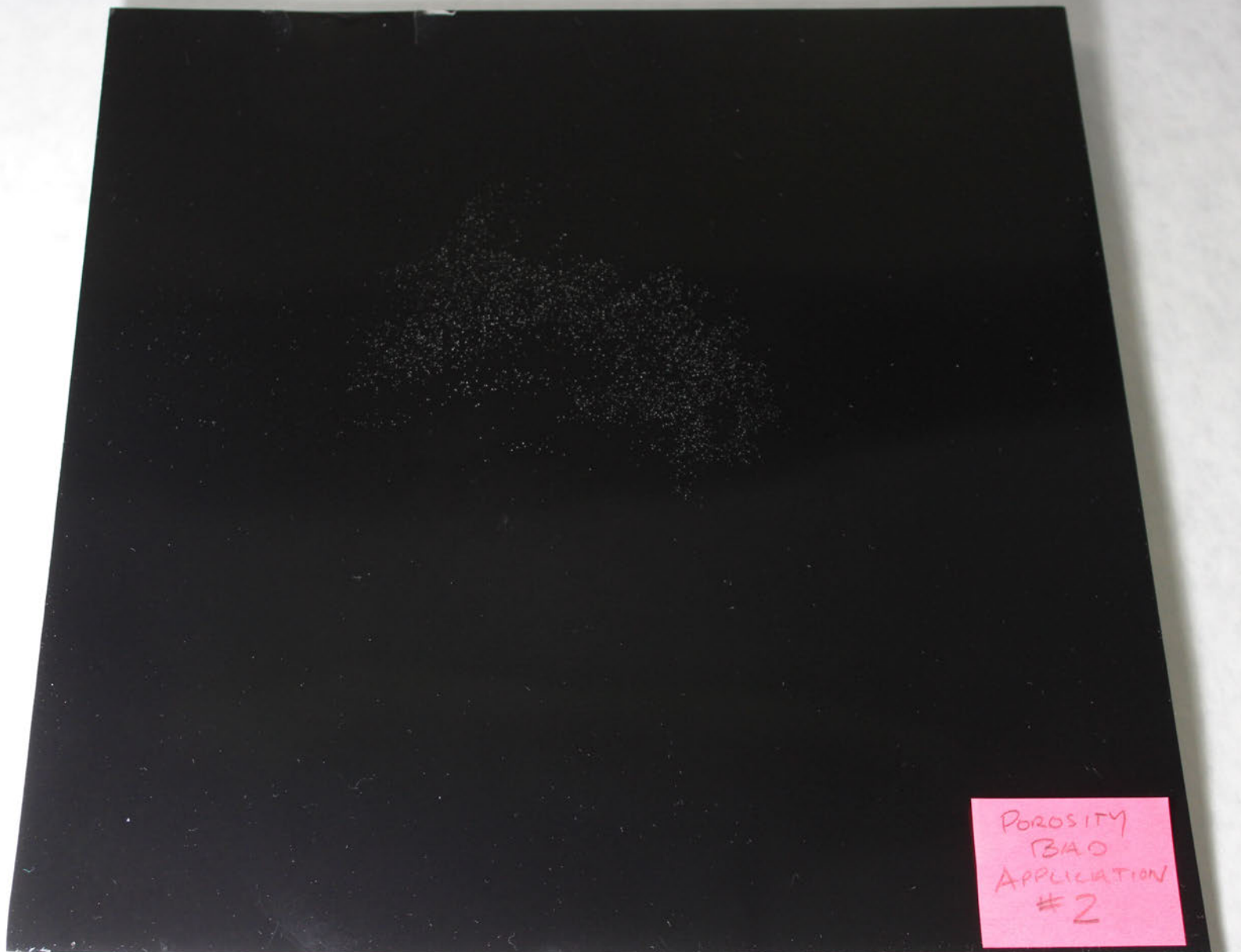


DURA-KOTE Troubleshooting



Porosity

- Porosity is air captured in gel coat
- Can be caused by bad application
- Cold molds
- Catalyst
- Catalyst ratio
- Spray tip size
- Spray angle
- Many other factors



