Troubleshooting
Solvent Paints

Reference material

↑	**Level up**
↓	**Level down**
↑ ↓	**Underlined : conditions with significant effect**

Solution (1) Tinner condition

Coating defect	Tinner condition	
	Evaporation rate	Solubility
Sagging	↑	↑
Lack of hiding power	↑	↑
Popping / Pinholing	↓	—
Hollows / Cratering	↑	—
Roughly surface / Orange peel	↓	↑
Atomization failure	↑	↑
Electrostatic effect (wraparaound effect) failure	↓	↑
Color separation	↑	↑
Poor gloss (flashing)	↓	↑
Lifting	↑	↓
Failure to reach recessed areas due to static electricity	↓	—

Solution (2) Coating condition

Coating defect	Coating condition			
	Coating air pressure	Viscosity of paint	Flow delivery	Static voltage
Sagging	—	↑	↓	—
Lack of hiding power	—	↑	↑	—
Popping / Pinholing	—	↓	↓	—
Hollows / Cratering	—	—	↓	—
Roughly surface Orange peel	↑	↓	↑	—

Reference material

Atomization failure	↑	↓	↓	↑
Electrostatic effect failure (wraparaound effect)	↑	↓	↓	↑
Color separation	—	↑	↓	—
Poor gloss (flashing)	—	↑	↑	—
Lifting	—	—	↓	—
Failure to reach recessed areas due to static electricity	↑	—	—	↓

Solution (3) Others

Coating defect	Coating condition
Sagging	Does vaporized thinner remain significantly in the setting room? Are the shape of the hanger and the way of hanging acceptable?
Lack of hiding power	Achieve a thick paint film in a single coating operation.
Popping / Pinholing	Is the paint film thicker than required? Is the setting time sufficient? Is the ventilation too strong during drying?
Hollows / Cratering	Check the air drain blaster for soiling.
Roughly surface Orange peel	Is any contamination on the workpiece? Is any contamination on the workpiece after coating? In the case of a large substrate, use care for the coating sequence (laps). Is the substrate temperature higher than appropriate?
Atomization failure	Is the thinner mixed uniformly?
Electrostatic effect failure (wraparaound effect)	Is the ground defective? Did you use a thinner intended for electrostatic coating?
Color separation	Poor atomization occasionally results in floating.
Poor gloss (flashing)	Did overbaking occur? Is spray dust on the surface? Is the primer surface defective? Did absorption occur?
Lifting	Did drying or adhesion failure of the primer occur?
Failure to reach recessed areas due to static electricity	In cases of electrostatic atomization, reduce the rpm or raise the electrical resistance (to an appropriate value).