



TROUBLESHOOTING **HOT MELT**

POOR ADHESION

There are 4 main reasons you might be experiencing poor adhesion with your hot melt.

The adhesive is mostly on one surface it is likely the result of a short 'open time' or a very difficult to bond surface.

Try increasing the temperature of the adhesive in the interim and contact your adhesive provider.

The adhesive is on both surfaces but is showing "legs" the bond of the adhesive may have been disturbed while still in a semi-molten state.

Check the compression, lower your adhesive temperature or switch to a faster setting adhesive.

The surface of the adhesive is glossy in appearance, or no fiber tear is present, there may have been little to no contact of the surfaces being adhered.

Try adjusting the pressure to keep the glued surfaces together while the hot melt cools.

There is an easy separation of the bond and/or no fiber tear, an improper adhesive may have been selected.

We recommend trying a more suitable product (which we're happy to produce)

CHARRING OF ADHESIVE

If you are experiencing charring of the adhesive, you should consider these three problems.

The temperature in the tank may be too high.

Lower the temperature in the tank.

Adhesive charring on the side walls of the tank.

Ensure the tank is kept filled.

Air may be oxidizing the adhesive.

To prevent this, you should keep the tank covered.

GELLING OF ADHESIVE

There are three possibilities as to why you may be experiencing gelling of the adhesive.

Adhesive overheating

Try draining and flushing the system and lowering the temperature.

Mixing incompatible adhesives.

Check with your Walmark rep for advice on compatible adhesives.

Unstable hot melt (if repeated)

Please check with your Walmark rep.

IMPORTANT: These recommendations and suggestions for use of this product are based on our best experience and knowledge. The suitability of this product for an intended application shall be solely up to the user. Do not change manufacturing procedures or materials for producing on a commercial scale without thoroughly investigating results. Consult your Walmark Adhesives representative for further suggestions and details.

STRINGING

In the instance that your adhesive is stringing, you should consider these four troubleshooting options.

Running temperature too low.	Raise the temperature, however, be careful not to raise the temperature too high or the heat stability may be affected.
The stock temperature may be too low.	Try prewarming the stock.
Poor timing or misalignment of the carton flap to the applicator roll.	This will require machine adjustment.
Poor shutoff of nozzle.	Try cleaning and repairing the nozzle shutoff.

ADHESIVE NOT FLOWING EVENLY FROM ALL NOZZLES

If the adhesive is not flowing evenly from all nozzles it could be a result of these two problems.

The nozzles may be clogged.	Clean or repair nozzle.
Remote nozzle in the multitude nozzle set-up may be affected by a pressure drop.	Increase the temperature or pressure slightly. Put larger orifice openings on remote nozzles.

FUMING OR SMOKING

There are two reasons you might be experience fuming or smoking of your adhesive.

Poor heat control.	Use a calibrated thermometer and reset the thermostat.
The adhesive may have poor heat stability.	Try reducing the temperature to the minimum required for a good bond. Cover the reservoirs or pre-melters whenever possible and open pots almost always for smoke. Use the suction fan over the pre-melter or reservoir and exhaust the fumes to the outside.

If your problem hasn't been solved here, please contact your Walmark Adhesives Rep.

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