

Hot Melt Troubleshooting Guide

PROBLEM	PROBABLE CAUSE	SUGGESTED SOLUTIONS
POOR ADHESION	Temperature too low. Insufficient adhesive amount. Coated or difficult substrate. Poor compression.	Increase temperature. Increase glue line. Select proper adhesive. Check compression.
POP OPENS Adhesive on one substrate	Insufficient glue amount. Temperature too low.	Increase pressure or nozzle size. Increase temperature.
Adhesive on two substrates	Too much adhesive. Poor compression. Shifting during compression. Temperature too high.	Decrease glue application. Increase compression time. Correct compression. Decrease temperature.
CHARRING	Temperature too high. Hot melt charring on side walls. Air oxidizing hot melt. Poor stability of hot melt.	Lower temperature in tank. Keep tank full. Close lid, consider nitrogen blanket. Decrease temperature.
GELLING	Overheating. Mixing incompatible adhesives. Poor stability of hot melt.	Drain system and lower temperature. Check with hot melt supplier. Select different hot melt.
SMOKING	Temperature too high. Poor stability of hot melt.	Lower temperature. Select different hot melt.
HOT MELT NOT FLOWING EVENLY FROM ALL NOZZLES	Nozzle clogged. Remote nozzle in multiple nozzle set-up may be affected by pressure drop.	Clean or repair nozzle and check filters. Increase temperature or pressure slightly. Install larger nozzle orifices on remote nozzle.
STRINGING / DROOLING	Temperature too low. Pressure too low. Nozzle too far from substrate. Poor shut off of nozzle.	Increase pot temperature. Increase pressure. Adjust nozzle. Repair or replace spool valve.

Need additional help?

For additional questions regarding adhesives applications, contact us at 317.834.5415

