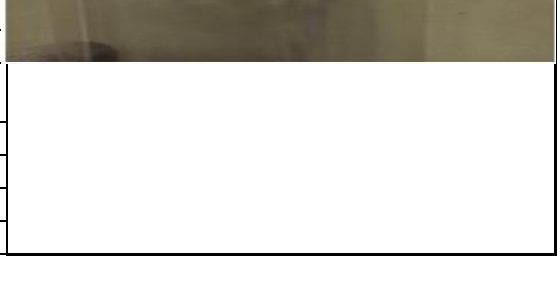
Sidel Defect Troubleshooting Guide CSD Bottles

Problem	Cause	Suggested Remedy	Picture Of Defect
Base Folds			
	1. Gate too hot.	1. Cool off gate.	
	2. Gate too cold.	2. Heat up gate.	
	3. Prebow preasure too low.	3. Raise preblow preasure.	
	4. Point "o" too far retarded.	4. Advance point "O"	
One Station Only	5. Bad preblow valve.	5. Replce preblow valve.	
	6. Preblow flow control closed off.	6. Open up flow control.	
			
Choked Necks	1. Preblow pressure too low.	1. Raise preblow pressure.	
	2. Point "0" too far retarded.	2. Advance Point "0".	
	3. Neck area too cold.	3. Heat up neck area.	
	4.Stretch rod touching preform.	4. Replace bent stretch rod.	
	5.Bad three way/pre-blow valve.	5. Replace bad valve.	
			
Pearl Feet	1. Process too cold in the feet.	1. Heat up the feet.	
	2. Insufficient material distribution(stretch pearl).	2. Redistribute material too feet. This can be accomplished by lowering the preblow or adjusting the heats to force more material intc the feet.	
			
Pearl Bottles	1. Process too cold.	1. Increase over all heat..	
	2. Insufficient material distribution in area of bottle(stretch Pearl)	2. Redistribute material to pearl area. This can be accomplished by lowering the preblow or adjusting the heats to force more material into the feet.	
			
Crack Gates	1. Gate too cold.	1. Heat up th gate area.	
	2. Strechrod gap too low	2. Re-adjust the strechrod gap.	
	4. Excessive crystalinity in preform gate.	4. Remove and replace preforms.	
			
Underblown Feet	1. Base too cold.	1. Increase temperature in base.	
	2. Loss of high blow pressure.	2. Check plant preassure.	
	3. Excessive material in feet.	3. Reprocess and redistribute material.	
	4. Bad three way valve.	4. Replace three way valve.	
	5. Preblow too high.	5. Lower preblow.	
	6. Foreign material in mold.	6. Clean molds.	
			

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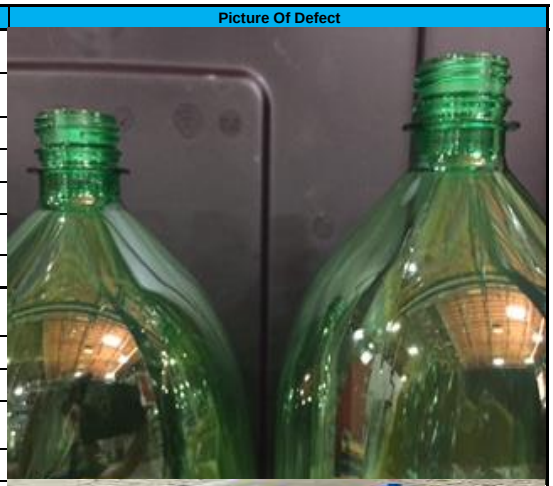
Problem	Cause	Suggested Remedy	Picture Of Defect
Short Bottle/low Volume	1. Height gauge improperly calibrated.	1. Recalibrate height gauge.	
	2. Process too cold.	2. Increase overall process temperature.	
	3. Loss of mold cooling.	3. Restore mold cooling.	
	4. Loss of high blow pressure.	4. Increase high blow pressure.	
	5. Exhaust cam too far advanced.	5. Retard exhaust cam.	
	6. Insufficient material viscosity in preform.	6. Remove and replace preforms.	
	7. Not enough high blow time.	7. Increase high blow time.	
Tall Bottle/High Volume	1. Height gauge improperly calibrated.	1. Recalibrate height gauge.	
	2. Process too hot.	2. Cool overall process.	
	3. Tooling out of specification.	3. Replace tooling.	
	4. Worned out mold or base locking rings .	.	
Flat Sides	1. Mold compensation improperly set.	1. Reset mold compensation.	
	2. Hole in compensation airline.	2. Replace mold compensation airline.	
	3. Blown compensation o-ring.	3. Replace mold compemsation o-ring.	
	4. Not enough material in the panel.	4. Add more material to the panel.	
Dameged Finish	1. Off center blow nozzle.	1. Recenter blow nozzle.	
	2. Preform loading wheel out of time on oven or mold	2. Reset timing.	
	3. Infeed loading top guide to low/high.	3 Re-adjust top guide.	
	4. Preform transfer arms out of time or adjustment.	4. Retime or reset transfer arms.	
	5. Preform hopper or feed system damaging finish.	5. Investigate and repair any pinch / jam point on preform feed system.	
	6. Damage occurring during preform manufacture.	6. Inspect preform container for damaged preforms. Replace preforms and notify Supervisor.	
Inclusions	1. Foreign material in regrind like plastic metals rubbers ext.	1. Notify supervisor of the findings and let him decide what to do.	
Low Top Load	1. Top load tester out of calibration.	1. Recalibrate top load tester.	
	2. Insufficient material distribution.	2. Reprocess and evenly distribute material.	
	3. Process too hot.	3. Cool overall process.	
	4. Insufficient material viscosity.	4. Replace preforms.	

