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Coatings Application Troubleshooting Guide

Problem	Possible Cause	Solutions
Product separating (Large areas of the product separating upon application)	Product too thin	> Apply thinner coats Review instructions on adjusting viscosity
	Pot pressure too low	> Increase pressure, 12 PSI recommended
	Gun pressure too low	> Increase pressure, 30 to 45 PSI active recommended
Orange peel effect (Finish has a dimpled appearance, similar to the texture of an orange peel)	Too much product	> Lower product output adjustment on gun
	No atomization	> Increase air pressure to gun
	Product too thick	> Adjust viscosity level as per instructions
Dry fume (Finish dull and rough, dry paint particles on surface)	Too much air at nozzle	> Decrease air pressure to gun and /or spray closer to surface
	Not enough product	> Increase product output adjustment on gun
Fish eyes (Small round depressions in the paint film, which normally appear as soon as product is applied)	Oil or grease, or silicon on surface	> Clean surface thoroughly with lacquer thinner or alcohol, reapply cleaning solution as per instructions
	Oil or water in air line	> Drain compressor and lines. > Drain & inspect all filters and separators. > Switch air lines > Clean pressure pot with lacquer and subsequently run lacquer thinner throughout spray equipment, including gun, then run cold water through equipment to rinse
	Contaminated rags	> Use only clean rags for prep work > Do not leave rags exposed to other contaminants
	Contaminated cleaning solution	> Keep caps or lids on cleaning solution containers. > If contaminated, discard solution and container appropriately.
	Silicone Contamination	> Clean pieces with solvent

Bad spray pattern	Air cap blocked	> Clean air cap thoroughly
	Nozzle blocked	> Clean nozzle thoroughly
	Damaged fluid needle	> Replace fluid needle
Blistering/Peeling – Paint coming off painted surface	Wrong cleaner used / cleaning not performed adequately	> Apply appropriate cleaning solution according to instructions
	Surface / Surrounding temperature too low	> Only apply when temperature at time of application and for next 24 hours will remain above 50°F.
	Surface exposed to precipitation while curing	> Painted surface must also be protected from precipitation for the first 24 hours
	Surface Contamination on Part	> Clean Surface with acetone or scuff surface
Heavy middle pattern	Incompatibility between surface material and coating	
	Atomizing air too low	> Increase air pressure to gun
	Air cap holes blocked	> Clean air cap thoroughly
Intermittent/Pulsating spray	Worn packing	> *Replace packing
	Air stuffing box nut too tight	> *Loosen air stuffing box nut
	Loose nozzle	> *Tighten nozzle
	Out of product	> Add product
Insufficient fluid flow	Blocked fluid nozzle	> Clean nozzle thoroughly
	Loss of air pressure	> Check air source/hose connections
	Blocked air pressure	> Clean air passage with brush
Coarse/Lumpy finish	Dirt or dust on surface	> Tack wipe surface
	Product contains particles	> Strain product before use
Runs/Sags	Product too thin	> Apply thinner coats > Review instructions on adjusting viscosity
	Passes too slow	> Speed up at 4-6 " distance
	Surface too cold	> Increase surface temperature
	Too much product	> Lower product output adjustment on gun

Paint Leak	Needle damaged	> *Replace fluid nozzle
	Loose nozzle/Packing set	> *Tighten nozzle and packing set
	Needle not closing	> *Replace valve spring
Pin Holes	Trapped Air	> Stir coating, never shake it. > Don't force dry too quickly, air needs to release before oven or IR exposure
* Consult your spray equipment manufacturer's operator's manual for more detailed information.		