



TROUBLE SHOOTING GUIDE



Duratec® Polyester Base Primer

Duratec Polyester Base Primer (707-051 Tan)

| Problem | Cause | Solution |
|-------------------|--|--|
| "Alligatoring" | Not enough catalyst used. | Check for proper catalyst levels. |
| | Substrate/primer incompatibility, chemical reaction. | Check compatibility of surfaces and products. |
| | Primer sprayed on cold surface. | Expose surface to higher temperature before spraying when ambient temperature is below 60°F, 16°C. |
| Blisters | Substrate not cured, gassing underneath primer. | Completely cure putties, pastes and compounds before applying base primer. |
| Cracking | Primer sprayed too thickly, too fast. | Increase the number of passes, adding dwell time between coats. For exceptionally thick buildup, allow for gel to occur before spraying and sanding further. |
| | Primer sprayed on cold surface; primer cure inhibited. | Expose substrate surface to higher temperature before spraying when ambient temperature is below 60°F, 16°C. |
| Dimples (craters) | Film build-up too rapid, solvent trapped in primer. | Increase the number of passes with less primer per pass to achieve desired thickness. Allow for "flash-off" between passes. |



Hawkeye Industries Inc.

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| Dry over-spray | Acetone used as a thinner. | Use slower solvent such as mek or Duratec Thinner. |
| | Spray pressure too high. | Set line pressure at 35-50 psi. |
| | Spray gun orifice too small. | Use larger orifice. |
| Fillers float to top of container, forming "crust" | Low-viscosity fillers float rather than sink. | Store containers upside down. Machine mix in the can. |
| Fisheyes | Substrate contaminated. | Do not use a "tack rag", slow evaporating solvent or solvent soluble or colored rags or colored paper to wipe the substrate surface. |
| | Contamination in the air. | Spray in a clean area to minimize airborne dust, water, waxes and/or silicones. |
| | Contamination in the air line. | Spray with dry, filtered air. |
| Gelling in the container | Outdated product. | Replace with new primer. Rotate products to use older primers first. |
| Lifting or peeling | Substrate not cured or substrate and base primer incompatible. | Completely cure putties, pastes and compounds before applying primer. Check compatibility of surfaces and products. |
| | Substrate too absorbent. | Apply Duratec Polyester Sealer (#823) prior to applying the primer. |



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| Orange peel | Spray equipment set up incorrectly. | Follow the instructions for equipment setup. |
| | Spray pressure incorrect. | Set pressure at 35-50 psi. |
| | Pot pressure incorrect. | Set pot pressure at 10-12 psi. |
| | Viscosity too high. | Thin with Duratec Thinner or mek solvent. |
| Pinholes | Substrate porosity. | Fill porous areas with product using squeegee, brush or roller before spraying. |
| Plug/pattern surface has rough finish | Base primer or fairing primer used as a plug/pattern surface. | Never use these two primers as plug/pattern topcoat. |
| Primer not easily mixed | Low-viscosity fillers float rather than sink. | Machine agitate the product in the container. |

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