

# FOAMS - TROUBLE SHOOTING GUIDE

## Possible Cause

## Problem

	Low temperature of iso and / or polyol	Substrate temperature is low	Loss of blowing agent from polyol	Off ratio - the amount of iso used is high	Insufficient Mixing	Moisture in the polyol	Off ratio - the amount of polyol used is high	Moisture in substrate	Moisture contamination - water in air supply	Check for contamination by silicone or grease lubricants	Check polyol reactivity	Raise temperature of iso & polyol	Look for errors in machine metering	Catalyst deactivation	Check for lead/lag conditions	Mould temperature	Release agent quality	Wax-build-up	Optimize pour pattern & / or size of vent holes	Tilt the mould when pouring	Shot size	Increase rate of polymer gelation	Reduce air entrapment during liquid laydown	Lower temperature of components
Density is high	•	•	•	•	•																			
Density is low						•	•	•	•							•								
Underpacked cavity			•		•		•					•				•			•		•			
Friable-crumbles & lacks strength					•		•				•													
Voids			•	•	•	•	•	•	•	•	•	•	•						•				•	
Foam is slow to cure	•				•						•	•	•	•		•								
Smoking			•										•											
Sticky spots					•		•	•		•			•			•								
Striations					•										•									
Foam rises & then collapses					•					•	•													
Large bubbles bursting on surface										•	•													
Coarse surface cells					•										•	•	•							
Air entrapment											•								•	•				
Excessive flash																			•		•	•	•	
Blowholes - small voids through part					•			•	•	•									•	•				
Blistering							•	•	•	•	•					•	•	•						•
Loose skin					•					•						•	•	•						
Poor green strength	•		•	•	•	•						•			•		•					•		
Shrinkage		•		•						•	•						•							
Tacky part surface					•	•					•		•			•								
Irregular cells under skin										•								•						
Thick skin	•	•									•	•				•			•		•			