



CHOICE BRANDS
A D H E S I V E S
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Canister Troubleshooting

<u>Problem</u>	<u>Possible Cause</u>	<u>Corrective Action</u>
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 cansisters 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 othe 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 CBA

Bonding Issues

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. Approximatley 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 staed 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 surfaes 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.