



# Wood Coating Troubleshooting

## Specks or grit in the film

Dust / grit in spray booth and in air

- Reduce airborne contaminants

Static charge on part

- Increase humidity in spray booth
- Wipe dry paint film with water – let dry

Add filter in line to spray gun

## Bubbles or haze in clear finish

Loose siphon tube – tighten

Reduce air movement over wet film

Add up to 5% (volume) retarder

- Solvent based: SS-032 Glycol Ether EB
- Water based: IM-078 Aqua Retarder

Use slower thinner

- Solvent based: SS-0076 Leveling Solvent III
- Water based: IM-078 Aqua Retarder

## Lacquer turns white and dusty

Contaminate causing nitrocellulose to crash

- Use only recommended thinners & additives
- Stain not completely dry before sealing
- Too much dye in stain
- Use a non-lacquer sealer (acrylic, conv. var.)

## Stain or glaze bleed back

Do not add additional solvent to the glaze

Reduce curing heat

Wipe bleed back spots away as they form

## Solvent pop

Reduce air movement over wet film

Use slower thinner

- Solvent based: SS-0076 Leveling Solvent III

Add a retarder at 4 oz/gal

- Solvent based: SS-032 Glycol Ether EB

## Fish eyes

Contaminate on substrate

- Clean with clean solvent or water

Dust / grit in spray booth and in air

- Reduce airborne contaminants

Oil contaminate in paint through throat seal

- Replace pump seals

Add “fisheye eliminator”

- Solvent based: IM-052 Additive B

## Low gloss

Reduce air movement over wet film

Ensure pail or drum is well mixed

## Clogged spray tips

Check gun filtration

- Should be smaller than the spray tip

Clear or replace siphon hose and fluid hose

Is the coating is drying on the tip?

## Coating drying on spray tip

Shaping air pressure too high (air assist)

Shaping air or fluid air too high (siphon / HVLP / pressure pot)

Spray more continuously

Wash spray tip when breaking from spraying

Spraying too close to substrate (backup to 6”-8”)

Add up to 5% (volume) retarder

- Solvent based: SS-032 Glycol Ether EB
- Water based: IM-078 Aqua Retarder

## Off color

Ensure pail or drum is well mixed

Confirm changes in curing / drying conditions