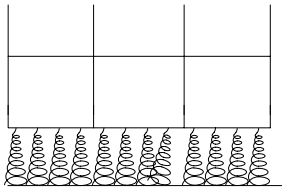
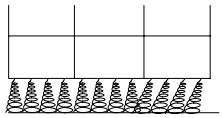
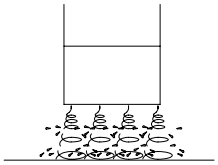
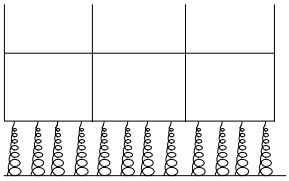
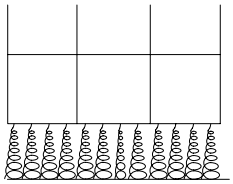
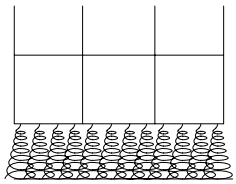
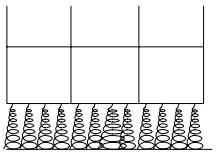
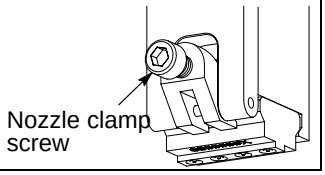
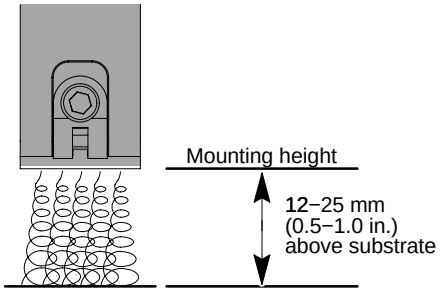
Universal Applicator Troubleshooting (Summit)

Problem	Possible Cause	Corrective Action	Example
Pattern off-center (skewed)	Blocked air passage(s) Blocked adhesive passage(s)	Remove the nozzle and use a pin-type probe to clean the blocked air passage(s). Remove the nozzle and use a pin-type probe to clean the blocked air passage(s).	
End pattern oriented toward center of applicator	Unbalanced air flow at the applicator	Eliminate the air current or add a module that provides only pattern air next to the end module.	
Pattern breaking up	Adhesive and/or pattern air temperature too hot or pattern air pressure too high	Adjust the applicator temperature and pattern air pressure settings to the last good run settings; then check the adhesive output.	
All patterns too narrow	Adhesive and/or pattern air temperature too cool, pattern air pressure too low, or applicator mounted too close to substrate	Adjust the adhesive or air temperature and air pressure settings to the last good run settings and/or check the applicator mounting height; then check the adhesive output.	
One pattern too narrow	Incorrect or damaged nozzle; possible restriction in heated air manifold or pattern air input on module	Verify that the nozzle part number is correct. Check the nozzle for damage and replace if needed. Remove the module and check for blockage in the pattern air path.	
All patterns too wide	Adhesive and/or pattern air temperature too warm, pattern air pressure too high, or applicator mounted too far from substrate	Adjust the adhesive or air temperature and air pressure settings to the last good run settings and/or check the applicator mounting height; then check the adhesive output.	
One pattern too wide	Incorrect or damaged nozzle; partially blocked adhesive or air passage(s) in nozzle	Verify that the nozzle part number is correct. Use a pin-type probe to clean the nozzle or check the nozzle for damage and replace if needed.	
Irregular pattern or adhesive leakage on one module	Nozzle O-ring missing or nozzle too loose (under-tightened)	Install a new nozzle O-ring, replace the nozzle, or tighten the nozzle clamp screw	

Operating Parameters

NOTE: These operating parameters are based on standard 0.018-in. nozzles when used with common nonwovens-grade construction and elastic adhesives. These parameters may vary when other adhesives or nozzle sizes are used.

Mounting height

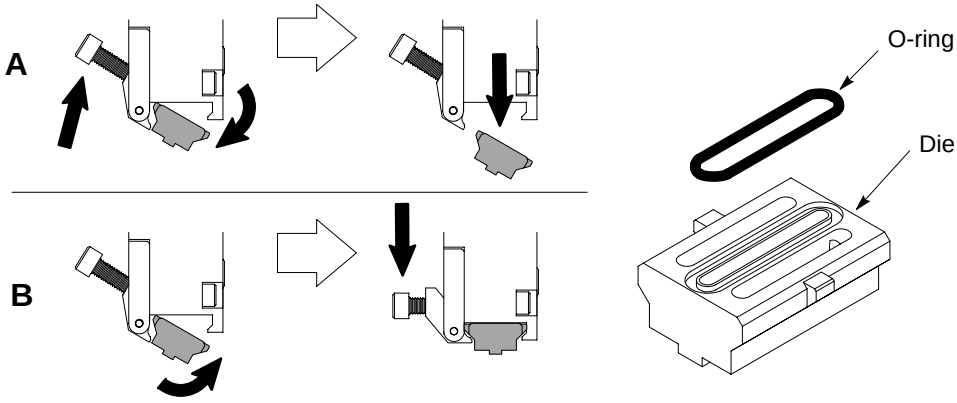


Pattern air temperature 9−15 °C (15−25 °F) above adhesive application temperature

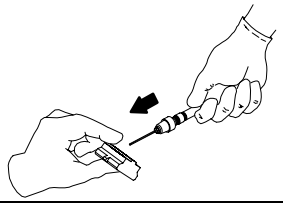
Pattern air pressure 0.3−1.7 bar (5−25 psi) typical

Module-actuating air pressure 4.1−6.2 bar (60−90 psi) typical

Nozzle removal (A) and installation (B)



Proper use of a pin-type probe



Part	Description
1022028	O-ring, 75 Viton, 0.578 ID x 0.040 in.
901915	Nozzle cleaning kit
901905	Nozzle brush

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