



Troubleshooting Guide for INJECTION MOLDING Phenolic & Granular Polyester

| PROBLEM | CORRECTIONS | | | | | | | | | | | Refer to Comment Sheet |
|-------------------------------|------------------|--------------------|------------------|-----------------|--------------------|-------------|---------------------|----------------|-----------|-----------|-----------|------------------------|
| | Mold Temperature | Injection Pressure | Holding Pressure | Injection Speed | Barrel Temperature | Screw Speed | Screw Back Pressure | Clamp Pressure | Shot Size | Hold Time | Cure Time | |
| Ball & Socket | 3D | 2I | 2I | 1D | | | | | | | | 4A |
| Bulge Opposite Insert | 3I | | | | 4I | | 4I | | | | | 1B & 2C |
| Cure Blister | 2I | | | 4D | 1I | | 1I | | | | 3I | |
| Dull Appearance | 1I | | | | 2I | | 2I | | | | | 3E & 4Y |
| Flash - Excessive | 4I | 2D | 2D | | 3I | | 3I | 6I | 1D | | | 5F |
| Flow Lines | 4D | 2I | 2I | 1I | 5D | | 5D | | | 3I | | 6A |
| Hard Spots | 4D | 2D | 2D | 3D | 1D | | 1D | | | | | 5H |
| Injection Too Slow | | 1I | | 2I | 3I | | 3I | | | | | 4K |
| Mold Staining | 4I | 5D | 5D | 6D | 3I | | 3I | 7D | | | | 1U & 2Y |
| Mottled Surface Appearance | 3D | | | | 2D | | 2D | | 1I | | | |
| Nonfills or Short Shots | 4D | 3I | 3I | | 2I | | 2I | | 1I | | | 5U & 6G |
| Nozzle Freezes Up | 1D | | | | 2D | | 2D | | | | | 3H |
| Orange Peel | 3I | 1I | 1I | 4D | 2I | | 2I | | | | | |
| Rubbery Parts or Runner | 1I | | | | 2I | | 2I | | | | | 3AA |
| Screw Does Not Go "Home" | | 2I | 2I | | 5D | | 5D | | 3D | | | 1J, 4W & 6K |
| Screw Pickup is Erratic | | | | | 1I | 2D | 1I | | | | | 3M & 4G |
| Screw Pickup is Too Slow | | | | | 2D | 1I | 2D | | | | | 3I |
| Part Shrinkage - Excessive | 2I | 1I | 1I | | 3I | | 3I | | | | 5I | 4U |
| Part Shrinkage - Insufficient | 1D | | 2D | | | | | | | | 4D | 3V |
| Sink Marks | 2I | 3I | 3I | 4D | | | | | 1I | | | 5U |
| Skin Blisters | 3D | | | 1D | | | | | 2D | | | 4U |
| Sprue Sticking | | 3D | 2D | | | | | | | | | 1N, 4H & 5X |
| Sticking in Mold | 3I | | 2D | | | | | | 4D | | | 6I 1P & 5E |
| Subgates Sticking in Mold | | | | | | | | | | | | 1BB, 2CC & 3DD |
| Trapped Gas | 6D | 5D | 5D | 4D | 3D | | 3D | 7D | | | | 1EE 2U & 8Z |
| Warpage When Ejected | | | | | | | | | | | | 1P, 2E, 3R & 4V |
| Warpage After Cooling | 1I | | | 3D | 2I | | 2I | | | | 5I | 4U, 6S & 7A |
| Wood Screwing | | | | | 2D | 3D | 1I | | | | | |

Legend: Number = Priority I = Increase D = Decrease Other Letters = Comment ID

Plastic Injection Molding Troubleshooting Guide

Tao Wei



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