



## LLDPE Blown Film Day-to-Day Trouble Shooting Guide

The following guidelines are provided for solving frequent day-to-day problems in LLDPE 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
Blocked Film	Reduce melt temperatures, raise frost line
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; Increase LDPE portion if using a blend
Pulsating Bubble	Check hopper for feeding continuity; Adjust air ring to lock bubble; Clean collapsing frame bars
Tacky or Sticky Film	Reduce melt temperature; Raise frost line; Give slip additive time to bloom to film surface
Slippery Film	Increase melt temperature
Die Lines on Film	Clean die lips; Clean die land; Allow adequate purging time between resin changes; Purge the extruder/die with purging compound
Die Lip Build-Up	Reduce melt and die temperature
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 Output	Replace plugged screen pack; use coarser mesh screen; Increase screw speed
Wrinkles on Film	Make small diagonal slits in the film; Align nip roll and die centers; Decrease web tension
Film Roll Edge Pinking/Yellowing	Wrap roll in PE film
Low Impact Strength	Increase/decrease melt temperature; Clean the die; Reduce LDPE contents in blend; Ensure film gage is uniform
Clear Bubbles in Film	Dry the resin, recycle material and master batches
Hazy Film	Lower frost line; Use chilled air; Increase melt temperature: Add 5 – 15% barefoot LDPE
Splitty Film	Increase melt temperature; Clean die; reduce or eliminate recycle material; Reduce LDPE in blend
Poor Film Printability	Increase treatment level