



## Cracking (Splitting)

### Description

Generally, splitting of the dry paint film. Especially, a breakdown in which the cracks penetrate at least one coat and may be expected to result ultimately in complete failure.

### Cause

- Excessive film thickness;
- Insufficient flash off time between coats;
- Wrong or poor thinner;
- Insufficient thinning;
- Excessive hardener or improper mixing ratio;
- Effect of old finish or previous repair;
- Application of thermosetting paint insufficiently cured coat or thermoplastic acrylic paint;
- Material applied and went beyond pot life cycle;
- Coating of very cold surface;

### Prevention

- Use correct thinner, hardener and follow recommended mixing ratio;
- Mix paint thoroughly;
- Prepare the surface properly;
- Allow sufficient flash off and drying time between coats;
- Ensure normal application conditions. Avoid spraying in cold conditions;

### Rectification

- If only top coat is affected, sand the affected area to a smooth surface and refinish;
- In extreme cases remove all paint to the bare metal and apply refinish system;