



Finishing Equipment Inc.

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WATERBORNE TROUBLESHOOTING

PROBLEM	DESCRIPTION	CAUSE	REMEDY
Sagging of Film	Excessive flow in paint during application.	1. Over-reduction of coating. 2. Application of too heavy a coat. 3. Excessive fluid flow from gun.	1. Use less water to reduce –heavier viscosity. 2. Use more passes to build film. 3. Cut back flow rate on gun.
Dry Spraying	Sandpaper like look on the part due to flow problems.	1. Lack of flow. 2. Evaporation rate too fast.	1. Increase fluid flow on gun. 2. Slow coating down with inhibitor.
Hiding	The ability of a paint to obscure the background over which it is applied.	1. Over reduction. 2. Improper atomization. 3. Low film thickness.	1. Increase spray viscosity – use less water. 2. Adjust spray equipment. 3. Increase film thickness with more passes.
Blushing	Whitening of the part as it is being sprayed.	1. Paint drying or flashing too fast. 2. High temperature and humidity.	1. Use inhibitor to slow paint down. 2. Decrease room temperature and humidity.
Gloss	The degree to which a surface reflects light.	1. Low gloss – overreducing. 2. Low gloss – film thickness. 3. High gloss – high film thickness. 4. Spotty low gloss – overbaking.	1. Increase spray viscosity – use less water. 2. Use more passes. 3. Decrease paint flow. 4. Regulate oven temperature and airflow.
Orange Peel	A pebbled or wavy effect on the surface of the paint.	1. Application of too thin a film not allowing proper flow. 2. Too much film thickness due to high viscosity.	1. Apply heavier coat / increase air pressure to atomize paint. 2. Decrease spray viscosity.
Mudcracking	Intersecting cracks penetrate at least one coat in a dried paint. Occurs when the coating becomes rigid before all of the volatiles have left the coating.	1. Low temperature. 2. High film thickness.	1. Raise the room temperature, paint temperature, and part temperature. Waterborne cannot be applied below 60 F. 2. Apply less film thickness.
Cratering or Pinholing	Defects on the paint surface – small holes in the film.	1. Silicon contamination. 2. Spots of grease on surface. 3. Drops of oil from equipment.	1. Locate source of contamination and eliminate. 2. Clean surface of part thoroughly. 3. Clean spray equipment.