

Possible Cause

Problem	Possible Cause												
	Off Ratio	Poor Mix	High Exotherm	Incorrect Processing Temperature	Poor Vacuum	Nitrogen or Solvent	Leaks in Mixing Head	Dirty Moulds	Casting Technique	Loss of Prepolymer NCO	Insufficient Cure	Curative Contamination	Low Green Strength
Low Hardness	•	•								•	•		
Wet Spots	•	•											
Poor Tear	•	•								•	•		
Cheesy Appearance	•	•		•							•		•
High Shrinkage	•		•	•								•	
Air Bubbles					•	•	•	•	•			•	
Snow Flake Effect			•						•				
White Skin			•						•				
Voids in Part			•	•				•	•				
Short Pot Life	•			•								•	
Cracking	•	•	•	•					•				•
Foaming						•	•					•	
Striations		•											
Low Tensile Strength	•	•								•	•		