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Troubleshooting Guide 2nd This
information is intended to be used only
as a guideline for designers and
processors of modified thermoplastics
for injection molding.

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High Injection Velocity Lowering the
injection speed will allow trapped air in
the mold to escape. It will also reduce
shear heating of the resin. Increase the
size, amount and/or location of the
vents. Reduce time the resin resides in

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barrel by speeding cycle or decreasing barrel size. Lower barrel heaters, screw

TROUBLESHOOTING GUIDE FOR INJECTION MOLDING

Injection Molding Troubleshooting Guide.
Cracking Crazing Black Specks or
Streaks. Problem. Delamination.
Problem. Gloss (Low) Blisters Blush
Bowling Bubbles. Source(s) Cause(s)
Machine Excessive residence time in
barrel Hang-up of molten material in
injection barrel or runner system
Contamination of injection barrel
Degradation due to malfunctioning
heater bands or thermocouples
Defective nozzle shutoff mechanism
Inefficient injection conditions Cracked
injection cylinder or pitted screw Oil ...

Injection Molding Troubleshooting Guide

This information is intended to be used only as a guideline for designers and processors of modified thermoplastics for injection molding. Because injection

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mold design and processing is complex, a set solution will not solve all problems. Observation on a “trial and error” basis may be required to achieve desired results.

Injection Molding Troubleshooting Guide - RTP Company

Process: (1) Increase injection pressure and injection speed to enhance shear heat (2) Increase the amount of injection (3) Increase material cylinder temperature and mold temperature. 2. Air Traps. Air traps is that air is trapped in the cavity to create bubbles in the part.

13 Plastic Injection Molding Defects and How to Fix Them

Materials, Design, Process Optimization, Troubleshooting and Other Practical Information from the Experts at Routsis Training. Plastics is a sophisticated and diverse discipline. To excel, you need a good grasp of a wide range of concepts and data. That's what

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this Injection Molding Reference Guide is all about.

Injection Molding Training Guides troubleshooting ...

The Injection Moulding Troubleshooting Guide covers some of the common problems encountered with this process, but is by no means complete. Conditions are variable and include: machine used, machine setup, mould type and complexity, materials and manufacturing environment. Specific conditions cannot be anticipated.

Injection Moulding Troubleshooting | HMC Polymers

Adjust and profile injection speed (slower when high shear defects are formed). Part wall thickness, gate location, or fill pattern causing flow stoppage or hesitations Mold a series of short shots to see how the defect forms. Measure wall thickness throughout the part to understand the causes of the filling pattern.

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Eastman | The results of insight

Injection 2 Injection Processing Problems
Please NOTE the following: Increased cycle time should not be used as a solution for a molding problem, except as the very last resort to maintain the integrity of the molded parts. Various processing changes are suggested as possible solutions for the different problems

Philosophy of Troubleshooting Injection Molding Problems

Molding Troubleshooting Guide Bond
Readout Bond readout is a surface distortion similar to a hump or sink that occurs over a bond line Probable Cause
Material Process • Mismatch of compliance between outer panel, inner panel and adhesive • Incompatible thermal expansion coefficients between the SM and the adhesive

TROUBLESHOOTING MOLDING PROBLEMS

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Increase injection speed and melt/mold temperature; Overmold breaks or impinges through hollow substrate. Improperly supported substrate; High injection pressure and melt temperature; Wrong location of gate; Fully support the substrate to resist hydraulic injection pressures and melting; Lower injection pressure and melt temperature; Relocate gate; Warped parts

Overmolding: Troubleshooting | Avient

Rise injection pressure, check the size of the injection molding parts each time the pressure rises, until the injection molded parts slightly appear. 2. Insufficient plastic inside the cavity. Increase the amount of plastic injection molding or check the bedding.

Plastic Injection Molding Troubleshooting Guide

Injection Molding Reference Guide
Materials, Design, Process Optimization,
Troubleshooting and Other Practical

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Scientific Molding Pocket Guide - Plastics Training

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Sample Pages Injection Molding Advanced Troubleshooting Guide

Troubleshooting Guide for Injection Molding Troubleshooting is the art and science of remedying defects after the process has demonstrated the ability to produce acceptable production parts. Most defects respond to one of a variety of process and/or material changes. The goal is to correctly identify which problem

Troubleshooting Guide for Injection Molding

This reference guide was originally prepared in 1990 as a convenient pocket sized resource for use in Injection Molding. This information is most useful by personnel who work in the injection molding field including press operators, technicians, engineers, designers, mold builders, etc. There are many reference data tables regarding plastics data, statistical methods, engineering calculations ...

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