DURA-KOTE Troubleshooting



Porosity

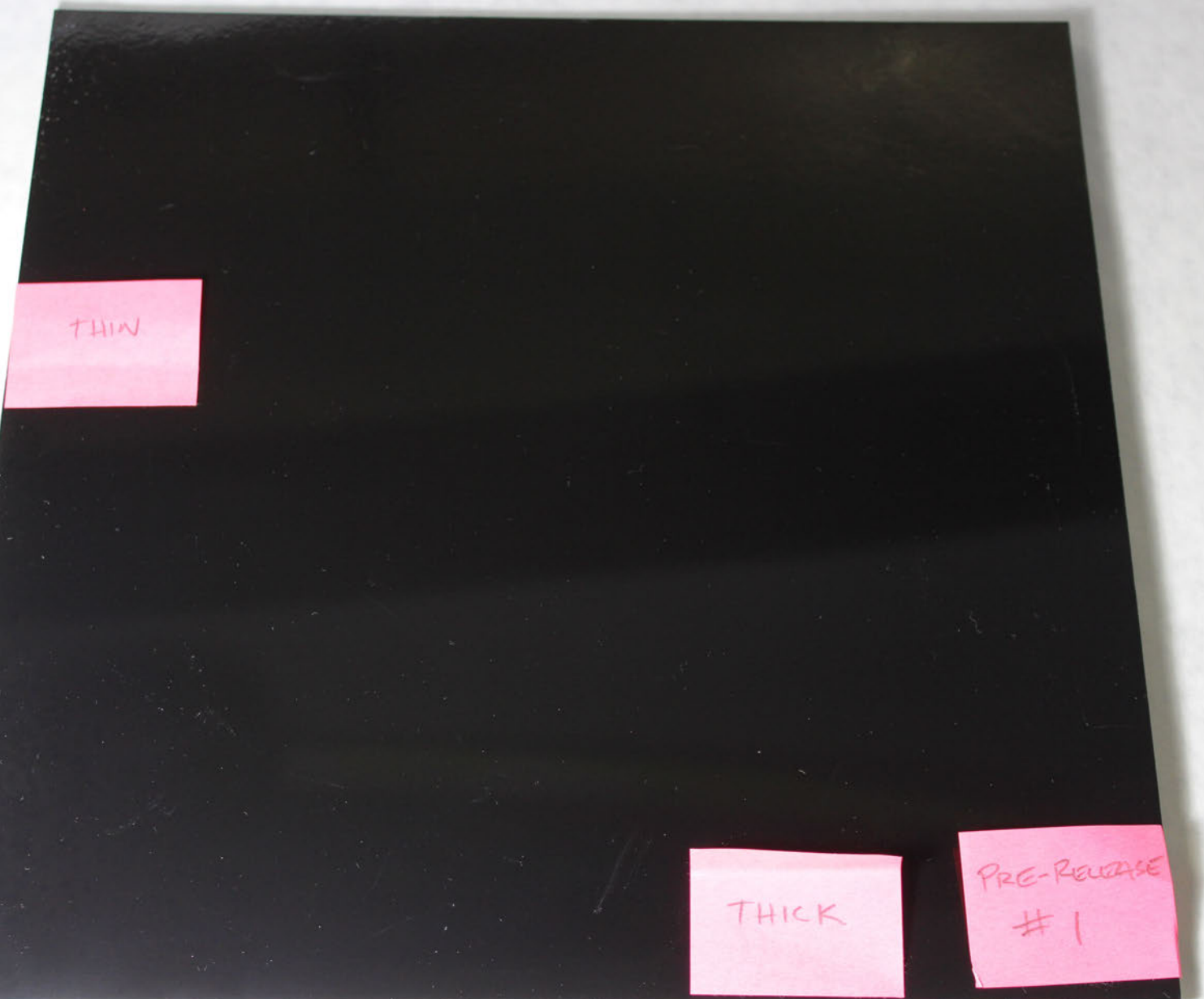
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DURA-KOTE Troubleshooting

Pre-Release

- Gel coat to thick
- Gel coat to thin
- Uneven gel coat thickness
- Gel time to fast
- Waited to long to laminate
- Slippery release
- Many other factors



DURA-KOTE Troubleshooting



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DURA-KOTE Troubleshooting



Porosity

- Water
- Oil
- Defects caused by other factors



DURA-KOTE Troubleshooting



Porosity

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- Oil
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DURA-KOTE Troubleshooting

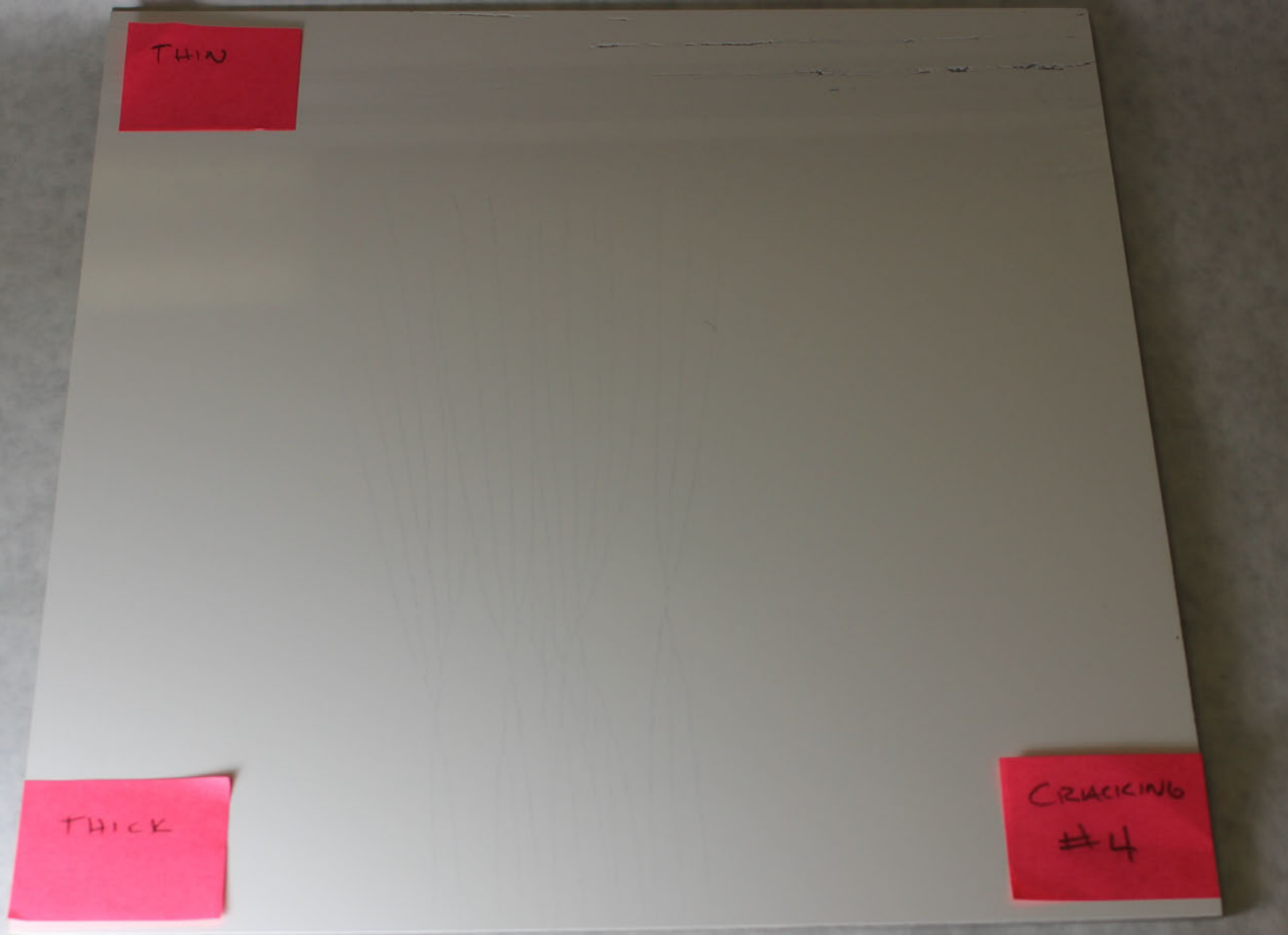


Porosity

- Water
- Oil
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DURA-KOTE Troubleshooting



