

TROUBLESHOOTING GUIDE

Common issues associated with incorrect deposition of HTP 100.	Root causes/ possible reasons of failure.	Potential Fix (Ranges from minor to severe)
<p>Coating is visibly cracked after drying/thermal cure.</p>	<ol style="list-style-type: none"> 1. Too many passes were deposited. 2. The distance between spray can and substrate was too close. 3. Inconsistent rate of deposition was too slow/too fast. 4. Thermal cure was too aggressive. 	<p>Increase the distance between the spray gun and the substrate.</p> <p>Increase the dry time at lower temperatures (80 and 120c).</p> <p>Decrease the number of passes per layer and increase the dwell time in-between each pass for e.g., 30-45 seconds.</p>
<p>Running/pooling or paint dripping.</p> <p>Tip:</p> <p>This can happen if the coating still appears glossy before another pass is applied</p>	<ol style="list-style-type: none"> 1. Spray contents was not mixed enough. 2. Insufficient dry time between each pass. 3. Too many passes were deposited. 4. Paint conditions was compromised. 	<p>Increase the distance between the spray gun and the substrate and try shaking the spray can periodically during the dry time between each pass.</p> <p>Increase the transitional rate at which the paint is being deposited, for e.g., 1 foot per second (move the Spray can faster during the back-and-forth motion).</p> <p>Decrease the number of passes per layer and increase the dwell time in-between each pass for e.g., 30-45 seconds.</p>
<p>Poor adhesion/Spallation.</p>	<ol style="list-style-type: none"> 1. Surface preparation, make sure the sample has been treated with the appropriate method for e.g., grit blast, scotch brite or SIC sandpaper abrasion. 2. Too many passes per layer. 3. Make sure the sample has been heat cleaned and rinse with the proper solvents. 4. Coating dry time was insufficient/too aggressive. 	<p>Extend the dry and thermal cure time.</p> <p>Remove the coating and re-apply following the troubleshooting guide.</p> <p>Note:</p> <p>Sample must be re heat cleaned and degreased before re-applying HTP 100.</p>