TROUBLE SHOOTING

No.	Symptoms	Possible Cause	Solution
1	Zinga does not dry	The incorrect solvent was used for thinning	Discard all suspect Zinga, and begin again with new Zinga from unopened tins.
2	Zinga dries but goes “rubbery” in places	It 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	Zinga ‘cobwebs’ when being sprayed by conventional spraygun	The Zinga has not been thinned correctly	Make sure that the Zinga is thinned approximately 5% with Zingasolv
4	Zinga has an ‘orange-peel’ appearance and also sometimes dries slower	The Zinga was applied too thickly, or was not thinned correctly	Dilute the Zinga ± 5% with Zingasolv and apply 2 or 3 thinner coats
5	More Zinga 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 Zinga is being used than estimated	The Zinga has been over-thinned	Use new Zinga from an unopened tin, and dilute it with the over-thinned Zinga
7	Excessive misting develops when spraying	The Zinga has been over-thinned	Use new Zinga from an un-opened tin. Dilute it with the over-thinned Zinga .
8	After drying the Zinga can be easily removed	The steelwork was not blast-cleaned, or was not given the correct profile	Select the correct grade of blast-media and re-blast the entire area
9	After drying, the Zinga coating remains ‘cheesy’	The Zinga 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 Zinga has been over-thinned or the blast-profile is too deep.	Check the viscosity of the liquid and apply subsequent coats until the patches disappear
11	A topcoat over Zinga forms blisters or delaminates	The top-coat has been applied too thick, causing solvent entrapment	Remove the topcoat (and Zinga if required) and re-apply at the correct dry film thickness
12	The paint topcoat remains cheesy after application onto Zinga	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 Zinga coating was not given sufficient curing time	Re-blast the entire affected area and re-apply both coatings. Pre-heating the steelwork helps drive any trapped solvents
14	Over hot-dip galvanizing, the Zinga layer breaks away	The HDG was too new to be over-coated with Zinga	Ensure that all passivation has been removed and sweep-blast the HDG at a pressure of 60 psi
15	Pin holes appear in a heat cured paint top coat on zinganised 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 zinganised steelwork to a temperature of 40^{o}C before application of finishing coats

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