



ZINGA Troubleshooting

NO.	SYMPTOM	POSSIBLE CAUSE	SOLUTION
1	ZINGA does not dry	The incorrect solvent was used	Discard all of the suspect ZINGA and begin again with new ZINGA, only dilute with Zingasolv
		Inadequate ventilation	Provide suitable ventilation
2	ZINGA dries but has a 'rubbery' appearance in some places	It was applied over an old paint coating	Re-blast the entire affected area to Sa 2.5 and then coat with ZINGA.
3	ZINGA 'cobwebs' when being sprayed on with a conventional spray-gun.	ZINGA has not been diluted enough	Add more Zingasolv
		The spray-gun pressure was set too high	Ensure the spray gun pressure is set between 2 - 4 bars maximum
		The spray-gun nozzle is too small, forcing the zinc through at a very high speed and losing too much solvent	Always ensure that the minimum nozzle size is 1.8 mm
4	The ZINGA layer shows an 'orange-peel' appearance and may also dry a bit slower	The coating has been applied too heavily	Dilute the ZINGA a bit more and apply less passes.
		ZINGA has not been diluted enough	
		The nozzle pressure is too high	Lower the nozzle pressure
5	More ZINGA is being used than was estimated	The blast-profile is too deep	Change the blast media to the correct type and grade
		DFT* was not respected	Reblast and recoat the areas where the maximum DFT is exceeded
6	Less ZINGA is being used than estimated	The blast-profiles are too low	Check the profiles and where necessary re-blast with the correct type and grade of blast-media.
		DFT was not respected	Check whether the DFT is within the specification range. Apply a second layer if the DFT is insufficient.
7	Excessive misting occurs during spraying	ZINGA was over diluted	Open a new tin of ZINGA and mix it with the over-thinned tin. Add a bit of Zingasolv to achieve the correct viscosity
		ZINGA was not properly mixed	Check the bottom of the can for zinc deposit and mix again.



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8	After drying, the ZINGA coating is not adhering sufficiently to the substrate	The surface does not have the adequate roughness profile	Blast-clean the steelwork using the specified type and grade of media
		The blast profile is very shallow	Re-blast to the correct depth
		ZINGA was applied over a thin layer of mill scale	Re-blast to the correct depth and ensure there is no loose scale present before application of ZINGA
		ZINGA was applied onto a surface that was not correctly de-dusted	Re-blast the affected areas and ensure that correct de-dusting is carried out before application of ZINGA
9	After drying, the ZINGA remains soft or 'spongy'	The ZINGA coating has been applied over oil or grease	The affected areas must be washed down with strong solvent, degreased and recoated
10	When viewed obliquely, the coated steelwork has a patchy appearance	Either ZINGA was over-thinned or the blast profile was too deep	Check the viscosity of the ZINGA and apply further coats until the patchiness disappears
11	The paint topcoat dries but does not go hard after several days	The top-coat was an alkyd-based coating	Blast-off all the coatings back to bare steel and re-apply the ZINGA. If an alkyd topcoat is required, then the ZINGA must be sealed with a compatible sealer
		The hardener was not added or added in the wrong proportion (for 2 components topcoats)	Blast-off all the coatings back to bare steel and re-apply the system with special attention to the mixing proportions of the 2 component topcoat.
12	A topcoat forms blisters and delaminates	The mist/full coat technique was not applied	Re-blast and recoat the surface with the correct application techniques
13	After rain exposure, the ZINGA layer is showing stains	ZINGA is reactive to moisture and air, the reaction products can show color variations	No action necessary. After time, the ZINGA layer will have a more uniform appearance.
14	The applied ZINGA is sagging on a vertical structure	ZINGA was over diluted	Open a new can of ZINGA and mix it with the over-thinned can. Add a bit of Zingasolv to achieve the correct viscosity
		ZINGA was applied too thick	Check whether the WFT** is within the specification range. Re-blast and recoat if the WFT exceeds the specification. If needed apply in 2 passages.
15	When used over hot-dip galvanising the ZINGA layer flakes off	The galvanising was either too new or too smooth	Remove ZINGA and obtain a rough surface profile on the galvanisation. Re-apply the ZINGA



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16	When applying ZINGA by airless spray we encounter some blocking after some time	Zinc particles have settled in the bottom valve or in the spray tip	Clean the bottom ball valve for zinc mud and use a 60 mesh filter at the spray tip. Release pressure when not spraying.
17	When applying ZINGA by airless spray we encounter some blocking after only 1 - 2 minutes	Either the spray-tip is too small, the ZINGA is not diluted enough or the inline filters have not been removed	Remove all filters, except for the 60 mesh filter at the spray tip. Place the spray tip with the correct size.
18	The ZINGA layer shows craters and/or heavy pinholes	The steel structure has too deep pittings	Level out the pittings and re-blast
		ZINGA was applied too thick	Re-blast and recoat if the DFT exceeds the specification
		Surface roughness profile is too coarse	Check the profiles and where necessary re-blast with the correct type and grade of blast-media
19	Heavy brush marks on the surface	ZINGA was not diluted enough before use or use of wrong type of brush	Go over entire surface with a short haired roller using fresh ZINGA diluted 10 - 15%. Be attentive for excessive thicknesses
20	The ZINGA layer is showing cracks	ZINGA was applied too thick	Check whether the DFT is within the specification range. Re-blast and recoat if the DFT exceeds the specification

*DFT = Dry Film Thickness

**WFT = Wet Film Thickness

For more specific and detailed recommendations or in case of any doubt concerning the application of ZINGA, please contact a Zingametall representative.