 2.8.
9. Resistance to humid atmospheres containing SO₂ to ISO 22479.
10. Acetic acid salt spray resistance to ISO 9227, item 2.10.
11. Machu test – accelerated corrosion, item 2.11.
12. Accelerated weathering, ISO 16474-2 where applicable, item 2.12. (1&2) This shall cover Gloss variation to ISO 2813 and colour change to ISO 11664-4.
13. Natural weathering testing to ISO 2810, Item 2.13.
14. Resistance to mortar EN 12206-1 (2.9), item 2.15.
15. Resistance to boiling water, item 2.16.
16. Constant climate condensation water test to ISO 6270-2, item 2.17.
17. Sawing, Milling and Drilling of the substrate as per item 2.18.
18. Filiform corrosion testing to ISO 4623-2 and assessed to ISO 4628-10, item 2.19.
19. Water spot test, item 2.20.
20. Scratch and Mar resistance testing to CEN/TS 16611, item 2.21.

Siderise carries out a 100% inspection of ALL metalwork and at the point of packing of each order.

The appearance shall be evaluated on the **significant surface** and is defined as 'part of the total surface which is essential to the appearance and serviceability of the item'.

Included:

- Male or Female Cover plates front facing edges.
- Outer facing edge of the Retaining Strip.



Not Included:

- Edges.
- Deep recesses.
- Secondary surfaces.

The organic coating on the significant surface shall NOT have any scratches through to the base metal.

Using normal or corrected vision (where applicable) – 20/20.

When the organic coating on the significant surface is viewed at an oblique angle of 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 metres.
- For parts used inside: viewed at a distance of 3 metres.