

HOT MELT TROUBLESHOOTING GUIDE



PROBLEM	PROBABLE CAUSE	SUGGESTED SOLUTIONS
POOR ADHESION	<ul style="list-style-type: none"> ▶ TEMPERATURE TOO LOW ▶ INSUFFICIENT ADHESIVE AMOUNT ▶ COATED OR DIFFICULT SUBSTRATE ▶ POOR COMPRESSION 	<ul style="list-style-type: none"> ▶ INCREASE TEMPERATURE ▶ INCREASE GLUE LINE ▶ SELECT PROPER ADHESIVE ▶ CHECK COMPRESSION
POP OPENS ADHESIVE ON ONE SUBSTRATE	<ul style="list-style-type: none"> ▶ INSUFFICIENT GLUE AMOUNT ▶ TEMPERATURE TOO LOW 	<ul style="list-style-type: none"> ▶ INCREASE PRESSURE OR NOZZLE SIZE ▶ INCREASE TEMPERATURE
ADHESIVE ON TWO SUBSTRATES	<ul style="list-style-type: none"> ▶ TOO MUCH ADHESIVE ▶ POOR COMPRESSION ▶ SHIFTING DURING COMPRESSION ▶ TEMPERATURE TOO HIGH 	<ul style="list-style-type: none"> ▶ DECREASE GLUE APPLICATION ▶ INCREASE COMPRESSION TIME ▶ CORRECT COMPRESSION ▶ DECREASE TEMPERATURE
CHARRING	<ul style="list-style-type: none"> ▶ TEMPERATURE TOO HIGH ▶ HOT MELT CHARRING ON SIDE WALLS ▶ AIR OXIDIZING HOT MELT ▶ POOR STABILITY OF HOT MELT 	<ul style="list-style-type: none"> ▶ LOWER TEMPERATURE IN TANK ▶ KEEP TANK FILLED ▶ KEEP LID CLOSED ▶ SELECT DIFFERENT HOT MELT
GELLING	<ul style="list-style-type: none"> ▶ OVERHEATING ▶ MIXING INCOMPATIBLE ADHESIVES ▶ POOR STABILITY OF HOT MELT 	<ul style="list-style-type: none"> ▶ DRAIN SYSTEM AND LOWER TEMPERATURE ▶ CHECK WITH HOT MELT SUPPLIER ▶ SELECT DIFFERENT HOT MELT
SMOKING	<ul style="list-style-type: none"> ▶ TEMPERATURE TOO HIGH IN TANK ▶ POOR STABILITY OF HOT MELT 	<ul style="list-style-type: none"> ▶ LOWER TEMPERATURE ▶ SELECT DIFFERENT HOT MELT
HOT MELT NOT FLOWING EVENLY FROM ALL NOZZLES	<ul style="list-style-type: none"> ▶ NOZZLE CLOGGED ▶ REMOTE NOZZLE IN MULTIPLE NOZZLE SET-UP MAY BE AFFECTED BY PRESSURE DROP 	<ul style="list-style-type: none"> ▶ CLEAN OR REPAIR NOZZLE ▶ INCREASE TEMPERATURE OR PRESSURE SLIGHTLY. INSTALL LARGER NOZZLE ORIFICES ON REMOTE NOZZLES
STRINGING/DROOLING	<ul style="list-style-type: none"> ▶ TEMPERATURE TOO LOW ▶ PRESSURE TOO LOW ▶ NOZZLE TOO FAR FROM SUBSTRATE ▶ POOR SHUT OFF OF VALVE 	<ul style="list-style-type: none"> ▶ INCREASE POT TEMPERATURE ▶ INCREASE PRESSURE ▶ ADJUST NOZZLE ▶ REPAIR OR REPLACE SPOOL VALVE