

Epoxy Troubleshooting Guide

Colour Differential:



Description:

Difference in colour or shading of topcoat.

Cause:

Re-touching after 15 minutes: Colour float issues arise when a pigmented epoxy has been applied and is re-touched or rolled again after sitting for 15 minutes or longer. Different shades in the colour may result.

Using different batch numbers: Colouring can vary from batch to batch. Different batches used on the same project can result in colour variances.

Repair:

Back roll the entire area always using a shed-resistant, 12mm nap roller. Always try to go across the entire area from side-to-side.

When possible, re-coats should always be completed with the same coating batch.

If batches are different, blend the coloured base coat (part a) first before adding hardener (part b).

Prevention:

If material needs to be re-touched or rolled for any reason, it needs to be done within 10 minutes of application.

Different batch numbers:

Always check to make sure that you have the same batch number on the pigmented side of the product prior to adding the hardener

Epoxy Troubleshooting Guide

Fish Eye

Description:

Fish eyes are round separations or indentions in the coating finish. They look like a crater with a rim around the perimeter and contain a small dot in the center. This is what gives it the name “fish eye”.



Cause:

Oil/Grease Contaminants: This can cause the epoxy to work improperly and fish eyes to appear.

Silicone: Contamination from silicone can cause fish eyes to appear.

Repair:

Oil/Grease:

- Remove the coating by grinding or another suitable method.
- Clean substrate; remove all oil/grease contamination.
- Re-coat the entire area.

Silicone:

- For isolated areas, sand with 80 grit sandpaper or diamond grind.
- For wide spread fish eye problem, remove the coating.
- Use solvent to remove contaminants from the substrate.
- Re-coat the entire area.

Prevention:

Oil/Grease: De-grease the surface properly using appropriate product. If it cannot be entirely removed, use a suitable oil-stop primer.

Epoxy Troubleshooting Guide

Milky or Cloudy Coatings

Description:

A milky or cloudy appearance in wet or cured coating.



Cause:

Moisture in the concrete or high humidity can cause moisture to be present on the surface when the material is being applied or before it's fully cured. This can result in a "milky or greasy" film. This is sometimes referred to as a "blush" or "amine blush".

Thick application: A milky or cloudy appearance can result from product being applied too thick. It's usually more noticeable if the coating is clear.

Repair:

- For moisture, remove affected area by diamond grinding.
- Monitor humidity levels and re-apply coating within the Product Data Sheet recommendations.
- If "greasy", wipe surface with Xylene or Acetone

Prevention:

Moisture: Test the area using a Moisture Meter.

Thick Application: Follow Product Data Sheet for mil thickness recommendations.

Epoxy Troubleshooting Guide

Orange Peel



Description:

A stipple appearance to the final coat of epoxy.

Cause:

Cold substrate or Cold Materials: This will prevent the product from leveling out causing an “orange peel” appearance.

Hot Substrate/Materials: This can cause the product to cure too rapidly which prevents the product from leveling out.

Repair:

- (1) Diamond grind the surface dull.
- (2) Remove all debris and dust by vacuum.
- (3) Re-apply the epoxy topcoat per the coating instructions.

Prevention:

Hot and Cold Substrate/Materials: Substrate should be above 15c and materials should be at 20c to 25c. If thinning is desired, use up to 5% Xylene mixed within the coating.

Epoxy Troubleshooting Guide

Peeling or Delamination

Description:

The epoxy is peeling or “letting go” from either the concrete or between layers of coatings.



Delamination from substrate:

Cause:

Improper Cleaning: The epoxy will not adhere to dirt, grease, or other contaminants.

No Primer Used: When priming is skipped, delamination may occur.

Moisture Vapour: Water vapour penetrating up through the substrate can cause peeling or delamination. After removing the problem areas, you may notice the concrete being dark from being damp.

Repair:

Improper Cleaning:

- The coating must be removed by grinding or blasting.
- Re-apply the epoxy after proper preparation.

No Primer Used:

- Remove the coating by suitable means.
- Prime and re-coat after proper preparation.

Epoxy Troubleshooting Guide

Moisture Vapour:

- Remove coating by suitable means.
- Measure moisture level; consult product data sheet before re-applying.

Prevention:

Improper Cleaning: Properly clean the substrate and provide a suitable profile by mechanical grinding or shot blasting.

