

## Trouble Shooting Animal Glue or Cake Flex Protein Adhesives

1.	<b>Animal Glue Coverage Chart</b> <b>Application Thickness</b> <b>(Wet film in mils*)</b> 1.0 2.0 3.0 4.0 * 1 mil = 0.001 inch	<b>Square Feet per Gallon</b> <b>(diluted)</b>  <b>1600</b> <b>800</b> <b>535</b> <b>400</b>
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<b>Troubleshooting</b>		
<b>PROBLEM</b>	<b>POSSIBLE CAUSES</b>	<b>SUGGESTED REMEDY</b>
<b>String Or Poor Machining</b>	Temperature Too Low	Raise temperature to 140-150F
	Too high coat weight	3mils maximum or less
	Water Evaporation	Dilute to running viscosity
<b>Poor Penetration or Poor Adhesive Transfer</b>	Insufficient Adhesive	Increase Application
	Spotty coverage Adhesive too thick	Application roll not round (repair) Dilute to recommended solids
<b>Adhesive Too Thin</b>	Overdilution	Add fresh adhesive Do not dilute in pan directly
	Wrong Adhesive	Try different SBA product
<b>Adhesive Too Thick</b>	Under dilution	Dilute to proper solids
	Uneven heating of pan Water evaporation	Heat pan with oil/water Dilute to proper solids
	Temperature too low	Raise temperature to 140-150F (60-70C)
<b>Adhesive Setting Too Slow</b>	Temperature Too High	Lower Temperature
	High Humidity	Refer to SBA Humidity Sheet
	Wrong Adhesive	Try Different SBA Product
<b>Adhesive Setting Too Fast</b>	Temperature too low Thermostat position	Raise Temperature Sensor should be in the pan
	Very low humidity	Humidify surrounding area or try different SBA product
<b>Glue Smearing at Trim Knives</b>	Adhesive setting too slow	see same problem above
	Not enough drying time	increase drying capacity
	Application too heavy	Reduce application