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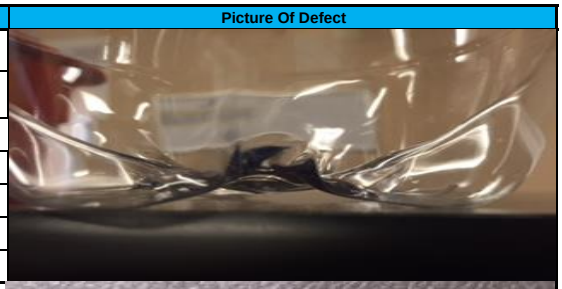
Problem	Cause	Suggested Remedy	Picture Of Defect
Low Base Clearance	1. Base clearance gauge out of calibration.	1. Recalibrate gauge.	
	2. Too much material in gate.	2. Redistribute material evenly through base.	
	3. Loss of mold base cooling.	3. Restore base mold cooling.	
	4. Cool jets off or out of position.	4. Reposition cool jets.	
Hole In Feet	1. Forein material in mold or preform.	1. Remove foreign material from mold or replace preforms.	
	2. Unmelted material in preform.	2. Notify your supervisor.	
	3. Insufficient material distribution (feet too thin).	3. Reprocess and redistribute material.	
	4. Bent or damaged stretch rod.	4. Replace stretch rod.	
Off Center Gate	1. Stretch rod adjusted too high.	1.Readjust stretch rod gap.	
	2. Preblow pressure too high or to soon.	2. Reduce preblow pressure or retard preblow cam.	
	3. Process too hot.	3. Cool process,Verify process with BIC,Verify that auto-correction is activated,verify that camera for preform temperature has not been moved.	
	4. Damage to oven chain or spindle causing loss of rotation.	4. Repair or replace spindle or section of chain.	
	5.Bent Strechrod.	5. Replace Strechrod.	
Burst Expansion Too High	1. Make sure the water temp on the Burst tester is between 59 to 62 degrees.	1. Purge water till your with in degrees.	
	2. Proces Too Hot.	2. Cool off overall Process.	
Bursting In The Gate	1. Gate too cold.	1. Heat up the gate.	
	2.Too much material in gate area.	2. Redistribute material to thin out the gate area.	
	3. Excessive crystalinity in preform gate.	3. Let your supervisor know.	
Drop Neck	1. Too much heat In zone one.	1. cool off zone one.	
	2. Too much material in neck area.	2.Heat up zone one or lower preblow.	
	3.Strechrod touching preform.	3. Bent stechrod replace rod.	
	4. Preblow too low.	4. Raise preblow.	
	5. Preblow too far retarted.	5. Advance preblow.	

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Problem	Cause	Suggested Remedy	Picture Of Defect
Haze	1. Overall temperature too hot.	1. Cool overall temperature.	
	2. Haze in one area.	2. Cool off the area.	
Blown Finishes	1. Incorret oven set up.	1. Look at master process and verify oven settings.	
	2. Preform riding high on spindle	2.Visually check preform as they get loaded on the spindle and ride thru the oven.	
	3.Oven fans not working.	3.Rapair or replace oven fans.	
	4. Too much heat on zone one.	4. Reduce heat in zone one.	
Gate Divots	1. Strechrod too low causing a divot on the base of the botttle.	1. Re-adjust the strechrod gap.	
	2. Broken thrust stop.	2. Replace thrust stop.	