

Hot Melt Adhesive Troubleshooting Tips



For Direct Mail Manufacturers

Mail Popping Open

POSSIBLE CAUSE

TRY

Coatings on paper

Confirm the paper type, and try a stronger adhesive

Not enough compression

Confirm that the pieces are getting the proper compression

Not enough glue

Adjust the pressure to pump or increase nozzle size

Fiber Tear on Paper

POSSIBLE CAUSE

TRY

Wrong glue

Confirm the glue is using the right peel strength

Too much glue

Lower pump pressure or decrease nozzle size

Temperature too high

Lower temperature 5 to 10 degrees at a time

Stringing

POSSIBLE CAUSE

TRY

Temperature too low

Increase temperature

Viscosity too high

Increase temperature

Nozzle too far from substrate

Adjust nozzle

Bead placement

Start and stop ¼ inch from edge

Air movement

Eliminate air drafts

Charring, Gelling, or Smoking of Adhesive in Reservoir

POSSIBLE CAUSE

TRY

Temperature too high

Check settings, reduce temperature

Contamination in reservoir

Cover reservoir and container

Excessive variation of adhesive

Cover reservoir and container

Dripping Nozzle

POSSIBLE CAUSE

TRY

Dirty nozzles

Clean or replace nozzles

Worn orifice or valve

Check and replace

Inadequate air pressure

Increase pressure

Air Bubbles

POSSIBLE CAUSE

TRY

Moisture in substrate

Dry out substrate

Adhesive melt tank empty

Fill and bleed lines

Damaged or open valve

Check valve and replace

If you continue to experience problems, contact CGM right away. We're equipped to help you solve "glue-emergencies" of any kind [24/7/365](tel:2477365).

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