Hawkeye Industries Inc.

TROUBLE SHOOTING GUIDE

Duratec® Polyester Hi-Gloss Coating

Duratec Polyester Hi-Gloss Coating (904-040 Clear, 602-021 Black, 608-021 Orange, 604-041 Un-pigmented)

Problem	Cause	Solution
"Alligatoring"	Not enough catalyst used.	Check for proper catalyst levels.
	Substrate/primer incompatibility, chemical reaction.	Check compatibility of surfaces and products.
	Coating sprayed on cold surface.	Expose surface to higher temperature before spraying when ambient temperature is below 60°F, 16°C.
Curing occurs on surface but not on substrate interface	Coating sprayed on cold surface; coating 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 product per pass to achieve desired thickness. Allow for "flash-off" between passes.
Dry over-spray	Acetone used as a thinner.	Use slower solvent such as mek or Duratec Thinner.
	Spray pressure too high.	Set pressure at 35-50 psi.
	Spray gun orifice too small.	Use larger orifice.

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Fisheyes	Substrate contaminated.	Do not use a "tack rag", slow evaporating solvent or solvent soluble or colored rags or 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Gelling in the container	Outdated product.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 coating. Rotate products to use older primers first.
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.

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Porosity	Spray pressure too high.	Reduce pressure to 35-50 psi.
	Spray orifice too small.	Use larger orifice.
	Acetone used as thinner.	Use slower solvent such as Duratec Thinner or mek.
Sagging on vertical surface	Coating applied too quickly.	Adjust spray equipment to spray 2-4 mils, 50-100 microns per pass and allow solvent "flash-off" time between passes.
	Spray gun orifice too large.	Use smaller orifice.
Surface not hard or glossy	Coating not allowed to "breathe" after sanding.	After sanding, allow time for solvents to escape before compounding and polishing.
	Surface wet sanded when undercured; coating absorbed water.	Dry sand with initial sanding step. Wet sand after "breathing" occurs.
	Ambient temperatures less than 60°F, 16°C when coating was sprayed.	Expose surface to higher temperature before spraying.
	Coating undercatalyzed.	Catalyze at 2 percent with full strength mekP catalyst.
	Low reactivity catalyst used.	Do not use 30 percent mekP catalyst or a catalyst with less than 8.8 percent active oxygen.

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