

Hot Melt Adhesives Troubleshooting Guide

For Technical Support:
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PROBLEM	PROBABLE CAUSES	SUGGESTED ACTION
Stringing	1. Nozzle too far from substrate	1. Adjust nozzle spacing
	2. Viscosity too high / temp too low	2. Increase temperature slightly
	3. Substrate temperature too low	3. Allow substrates to adjust to ambient temps
	4. Bead squeezing out past flap	4. Adjust bead length so adhesive stays beneath flap
	5. Air pressure to Solenoid too low	5. Ensure incoming air pressure is greater than 50 psi; inspect muffler buildup
Dripping Nozzle	1. Faulty module	1. Inspect and replace if necessary
	2. Worn nozzles or tip	2. Check and replace
	3. Inadequate air pressure	3. Increase air pressure
Charring, Gelling or Smoking of Adhesive in Reservoir	1. Temperature too high	1. Check thermostat, reduce temperature, setback temperature or turn off when not in use
	2. Oxidized adhesive	2. Replace compromised adhesive and cover reservoir
Case Popping Open Out of Compression	1. Adhesive cooling too slowly / too much applied	1. Decrease application temperature and pressure
	2. Not enough hot melt applied	2. Increase temperature and pressure
	3. Substrates shift under compression	3. Adjust machine settings
Poor Penetration or Adhesive Failure	1. Poor penetration, temperature too low	1. Increase temperature
	2. Not enough hot melt applied	2. Increase pressure or nozzle size
	3. Poor or excessive compression, wrong product	3. Adjust compression, evaluate application
	4. Hot melt temperature fluctuating	4. Keep reservoir full and covered, lift hoses off cold floor
Air Bubbles in Hot Melt (at applicator)	1. Moisture in the tank or adhesive	1. Inspect tank and adhesive
	2. Damaged or open valve allowing air into system	2. Check valve and replace if defective
Bubbles in Hot Melt (on substrate)	1. Moisture in substrate causing vapor boil-out	1. Check by applying adhesive to dry substrate (metal or other) and dry out substrate

Stringing/ Angel Hair/ Cob Webbing



Foam in Hot Melt at Applicator



Bubbles in Hot Melt on Substrates



Oxidation, Charring of Hot Melt



Joint Disrupted / Opened While Still a Hot Liquid

