

Malfunction and troubleshooting

Trouble	Cause/s	Solution/s
The temperature of the expansion chamber does not reach the rated temperature.	The steam line is blocked. The expansion chamber's inlet steam is blocked.	Clean the steam line. Clean the expansion chamber's inlet steam.
The temperature of conditioning does not reach the required temperature.	Insufficient steam temperature Blocked steam line	Check and then adjust the steam pressure at 4bar; Clean the steam line;
The extruder delivers coarse surface materials in different lengths after expansion	Conditioning process is done poorly. Some die holes are blocked. Particle size is not sufficient. The quality of the die plate is not good.	Start to condition the material, then stop the machine and clean the die plate. Increase particle size. Use high-quality die plates.
The throughput has reduced.	The worn shearing block; The sever worn screw's head;	Use a new shearing block. Use a new screw head.
Materials are not discharged following the normal operation.	Feeding duration is excessively short/ feeding is cut off. Blocked die holes;	Turn off the machine to check it.
Wave-like discharge intermittently occurs	The expansion chamber is insufficiently full.	Throughput should be increased.
Expansion occurs excessively.	The temperature is excessively high. The rotation speed of the main machine is excessively high. The throughput and the area of the die plate holes do not match.	Decrease the temperature. Lower the rotating speed. Readjust throughput or change the area of die plate holes.
The expanded pellet is excessively long or short.	The cutting speed is excessively high or low.	Set the cutting drive rotating speed.
Product is formed poorly	The raw materials are of improper formula. The processing temperature is excessively high. Feeding is not stable; The moisture content of the product is very high or low. Cutting speed is improper. Sever worn blade; Grinding particle size is very large.	Change the raw materials formula. Set an even feeding. Increase or decrease the moisture content or steam volume. Set the machine on an appropriate rotating speed. Further grind the raw materials until the smaller particle size is reached.