

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