

Troubleshooting

Problem	Reason	Action Required
Nozzle will not fit on to cartridge	Nozzle ports not aligned with cartridge ports	Align ports correctly and twist nozzle on
Dispensing gun fails to pressurize cartridge	Damaged piston slide	Check instructions. Replace slide if necessary
Compound does not bond to Backing Paper	Wrong side of Backing Paper used	Apply to 'shiny' side. See Backing Paper instructions
Material cures in the nozzle	Stop/start operation OR nozzle attached for a long period before use	Replace nozzle and proceed without delay
Material does not come out of the nozzle after replacing a previous nozzle	Cartridge ports have cured over	Remove cured material or discard cartridge.
When using a new cartridge the first part of the replica does not cure	Cartridge not primed before attaching nozzle	Prime cartridge before first use. NOTE: Cartridge will work satisfactorily with subsequent nozzles
Material cures too quickly or too slowly	Incorrect grade being used for the ambient temperature	Choose a grade appropriate for the conditions. (see compounds)
Air bubble entrapment	Poor application	Keep the nozzle in contact with the surface. For blind holes place the tip of the nozzle at the bottom of the hole
Replica distorts and resolution is poor when examined microscopically	Replica too soft when removed due to incomplete curing	Extend curing period
Replica surface does not cure	Cure inhibited by surface contamination e.g. grease or oil	Check surface cleanliness
Replica breaks during removal	Severe re-entrant geometry. Replica not completely cured	Allow adequate curing time. Remove slowly applying constant pressure
Excessive voids when using thixotropic materials	Air entrapment due to poor application	Keep the nozzle in contact with the surface. Overlap runs and use Backing Paper
Replica adheres to surface	Mechanical attachment to fibres or porous surfaces	Remove slowly applying constant pressure
Base piston on cartridge leaks	Excessive pressure on dispensing gun due to nozzle blockage	Remove cured material if possible or replace cartridge