Cracking

- Thick
- Thin
- Part flexing while green
- De-molding part strain
- Thick application can increase the chances of cracking



DURA-KOTE Troubleshooting

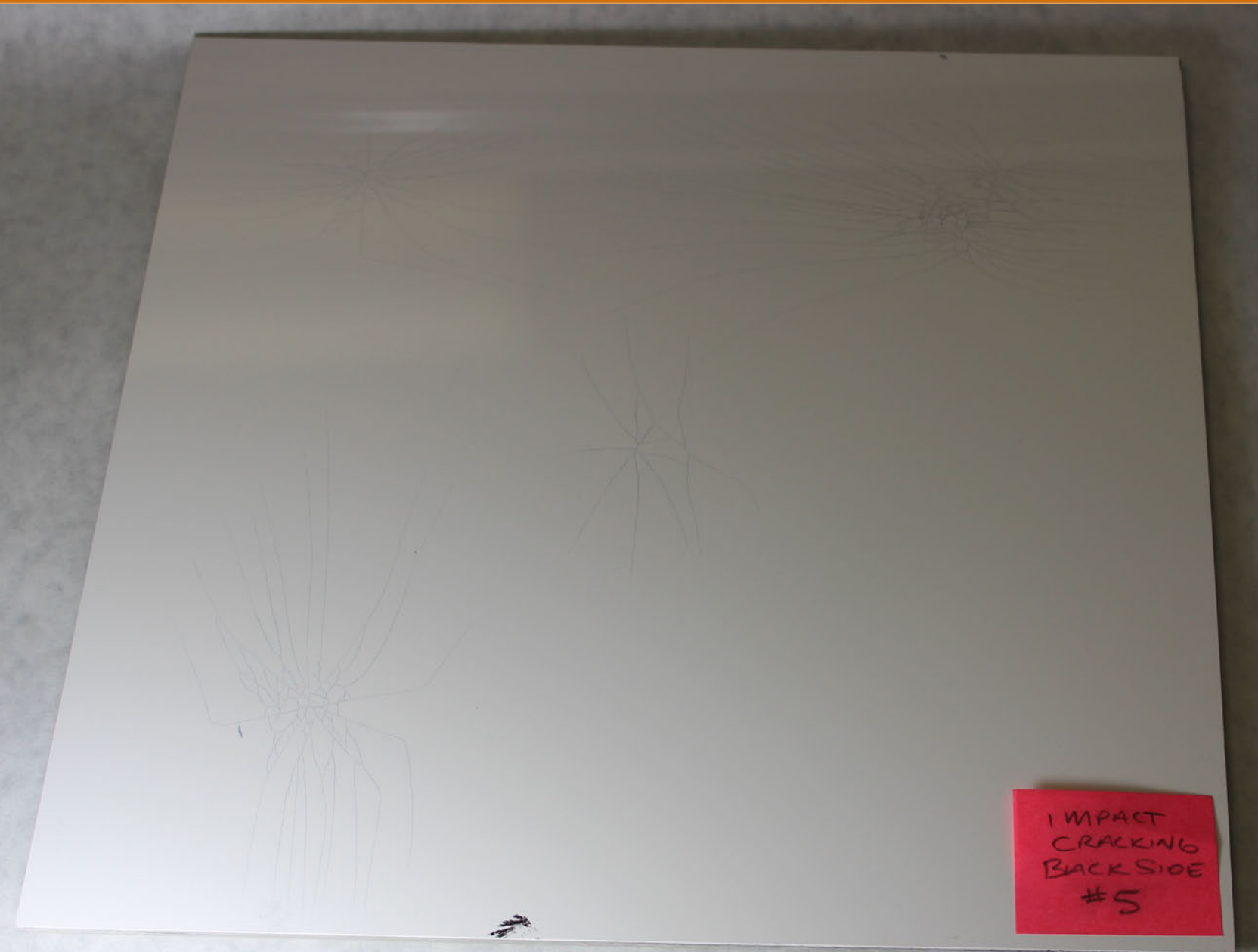


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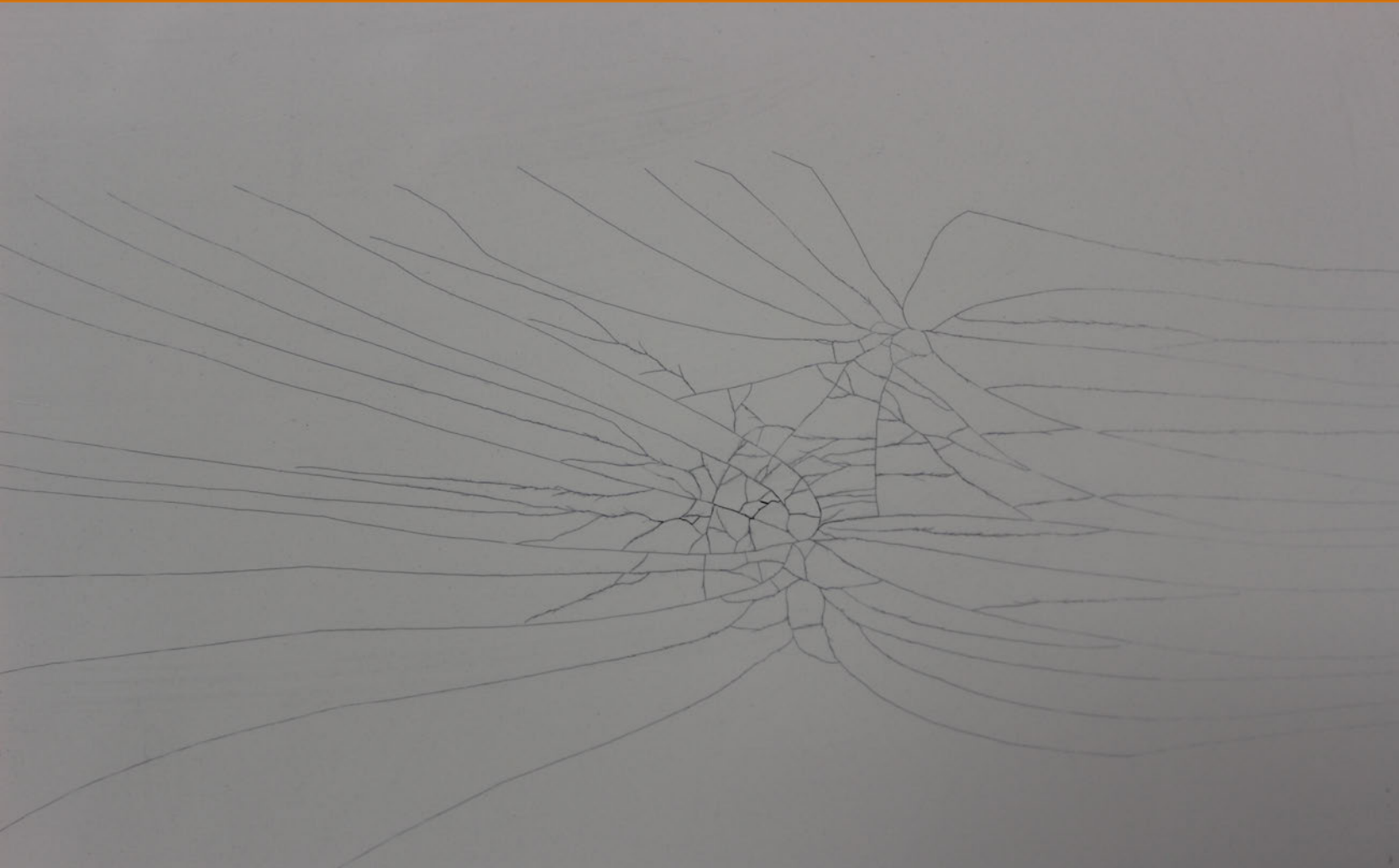


Backside Impact Cracking

