

HOT MELT TROUBLE SHOOTING 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 filled Keep lid closed Select different hot melt
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 in tank 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 Increase temperature or pressure slightly. Install larger nozzle orifices on remote nozzles
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