



TROUBLE SHOOTING

MGDUFF

No.	Symptoms	Possible Causes	Solution
1	Zingard does not dry	The incorrect solvent was used for thinning	Discard all suspect Zingard and begin again from unopened tins.
2	Zingard dries but goes "rubbery" in places	Zingard was applied over an old paint coating	Re-blast the entire affected area and check that a surface cleanliness of SA 2.5 has been achieved before progressing any further.
3	Zingard "cobwebs" when being sprayed by conventional spraygun	The Zingard has not been thinned correctly	Make sure that the Zingard is thinned approximately 5% with Zingasolv
4	Zingard has an "orange peel" appearance and also sometimes dries slower	The Zingard was applied to thickly or was not thinned correctly	Dilute the Zingard with up to 5% Zingasolv and apply 2 or 3 thinner coats
5	More Zingard than estimated is being used	The blast profile is too deep N.B. Dry film thicknesses are measured from the top of the blast profile, not the troughs.	Change the blast-media to the correct grade before proceeding.
6	Less Zingard is being used than estimated	The Zingard has been over-thinned or the blast profile is too shallow	Use new Zingard from an unopened tin and dilute it with the over-thinned Zingard or change the blast media.
7	Excessive misting develops when spraying	The Zingard has been over-thinned	Use new Zingard from an unopened tin. Dilute it with the over-thinned Zingard.
8	After drying the Zingard can be easily removed	The steel was not blast cleaned or was not given sufficient profile	Select the correct grade of blast-media and re-blast the entire area
9	After drying the Zingard coating remains "cheesy"	The Zingard has been applied over oil or grease	The affected area must be thoroughly washed down with strong detergent or a steam lance and re-blasted
10	After being coated the steelwork displays a patchy appearance when viewed obliquely	Either the Zingard has been over-thinned or the blast profile is too deep	Check the viscosity of the liquid and apply subsequent coats until patches disappear.
11	A topcoat over Zingard forms blisters or delaminates	The tie-coat/topcoat has been applied too thick causing solvent entrapment	Remove the topcoat (and Zingard if required) and re-apply at the correct dft for each component layer.
12	The paint topcoat remains "cheesy" after application onto Zingard	The top-coat was an alkyd enamel	Wash off the coatings with acetone and re-blast the entire affected area.
13	Powder-coating displays pinholes after the baking schedule has been completed	The Zingard coating was not given sufficient curing time	Re-blast the entire affected area and re-apply both coatings. Pre-heating the steelwork helps drive off any trapped solvents
14	Over hot-dipped galvanising the Zingard layer breaks away	The HDG was too new to be over-coated with Zingard	Ensure that all passivation has been removed and sweep-blast the HDG at a pressure of 60psi.
15	Pin holes appear in a heat cured paint top coat on Zingard coated steelwork that was exposed to moisture prior to being finished	Moisture trapped in the porosity of the zinc layer has been driven out through the paint coating on drying	Preheat damp Zingard coated steelwork to a temperature of 40°C before application of finishing coats using heat lamps etc.