

## Trouble Shooting Guide for Contact Adhesives

### **Weak, Zipper or Spotty Bonds**

Insufficient adhesive .....	Apply more adhesive
Insufficient Pressure .....	Apply more pressure
Exceeded Open time .....	Shorten open time; apply another coat and rebond
Low Temperature .....	Raise surrounding temp to 50° F

### **Soft or Leggy Bonds**

Insufficient drying .....	Extend dry time
“Blushing” or glassy look .....	Extend dry time, use fans to move air

### **Edge Lift**

Insufficient Adhesive .....	Make sure edges are double coated
Adhesive not dry .....	Extend dry time
Core Edges weak bond .....	Apply double coat to edges

### **Bubbling**

Insufficient dry time .....	Extend dry time
Voids or low spots in core .....	Fill uneven surface or use better board
Poor lamination .....	Avoid trapping air, laminate from center

### **Warping**

Unequal expansion .....	Examine substrates, acclimate to temp
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### **Seams Shrinking or lifting**

Unequal expansion .....	Acclimate substrates prior to lamination
Insufficient adhesive .....	Apply more adhesive
Insufficient pressure .....	Apply more pressure

### **Adhesive Peeling from Substrate**

Surface Contamination .....	Clean surfaces
Poor Adhesion .....	Determine if right adhesive in use
Substrates contain plasticizer .....	Determine if right adhesive in use