

DECORATIVE COATINGS

GENERAL TECHNICAL DATA SHEET

AIRLESS SPRAY APPLICATION : TROUBLE SHOOTING CHART

DEFECT	CAUSE	SUGGESTED CORRECTION
Runs and Sags	- Improper spray technique	Avoid excessive wet film thickness. and / or excessive thinning
	- Gun is passed too close to workpiece	The spray gun should be held at a distance about 1 ft. (30 cm) from the surface for general work.
	- Gun held at wrong angle to surface	Hold gun at right angle to the surface and move in a straight line parallel to surface.
	- Excessive deposit	In addition to the above suggestions, check spray nozzle for excessive wear or improper selection.
	- Excessive dilution	Paint materials have a range of viscosity and solid contents below which it cannot be diluted and still hold specified film thickness. Therefore, do not thin the paint unless absolutely necessary.
Streaks	- Wrong nozzle	Select a smaller nozzle
	- Nozzle is worked out	Select a new nozzle
	- Incorrect overlapping of strokes.	Follow the previous stroke accurately.
	- Too high viscosity	Increase pressure / thin down the paint.



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Too high film	- Improper technique	See notes for “Runs and Sags” Use a smaller nozzle. Hold the gun at right angle to the surface.
Dry over-spray	- Excessive atomisation Nozzle too small, Improper technique	Reduce pressure. Use a large nozzle. Hold spray gun closer to workpiece. Trigger gun at edges. Spray at right angles to workpiece.
Excessive spray fog	- Excessive atomisation	Reduce pressure
	- Paint thinned down too much	Only the correct amount of thinner should be added.
Pinholes	- Paint film too heavy	Apply less wet film thickness.
	- Poor atomisation	Increase pressure.
Orange peel	- Paint not thinned sufficiently	Add the correct amount of thinner.
Blistering	- Rust, oil or grease on surface	Degrease the surface properly before painting.
	- Moisture on or in the surface	Surface temperature must be above the dew point.
	- Solvents trapped under dried paint	Use a faster solvent.