

Winder and Roll Troubleshooting Guide

Problem	Causes(s)	Possible Solution(s)
Baggy Edges	Bowed roll angle out of adjustment	Adjust
	Uneven cooling of film edges	Adjust gap of collapsing frame Adjust collapsing frame angle
Bumpy Roll	Excessive tension	Adjust to reduce tension
	Damaged winding shaft	Replace apparatus
	Hot web	Decrease the temperature of the chill roll
	Gauge variation	Remove air drafts Adjust the die gap
Core Collapse	Tightly wound film	Reduce tension
	Excessive lay on pressure	Reduce lay on pressure
Creases	Stretching between nip and rollers	Reduce winding speed
	Inconsistent nip speed	Adjust or replace nip assembly drive
Floppy Web	Insufficient tension	Adjust to increase tension
	Rolls out of alignment	Align rollers
Fluctuating Tension	Faulty drive	Replace
	Bearing sticking	Check roll turning resistance
	Dancer potentiometer malfunction	Check pot and wiring
	Moisture in dancer's pneumatic components	Check and replace as required Filter plant air to remove water
	Force transducer problem	Check transducer and wiring
Fuzzy Roll End	Dull blades	Replace
	Blades not aligned properly to the web	Check blade adjustment
Hard Roll	Excessive winder tension	Reduce tension
	Excessive lay on pressure	Reduce lay on pressure
	Hot web	Decrease chill roll temperature
Film Sag	Film collapsed too warm	Decrease film temperature
	Excessive drag in collapsing frame	Increase collapsing frame angle
		Increase nip roller height
		Use smooth surfaces
Uneven bubble cooling	Examine collapsing frame for uneven contact with the bubble	
Soft Roll	Insufficient tension	Increase tension
	Insufficient lay on pressure	Increase lay on pressure
Starring	Excessive tension	Reduce tension
Telescoping	Insufficient tension	Increase tension
	Air between film layers	Increase lay on roller pressure
	Misaligned rolls	Check and align rolls in turret and winding areas
	Insufficient nip drive tension	Increase tension
	Slippery Film	Decrease amount of slip added to resin
Increase tension of film		
Increase temperature of film		

Problem	Causes(s)	Possible Solution(s)
Uneven Roll Width	Rolls not aligned	Check alignment of all rolls
		Examine contacting web in the turret and winder equipment
	Air drafts	Rotate die
		Eliminate source of air drafts
	Incorrect winding tension	Check for alternating tension
		Check tension prior to and after the nip roll for uniformity
Surging	Adjust extruder temperature profile	
	Reduce amount of scrap recycle	
Low lay on roll pressure	Increase	

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