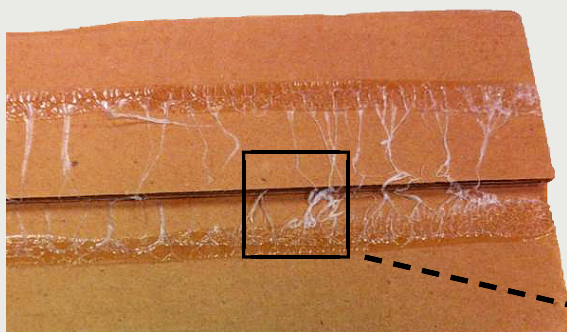


TROUBLESHOOTING CASE & CARTON FAILURES

Part 2

"Chewing Gum Failure"

WHAT IS "CHEWING GUM FAILURE"?



Chewing gum failure occurs when the adhesive is too hot, there is too much adhesive applied, or the adhesive is too slow to form a bond.

Just as its name describes, the failure appears to look like chewing gum. You will notice adhesive on both sides of the substrate and stringing from the adhesive bead.



CAUSES & SOLUTIONS



Adhesive too hot



Lower running temperature within recommended range



Too much adhesive



Reduce adhesive bead width



Adhesive too slow



Investigate faster setting adhesive

