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This guide is specific to polyethylene heat shrink film for tray wrap such as cans, bottles or other unitized packages. For olefin films, download the [Clysar troubleshooting guide](#). If your question is not answered in the table below, [contact us](#).

Creating optimum shrink film conditions is a lot like [heat sealing](#). The key variables are heat and dwell time.

The answer to the common question “ What is your recommended tunnel temperature ?” is “ it depends ” . It depends on the residence time and velocity of air in the tunnel. If you absolutely need a temperature, a good starting point is 300°F. The lowest possible heat is best for several reasons.

PE SHRINK FILM TROUBLESHOOTING GUIDE		
Problem	Cause	Solution
Elliptical shaped holes in film	Excessive heat or tunnel dwell time	Reduce heat and / or tunnel residence time
Big holes in the top of the package (“ ballooning “).	Air gets trapped in the package	Narrower film or increased TD shrink
Overlap on bottom of pack does not seal (wand cutoff style only)	Insufficient pressure in overlap	Increased air on bottom of tray
Film won't seal (heat seal pass through)	Seal bar out of adjustment or needs maintenance	Check Teflon and nichrome wire. Check alignment and seal bar pressure.
Film has mottled appearance	Excessive heat or tunnel dwell time	Reduce heat and / or tunnel residence time
Cans and bottles fall out of side of package	Bullseye is too big	Wider film or less TD shrink
Packages slide on pallet	Film is too slippery (COF is too low)	Insist on zero slip in resin
Packages are loose on arrival	Too much linear low density or repro in resin	Threaten to stop buying unless extruder uses 100% virgin fractional melt resin
Film needs constant adjustment to heats and fans	Extruder has slipped in regrind and repro	Threaten to switch suppliers unless extruder uses the same 100% virgin fractional melt resin every time
Not getting as many packages as you should from a roll of film	Extruder is supplying film thicker than specified	Insist on roll tickets with both weight and footage