



TROUBLE SHOOTING GUIDE



Duratec® Vinyl Ester Fairing Primer

Duratec Vinyl Ester Fairing Primer (1799-051 Blue)

Problem	Cause	Solution
"Alligating"	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.





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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Gelling in the container	Outdated product.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.



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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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