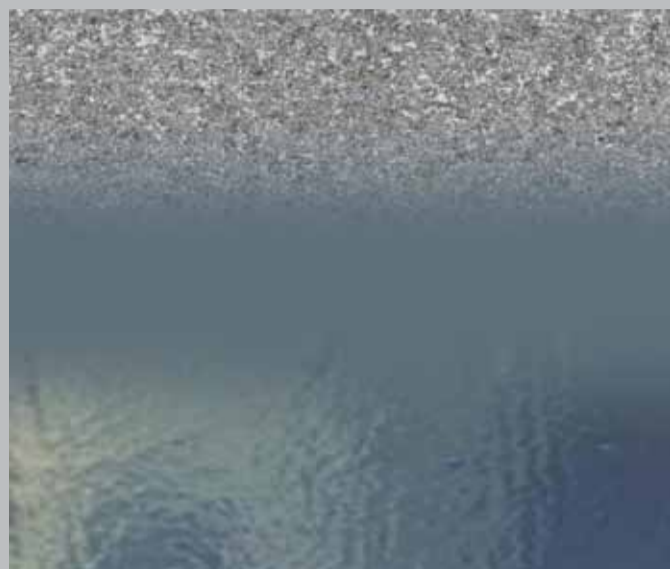


Standard Paint Application Failures

Guide and reference photographs for steel surfaces sprayed with epoxy paint



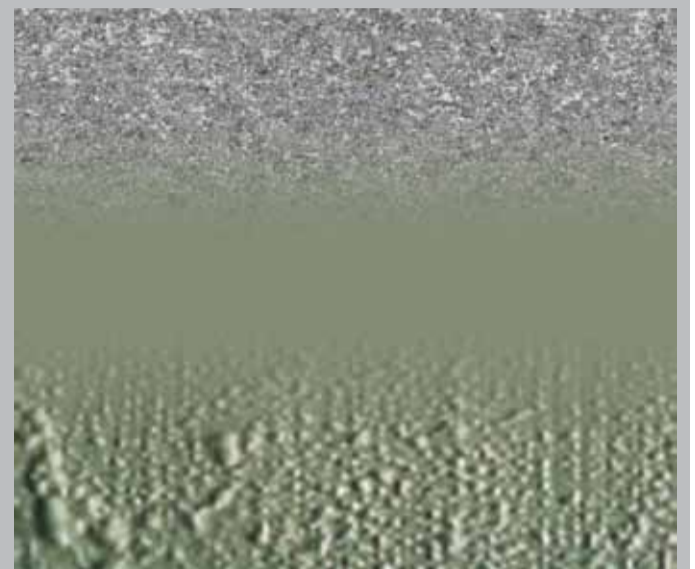
Sagging (recognised as "curtains") occurs when:

- Paint is applied in excess of the DFT specified.
- Too much thinner has been added to the paint.
- The gun is held too close to the surface.



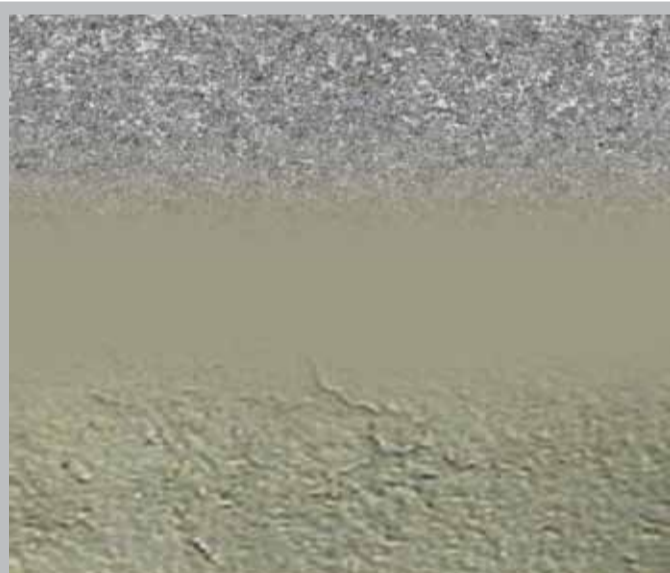
Pinholes occur when:

- Using the wrong spraying technique, such as excessive air pressure, excessive film thickness, strong wind (too much ventilation) and too much application distance may cause craters, pinholes and pores.
- Pinholes in a paint film can also result from overspray.



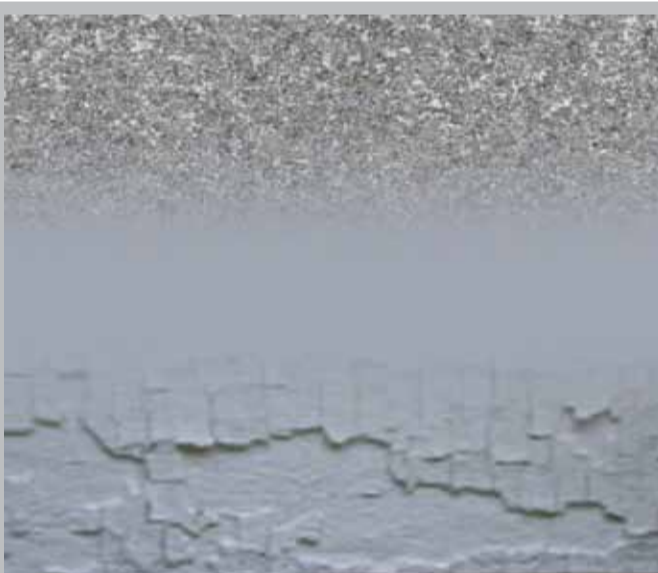
Blistering can be caused by a number of different conditions:

- Soluble salts contaminating the substrate or contaminating the surface between coats.
- Contamination of the surface (e.g. oils, waxes, dust, etc.)
- Poor or inadequate solvent release from the coating. Entrapped solvents can increase the water absorption and moisture vapour transmission of the coating and lead to blistering.



Lifting is a raising of the undercoat.

- It is caused by a stronger solvent in the topcoat attacking the previously applied film.
- The result is a wrinkled surface.



Delamination/peeling caused by:

- Unsatisfactory surface preparation.
- Incompatible primer or undercoat.
- Substrate or intercoat contamination.
- Excessive cure time between coats.



Orange peel caused by:

- Improper atomisation due to low air pressure.
- Spraying too close to the surface.
- Rapid solvent evaporation.