



Poor adhesion between coating layers

Poor adhesion between coating layers refers to defective mutual adhesion between multilayer paint films. It is a common practice to use cuts such as cross cut or scratch marks into the paint film, apply and peel a cellophane tape, and examine the condition of delamination between the top and under coats for judgment.

Q1:

Did you use the designated top coat and primer?

A1:

Use the designated combination of top coat and primer.

Extra care is required for instances where the primer is hard and the top coat is soft.

Q2:

Were the drying conditions used for the primer appropriate?

Specifically, for baking, did overbaking occur?

A2:

Adjust to the specified drying conditions.

(The paint film of overbaked primer becomes harder than necessary and is likely to result in poor adhesion between coating layers.)

Q3:

Were the drying conditions used for the top coat appropriate?

Specifically, for baking, did underbaking occur?

A3:

Adjust to the specified drying conditions.

For baking, it is generally better in terms of adhesion between coating layers that the top coat baking conditions are slightly toward overbaking in comparison with the primer baking conditions.

Q4:

Did you change the coating process or the type of paint?

A4:

Adhere to the specified coating process.

When modifying the process, change accordingly to an appropriate paint.

Be careful because under coatings are divided into non-sanding and sanding types.

Q5:

Is the film thickness of the primer excessively thin?



A5:

Adjust the specified film thickness.

Q6:

Did you apply a coat over the primer as it was (without polishing), having been left uncoated for an extended period of time?

A6:

Incorporate a polishing process because soiled surfaces of coats or increases in hardness during exposure result in poor adhesion between layers.

Q7:

Does the treated surface show yellow rust, a temper color or other mottling, or a dusty look?

A7:

Control the condition of solution for pre-treatment appropriately.

Check the angle and clogging of the spray nozzle .

If faulty, correct these condition.

Q8:

Did you use the specified thinner for the primer?

A8:

Some thinners contain an additive that is detrimental to-adhesion between layers.

Use the specified thinner.

Q9:

Did you mix an incorrect type of paint?

A9:

Check the paint film using paint from a fresh can.

Q10:

Did you change the batch of paint?

A10:

Check whether there was a recent batch change or an old batch was used.

Q11:

Blushing occurs on the primer?



Poor adhesion between coating layers

A11:

Blushing occurs if under coating is performed in a highly humid condition, degrading adhesion between the primer and the top coat.

If the temperature is very low during under coating, probable results include cheesiness and blushing due to condensation.

In particular, epoxy primers require attention.

Use a thinner that evaporates slowly for the primer.

Polish the paint film of the primer.