



## SHRINK WRAP TROUBLESHOOTING GUIDE

---

### PROBLEMS AND SOLUTIONS

#### **Film Splitting at Centerfold during Operation**

1. Check to see if roll has been dropped
2. Check loading tray for sharp edges

#### **Burn Holes- “Hot Spots”**

1. Check for location of air evacuation hole
2. Speed up tunnel conveyor
3. Move air evacuation hole to proper position for best results when shrinking
4. Decrease tunnel temperature
5. Adjust tunnel air flow

#### **Film Splits at Hole Punch**

1. Check hole punch for striker alignment or damaged die
2. Check location of air evacuation hole
3. Move air evacuation hole to proper location for best results when shrinking

#### **Film Splits at Top of Package**

1. Check hole punch for striker alignment or damaged die
2. Check for location of air evacuation hole
3. Move air evacuation hole to proper location for best results when shrinking
4. Make sure that the tunnel is functioning properly
5. Speed up the tunnel conveyor



## SHRINK WRAP TROUBLESHOOTING GUIDE

---

### PROBLEMS AND SOLUTIONS

6. Use more film around the product
7. Decrease the tunnel temperature
8. Adjust tunnel air flow

#### **Excessive Smoking**

1. Check an clean wire and insulating material
2. Check condition of sealing pad and Teflon tape
3. Check for even clamp pressure
4. Make sure seal is made with minimum wire temperature
5. Increase wire temperature
6. Decrease dwell time

#### **“Angel Hair”- “Stringy Seals”**

1. Check and clean wire and insulating material
2. Check condition of sealing pad and Teflon tape
3. Check for even clamp pressure
4. Make sure seal is made with minimum wire temperature
5. Make sure that sealing cycle is completed before sealing jaws are released
6. Make sure that magnetic hold-downs are released at the same time
7. Make sure that L-sealer take away conveyor does not engage before the sealing jaws are released
8. Increase wire temperature
9. Take off Teflon sleeve



## SHRINK WRAP TROUBLESHOOTING GUIDE

---

### PROBLEMS AND SOLUTIONS

#### Off Center Seal

1. Adjust the loading platform so that seal is in center of package

#### Crows Feet

1. Slow down tunnel conveyor
2. Adjust tunnel air flow
3. Move air evacuation hole to the proper position for the best results in shrinking
4. Increase tunnel temperature
5. Make sure that the tunnel is functioning properly

#### Fish Eyes

1. Make sure that the tunnel is functioning properly
2. Slow down the tunnel conveyor
3. Adjust tunnel air flow
4. Use less film around product
5. Increase tunnel temperature

#### Dog Ears

1. Use less film around the product
2. Slow down tunnel conveyor
3. Adjust tunnel air flow
4. Move air evacuation hole to the proper position for the best results in shrinking
5. Increase tunnel temperature



## SHRINK WRAP TROUBLESHOOTING GUIDE

---

### PROBLEMS AND SOLUTIONS

#### Erratic Shrinking

1. Make sure that the tunnel is functioning properly
2. Slow down tunnel conveyor
3. Adjust tunnel air flow
4. Move air evacuation hole to the proper position for the best results in shrinking
5. Increase tunnel temperature
6. Severe Ballooning
7. Check for location of air evacuation hole
8. Move air evacuation hole to the proper position for the best results in shrinking

#### Weak or Split Seals

1. Check and clean wire and insulating material
2. Check condition of sealing pad and Teflon tape
3. Check for even clamp pressure
4. Check to make sure there is no tension on the film during sealing
5. Make sure seal is made with minimum wire temperature
6. Make sure that sealing cycle is completed before sealing jaws are released
7. Make sure that magnetic hold downs are released at the same time
8. Make sure that L-sealer take away conveyor does not engage before the sealing jaws are released
9. Increase wire temperature



## SHRINK WRAP TROUBLESHOOTING GUIDE

---

### PROBLEMS AND SOLUTIONS

10. Decrease wire temperature
11. Decrease or increase seal time
12. Take off Teflon sleeve

#### **Seal Failure in Tunnel**

1. Check and clean wire and insulating material
2. Check condition of sealing pad and Teflon tape
3. Check for even clamp pressure
4. Check to make sure that there is no tension on the film during sealing
5. Make sure that the sealing cycle is completed before sealing jaws are released
6. Check for location of air evacuation hole
7. Make sure that magnetic hold downs are released at the same time
8. Make sure that L sealer take away conveyor does not engage before the sealing jaws are released
9. Make sure that the tunnel is functioning properly
10. Use more film around the product
11. Decrease tunnel temperature
12. Adjust tunnel air flow
13. Take off Teflon sleeve



## SHRINK WRAP TROUBLESHOOTING GUIDE

---

### PROBLEMS AND SOLUTIONS

#### **Film Build Up On Sealing Wire**

1. Check and clean wire and insulating material
2. Check condition of sealing pad and Teflon tape
3. Check for even clamp pressure
4. Make sure seal is made with minimum wire temperature
5. Increase wire temperature
6. Take off Teflon sleeve
7. Check for poly switch – turn off

#### **Film Cannot Be Separated**

Call for advice

#### **Static In Film**

Call for advice

#### **Film Collapses The Package**

Call for advice

Try Syfan LSF (Low Shrink Force Film) or G22 PVC

#### **Adjustments Do Not Work**

Call for Advice