No Primer: Use a suitable primer or prepare a primer following directions

Moisture Vapour Transmission:

- Substrates should have a properly installed and effective vapour barrier if in contact with the ground.
- Always perform a moisture test prior to installation. Test results should be no more than 75% relative humidity per 24 hours.
- Approved primer systems should be used on readings that are higher and/or mitigate the moisture levels.

Epoxy Troubleshooting Guide

Delamination between Coats:

Cause:

- Beyond re-coat window: Coating was applied beyond the recommended time for re-coating.
- Surface contaminants: Surface was contaminated by water, humidity, oil, dust or grease.
- Improper Mixing Methods: Coating was not mixed at proper ratio or for 3 minutes *at minimum*.

Repair:

Beyond re-coat window:

- Remove all loose or un-bonded coating.
- Surface needs sanding, using a diamond grinder or sander with 80 grit sandpaper.
- Vacuum to remove all dust and debris.
- Wipe the floor with Xylene or Acetone. Follow all safety instructions.
- Re-apply epoxy following Product Data Sheet instructions.

Surface Contamination:

- Make sure surface is clean and dry and free of any contaminants prior to coating. Vacuum or mop any water or dust.
- Oil and grease must be removed using a degreaser.
- Make sure the surface is dry before applying another coat.
- If surface coat has been on longer than 36 hours, you must diamond grind the floor dull.
- Remove any dust from surface by vacuum.
- Wipe surface with Xylene or Acetone. Follow safety instructions.
- Re-apply epoxy coating following Product Data Sheet instructions.

Improper Mixing:

- Remove any loose, peeling or uncured coating.
- Any uncured coating must be solvent wiped with Xylene or Acetone
- Diamond grind the coating.
- Vacuum the surface to remove dust and debris.
- Solvent wipe surface with Xylene or Acetone.
- Re-apply the epoxy following Product Data Sheet instructions.

Prevention:

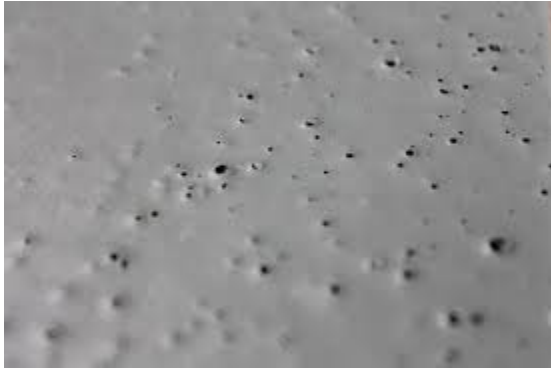
Beyond Re-coat Window: Each coat needs to be applied within 24 hours.

Surface Contamination: Check substrate carefully before applying epoxy. Remove any contamination prior to coating.

Improper Mixing: Follow directions on labels and Product Data Sheets.

Epoxy Troubleshooting Guide

Pinholes/Bubbling



Description:

Pinholes in the coating appear as small blisters or bubbles. After the blisters pop, they leave a round crater and the pinhole can be seen through the transparent film.

Cause:

Outgassing: Air escapes from the porous substrate and becomes trapped in the coating.

Temperature/Humidity: If too hot or humid, it can result in rapid drying that causes air entrapment in the coating.

Air Movement: Air movement from fans, door or vents blowing directly on the surface may cause flash drying which causes bubbles.

Sunlight: Direct sunlight can cause the product to tack up before necessary air release has occurred, which results in bubbles.

Mixing: Mixing at too high of a speed entraps air, resulting in bubbles.

Surface Prep: Extreme/aggressive shot blasting opens the pores in the concrete causing air to be trapped when the coating is applied resulting in bubbles.

Roller Covers: Not using the proper nap recommended. *12mm nap, Shed-Resistant, Rollers are recommended.*

Repair:

- Sand the problem areas dull. Vacuum dust and debris.
- Fill large craters with epoxy patching material.
- Sand patched areas and vacuum.
- Re-apply coating at recommended rate and follow directions.

Epoxy Troubleshooting Guide

Prevention:

Outgassing: Use a primer system on all porous concrete. Follow directions for mixing and using primer. Spike rollers can be used if bubbles appear but may not completely remove them.

Air Movement: Eliminate any source of direct air blowing onto the surface.

Temperature and Humidity: Follow all directions to ensure you are within the products recommended ranges.

Sunlight: Avoid direct sunlight when applying.

Mixing: Always use a jiffy mixer at medium to slow speeds. If air bubbles are present in coating, allow to sit briefly before pouring on the floor.

Roller Covers: Always follow recommended nap and type of cover. *12mm nap, Shed-Resistant, Rollers are recommended.*

Surface Prep: Avoid aggressive shot blasting.

