

Trouble Shooting Guide

PROBLEM	Off Ratio	Poor Mix	High Exotherm	Incorrect Processing Temperature	Poor Vacuum	Nitrogen or Solvent	Leaks in Mixing Head	Dirty Molds	Casting Technique	Loss of Prepolymer NCO	Insufficient Cure	Curative Contamination	Low Green Strength
Low Dorometer													
Wet Spots													
Poor Tear													
Cheesy Appearance													
High Shrinkage													
Air Bubbles													
Snow flake effect													
or White Skin													
Voids in Part													
Short Pour Life													
Cracking													
Unexpected Foaming													
Striations													
Low Tensile strength													