

PROBLEMS	POSSIBLE CAUSES	SUGGESTED SOLUTIONS
<b>Charring or Gelling of Adhesive in Reservoir</b>	<ol style="list-style-type: none"> <li>1. Temperature too high</li> <li>2. Overheating reservoir walls</li> <li>3. Faulty heating control</li> <li>4. Oxidation of adhesive</li> <li>5. Incompatible adhesives</li> </ol>	<ol style="list-style-type: none"> <li>1. Lower reservoir temperature</li> <li>2. Keep reservoir full of adhesive</li> <li>3. Check control &amp; replace if necessary</li> <li>4. Maintain level of adhesive in reservoir. Keep reservoir covered with adhesive. Nitrogen blanket may be necessary</li> <li>5. Change adhesive. May have to flush system with neutral material</li> </ol>
<b>Substrates Popping open out of Compression Unit</b> <i>(one side only)</i>	<ol style="list-style-type: none"> <li>1. Temperature of adhesive too low.</li> <li>2. Too little adhesive applied</li> </ol>	<ol style="list-style-type: none"> <li>1. Increase temperature</li> <li>2. Increase pressure or nozzle size. Be sure problem nozzle is clear</li> </ol>
<b>Substrates Popping open out of Compression Unit</b> <i>(both sides)</i>	<ol style="list-style-type: none"> <li>1. Temperature of adhesive too high</li> <li>2. Insufficient compression</li> <li>3. Too much adhesive</li> <li>4. Substrate shifting during compression</li> </ol>	<ol style="list-style-type: none"> <li>1. Decrease temperature</li> <li>2. Increase compression time/force</li> <li>3. Decrease application rate</li> <li>4. Correct mechanics</li> </ol>
<b>Smoke</b>	<ol style="list-style-type: none"> <li>1. Temperature of adhesive too high</li> <li>2. Excessive exposure to air</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce temperature</li> <li>2. Keep pot covered at all times</li> </ol>
<b>Stopped or Reduced Adhesive Flow</b>	<ol style="list-style-type: none"> <li>1. Plugged nozzle</li> <li>2. Blocked filter</li> <li>3. Temperature or pressure too low</li> </ol>	<ol style="list-style-type: none"> <li>1. Flush system thoroughly; replace nozzle</li> <li>2. Clean existing or replace with new</li> <li>3. Adjust one or both</li> </ol>
<b>Stringing</b>	<ol style="list-style-type: none"> <li>1. Nozzle too far from substrate</li> <li>2. Low pressure</li> <li>3. Temperature of adhesive too low</li> <li>4. Poor machine timing or alignment</li> <li>5. Hot melt has exceeded pot life</li> </ol>	<ol style="list-style-type: none"> <li>1. Move nozzle closer</li> <li>2. Adjust pressure</li> <li>3. Increase temperature</li> <li>4. Adjust timing or alignment</li> <li>5. Flush system and refill with fresh adhesive</li> </ol>
<b>Bubbles in Adhesive</b>	<ol style="list-style-type: none"> <li>1. Moisture in substrate is evaporating</li> <li>2. Air leaking into pump</li> <li>3. Cavitation of pump</li> </ol>	<ol style="list-style-type: none"> <li>1. Dry stock or lower application temperature</li> <li>2. Replace seals and/or pump.</li> <li>3. Increase supply of molten adhesive (use premelter or increase wattage)</li> </ol>
<b>Poor Adhesion</b>	<ol style="list-style-type: none"> <li>1. Temperature too low</li> <li>2. Inadequate adhesive</li> <li>3. Difficult or coated substrate</li> </ol>	<ol style="list-style-type: none"> <li>1. Increase Temperature</li> <li>2. Increase pressure or nozzle size</li> <li>3. Consider selecting an alternative adhesive</li> </ol>
<b>Splashing from Substrate</b>	<ol style="list-style-type: none"> <li>1. Temperature of adhesive too high</li> <li>2. Air pressure too high</li> <li>3. Incorrect nozzle position</li> </ol>	<ol style="list-style-type: none"> <li>1. Lower temperature</li> <li>2. Lower air pressure</li> <li>3. Change angle of nozzle</li> </ol>