



Hot Melt Adhesives Troubleshooting Guide

For Technical Support: Toll-Free # 1-800-458-3252 | Visit 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 Open out of 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 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 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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