

# Troubleshooting Diagnosis Card

Identify the symptom, find the cause, apply the fix. Chapter 8 has the full diagnosis flowchart.

**F** F = Fixable

**P** P = Partially fixable

**N** N = Cannot fix — remake

| Symptom                             | Most Likely Cause  | Fix?     | Immediate Response   |
|-------------------------------------|--|----------|--|
| <b>Sticky surface / not curing</b>  | Wrong ratio, incomplete mixing, too cold, or >10% colorant   | <b>F</b> | Reheat to 75°F, wait 72 hrs. If still sticky: sand layer off and recoat.     |
| <b>Bubbles on surface</b>           | Air in mixing, poured too fast, or cold thick resin          | <b>F</b> | Torch 6" above surface within 10 min of pour. Do not over-torch.             |
| <b>Cloudy / milky finish</b>        | Humidity above 50%, moisture in mold, or in water colorant   | <b>P</b> | Surface haze: sand 2000-grit and polish. Internal fix. cloudiness: cannot    |
| <b>Fish eye craters</b>             | Silicone contamination on mold, surface, or inclusions       | <b>P</b> | Small: drill out and fill with clear resin. Widespread: sand and recoat.     |
| <b>Overheating / smoke</b>          | Too much volume per pour, depth exceeded, or fast-cure resin | <b>N</b> | Do not touch — let cure and dispose. Next time: in pour thinner layers.      |
| <b>Yellowing after cure</b>         | UV exposure on non-UV-stabilised resin                       | <b>F</b> | Sand surface, apply UV-resistant topcoat. Display away from sunlight.        |
| <b>Uneven surface / tide marks</b>  | Dust during cure, or torch brush marks                       | <b>F</b> | Sand 400→800→1500-grit, polish with Novus 2 then Novus 1.                    |
| <b>Resin pulled from mold edges</b> | Mold not sealed or level, or uneven pour                     | <b>P</b> | Fill gap with clear resin via syringe. Widespread: and demold sand.          |
| <b>Colour bleeding / migration</b>  | Incompatible colorants or layer poured before full cure      | <b>N</b> | Cannot fix. Prevention: 24 hrs between layers, seal alcohol ink layers.      |
| <b>Inclusions sinking</b>           | Added too early (resin too liquid) or inclusion too heavy    | <b>P</b> | Work in gel stage for heavy inclusions. Add during pour as resin thickens.   |
| <b>Delamination between layers</b>  | No sanding between sessions, or surface contaminated         | <b>P</b> | Inject clear resin into edge gap and clamp. Internal: remove layer, restart. |
| <b>Mold flex / warped bottom</b>    | Flexible mold on uneven surface or during unsupported cure   | <b>P</b> | Flatten base by sanding. Support flexible molds on flat rigid surface.       |

**GOLDEN RULE:** If in doubt about the cause, change one variable at a time and test before repouring.

Full troubleshooting with diagnosis flowchart: Chapter 8, Epoxy Resin Art for Beginners.