POLYURETHANE TROUBLE SHOOTING GUIDE

Possible Causes

PROBLEM	Off Ratio	Poor Mix	High Exotherm	Incorrect Processing Temperature	Poor Vacuum	Nitrogen, Water or Solvent	Leaks in Mixing Head	Dirty Molds	Casting Technique	Loss of Prepolymer NCO	Insufficient cure	Curative Contamination	Low Green Strength
Low Durometer	■	■								■	■		
Wet Spots	■	■											
Poor Tear	■	■								■	■		
Cheesy Appearance	■	■		■							■		■
High Shrinkage	■		■	■								■	
Air Bubbles					■	■	■	■	■			■	
Snow Flake Effect			■						■				
White Skin			■						■				
Voids in Part			■	■				■	■				
Short Pour Life	■			■								■	
Cracking	■	■	■	■					■				■
Unexpected Foaming						■	■						
Striations		■											
Low Tensiles Strength	■	■								■	■		