Excessive / Insufficient film thickness

Excessive/insufficient film thickness refers to failure to hide the ground color of the substrate or lack of paint film smoothness (some roughness to the touch).

Q1:

Is the discharge quantity of the spray gun insufficient or excessive?

A1:

Review the settings.

Q2:

Is the high voltage of the spray gun insufficient or excessive?

A2:

Review the settings.

Q3:

Has the spray gun clogged (in cases of insufficient film thickness)?

A3:

Discharge air or fluidizing air retaining moisture can cause blocking.

Q4:

Is the spray gun out of order?

A4:

Replace it with a spare spray gun.

Contact the manufacturer.

Q5:

Is the stroke of the automatic coating machine normal?

A5:

Review the settings.

The electrical circuits (limit switches and sensors) are faulty.

Q6:

Is the coating start/stop timing correct?

A6:

Review the settings.

The electrical circuits (limit switches and sensors) are faulty.

Q7:

Is the operation of the automatic coating machine normal?

A7:

Possible causes include : Loose drive chain, Faulty electrical circuits, and Loose anchor bolt(s).

Excessive / Insufficient film thickness

Q8:

Is the fluidizing air pressure insufficient or excessive?

A8:

A typical value is 0.03 MPa (typical range: 0.02 to 0.04 MPa).

See the description of “Spits.”

Q9:

Is the paint sufficient? (If insufficient)

A9:

Insert the suction pipe more deeply.

Q10:

Is the paint suction sufficient? (If insufficient)

A10:

Insert the suction pipe more deeply.

Q11:

Has the ejector failed?

A11:

Inspect the ejector regularly.

If it is considerably worn out, replace it.

Q12:

Is the conveyor speed too fast or slow?

A12:

Review the settings.

Q13:

Does the conveyor jerk?

A13:

Inspect the conveyor conditions to solve the jerk issue.