

GENERAL LABELING TROUBLE SHOOTING GUIDELINES*

PROBLEM	PROBABLE CAUSE	SUGGESTED SOLUTIONS
Labels Curling Away From Bottles	<ul style="list-style-type: none"> Excessive adhesive Poor wiper (compression) action Poor label stock Not enough adhesive tack Containers are wet 	<ul style="list-style-type: none"> Keep glue film down to operational minimum Adjust compression Stiff, dry labels: wrong grain direction Use a tackier product Dry containers or use proper adhesive
Blistering or Wrinkling of Labels	<ul style="list-style-type: none"> Non-symmetrical surface Excessive adhesive Poor label stock Adhesive drying too fast Poor wiper action 	<ul style="list-style-type: none"> Reposition label placement or redesign container Keep glue film down to operational minimum Check labels for proper humidity content Use a slower drying product Adjust compression
Failure to Pick Labels Out of Magazine	<ul style="list-style-type: none"> Transfer mechanism not properly contacting labels Excessive adhesive Not enough adhesive tack Magazine prongs, hooks, etc. too tight Adhesive drying too fast Back pressure low in magazine 	<ul style="list-style-type: none"> Adjust machine Keep glue film down to operational minimum Use a tackier adhesive Adjust magazine Use slower product Adjust magazine
Spotty Adhesion	<ul style="list-style-type: none"> Poor filming characteristics of adhesive Bottle surface contaminated Adhesive not suited for surface treatment Poor surface treatment on bottle Excessive coating on bottle Transfer and glue rollers not in proper contact 	<ul style="list-style-type: none"> Select another adhesive Clean bottle Select another adhesive Check bottle Check bottle Adjust machine
Labels Tearing in Machine	<ul style="list-style-type: none"> Adhesive setting too fast Pickers, pads, pallets out of alignment Faulty adjustment of label hopper Wipers/rollers dirty Thin labels 	<ul style="list-style-type: none"> Use slower adhesive Adjust machine Adjust hopper Clean Use heavier labels
Labels Falling Off	<ul style="list-style-type: none"> Excessive adhesive Wrong adhesive for surface Labels coated or glue resistant Insufficient adhesive Container too hot or too cold Poorly treated or over-coated surface 	<ul style="list-style-type: none"> Keep glue film down to operational minimum Select proper adhesive Change labels or select proper adhesive Use proper glue film thickness Condition containers or select proper adhesive Check bottles, select proper adhesive
Staining or Discoloration of Labels	<ul style="list-style-type: none"> Ink, metallization water or alkali sensitive Thin label stock Highly absorbent labels Oil or grease from machinery Glue contamination Excessive Adhesive 	<ul style="list-style-type: none"> Select proper adhesive Use thinner glue film or change label stock Use "cohesive" type glue, with low penetration Check and clean equipment Use fresh adhesive Keep glue film down to operational minimum
Smearing of Adhesive on Bottle	<ul style="list-style-type: none"> Excessive Adhesive Compression too tight Adhesive build-up Viscosity too low 	<ul style="list-style-type: none"> Keep glue film down to operational minimum Adjust compression Clean equipment Use higher viscosity adhesive
Misaligned Labels	<ul style="list-style-type: none"> Uneven glue application Excessive adhesive Gripper fingers are loose Uneven compression action Label magazine crooked 	<ul style="list-style-type: none"> Adjust machine Keep glue film down to operational minimum Adjust Adjust Adjust

* The Guideline provided above is based on general experience and is not related to a specific problem experienced by a specific customer.