



Trouble Shooting Guide for Contact Adhesives

Weak, Zipper or Spotty Bonds

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

Soft or Leggy Bonds

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

Edge Lift

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

Bubbling

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| 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

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| Unequal expansion | | Examine substrates, acclimate to temp |
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Seams Shrinking or lifting

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

Adhesive Peeling from Substrate

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