- Commonly caused by beating on the mold with a hammer during de-lamination



DURA-KOTE Troubleshooting



Backside Impact Cracking

- Commonly caused by beating on the mold with a hammer during de-lamination



DURA-KOTE Troubleshooting



Backside Impact Cracking

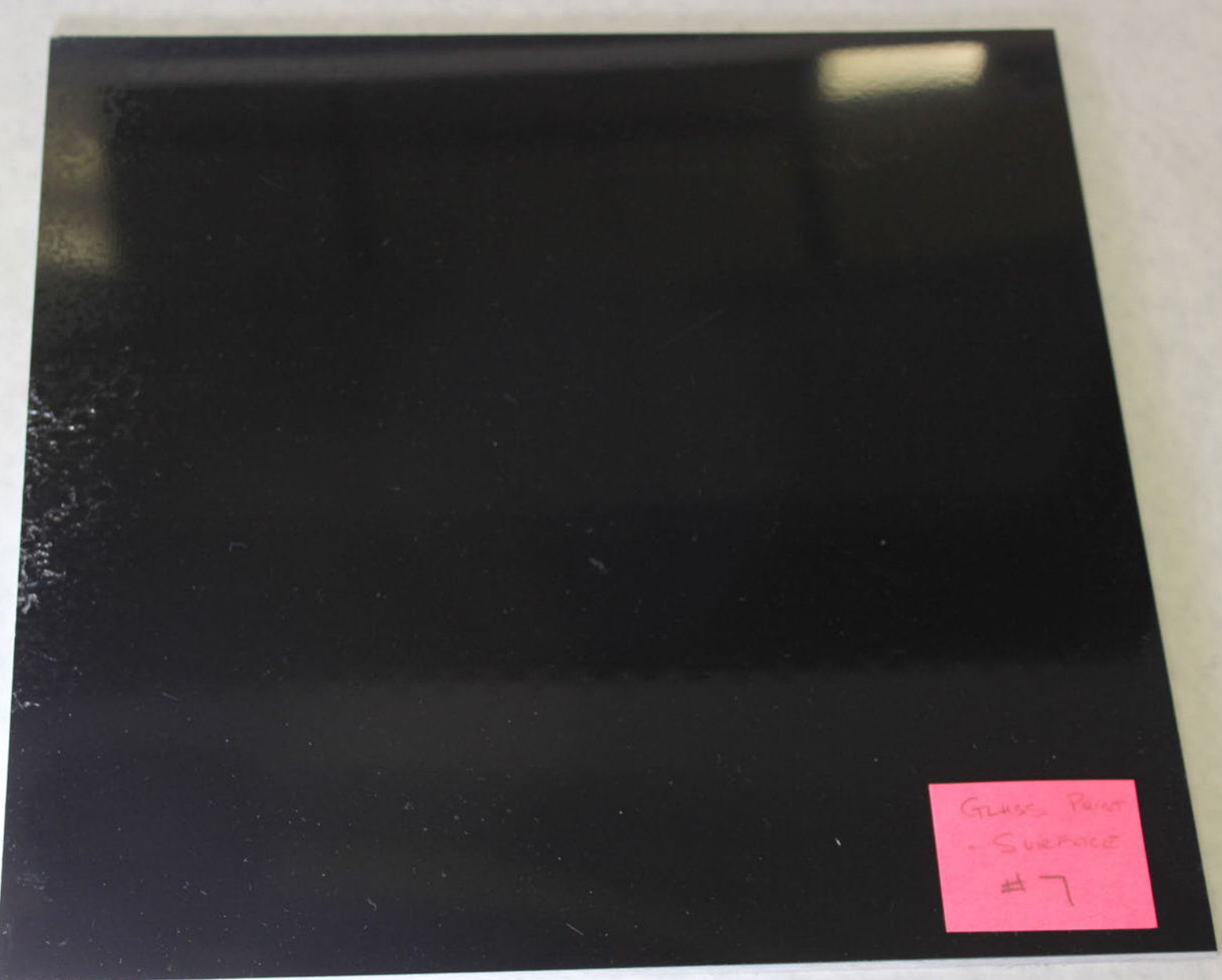
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DURA-KOTE Troubleshooting

