

Hot Melt Adhesive Troubleshooting Tips



For Package Manufacturers

Cases Popping Open Out of Compression

| POSSIBLE CAUSE | TRY |
|------------------------------------|--|
| Hot melt cooling too slowly | Lower application temperature |
| Insufficient glue | Check temperature, increase pressure |
| Too much adhesive | Check temperature, decrease pressure |
| Substrates shift under compression | Adjust compression to maintain uniform |

Poor Penetration or Transfer of Adhesive

| POSSIBLE CAUSE | TRY |
|---------------------------|--|
| Temperature too low | Increase temperature |
| Not enough adhesive | Increase pressure, temperature, or nozzle size |
| Poor mating of substrates | Adjust compression |

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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