

SBC

TROUBLESHOOTING GUIDE

(CATEPOX® Heat- and Wear-Resistant Coating)

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1. PURPOSE

This Troubleshooting Guide provides assistance in identifying, analysing and resolving issues that may occur during the application, curing or service life of **CATEPOX® Heat- and Wear-Resistant Coating**.

The purpose of this document is to support users in maintaining the expected performance, durability and protective properties of the coating system while minimizing downtime and repair costs.

2. SCOPE

This guide applies to issues that may arise during:

- Surface preparation;
- Material mixing;
- Coating application;
- Curing;
- Service conditions;
- Maintenance and repair activities.

It is intended for use by applicators, inspectors, maintenance personnel and technical support staff.

3. COMMON PROBLEMS AND POSSIBLE CAUSES

Problem	Possible Cause
Poor adhesion	Inadequate surface preparation or surface contamination
Blistering	Moisture trapped beneath or within the coating
Cracking	Excessive film thickness or improper curing
Runs and sags	Excessive material application or incorrect application technique
Uneven surface finish	Inadequate mixing or improper application

Problem	Possible Cause
Discolouration	UV exposure, chemical attack or improper storage conditions
Slow curing	Low temperature, high humidity or incorrect mixing ratio

4. DIAGNOSIS

When a defect is identified, verify the following:

- Condition of the substrate;
- Dry film thickness (DFT);
- Adhesion of the coating;
- Mixing ratio of Components A and B;
- Application method;
- Ambient temperature;
- Relative humidity;
- Surface temperature;
- Curing time and curing conditions.

A systematic assessment should be completed before corrective actions are initiated.

5. RECOMMENDED CORRECTIVE ACTIONS

Depending on the identified defect, corrective actions may include:

- Removal of defective coating;
- Re-preparation of the substrate;
- Correct mixing of fresh material;
- Reapplication of the coating system;
- Improvement of curing conditions;
- Complete recoating where local repair is not technically acceptable.

All repair work shall be performed in accordance with the **Repair Procedure** and **Application Guide**.

6. PREVENTIVE MEASURES

To minimise the occurrence of defects:

- Follow the Technical Data Sheet at all times;
- Ensure proper surface preparation;

- Observe the specified mixing ratio;
 - Monitor environmental conditions before and during application;
 - Apply the specified coating thickness;
 - Use only materials within their stated shelf life;
 - Follow the recommended curing times before placing the coating into service.
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7. WHEN TO SEEK TECHNICAL ASSISTANCE

Technical support from SBC is recommended if:

- Coating failures repeatedly occur;
 - Large surface areas are affected;
 - Adhesion failures cannot be explained;
 - Chemical attack has occurred;
 - Structural corrosion is present;
 - The appropriate repair method cannot be determined;
 - Additional technical evaluation or testing is required.
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8. DOCUMENTATION

For every coating defect, the following information should be recorded:

- Project name;
- Location;
- Inspection date;
- Batch (LOT) number;
- Description of the defect;
- Photographs;
- Corrective actions taken;
- Results of the follow-up inspection.

These records should be retained as part of the project quality documentation.

9. RELATED DOCUMENTS

- Technical Data Sheet (TDS)
- Safety Data Sheet (SDS)

- Application Guide
 - Repair Procedure
 - Maintenance Guide
 - Inspection and Acceptance Checklist
 - Quality Control Plan
 - System Specification
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10. DOCUMENT CONTROL

This Troubleshooting Guide forms part of the SBC document management system.

The document shall be reviewed whenever:

- A new product version is introduced;
- Application technology is modified;
- Applicable standards or regulations are revised;
- Or at least once every three years as part of the regular document review process.