



**PROTECTIVE COATINGS**

**GENERAL TECHNICAL DATA SHEET**

**AIRLESS SPRAY APPLICATION : TROUBLE SHOOTING CHART**

<b>DEFECT</b>	<b>CAUSE</b>	<b>SUGGESTED CORRECTION</b>
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.
do not thin	- 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, 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  - Paint thinned down too much	Reduce pressure  Only the correct amount of thinner should be added.
Pinholes	- Paint film too heavy Poor atomisation	Apply less wet film thickness. Increase pressure.
Orange peel	- Paint not thinned sufficiently	Add the correct amount of thinner.
Blistering	- Rust, oil or grease on surface  - Moisture on or in the surface  - Solvents trapped under dried paint	Degrease the surface properly before painting.  Surface temperature must be above the dew point.  Use a faster solvent.