



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 re-bond
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