### Film Striking
- **Problem:** Floppy Web on Chill Roll
- **Possible Solution(s):**
  - Decrease the chill roll temperature
  - Use a resin with a higher density
  - Decrease the tension
  - Check the chill roll temperatures and adjust as necessary
  - Increase extrusion temperature
  - Change die lips
  - Increase the die gap
  - Increase tension of the winder
  - Increase the chill roll temperature
  - Scratches
    - Increase chill roll temperature
    - Use a resin with a lower melt index
    - Check temperatures and adjust accordingly
    - Increase restriction
    - Decrease the air gap
    - Use resin with a higher density
    - Decrease die gap
    - Use a resin with a higher melt index
  - Poor Barrier
    - Increase the die gap
    - Decrease the chill roll temperature
    - Decrease the air gap
    - Use resin with a higher melt index
    - Increase restriction
    - See if the regrind feed is force feeding the extruder (blenders)
    - Increase restriction
    - Use a resin with a higher melt index
    - Check the air knife blower speed and adjust as necessary
    - Use a resin with a higher density
    - Increase the extrusion temperature
    - Use resin with a higher density
    - Decrease the die gap
    - Decrease the output and/or take up speed
    - Increase extrusion temperature
    - Use resin with a higher density
    - Increase the extrusion temperature
    - Decrease the additive formulation, namely the ash level
    - Decrease the temperature on the secondary chill roll
    - Increase the air gap
    - Adjust the deckles
    - Increase the tension
    - Use a resin with a higher density
    - Increase the extrusion temperature
  - Scratches
    - Increase chill roll temperature
    - Use a resin with a lower melt index
    - Check temperatures and adjust accordingly
    - Increase restriction
    - Decrease the air gap
    - Use resin with a higher density
    - Decrease die gap
    - Use a resin with a higher melt index
  - Air gap
    - Decrease the air gap
    - Use a resin with a higher melt index
  - Process Not Achieved
    - Decrease the taper
    - Check the balance
  - Stiffness
    - Tightly wound film
    - Warm film
  - Nylon
    - See if the regrind feed is force feeding the extruder (blenders)
    - Increase restriction
    - Use a resin with a higher melt index
    - Check the air knife blower speed and adjust as necessary
  - Surging of the extruder
    - Use a resin with a lower melt index
  - Insufficient roll tension
  - High neck-in
  - Resin density
  - Extruder output/take up
  - Resin density
  - Die gap
  - Treatment level
  - Resin melt index
  - Winder tension
  - Extruder output/take up
  - Chill roll temperature
  - Extrusion temperature
  - Additives
  - Die gap
  - Extruder output/take up
  - Air gap
  - Resin melt index
  - Resin density
  - Extruder output/take up
  - Screen pack
  - Die gap
  - Tightly wound film
  - Warm film
  - Excessive bow

### Operations
- **Possible Solution(s):**
  - Check the passages
  - Use a resin with a lower density
  - Decrease the output rate and/or take up speed
  - Increase the chill roll temperature
  - Use a resin with a lower melt index
  - Decrease the extrusion temperature
  - Repair surface
  - Decrease the temperature on the secondary chill roll
  - Decrease the level of treatment applied to the film
  - Decrease the barrel temperatures
  - Use a resin with a higher density
  - Decrease air gap
  - Decrease the additive formulation
  - Decrease extrusion temperature
  - Increase restriction
  - Increase the output rate and/or take up speed
  - Increase restriction
  - Increase the chill roll temperature
  - Cast Film T

### Gauge Variation (cont.)
- **Possible Solution(s):**
  - Decrease the taper
  - Check the balance
  - Apply heat to the die lips
  - Increase melt temperature
  - Check the roll speed and adjust accordingly
  - Decrease die gap
  - Increase restriction
  - Check for wearing of the screw and repair/replace as necessary
  - Ensure proper screw design
  - Examine the filters for possible clogging and clean/replace as necessary
  - Check for wearing of the screw and repair/replace as necessary
  - Modify screw design with static mixers to achieve homogeneity
  - Check for wearing of the screw and repair/replace as necessary
  - Screen pack
  - Check for wearing of the screw and repair/replace as necessary
  - Proper screw design
  - Examine the filters for possible clogging and clean/replace as necessary
  - Check for wearing of the screw and repair/replace as necessary

### Elongation
- **Possible Solution(s):**
  - Increase restriction
  - Decrease the air gap
  - Use resin with a higher density
  - Increase restriction
  - Increase the output rate and/or take up speed
  - Increase restriction
  - Increase the chill roll temperature