RIGHT CHOICE COATINGS & SEALERS

Epoxy Troubleshooting Guide

Not Drying / Slow



Description:

The epoxy does not fully cure, or remains soft/tacky 24 hours after application.

Cause:

- Improper mix ratios
- Improper mixing methods
- Cold ambient temperatures

Repair:

- Remove the uncured coating down to the clean substrate by using solvent, scraping or mechanical grinding. Follow safety instructions on solvent.
- Re-apply the epoxy coating per Product Data Sheet.
- Never apply epoxy over uncured material.

Prevention

Improper Mix ratios: Always read and follow the printed information on the product containers or the Product Data Sheet. Use buckets that have pre-printed measuring guides to ensure the proper mix ratio.

Improper Mixing Methods: Always mix the base side (part a) first *thoroughly*. Then combine with the hardener (part b). Always mix for 3 minutes using a Jiffy mixing paddle at medium to slow speed, never a drywall mud mixing blade. Never flip buckets upside down on the floor to drain. This could result in sticky spots.

Cold Material: Always make sure the product containers have been brought to suitable room temperatures. Cold materials are difficult to mix and to work with.

Cold Ambient Temperatures: This will cause slower than normal drying times. This can cause air bubbles and blisters since the epoxy will remain thick and prevent vapour in the floor from escaping. Make sure the room is brought to suitable temperatures for at least 2 full days prior to application.

Cold Surface Temperatures: Concrete that is 13c or lower will greatly affect the drying time of the epoxy. It can also hurt the physical performance properties of the epoxy. A cold surface can also cause adhesion issues with your project. Make sure the concrete is at least 15c for a minimum of 2 days prior to application.

Epoxy Troubleshooting Guide

Stains / Tyre Marks



Cause:

Tyre Marks: Marks left behind from vehicles.

Chemicals or Spills: Contamination left from spilling products on the surface.

Prevention:

Chemicals or Spills: Epoxies take approximately 7-10 days to fully cure. It is important to allow a minimum of 24 hours for foot traffic and at least 5 full days for forklift traffic or heavy loads.

Tyre Marks: Due to the tyres being manufactured with plasticizers, which improve cold weather traction, they tend to leach this plasticizer on to the epoxy floors *when the tyres are warm or hot from driving*. This chemical reaction between the tyres and epoxy floors are sometimes unavoidable. To help prevent this, consider placing a rubber mat at the location where tyres will be on a constant basis.

Epoxy Troubleshooting Guide

Sticky or Uncured Coating

Description:

The epoxy does not fully cure, or it is still soft/sticky after 24 hours.



Cause:

- Improper mixing ratio
- Improper mixing
- Material was cold
- Cold ambient temperatures
- Cold surface temperatures

Repair:

- Remove the uncured coating down to the clean substrate by using solvent wiping, scraping and grinding or blasting. Follow all safety precautions.
- Re-coat the entire floor following Product Data Sheets.
- Never apply over uncured material.

Prevention:

Improper Mix Ratio: Always read and follow the mix ratios on the bucket labels and/or the Product Data Sheets. Use mixing containers that have printed measurements on them.

Improper Mixing Methods: Always mix the base side (part a) first thoroughly. Then combine with the hardener (part b). Always mix for 3 minutes using a Jiffy mixing paddle at medium to slow speed, never a drywall mud mixing blade. Never flip buckets upside down on the floor to drain. This could result in sticky spots.

Cold Materials: Cold materials will result in slower than normal cure times and can affect their appearance when dry. Cold material is difficult to mix, roll out and to level out. Product should always be allowed to acclimate to the proper temperatures recommended on the Product Data Sheets.

Epoxy Troubleshooting Guide

Yellowing



Description:

The epoxy has developed a yellow or amber hue. This will affect both clear and pigmented epoxies.

Cause:

Sunlight: Epoxies, when exposed to sunlight- direct or partial, will amber or yellow.

Repair:

- Remove any dirt, grease or oil by cleaning with appropriate cleaning agent.
- Dull the surface using a diamond grinder or other mechanical method. Then remove dust.
- Re-apply coating as per manufacturers recommendations.

Prevention:

- When using a decorative vinyl flake system, use a *full flake* system. Remember to apply a UV stable, clear, urethane topcoat.
- When using a solid color, use a UV stable, clear, urethane topcoat. This will not prevent yellowing entirely but will hinder it. You may also wish to use a pigmented urethane topcoat.