Glass Print on Surface

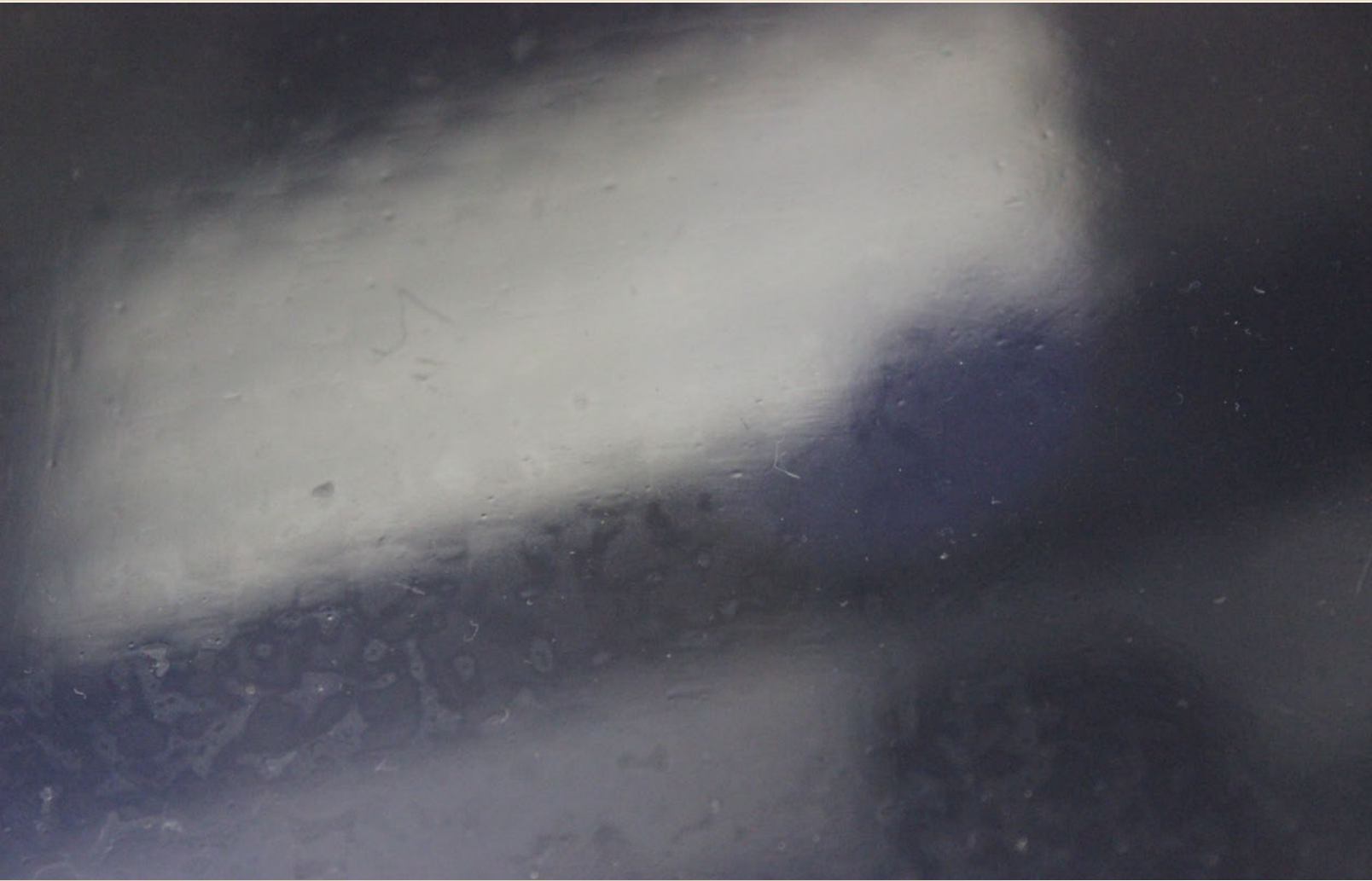
- Not enough resin to wet the glass fiber
- Not using a skin coat
- Gel coat not sufficiently cured before laminating
- Not using a barrier coat



GLASS PRINT
- SURFACE
7



DURA-KOTE Troubleshooting



Glass Print on Surface

- Not enough resin to wet the glass fiber
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DURA-KOTE Troubleshooting

