

Troubleshooting Guide for Fiber Extrusion

Problem	Possible Causes	Possible Solutions
1. Breaks on spinneret	Deposit on spinneret, or too fast take off	<ul style="list-style-type: none"> • Reduce spinneret temperature • Clean spinneret • Reduce line speed
2. Breaks on godets	Granules contaminated, line speed too high, or draw ratio too high	<ul style="list-style-type: none"> • Check granules on impurities, dust • Reduce line speed • Decrease draw ratio • Increase rotation speed slow godets
3. Output too low	Melt viscosity too high	<ul style="list-style-type: none"> • Increase barrel temperatures
4. Irregular thickness of Tapes/strapping	Incorrect extruder settings	<ul style="list-style-type: none"> • Reduce die temperature • Increase die back pressure
5. Color differences in tapes / strapping	Poor pigment dispersion	<ul style="list-style-type: none"> • Decrease rotation speed of screw • Decrease melt temperature • Increase die back pressure
6. Fibers, filaments sticking on godets	Too low spinfoil apply, wrong spinfoil, or too high temperature of slow godets	<ul style="list-style-type: none"> • Check spinfoil apply/applicator • Change the neat oil • Reduce temperature of slow godets
7. Poor adhesion between fibers, filaments on godets	Too low spinfoil apply, wrong spinfoil, too high temperature of slow godets	<ul style="list-style-type: none"> • Check spinfoil apply/applicator • Change the neat oil • Reduce temperature of slow godets
8. Tensile strength too low	Inaccurate draw ratio	<ul style="list-style-type: none"> • Increase draw ratio
9. Elongation too low	Inaccurate draw ratio	<ul style="list-style-type: none"> • Reduce draw ratio
10. Fibrillation of tapes	Draw ratio too high	<ul style="list-style-type: none"> • Reduce draw ratio
11. Die deposit	Incorrect extruder settings	<ul style="list-style-type: none"> • Reduce melt and/or die temperature