

Liquid Adhesives Troubleshooting Guide

PROBLEM	PROBABLE CAUSE	SUGGESTED SOLUTIONS
POOR ADHESION/NOT AGGRESSIVE	Difficult substrate material. Wrong product. Lack of sufficient compression. Poor surface treatment. Unacceptable dyne level. Wrong product for substrate.	Different substrate or adhesive. Increase compression (tighten compression belts).
POPS OPEN	Lack of sufficient compression. Excessive memory on glue lap. Poor scored glue lap. Insufficient amount of glue.	Tighten compression belts. Knock out glue lap. Increase adhesive on substrate.
NOT SETTING FAST ENOUGH	Product not aggressive enough.	Change to more aggressive product.
NOZZLES TIPS CLOGGING/ DRYING WHILE MACHINE IS DOWN	Product settled.	Place wet rags or Vaseline on tips. Agitate product.
GLUE POT SLINGING	Speeds too fast for viscosity. Wheel out of round.	Change to higher viscous material. New wheel.
EXTRUSION SPLATTER	Pressure too high. Viscosity too thin. Wrong size glue tip.	Lower pressure. Switch to higher viscous material.
STRINGING/DROOLING	Pressure too low. Nozzle too far from substrate. Poor shut off of nozzle.	Increase pressure. Adjust nozzle. Repair or replace spool valve.
GLUE FOAMING	Excessive stirring. Compressed air in sealed system. Not enough anti-foam agent.	Reduce stirring. Clear lines. Additional anti-foam agent needed.
MOLD	Manufacture date 6 months old. Product stored in high heat/humidity. Container not sealed.	Keep in a climate controlled area. Seal container properly.

Need additional help?

For additional questions regarding adhesives applications, contact us at 317.834.5415