### Gauge Variation
- **Possible Solution(s):**
  - Decrease the taper
  - Check the balance
  - Apply heat to the die lips
  - Increase melt temperature
  - Check the roll speed and adjust accordingly
  - Decrease die gap
  - Increase restriction
  - Check for wearing of the screw and repair/replace as necessary
  - Ensure proper screw design
  - Examine the filters for possible clogging and clean/replace as necessary
  - Check for wearing of the screw and repair/replace as necessary
  - Modify screw design with static mixers to achieve homogeneity
  - Check for wearing of the screw and repair/replace as necessary
  - Screen pack
  - Check for wearing of the screw and repair/replace as necessary
  - Proper screw design
  - Examine the filters for possible clogging and clean/replace as necessary
  - Check for wearing of the screw and repair/replace as necessary

### Film Blocking
- **Possible Solution(s):**
  - Decrease the taper
  - Check the balance
  - Apply heat to the die lips
  - Increase melt temperature
  - Check the roll speed and adjust accordingly
  - Decrease die gap
  - Increase restriction
  - Check for wearing of the screw and repair/replace as necessary
  - Ensure proper screw design
  - Examine the filters for possible clogging and clean/replace as necessary
  - Check for wearing of the screw and repair/replace as necessary
  - Modify screw design with static mixers to achieve homogeneity
  - Check for wearing of the screw and repair/replace as necessary
  - Proper screw design
  - Examine the filters for possible clogging and clean/replace as necessary
  - Check for wearing of the screw and repair/replace as necessary

### Low LD Low Strength
- **Possible Solution(s):**
  - Decrease the taper
  - Check the balance
  - Apply heat to the die lips
  - Increase melt temperature
  - Check the roll speed and adjust accordingly
  - Decrease die gap
  - Increase restriction
  - Check for wearing of the screw and repair/replace as necessary
  - Ensure proper screw design
  - Examine the filters for possible clogging and clean/replace as necessary
  - Check for wearing of the screw and repair/replace as necessary
  - Modify screw design with static mixers to achieve homogeneity
  - Check for wearing of the screw and repair/replace as necessary
  - Proper screw design
  - Examine the filters for possible clogging and clean/replace as necessary
  - Check for wearing of the screw and repair/replace as necessary

### Low Gloss
- **Possible Solution(s):**
  - Decrease the taper
  - Check the balance
  - Apply heat to the die lips
  - Increase melt temperature
  - Check the roll speed and adjust accordingly
  - Decrease die gap
  - Increase restriction
  - Check for wearing of the screw and repair/replace as necessary
  - Ensure proper screw design
  - Examine the filters for possible clogging and clean/replace as necessary
  - Check for wearing of the screw and repair/replace as necessary
  - Modify screw design with static mixers to achieve homogeneity
  - Check for wearing of the screw and repair/replace as necessary
  - Proper screw design
  - Examine the filters for possible clogging and clean/replace as necessary
  - Check for wearing of the screw and repair/replace as necessary

### Scratches
- **Possible Solution(s):**
  - Decrease the taper
  - Check the balance
  - Apply heat to the die lips
  - Increase melt temperature
  - Check the roll speed and adjust accordingly
  - Decrease die gap
  - Increase restriction
  - Check for wearing of the screw and repair/replace as necessary
  - Ensure proper screw design
  - Examine the filters for possible clogging and clean/replace as necessary
  - Check for wearing of the screw and repair/replace as necessary
  - Modify screw design with static mixers to achieve homogeneity
  - Check for wearing of the screw and repair/replace as necessary
  - Proper screw design
  - Examine the filters for possible clogging and clean/replace as necessary
  - Check for wearing of the screw and repair/replace as necessary

### Poor Barrier
- **Possible Solution(s):**
  - Decrease the taper
  - Check the balance
  - Apply heat to the die lips
  - Increase melt temperature
  - Check the roll speed and adjust accordingly
  - Decrease die gap
  - Increase restriction
  - Check for wearing of the screw and repair/replace as necessary
  - Ensure proper screw design
  - Examine the filters for possible clogging and clean/replace as necessary
  - Check for wearing of the screw and repair/replace as necessary
  - Modify screw design with static mixers to achieve homogeneity
  - Check for wearing of the screw and repair/replace as necessary
  - Proper screw design
  - Examine the filters for possible clogging and clean/replace as necessary
  - Check for wearing of the screw and repair/replace as necessary