Sticking pellet

Found Sticking pellet Found Sticking pellet Example: 27/8/15 (Sticking due to cann't can) Figh Barrel Temp - High Barrel Temp 2. Too High Pollet water Temp 4. Too Low Pellet water Temp 5. Too High Die plate Temp 4. Too Low Pellet water Temp 5. Too High Die plate Temp 6. Too High Die plate Temp 7. Temp 7. Temp 8. Too High Die plate Temp 8. Too High Die plate Temp 9. Too High Die plate Te	Process 1. Too High Polymer melt temp 1. Too High Polymer melt temp 1. High After cooler temp 1. High After cooler temp 1. High After cooler temp 1. Too High Polymer melt temp 2. Too High Polymer melt temp 2. Too High Polymer melt temp 1. High After cooler temp 1. High After cooler temp 1. Too High Polymer melt temp 2. Too High Die plate Temp 3. Too High Die plate Temp 3. Too Low Pellet water Temp 4. Too Low Pellet water Temp 4. Too Low Pellet water Temp 4. Too Low Pellet water Temp 5. Too high Die plate Temp 6. Company 6. Too Low Pellet water Temp 7. Sticking due to cutter was increasing *** 7. Sticking due to cutter was increasing *** 7. Sticking due to cutter was increasing *** 7. Sticking bellet and flow thack to R1901 current was increasing *** 7. Sticking pellet and flow thack to R1901 current was increasing *** 7. Sticking pellet water from 7. Stickin	Problem				
Example : 27/8/15 (Sticking due to cann't cut) Too High Polymer melt cut)	Example : 27/8/15 (Sticking due to caum't cut) Too High Polymer melt temp High After cooler temp High After cooler temp High After cooler 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 bigh - wear miss alignment 2. Sticking By Temperature Sticking pellet and flow back to R1901 urrent was increasing ** 1. Sticking By Temperature 1. Sticking by temp or Cutter defect 1. Sticking be a still flow of the plan		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)	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	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	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 ∘C) Increase Pellet water flow; FI17105 (↑≤820 m3/hr) Decrease After cooler Temp; TIC13099 (↓≥235 ∘C) DON'T 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	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