



Remedies for Low Density Polyethylene (LDPE) film production faults

Problem	Variables in order of importance	Possible solutions
SPLITTY FILM - MD	3, 6, 26, 1, 39	<ol style="list-style-type: none"> 1. INCREASE BLOW - UP - RATIO 2. REDUCE BLOW - UP - RATIO 3. INCREASE NECK LENGTH 4. REDUCE NECK LENGTH 5. INCREASE MELT TEMPERATURE 6. REDUCE MELT TEMPERATURE 7. CLEAN AIR RING 8. REDUCE FEED SECTION WATER TEMP 9. INCREASE FEEDSECTION WATER TEMP 10. SCREEN PACK TOO TIGHT (OR DIRTY) - USE 40/60/40 11. REDUCE WINDER TENSION 12. INCREASE COLLAPSER WIDTH 13. REDUCE COLLAPSER WIDTH 14. INCREASE COLLAPSING HEIGHT 15. REDUCE COLLAPSING HEIGHT 16. INCREASE DIE BODY TEMPERATURE 17. REDUCE DIE BODY TEMPERATURE 18. INCREASE DIE LIP TEMPERATURE 19. REDUCE DIE LIP TEMPERATURE 20. LEVEL DIE AND/OR AIR RING 21. REDUCE OR ELIMINATE AIR DRAFTS 22. STABILIZER/IRIS NOT CENTERED 23. STABILIZER/IRIS TOO TIGHT 24. COLLAPSING FRAMES NOT EVEN 25. CHECK ALIGNMENT OF ENTIRE LINE 26. INCREASE AIR RING VELOCITY 27. REDUCE AIR RING VELOCITY 28. CHECK DRIVE ADJUSTMENTS & TACH 29. REDUCE OUTPUT (SCREW SPEED) 30. INCREASE OUTPUT (SCREW SPEED) 31. CHECK CONCENTRATE COMPATIBILITY 32. NIPS NOT PARALLEL TO DIE 33. CLEAN DIE 34. DIE DAMAGED 35. DIE FLOW DISTRIBUTION PROBLEM 36. INCREASE UPSTREAM ZONES 37. MOLECULAR WEIGHT TOO LOW 38. INCREASE DIE GAP 39. REDUCE DIE GAP 40. CALL RESIN MANUFACTURER
SPLITTY FILM - TD	4, 27, 5, 38	
BUBBLE INSTABILITY - VERTICAL	29, 27, 1, 40	
BUBBLE INSTABILITY - LATERAL	6, 27, 4, 37, 40	
POOR BUBBLE SHAPE	3, 6, 23, 30, 26, 39, 1	
FILM BLOCKING	14, 6, 26	
STRIPES IN FILM	16, 31, 33, 34, 35, 40	
MELT FRACTURE	18,5, 31, 33, 38, 40	
INHOMOGENOUS FILM STRUCTURE	6, 5, 31, 18, 40	
SMILE WRINKLES ACROSS WEB	14, 13, 6	
WRINKLES IN MACHINE DIRECTION	15, 12, 23, 5	
EXCESSIVE BUBBLE BREAKS	10, 6, 31, 33, 40	
EXCESSIVE GAUGE VARIATION	6, 16, 7, 21, 24, 23, 22, 20, 32, 33, 34, 35, 25	
TAPERED ROLLS	20, 21, 24, 32, 22, 25	
NON - UNIFORM ROLL HARDNESS	16, 7, 6, 24, 23, 22, 33, 34, 35, 31	
NON - UNIFORM ROLL EDGES	6, 4, 27, 21, 23, 29, 37, 40	
EXCESSIVE BACK PRESSURE	10, 16, 29, 33	
HIGH MELT TEMPERATURE	10, 9, 26, 29	
DRIVE AMPS FLUCTUATION	8, 28, 6	
DRIVE AMPS AND PRESSURE VARIATION	8, 6, 31, 28	
DIE LIP BUILD - UP	6, 19, 31, 40	
POOR PIGMENT DISPERSION	31,6, 33, 34, 16	
CONROL ZONE OVERRIDE	36, 29, 4	
OUTPUT LOW (LOSS OF FEED)	8, 6, 9	
CRUSHED CORES	11,6, 14	
LOW DART IMPACT	3, 6, 26, 1, 30, 33, 34, 35, 31, 37	
LOCALIZED GELS IN BUBBLE	33, 35, 10, 34	
LARGE, SECONDARY GELS	6, 10, 31, 33, 40	