Angel Hair or Tails

Problem	Typical Cause	Effect	Action check list	Remark
Found Angel Hair Example : 18/12/14 (Cutter miss alignment)  Example : 9/7/15 (after SU) 	**<u>Process</u>** 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 **<u>Mechanical</u>** 1. Cutter defect - Gap too high - wear - miss alignment 2. Die plate defect - Nip loosen - Orifice crack	1. Found Angel hair at Sampling point S-5101 2. Hair that peel out from pellet may cause of PDI19103 increasing and M1910 blockage	1. Adjust Process Step **<u>DO!!</u>** □ Decrease Barrel water; TI17110 (↓ ≥ 150 ₀C) □ Increase Pellet water flow; FI17105 (↑ ≤ 820 m3/hr) □ Decrease After cooler Temp; TIC13099 (↓ ≥ 235 ₀C) **<u>DON'T</u>** □ Don't decrease PEW temp (keep at 40₀ C) □ Don't decrease Die plate Temperature (keep HS header at 37 barg) ----------risk of Die freezing---------- 2. Adjust Cutter knife **<u>DO!!</u>** □ Forward Cutter 3. If Angel hair still found after adjust Step 1 & 2. **<u>DO!!</u>** □ Keep monitoring and Report in Daily meeting to find out with TE & AS	<u>After adjusted</u> -Monitor each step for 30 min (on site) - If Angel hair still found, do next step <u>After adjusted</u> -Monitor for 30 min (on site and S-5101 report browser) - *Too much forward* cutter related to *cutter torque high* - manual SP3A If Can't control product quality and have to judge product to NP