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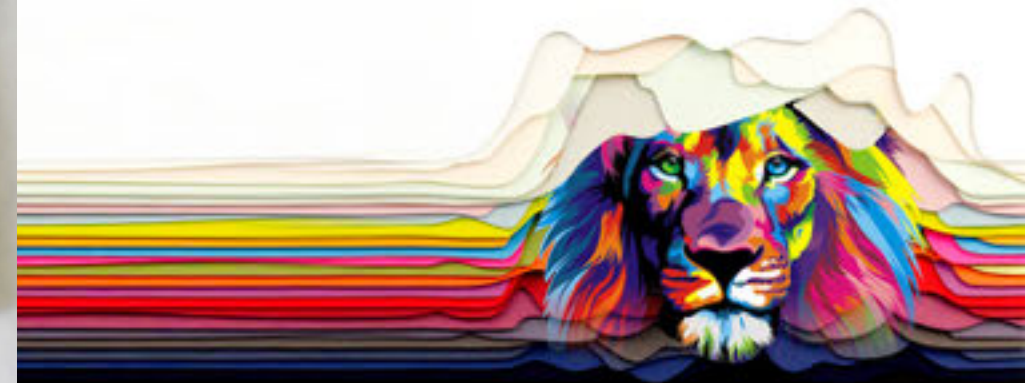


DURA-KOTE Troubleshooting



Air Dimples

- After a day or week, the surface quality gets worse due to air entrapment caught in laminate
- Temperature change will cause dimples to increase and become more visible over time



