

Application Troubleshooting Guide

Condition	Possible Problem	Application Suggestions
Orange Peel	<ul style="list-style-type: none"> Improper or worn fluid tip Atomizing air too low 	<ul style="list-style-type: none"> Increase air pressure Decrease pot pressure Dilute with water to lower viscosity but do not exceed the amount stated in the dilution section Change spray distance from part of surface
Lumpiness on Surface After Spraying	<ul style="list-style-type: none"> Pot life of catalyzed material has been exceeded Check/reduce catalyst level Spray over improperly cured primer 	<ul style="list-style-type: none"> Mix paint well Check for sources of dirt on surface, filter or material hose Filter paint
Runs and Sags	<ul style="list-style-type: none"> Too much thinner and/or water used or increase solids level of paint Pot life of catalyzed material has been exceeded Improper spray technique Surface to be coated is too cold 	<ul style="list-style-type: none"> Atomizing air too low; increase air pressure Decrease pot pressure Too much thinner and/or water used Change spray technique Mix paint well Check surface temperature
Dry Spray	<ul style="list-style-type: none"> Surface to be coated is too hot Add thinner and/or water to reduce viscosity 	<ul style="list-style-type: none"> Reduce atomization pressure Adjust pot/fluid pressure Move spray gun closer to surface to be coated
Pin Holes	<ul style="list-style-type: none"> Did not dilute system to desired viscosity Surface contamination -- oil, silicone, etc. 	<ul style="list-style-type: none"> Dilute and lower the viscosity Apply thinner coats Reduce the temperature to slow down evaporation
Fish Eyes and Craters	<ul style="list-style-type: none"> Did not allow for sweat in time Silicone contamination on surface Oil on surface to be coated 	<ul style="list-style-type: none"> Allow coating to sweat in Filter paint Clean surface
Blistering Clouding, Blushing	<ul style="list-style-type: none"> Exceeded recommended film thickness Oil, fingerprints, grease on surface Lack of air circulation Moisture trapping 	<ul style="list-style-type: none"> Decrease film thickness Clean surface Allow longer flash for baking systems Do not expose coating to water before thoroughly dry Circulate air movement with fans
Wrinkling	<ul style="list-style-type: none"> Too much material on surface Check surface temperature Improperly cured primer coat 	<ul style="list-style-type: none"> Apply thinner coats as coating thickness may be too heavy Check that the primer is compatible and cured
Crawling	<ul style="list-style-type: none"> Surface contamination -- oil, silicone, etc. 	<ul style="list-style-type: none"> Clean substrate surface
Poor Adhesion	<ul style="list-style-type: none"> Poor preparation Incompatible primers Surface contamination -- oil, silicone, etc. 	<ul style="list-style-type: none"> Rough up the substrate surface Clean substrate surface Limit recoat time
Spray Gun Clogging	<ul style="list-style-type: none"> Pot life of catalyzed material has been exceeded 	<ul style="list-style-type: none"> Filter paint Clean spray gun
Short Pot Life	<ul style="list-style-type: none"> Check expiration date of material High temperature Material excessively mixed High temperature 	<ul style="list-style-type: none"> Mix slowly Keep material and water cool in warmer conditions Check expiration date of material Slowly add cool water when reducing
Foaming in the Pot	<ul style="list-style-type: none"> Material excessively mixed High temperature Check expiration date of material 	<ul style="list-style-type: none"> Mix slowly Keep material from excessive heat Check expiration date of material Slowly add cool water when reducing
Air Entrapment in Film	<ul style="list-style-type: none"> Check roller cover nap -- 1/4" to 3/8" Excessive film thickness 	<ul style="list-style-type: none"> Use recommended nap thickness Decrease film thickness
Tackiness	<ul style="list-style-type: none"> Exceeds air temperature and humidity levels Lack of Air circulation 	<ul style="list-style-type: none"> Check air temperature and humidity levels prior to application Circulate air movement in higher humidity conditions
Lap Marks	<ul style="list-style-type: none"> Not maintaining a wet edge Rolling into the coating and not feathering out lap marks Exceeding the recommended mils thickness 	<ul style="list-style-type: none"> Maintain wet edge Lift roller off when rolling Do not roll into coating but roll up to and feather lap marks