



TROUBLE SHOOTING GUIDE



Duratec® Vinyl Ester Solventless Primer

Duratec Vinyl Ester Solventless Primer (1794-034 White, 1799-034 Gray)

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.
	Substrate not cured, gassing underneath primer.	Completely cure putties, pastes and compounds before applying 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.
Curing occurs on surface, but not on substrate interface	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.
	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.
Gelling in the container	Contamination in the air line.	Spray with dry, filtered air.
	Outdated product.	Replace with new primer. Rotate products to use older primers first.
Lifting or peeling	Substrate not cured or substrate and primer incompatible.	Completely cure putties, pastes and compounds before applying primer. Check compatibility of surfaces and products.



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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.
Pattern surface sticks to mold upon release	Viscosity too high.	Thin with Duratec Thinner or mek solvent.
	Improper release preparation.	Follow manufacturer's instructions when applying release materials.
	Primer not fully cured before compounding and polishing.	Follow instructions in the application guide for pattern surfacing.
	Excessive gel time for tooling gel coat.	Follow manufacturer's recommendations for gel time.
Pinholes	Improper release materials.	Use only sealer-glaze and wax release materials.
	Substrate porosity.	Fill porous areas with product using squeegee, brush or roller before spraying.



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Plug/pattern surface not hard or glossy	Primer not allowed to “breathe” after sanding.	Allow time for solvents to escape before compounding and polishing.
	Surface wet sanded when undercured; primer absorbed water.	Dry sand with initial sanding step. Wet sand after “breathing” occurs.
	Ambient temperature less than 60°F, 16°C when primer was sprayed.	Expose surface to higher temperature before spraying.
	Low reactivity catalyst used.	Do not use 30 percent mekP catalyst or a catalyst with less than 8.8 percent active oxygen.
Plug/pattern surface loses gloss during mold building	Primer not fully cured prior to compounding and polishing.	Dry sand with initial sanding step. Wet sand after “breathing” occurs.
	Old, outdated primer.	Add 0.2 percent of 6 percent cobalt to primer and test for gel time.
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 mek or Duratec Thinner.



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Pre-release of primer when used in-mold	Primer sprayed too thickly.	Spray from 8-20 mils, 200-500 microns thick.
	Primer not completely mixed.	Machine mix completely prior to spraying,
	Primer not continuously mixed.	Agitate continuously when spraying,
	Improper release system used.	Use higher surface energy release system.
Print through (developed during mold building) transfers to mold.	Putties, pastes and compounds under primer not cured.	Completely cure putties, pastes and compounds before priming.
	Putties, pastes and compounds post-shrink with exposure to excessive exotherm.	Use qualified putties, pastes and compounds for acceptable heat distortion temperatures.
	Exposure to excessive exotherm during mold building.	Maintain exotherm below 200°, 93°C during mold building.

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