Sticking pellet

Problem	Typical Cause	Effect	Action check list	Remark
Found Sticking pellet Example : 27/8/15 (Sticking due to cann't cut)  Example : 27/5/15 (Sticking due to cutter wear)  Example : 27/8/15 (Stick after cut) 	**Process** 1. Too High Polymer melt temp - High After cooler temp - High Barrel Temp 2. Too High Pellet water Temp 3. Too High Die plate Temp 4. Too Low Pellet water Flow **Mechanical** 1. Cutter defect - Gap too high - wear - miss alignment	1. Found a lot of sticking pelelt at Over-size bag 2. F1905 blockage by Sticking pellet and flow back to R1901 and may cause R1901 overload trip ** Sign : FI19101 tend to reduce and R1901 current was increasing **	Before Adjust OP should verify sticking pellet type first (Sticking by temp or Cutter defect) 1. **Sticking By Temperature** - Adjust Process Step **DO!!** ☐ Decrease Barrel water; TI17110 (↓ ≥ 150 ₀C) ☐ Increase Pellet water flow; FI17105 (↑ ≤ 820 m3/hr) ☐ Decrease After cooler Temp; TIC13099 (↓ ≥ 235 ₀C) **DON'T** ☐ Don't decrease PEW temp (keep at 40₀C) ☐ Don't decrease Die plate Temperature (keep HS header at 37 barg) ----------risk of Die freezing---------- **2. Sticking By Cutter defect** - Adjust Cutter knife **DO!!** ☐ Forward Cutter 3. If Sticking pellet still found after adjust Step 1 & 2. **DO!!** ☐ **Check Over size bag still open** ☐ **By-pass F1905** (prevent pellet overflow to R1901 then overload trip) ☐ Keep monitoring and Report in Daily meeting to find out with TE & AS	After adjusted -Monitor each step for 30 min (on site) - If Sticking pellet still found, do next step After adjusted -Monitor for 30 min (on site and S-5101 report browser) - *Too much forward* cutter related to *cutter torque high*