DURA-KOTE Troubleshooting

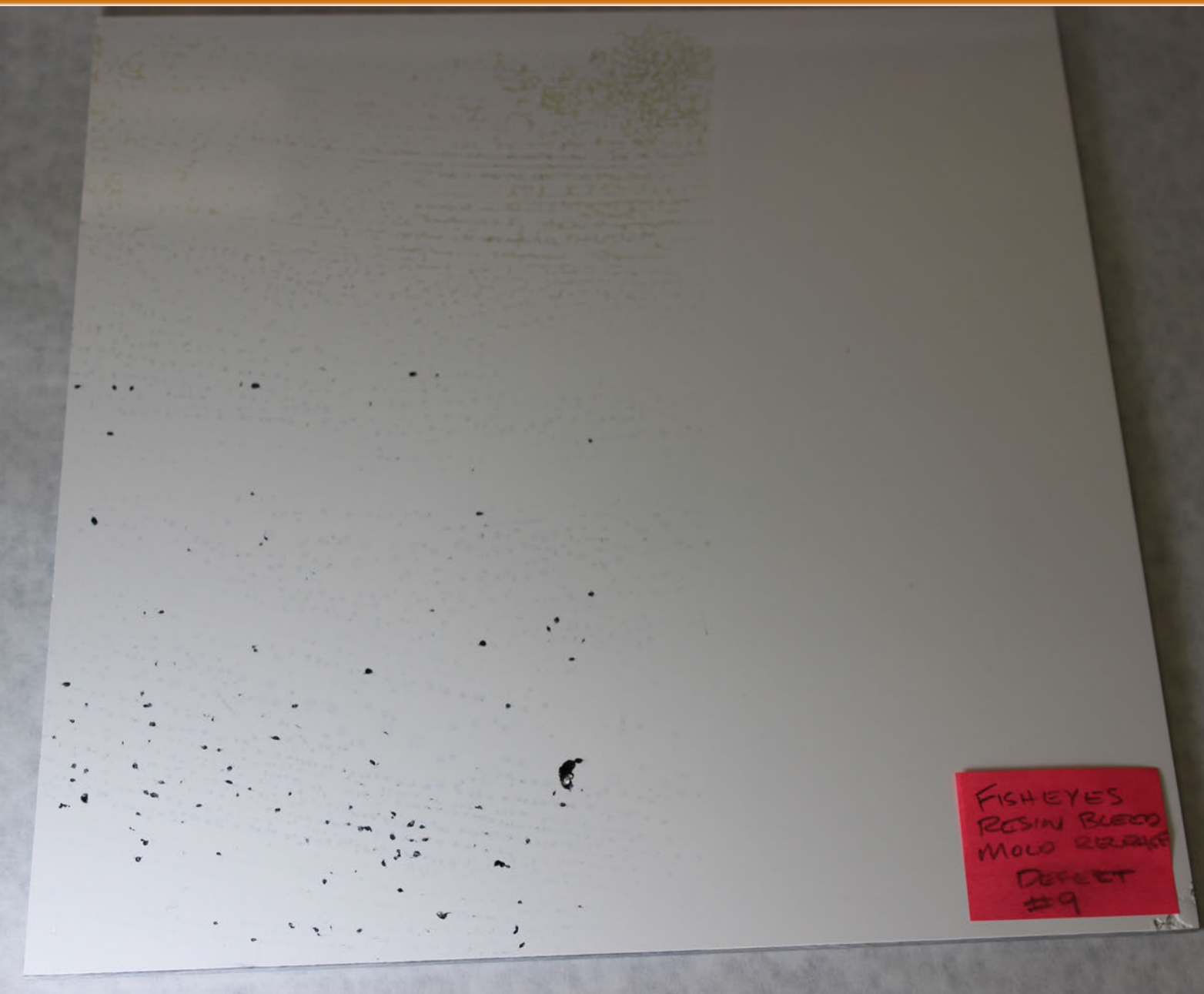


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DURA-KOTE Troubleshooting



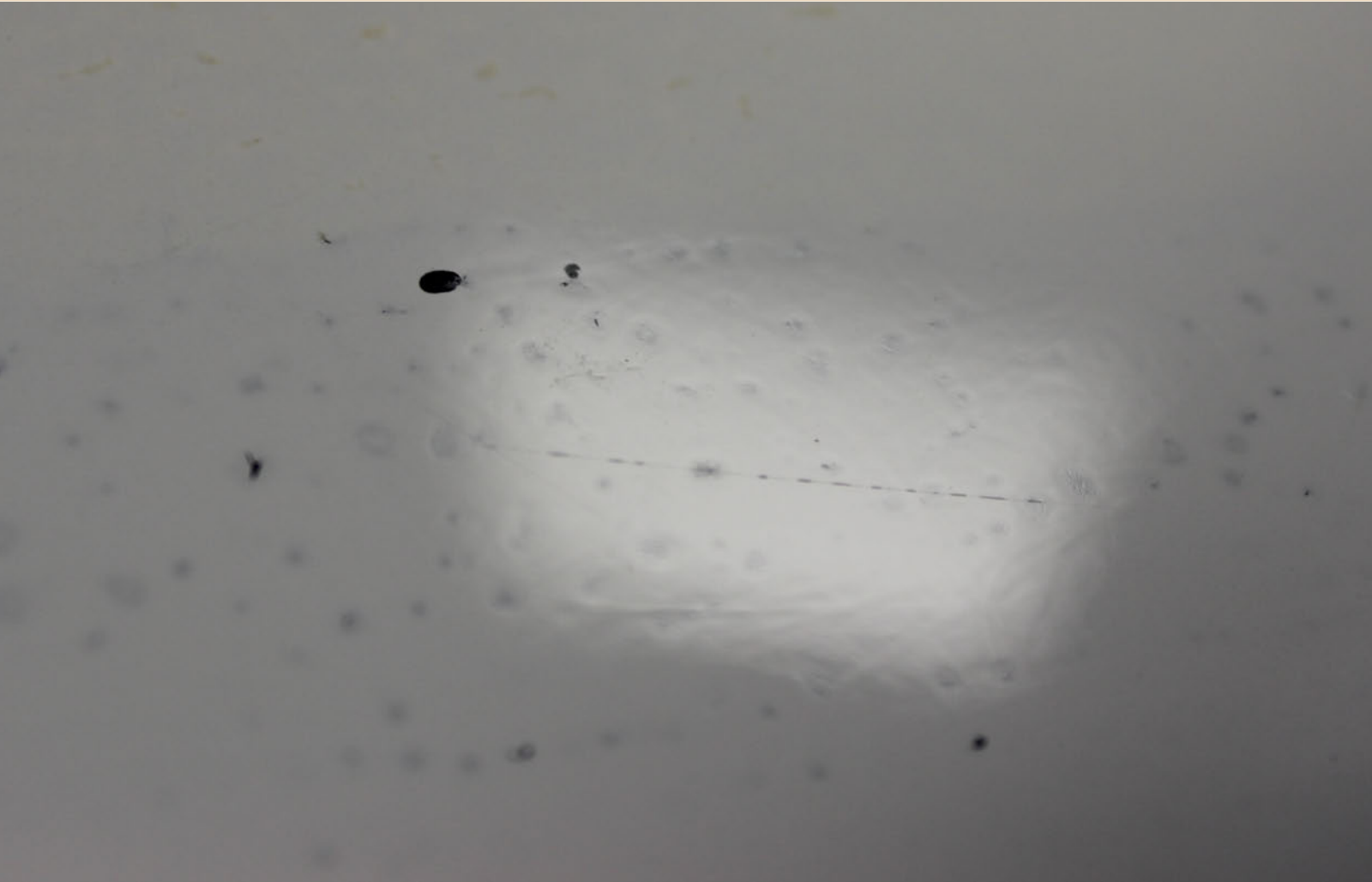
FISHEYES
RESIN BLEED
MOLD RELEASE
DEFECT
#9

