

**TROUBLE SHOOTING
GUIDE
STARFLEX JELLY GLUE**



PROBLEM	POSSIBLE CAUSES	SUGGESTED REMEDY
Stringing, Poor, Machining, Glue Build Up	1. Temperature too low	Maintain proper temperature 140° - 150°F (60° - 66°C). Check temperature with accurate immersion thermometer.
	2. Water evaporation	Clean, <u>hot</u> water should be added occasionally to maintain viscosity (to compensate for evaporation loss) Caution: Do not add cold water. This will lower temperature and further aggravate the situation.
	3. Under dilution	STARFLEX should be diluted as required with clean, hot water and thoroughly mixed to maintain proper viscosity.

	4. Temperature too high burning glue	Burned glue will contaminate fresh glue. Clean out all pots and vessels. Use fresh glue at the proper temperature 140° - 150°F (60° - 66°C).
Adhesive too thin	1. Over dilution	Add fresh adhesive.
	2. Wrong adhesive	Try a different STARFLEX product.
	3. Temperature too high	Reduce temperature to 140° - 150°F (60° - 66°C).
Adhesive too thick	1. Under dilution	Dilute with clean, hot water, mix thoroughly before using to maintain proper viscosity.
	2. Temperature too low	Raise temperature to 140° - 150°F (60° - 66°C).
	3. Water evaporation	Clean, <u>hot</u> water should be added occasionally to maintain viscosity and compensate for water evaporation.
	4. Wrong adhesive	Try different STARFLEX product.
Adhesive setting too fast	1. Temperature too low	Raise temperature to decrease setting speed. Suggest 145° - 155°F (63° - 68°C).
	2. Low humidity	Try different STARFLEX product.

	3. Application too thin	Increase amount of adhesive being applied.
Adhesive setting too slow	1. Temperature too high	Lower temperature to increase setting speed. Suggest 130° - 140°F (54° - 60°C).
	2. High humidity	Refer to Olympic Humidity Guidelines.
	3. Adhesive application too thick.	Decrease amount of adhesive being applied. Thin uniform coat.
Poor adhesive transfer	1. Adhesive application too thin	Increase amount of adhesive being applied.
	2. Adhesive application too thick	Dilute with clean, <u>hot</u> water to proper viscosity and solids.
	3. Application rollers out of round	Check application rollers.
	4. Uneven compression	Check compression rollers.

NON-WARRANTY:

As the storage, handling and usage of this product is beyond the control of the Producer and Seller, no warranty as to the results to be obtained is made, expressed or implied, whether the product is purchased or furnished as a sample. The Purchaser or User should, therefore, by their own tests and experiments determine the suitability of this product for their own particular use.