

## Troubleshooting Guide for Biaxially Oriented Film

Problem	Possible Causes	Possible Solutions
<b>1. Irregular film thickness</b>	Incorrect extruder settings	<ul style="list-style-type: none"><li>• Reduce die temperature</li><li>• Increase die back pressure</li></ul>
<b>2. Breaks at stretching</b>	Unmelted particles in film, draw ratio too high, or temperature stretch oven too high	<ul style="list-style-type: none"><li>• Check granules on contamination</li><li>• Reduce draw ratio</li><li>• Increase oven temperature or reduce line speed</li></ul>
<b>3. Poor gloss</b>	Inaccurate chill roll settings	<ul style="list-style-type: none"><li>• Reduce chill roll temperature</li><li>• Reduce air gap / use vacuum box</li><li>• Clean chill roll surface</li></ul>