



Refers to an unevenly coated surface similar to the skin of the orange, such as formed by spray coating.

**Q1:**

**Is the paint film thin?**

**A1:**

Achieve the specified film thickness.

**Q2:**

**Is the thinner a quick-drying type?**

**A2:**

Use a thinner that evaporates slowly.

**Q3:**

**Is the solvency of the thinner appropriate?**

**A3:**

Use a thinner with high solvency.

**Q4:**

**Is the viscosity of the paint high?**

**A4:**

Adjust to appropriate viscosity.

**Q5:**

**Is the flow delivery too small?**

**A5:**

Adjust the flow delivery appropriately.

**Q6:**

**Is the moving speed of the spray gun too fast?**

**A6:**

Set the spray gun speed to an appropriate value.

**Q7:**

**Is the spray gun nozzle clogged?**

**A7:**

Clean the nozzle.

Investigate the cause of the clogging nozzle.

**Q8:**

**Is the air pressure too high?**



**A8:**

Use an appropriate air pressure.

**Q9:**

**Is atomization poor?**

**A9:**

Reconfigure the coating conditions to improve the atomization. (Refer to the reference material.)

**Q10:**

**Did you change the coating equipment?**

**A10:**

Reconfigure the coating conditions.

**Q11:**

**Is the paint booth temperature or the setting chamber temperature high?**

**A11:**

Use a thinner that evaporates slowly.

Reduce the viscosity.

Use an air curtain as a barrier between the hot-air oven and the setting chamber.

**Q12:**

**Is the air velocity too high in the paint booth, setting chamber, or drying chamber?**

**A12:**

Adjust the air velocity appropriately.

**Q13:**

**Is the setting time provided as specific?**

**A13:**

Use a thinner that evaporates slowly.

**Q14:**

**Did you change the coating process?**

**A14:**

Reconfigure the coating conditions.

**Q15:**

**Is the primer surface poor?**

**A15:**

Improve the primer surface. Sandpaper the primer.



**Q16:**

**Did you change the substrate?**

**A16:**

Reconfigure the coating conditions.

**Q17:**

**Are the hanging and hanger pitch appropriate for uniform coating?**

**A17:**

Ensure an appropriate hanger pitch and way of hanging.

**Q18:**

**Are the hanger connections dirt, such as with paint?**

**A18:**

For electrostatic coating, ensure that the connections are constantly maintained in a clean condition for good conductivity.

**Q19:**

**How are the surface roughness of the workpiece and the roughness of the pretreated surface evaluated?**

**A19:**

Check the surface roughness of the workpiece.

Review the coating process.

**Q20:**

**Is it recoating?**

**A20:**

Sandpaper the previous paint film.

Use a thinner that evaporates slowly.