



Color tone/gloss deviation refers to failure to finish the color tone and gloss of a paint film as indicated by the designated standard panel.

Q1:

Has the substrate shape substantially changed from the previous ones?

A1:

Gloss appearance is subject to change depending on the substrate shape.

If it is deemed necessary, review the standard panel.

Q2:

Is the standard panel clean?

A2:

If soiled or past the expiration date, replace the standard panel.

Q3:

Is it metamerism?

(Specifically, note differences between the paint film and our competitors' standard panels.)

A3:

Control the finished surface to be close to the standard panel.

* Metamerism: It is a phenomenon in which the color tone varies with the type of light source used to examine the color.

Q4:

Has any different type of paint mixed in?

A4:

Replace with fresh paint (fresh powder). If the paint has some issue, replace it with a fresh batch.

Q5:

Is the film thickness thinner than appropriate?

A5:

Achieve the appropriate film thickness.

A thinner film fails to hide and is affected by the ground color.

Q6:

Did excessive spray dust occur?

A6:

Review and adjust the ventilation, manner of coating, and coating conditions.

Q7:

Is the substrate temperature significantly lower than the paint booth temperature?

**A7:**

Raise the substrate temperature because otherwise condensation occurs on the substrate, resulting in a dull gloss on the coated surface.

Q8:

Did overbaking or underbaking occur?

A8:

Measure the oven temperature.

Correct the time, temperature, and temperature rising curve appropriately.

Adjust the airflow opening.

Overbaking results in discoloration and/or a dull gloss.

Q9:

Did gas checking occur?

A9:

Check the burner flame conditions.

(Care is required particularly when starting the equipment in the morning and after the lunch break.)

Q10:

Has moisture mixed in the air used for coating?

A10:

Inspect, and conduct maintenance of, the air dryer and oil filter. Moisture, if mixed in, causes milkiness.

Q11:

Is it an effect of thermochromism?

A11:

Normally, paint films are observed one day after baking.

(Red colors in particular exhibit a different color tone when observed immediately after baking, with the substrate being still hot.)

Q12:

Did the ground surface or chemically converted surface absorb paint/coating?

A12:

Check coated surfaces by conducting a coating test on different ground surfaces.