Troubleshooting Guide for Blow Molding

Problem	Possible Causes	Possible Solutions
1. Parison not being blown	Defective blow timer, clogged blow lines, or too sharp pinch- offs	Replace blow timer Clean blow lines Stone pinch-offs to create more pinch area Reset cushion Clean tooling
Z. Parison curling	Mandrel and bushing not flush, bushing too cold, low container weight, or stock resin temperature too low	Remachine tooling Raise bushing temperature Check heat coetrollers Increase container weight Increase stock resin temperature Center mandrel in die Check screw tip design
3. Drawdown, parison sag/stretch	Too high parison temperature, melt index of resin too high, or mold open time too high	Decrease stock temperature Increase extrusion pressure/rate Decrease extrusion back pressure Use lower melt index resin Reduce mold open time Decrease container weight
4. Parison tail sticking to parts	Parison too long	 Shorten parison length or increase pinch-off land area to cool compressed tail
5. Rough parison surface/uneven parison thickness	Extrusion speed too fast, cold parison, stock temperature too low, resin melt index too low, loose mandrel, or insufficient venting	Adjust extrusion rate Increase stock temperature Use resin with higher melt index Check mold alignment Check tool design Add venting by either sandblasting the mold surface channels or venting the interior of the mold
6. Black specks in containers	Resin hang-up in die, or material contamination	Clean die surface and tooling Check material for contamination
7. Bubbles/fish eyes	Blow air orifice too small or restricted, low stock temperature, mold temperature too low, tooling damage, or wet and contaminated resin	Check the orifice for restrictions and size Increase air pressure Increase melt temperature Increase mold temperature Check tooling Check resin for moisture Check for contamination Check for resin lines and/or streamers

Troubleshooting Guide For Injection Blow Moulding

Raffaela Di Napoli

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