



# TROUBLE SHOOTING GUIDE



## Duratec® Polyester Hi-Gloss Topcoat

### Duratec Polyester Hi-Gloss Topcoat (904-045 Clear)

<b>Problem</b>	<b>Cause</b>	<b>Solution</b>
"Alligating"	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Gelling in the container	Outdated product.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. Spray orifice too small. Acetone used as thinner.	Reduce pressure to 35-50 psi. Use larger orifice. 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.
Surface not hard or glossy	Spray gun orifice too large. Coating not allowed to "breathe" after sanding. Surface wet sanded when undercured; coating absorbed water. Ambient temperatures less than 60°F, 16°C when coating was sprayed. Coating undercatalyzed. Low reactivity catalyst used.	Use smaller orifice. After sanding, allow time for solvents to escape before compounding and polishing. Dry sand with initial sanding step. Wet sand after "breathing" occurs. Expose surface to higher temperature before spraying. Catalyze at 2 percent with full strength mekP catalyst. Do not use 30 percent mekP catalyst or a catalyst with less than 8.8 percent active oxygen.

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