

F.A.Q.

Spraying Seal Coatings

ORANGEPEEL:

Surface looks like the peel of an orange, or a miniature topographic map.

Cause:

The film does not level out completely because the lacquer dries before it can flow together.

Corrections:

- * Add Star (TM) FLASH-OFF CONTROL SOLVENT as needed to your sealer. (Use retarder as a last resort, it will slow your entire finishing and drying schedule.)
 - * Use a matched and proper thinner for your sealer
- Thin not more than 20% unless specified by the manufacturer.
- * Spray at 8 - 12 inches from the surface.
 - * Use as little air pressure as will allow a proper coat of material to be applied.
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OVERSPRAY:

Roughness or sometimes white looking fuzz stuck in the finish surface.

Cause:

- * Too much air pressure or bounce-back from spraying too close to the surface; or spraying into blind corners and cubby holes, as in bookshelves or desks.
- * Excessive air flow pre-dries the atomized lacquer before it can reach the surface (such as when spraying outdoors on a windy day).

Corrections:

- * Add Star (TM) FLASH-OFF CONTROL SOLVENT to your lacquer.
 - * Spray at 8 -12 inches from surface.
 - * Use as little air pressure as will allow a proper coat of material to be applied.
 - * Spray in an environment free from gusts or excessive air flow.
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FISH-EYES or CRATERING:

Usually round depressions in sealer, sometimes clear to the substrate, that looks like moon craters.

Cause:

- * Contamination in the finish or substrate from silicone and oils.
- * In refinishing; -- usually from inappropriate wood care products.

Corrections:

- * Clean surfaces thoroughly with Xylene (only a partial help) .
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PIN HOLES:

Tiny holes that look like somebody took a pin and put holes in the film of lacquer.

Cause:

- * Moisture in the sealer when being sprayed.

Corrections:

- * Bleed traps on air lines, bleed compressor tank completely, and make sure air lines are free of moisture on a **Daily** basis.
 - * Install a moisture trap and a moisture filter as close to the spray gun as possible.
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GRAININESS:

The film looks as if someone threw sand into the lacquer film.

Cause:

- * Too much air pressure can cause entrapment of air bubbles in the lacquer film.

Corrections:

- * Reduce air pressure; and increase fluid pressure; and reduce film build up.
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BLISTERS:

A raised bubble on surface of sealer

Cause:

Too heavy of a film build-up of sealer at one time.

Corrections:

- * Cut back fluid and air pressure.
- * Thin down the sealer (usually not more than 20%)
- * Spray lighter coats.

BUBBLING:

Surface looks as if the lacquer boiled and remained grainy.

Cause:

Sealer and surface to be sprayed is too hot.

Corrections:

- * Spray lighter coats;
- * thin down sealer;
- * use less air and fluid pressure.

Note: When it is over 85 dreg F, it is best to stop and do something else.

BLUSHING:

Film looks whitish, cloudy, or milky.

Causes:

- * Moisture trapped in the surface of the sealer from the spray equipment or atmosphere.
- * Close doors, - heat rooms, - heat objects being sprayed.

***Summer:**

- * Air pressure to pump should be 40 lbs. air assist should be 20-30 lbs.
- * To much air pressure to pump and air assist can cause tiny bubbles or gassing along the grain.

Winter:

- * The same as summer except increase pump pressure to 45 lbs., air assist should remain the same.
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BLOOMING:

Film looks bluish, or iridescent.

Causes:

Undried moisture trapped under the surface of the Sealer.

Corrections:

- * Always allow sufficient drying time
(for thorough deep drying, not just surface dry or "dry to the touch")
- * Extend Dry Times of products in cold or humid conditions.

SAGGING, & RUNS

Runs and drips of lacquer that collect by gravity in thick ridges.

Causes:

- * Over thinning;
- * Cheap and/or mismatched thinner;
- * Cold surface and material;
- * Too much material applied per coat or coats applied in rapid succession;
- * Worn or damaged spray gun cap, nozzle, and/or needle.

Corrections:

Remedy or fix any or all of the conditions above in "causes" for sags & runs.

POOR ADHESION & New Sealer Cracking off of corners.

First coat flakes off with fingernail and edges or corners chip off easily with minor impact, or bumps. --- Finish lacks durability and rubs, chips, or flakes off easily.

Causes:

- * Dry spray; from too much air flow as in too much fan speed in a booth or outdoor spraying
- * Dusty surface or other surface contamination, poorly cleaned or prepared just prior to spraying.
- * Too much atomization air or too little material leaving the gun.
- * Spray gun too far away from surface.

Corrections:

Remedy or fix any or all of the conditions above in "causes" of Poor Adhesion