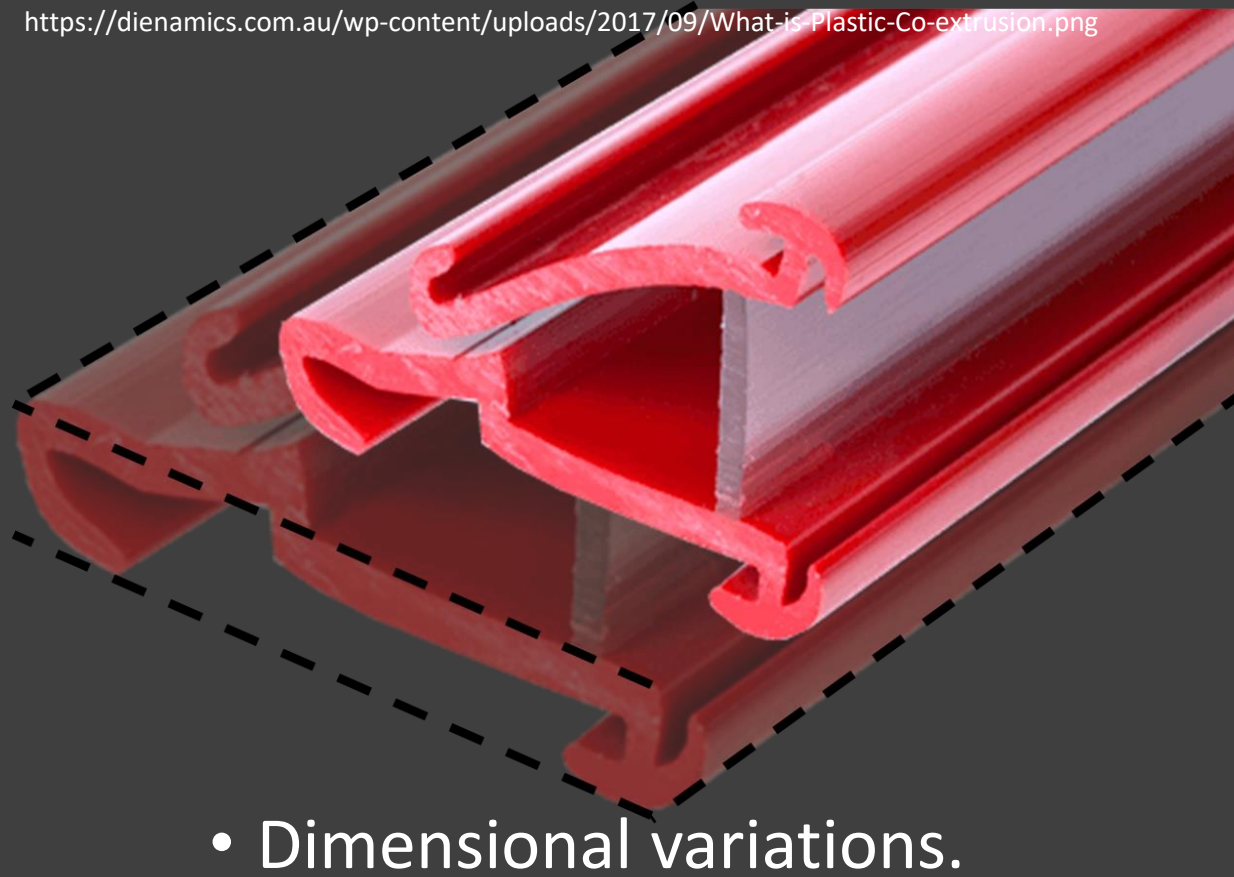




Common defects in extrusion process





- Dimensional variations.



- Aesthetics

Typical extrusion problems




Watch the next video,
identify the general stages
of the process, and propose
the inherent issues related
to each step and the
probable flaws they may
cause to the final product.



Click here!



Problem	Image	Cause	Solution
1. Lumpy Surface		Too cold	<ul style="list-style-type: none"> • Increase all temperatures • Increase screen packs
2. Surging		Equipment or Settings	<ul style="list-style-type: none"> • Take off puller irregular • Motor speed varies • Inconsistent Rpm's • Uneven feed • Bridging in hopper • If Ammeter is varying by 5% or more, increase temperature of the feed
3. Orange Peel Surface		Overheating	<ul style="list-style-type: none"> • Raise die temperature • Decrease speed

			
4. Pimples on Surface		Resin Gels	<ul style="list-style-type: none"> • Increase screens • Decrease speed
5. Excessive Shrinkage		Too much stress	<ul style="list-style-type: none"> • Cool slower • Decrease speed • Design die with lower draw down
6. Bubbles		Moisture	<ul style="list-style-type: none"> • Dry Material at 220F for one hour

Typical extrusion
problems, causes
and solutions



Reivew Article

DEFECTS IN EXTRUSION PROCESS AND THEIR IMPACT ON PRODUCT QUALITY

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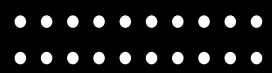
A Study of Plastic Extrusion Process and its Defects

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More detailed information
about extrusion problems
and how to solve them can
be found in:



HDPE 1000mm inner diameter production

