



Polyethylene Blow-Molding Day-to-Day Trouble Shooting Guide

The following guidelines are provided for solving frequent day-to-day problems in Polyethylene Blow Molding process. 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
Parison Blow Out	Reduce blow pressure; Increase clamp pressure; Increase parison length; Increase cooling of pinch-off area
Bubbles in Bottle Wall	Dry resin; Tighten die lip bolts
Curling of Parison	Slowly decrease melt temperature; Lower die tip temperature; Decrease screw back pressure; Check positioning of the die and mandrel; Clean die face
Parison Curtaining	Reduce parison temperature; Reduce extrusion rate; Check preblow air pressure
Die Lines	Clean die head; Increase melt temperature
Excessive Bottle Flash	Reduce extrusion rates; Center die
Rough Bottle Surface	Increase die and melt temperature; Clean tooling; Increase mold temperature; Ensure mold vent is open
Machine Output Fluctuating	Ensure hopper is not bridged; Reduce screw speed; Clean screw
Sagging Parison	Reduce melt temperature; Decrease parison drop time; Reduce parison weight

High Parison Swell	Decrease extrusion pressure; Increase melt temperature
Unable to Form Handles	Lower melt temperature; Increase blow air pressure
Bottle Leaking at Cap	Align blow pin; Replace blow pin
Weak Weld Line	Increase air pressure; Ensure mold vent is open
Bottle Weight out of Spec	Adjust mandrel position; Increase or decrease screw rpm; Reduce melt temperature
Weak Pinch Weld Line	Adjust mold closing speed; Reduce melt temperature
Part Sticking in Mold	Reduce melt temperature; Align parison; Decrease blowing air pressure
Wall Thickness Not Uniform	Adjust parison program; Straighten parison drop
Part Warping	Reduce melt temperature; Reduce mold cooling
Low Bottle ESCR	Increase melt temperature
Low Impact Strength	Improve pinch-off; Realign mold parts; Reduce regrind