

# Eagle Bridges Industrial Paints



**SERVING THE SOUTH  
WITH FLYING COLORS**

## Coatings Troubleshooting Guide

Usually a performance problem can be solved by checking seemingly apparent but often overlooked possibilities. This list will help correct most difficulties encountered by users.

### PROBLEMS WITH COATING IN THE CONTAINER

PROBLEM	DESCRIPTION	CAUSES	REMEDIES
Settling or Separation	Pigment packed in bottom Clear liquid on top Streaked color float on top	Long term storage before use Storage in hot area Extended storage after thinning	Stir with power agitator Stir from bottom with 1x4 board Inventory control-first in first out
Skinning or Seeding	Dried skin on top of paint Pieces of skins mixed in paint Jelly like substance on top Seed like particles in paint	Container not tightly sealed Storage in partly used container Storage in sun or heated area	Remove skin with a spatula Strain out pieces with filter bag Float a little thinner on top of paint before storing partial containers.
Coating is too thick	Not readily pourable Puffy like whipped cream Too viscous for spraying	Long term storage before use Temperature too cold Storage in partly used container	Add thinner and stir thoroughly If old, mix with fresh paint and stir Warm the liquid coating
Coating is too thin	Too runny Looks watery Viscosity not uniform from top to bottom	Temperature too hot Too much thinner added Long term storage before use	Cool the liquid coating Mix with fresh unthinned coating

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### PROBLEMS WITH DRY FILM PERFORMANCE

PROBLEM	DESCRIPTION	CAUSES	REMEDIES
Poor Adhesion	Easily scratches off of substrate Flakes off Fails cross hatch test	Film not cured Substrate not clean before coating Wrong coating for given substrate	Allow more dry time Prepare surface before painting Call for tech service advice
Film Irregularities	Appearance undesirable	See "Application Problems"	See "Application Problems"
Color not on standard	Color too light or too dark Color off shade Color not uniform over total surface	Coating not well mixed before use Equipment not clean from prior use Oven over bake-too hot or too long	Stir with power agitator Flush equipment with clean thinner Adjust bake time and temperature
Note: Compare hand painted sample, not sent through system, against a system painted part. If not corrected, call for tech service advice.			
Gloss not on standard  See note above for this problem also.	Gloss too flat Gloss too shinny Gloss not uniform over total surface Film looks gritty	Dirty substrate Coating not well mixed before use Equipment not clean from prior use Dust falling on part during drying Part over/under baked Applied film too thin	Prepare surface before painting Stir with power agitator Flush equipment with clean thinner Eliminate dust from drying area Adjust bake time and temperature Apply thicker wet film
Blistering  Usually occurs only in forced or baked films	Small pinpoint blisters Larger water like blisters	Top dries before all solvent escapes Moisture in atomization air	Add some slow thinner Install moisture trap in air line Allow more flash time before baking
Craters Fish Eyes Pin Holes	1/32 to 1/8" holes in film Larger holes where film pulls back Very small pin size holes	Substrate contamination Surface tension problems Dry spray or not enough paint to flow	Prepare surface before painting Use surface tension additive Add slow thinner and apply thicker
Corrosion	Early flash rust Pin point rusting Corrosion at scratches or film breaks	Improper surface preparation Pin holes from improper application Lack of backup coat	Prepare surface and use primer Add slow thinner and apply thicker Use rust protective primer or apply a second top coat
Short term protection is a matter of good application. Long term depends on formulation resistance.			

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### APPLICATION PROBLEMS

PROBLEM	DESCRIPTION	CAUSES	REMEDIES
Orange Peel/poor flow	Looks like skin of orange Bumpy film Textured appearance	Improper atomization Viscosity too thick Film setting too fast	Increase pressure/use smaller tip Add thinner Cool substrate/add slow thinner
Dry spray	Rough, dusty looking film Lap marks don't flow together May have very small pin holes Lower than standard gloss	Viscosity too thick Surface too hot/ too much air flow Flashes too fast Not enough fluid output	Add slow thinner Cool the surface/reduce air flow Reduce atomization air Increase fluid/larger tip
Not Enough Hide	Substrate shows through Splotchy, uneven color Light and dark spots	Film too thin May be dry spray Viscosity too thin	Apply more coating See dry spray above Use less thinner
Sags, Runs, Curtains	Streaks Lines of uneven sags Paint running from corners or edges	Too much paint Setting too slow Improper atomization	Warm the substrate Use faster thinner Decrease fluid flow/smaller tip
Random Blemishes	Rough spots Low gloss areas Hazy areas	Contaminated substrate Coating not well mixed Contaminated equipment	Prepare and clean substrate Use power agitation
Substrate flaws not covered	Marks & scratches on substrate Welds not covered Phosphate or metal prep showing	Fabrication problems Faulty welding materials Prep. System out of balance	Sand or polish substrate Use a primer/filler coat Adjust the prep. system
Drying or curing	Parts stick together Surface not cured for Handling Won't pass hardness test Won't pass solvent rub test Resistance properties below standard	Humidity too high Temperature too low Oven time too short Film too thick Poor air flow in drying areas Cold parts or paint	Heat part and paint Increase oven temperature Increase oven time Add fast thinner/reduce fluid output Install fan to move air Add catalyst to paint
Lifting of undercoats	Cracked or wrinkled film Large blisters, down to Substrate	Recoated during critical dry time First coat not cured	Recoat quicker/dry base coat longer Bake first coat before recoating
Discolorations	Seed like stains Yellowed streaks Over all yellowed appearance	Prep. System out of balance Substrate contaminating stains Over bake of film	Adjust the prep. System Prepare and clean the substrate Lower temp./reduce time
Handling deficiencies	Prints, mars or scratches Chips from brittleness Sticks to packaging	Not totally cured Over baked Not totally cured	See cure and drying problems Lower temp. reduce time