



HDPE Blown Film Day-to-Day Trouble Shooting Guide

The following guidelines are provided for solving frequent day-to-day problems in HDPE blown film processing. The suggested solutions should be tried one at a time to correct the problem. However, if the problem persists, please call your local Area Sales Executive from EQUATE for assistance.

Problem	Possible Solution
Frequent Bubble Breaks	Raise melt temperature; Replace screen pack with a finer mesh; Stop using regrind material; Clean extruder with a purging compound
Unstable Bubble	Reduce melt temperature; Lower cooling air flow rate; Eliminate air draft; Ensure air ring opening is uniform
Pulsating Bubble	Check hopper for feeding continuity; Adjust air ring to lock bubble; Clean collapsing frame bars
Bubble not symmetrical	Adjust die pin positioning bolts; Condition die by running material for long time; Increase LLDPE content if used
Die Lip build Up	Reduce melt and die temperature; Refurbish die
Die Lines on Film	Clean die lips; Clean die land; Allow adequate purging time between resin changes; Purge the extruder/die with purging compound
Excessive Film Gage Variation	Clean die gap; Ensure die pin is centered; Center air ring; ensure air ring lip is uniformly open: rotate die or air ring if the features available
Gels in the Film	Ensure heater band controls are functioning; Discontinue regrind; Use finer mesh screen, Avoid long heating times before start up; Flush with purging compound

Melt Fracture	Increase melt temperature; Increase die lip temperature; Clean die lips (with brass shim); Lower LLDPE amount in blend if used
Lower Output	Replace plugged screen pack; use coarser mesh screen; Increase screw speed; Check throat cooling
Wrinkles on Film	Make small diagonal slits in the film; Align nip roll and die centers; Decrease web tension
Port Lines	Increase die and melt temperature. Blend with LLDPE
Film Roll Edge Pinking/Yellowing	Wrap roll in PE film
Low Impact Strength	Increase neck height and optimize blow-up ratio; Increase melt temperature; Eliminate regrind addition
Low Tear Strength	Increase neck height and optimize blow-up ratio; Increase LLDPE content; Raise melt temperature
Poor Film Printability	Increase treatment level