



CHOICE ADHESIVES

Canister Troubleshooting

| Problem | Possible Cause | Corrective Action |
|---|---|--|
| Poor Spray Pattern | Cold canister | Warm canister to room temperature. (65°F+) Keep canister off concrete floor |
| | Partially open valve | Be sure canister valve is fully opened |
| | Wrong tip in use | Check spray tip. Most products require 6501 tip |
| | Clogged tip or spray gun | Insure gun and tip are free of clogs. To clean, turn off canister valve and drain adhesive from the hose before detaching gun or hose. Use 680 solvent or Citrus Cleaner to remove adhesive build up. |
| Canister “spits & sputters” when spraying | Cold canister | Be sure canisters are stored and used at room temperature at least 65°F for optimum results. Warm canister to room temperature prior to use. Immerse smaller canisters in warm water to speed the recovery process. |
| “Railroad tracking” or heavy line of adhesive top and bottom of the pattern | Incorrect tip in use | Make sure correct tip is in use. Low VOC products use 6501 or 9501 tip. All other products use 6501. |
| | Improper gun adjustment | Adjust pattern until tracking disappears. Generally, 3 to 5 full turns from the closed position |
| Canister is full but will not spray. With valve open nothing comes out. | Defective or clogged valve | Contact Choice Adhesives |
| <u>Bonding Issues</u> | | |
| Edges lifting | Lack of pressure | Apply a minimum of 30 PSI with 3” J roller |
| | Insufficient adhesive | Apply 2.5-3.0 dry grams of adhesive. Approximately 85% coverage – double spray edges. |
| | Dimensional change of laminate “growth and shrinkage of laminate” | Acclimate adhesive and substrates to shop environment for at least 48 hours prior to fabrication 70°F and 50% relative humidity is ideal |
| Low Bond Strength | Exceeded open time | Read and be sure to adhere to the stated open time of the adhesive |
| | Did not allow solvent to flash completely | Be sure solvent has evaporated prior to bonding. Check by using the dry knuckle test or exotherm test on laminate to insure solvents have flashed off prior to bonding. |
| | Surface is contaminated | Insure all surfaces to receive adhesive are clean and free of dust, dirt, grease or debris |
| | Insufficient pressure applied | Proper pressure is critical to a good bond. Use at least a 3” J roller and apply a minimum of 30 PSI to insure good film fusion. |
| | Insufficient adhesive applied | Apply 2.5-3.0 dry grams of adhesive approximately 85% coverage over entire surface double coating edges. |
| Laminate bubbling | Dry time not observed trapping solvent | Be sure solvent has evaporated prior to bonding. Check by using the dry knuckle test or exotherm test on laminate. |
| | Contamination of surfaces preventing film fusion | Insure all surfaces to receive adhesive are clean and free of dust, dirt, grease or debris. |
| | Areas of insufficient adhesive coverage | Apply 2.5-3.0 dry grams of adhesive approximately 85% coverage over entire surface double coating edges. |