### TROUBLESHOOTING GUIDE

#### TROUBLE  |  POSSIBLE CAUSES  |  SOLUTIONS
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1. Poor mixing/coalescence/separation (loss of color, gloss, or finish quality)  |  1a. Inadequate mixing  |  a. Check mixing equipment for proper operation.  
1b. Inadequate coating throughput  |  b. Increase coating throughput.  
1c. Tempering issues  |  c. Adjust tempering process.  
1d. Poor mixing/coalescence/separation  |  d. Check mixing equipment for proper operation.  
1e. Inadequate mixing  |  e. Increase coating throughput.  
2. Poor adhesion  |  2a. Improper surface preparation  |  a. Follow proper surface preparation according to manufacturer’s recommendations.  
2b. Poor primer adhesion  |  b. Use appropriate primer system.  
2c. Inadequate primer coating  |  c. Apply adequate primer coating.  
3. Poor gloss or gloss loss  |  3a. Inadequate gloss development  |  a. Increase coating solids content.  
3b. Inadequate gloss development  |  b. Increase coating solids content.  
3c. Poor gloss or gloss loss  |  c. Increase coating solids content.  
4. Poor flow or sagging  |  4a. Inadequate flow aids  |  a. Add flow aids as recommended by manufacturer.  
4b. Inadequate flow aids  |  b. Add flow aids as recommended by manufacturer.  
5. Poor dry film thickness  |  5a. Inadequate pigment loading  |  a. Increase pigment loading.  
5b. Inadequate pigment loading  |  b. Increase pigment loading.  

#### TROUBLE  |  POSSIBLE CAUSES  |  SOLUTIONS
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6b. Inadequate cure temperature  |  b. Increase cure temperature.  
7. Poor physical properties  |  7a. Inadequate cure time  |  a. Increase cure time.  
7b. Inadequate cure time  |  b. Increase cure time.  
8b. Inadequate colorant loading  |  b. Increase colorant loading.  
9b. Inadequate gloss development  |  b. Increase gloss development.  
10b. Inadequate adhesion promoter  |  b. Apply adequate adhesion promoter.  
11b. Inadequate flow aids  |  b. Add flow aids as recommended by manufacturer.  
12b. Inadequate pigment loading  |  b. Increase pigment loading.  

#### TROUBLE  |  POSSIBLE CAUSES  |  SOLUTIONS
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13. Poor gloss or gloss loss  |  13a. Inadequate cure temperature  |  a. Increase cure temperature.  
13b. Inadequate cure temperature  |  b. Increase cure temperature.  
14. Poor flow or sagging  |  14a. Inadequate flow aids  |  a. Add flow aids as recommended by manufacturer.  
14b. Inadequate flow aids  |  b. Add flow aids as recommended by manufacturer.  
15b. Inadequate pigment loading  |  b. Increase pigment loading.  
16b. Inadequate adhesion promoter  |  b. Apply adequate adhesion promoter.  
17. Poor gloss  |  17a. Inadequate gloss development  |  a. Increase gloss development.  
17b. Inadequate gloss development  |  b. Increase gloss development.  
18b. Inadequate colorant loading  |  b. Increase colorant loading.  
19b. Inadequate flow aids  |  b. Add flow aids as recommended by manufacturer.  
20b. Inadequate pigment loading  |  b. Increase pigment loading.  

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**Your source for powder coatings.**