



# Hot Melt Adhesives Troubleshooting Guide

For Technical Support: Toll-Free # 1-800-458-3252 | Visit [www.ajadhesives.com](http://www.ajadhesives.com)

| PROBLEM   | PROBABLE CAUSES                          | SUGGESTED ACTION   |
|-----------|--|--|
| Stringing | Nozzle too far from substrate            | Adjust nozzle spacing  |
|           | Viscosity too high / Temperature too low | Increase temperature slightly  |
|           | Substrate temperature too low            | Allow substrates to adjust to ambient temperature                            |
|           | Bead squeezing out past flap             | Adjust bead length so adhesive stays beneath flap                            |
|           | Air pressure to Solenoid too low         | Ensure incoming air pressure is greater than 50 PSI; inspect muffler buildup |

Stringing / Angel Hair / Cob Webbing



| PROBLEM         | PROBABLE CAUSES         | SUGGESTED ACTION                              |
|-----------------|-------------------------|---|
| Dripping Nozzle | Faulty module           | Inspect and replace module if necessary       |
|                 | Worn nozzles or tip     | Check and replace nozzles or tip if necessary |
|                 | Inadequate air pressure | Increase air pressure                         |

| PROBLEM  | PROBABLE CAUSES      | SUGGESTED ACTION   |
|--|----------------------|--|
| Charring, Gelling, or Smoking of Adhesive in Reservoir | Temperature too high | Check thermostat, reduce temperature, setback temperature, or turn off when not in use |
|  | Oxidized adhesive    | Replace compromised adhesive and cover reservoir                                       |

Charring of hot melt / Oxidation





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| PROBLEM                                    | PROBABLE CAUSES   | SUGGESTED ACTION                              |
|--|---|---|
| Case Popping<br>Open out of<br>Compression | Adhesive cooling too slowly / too much adhesive applied | Decrease application temperature and pressure |
|  | Not enough hot melt applied                             | Increase temperature and pressure             |
|  | Substrates shift under compression                      | Adjust machine settings                       |

Joint disrupted / Case opened while still hot liquid



| PROBLEM                                 | PROBABLE CAUSES                                 | SUGGESTED ACTION   |
|---|---|--|
| Poor Penetration or<br>Adhesive Failure | Poor penetration, temperature too low           | Increase temperature                                       |
|   | Not enough hot melt applied                     | Increase pressure or nozzle size                           |
|   | Poor or excessive compression, or wrong product | Adjust compression or evaluate application                 |
|   | Hot melt temperature fluctuating                | Keep reservoir full and covered, lift hoses off cold floor |

| PROBLEM                                    | PROBABLE CAUSES                                | SUGGESTED ACTION                     |
|--|--|--------------------------------------|
| Air Bubbles in Hot<br>Melt (at applicator) | Moisture in the tank or adhesive               | Inspect tank and adhesive            |
|  | Damaged or open valve allowing air into system | Check valve and replace if defective |

Bubbles in hot melt adhesive at applicator





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| PROBLEM                            | PROBABLE CAUSES                              | SUGGESTED ACTION  |
|------------------------------------|--|---|
| Bubbles in Hot Melt (on substrate) | Moisture in substrate causing vapor boil-out | Check by applying adhesive to dry substrate (metal or other) and dry out substrate if necessary |

Bubbles in Hot Melt on Substrate



| PROBLEM              | PROBABLE CAUSES                     | SUGGESTED ACTION   |
|----------------------|-------------------------------------|--|
| Bead width variation | Mixed nozzles installed             | Check part numbers engraved on nozzles match each other                      |
|                      | Split O Ring between module and gun | Remove guns and replace O Rings between module and gun body                  |
|                      | Module not functioning              | Swap other modules with offending module to see if module is non-functioning |
|                      | Blocked nozzles                     | Check and replace nozzles if necessary                                       |

Bead width variation on substrate



If issues still persist, reach out to AJ Adhesives Technical Support at  
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