Fisheyes

- Resin Bleed
- Mold Release
- Other Factors



DURA-KOTE Troubleshooting

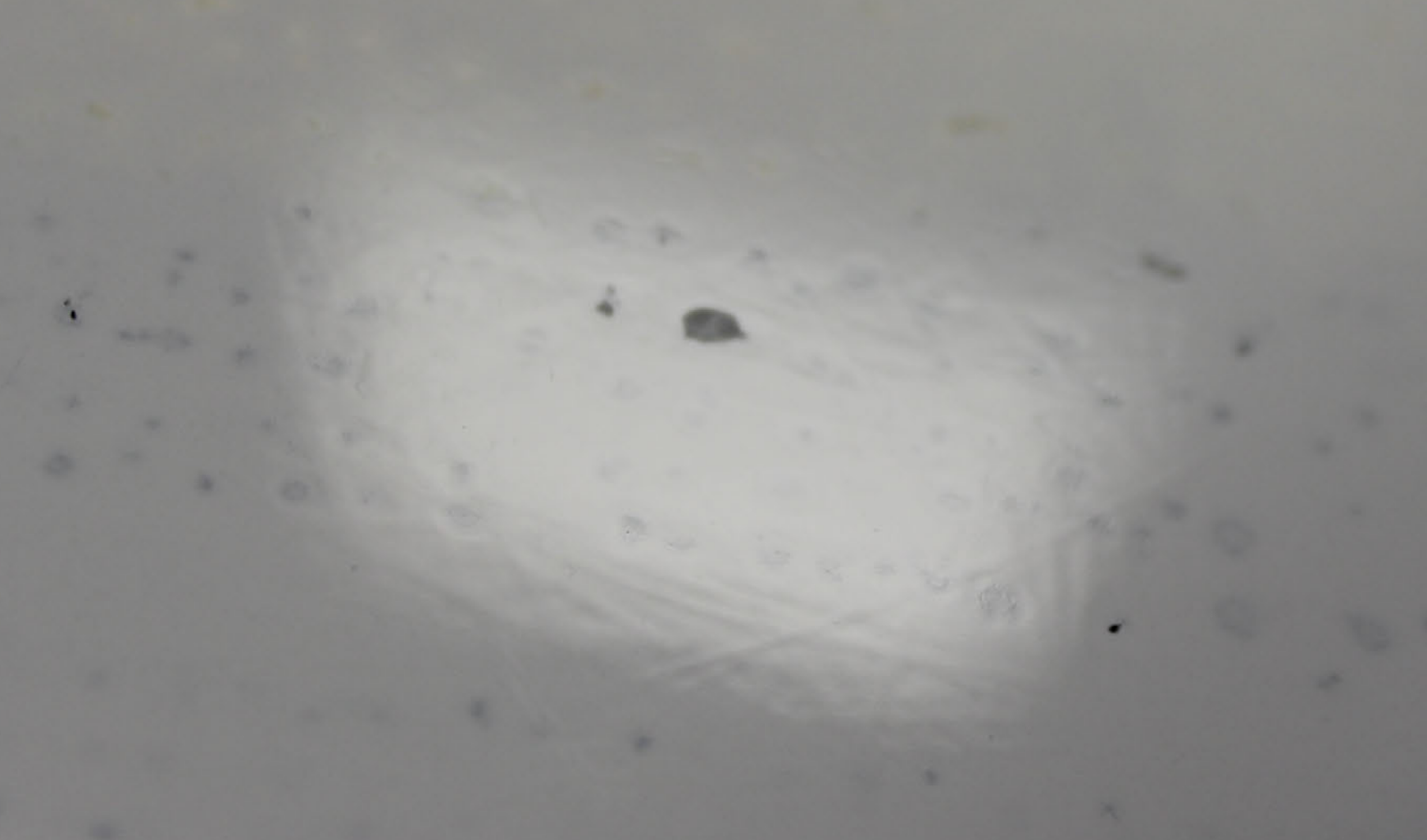


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DURA-KOTE Troubleshooting



Fisheyes

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DURA-KOTE Troubleshooting

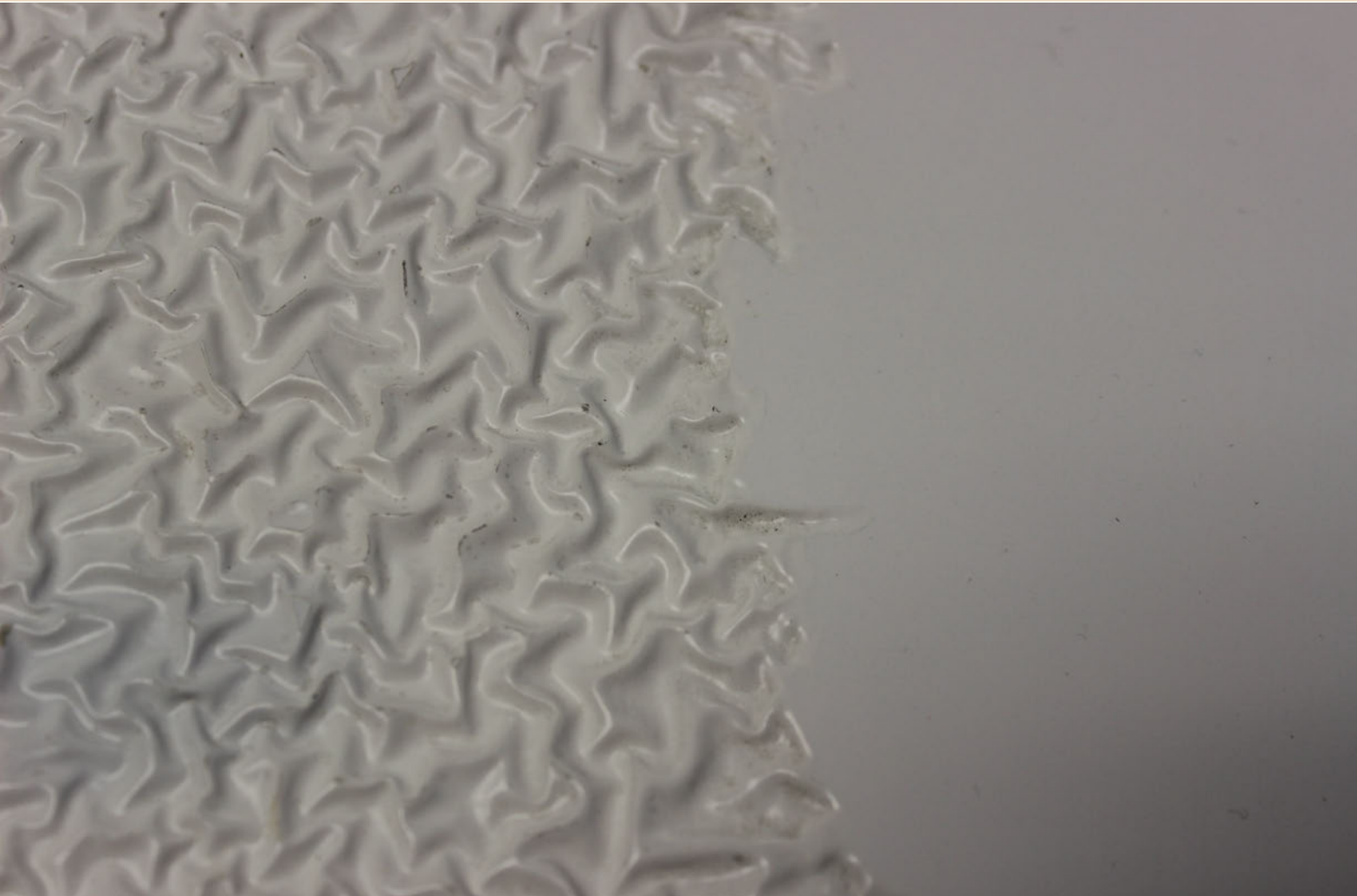


Alligators

- Under cured gel coat in contact with styrene



DURA-KOTE Troubleshooting



Alligators

- Under cured gel coat in contact with styrene

