



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

Mike Jess



Plastic Injection Molding Troubleshooting Guide:

Injection Molding Advanced Troubleshooting Guide Randy Kerkstra, Steve Brammer, 2021-04-09 This highly practical troubleshooting guide solves problems at the machine systematically and quickly Drawing on a wealth of hands on experience from the authors who have built strong reputations in the field the book is structured by type of problem solution Thus it is an ideal reference to be consulted at the machine Included is valuable information on robust process windows cycle time evaluations scrap savings and runners gates with no existing standard in the industry No other book provides the unique insights found here **Injection Molding Troubleshooting Guide, 3rd Ed.** Jay W. Carender, 2011-11-04 The IM Troubleshooting Guide was originally prepared in 1996 as a 48 page 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 etc This 3rd ED is at 104 pages and includes selected extra pages from other APEBOOKS that are helpful in process set up and troubleshooting This book includes many useful definitions and tips for troubleshooting molding problems both process and tooling related The book was written based on many years of process engineering The solutions for correcting process problems are listed in the best order to solve the problem based on factors such as ease timeliness to perform versus cost to implement and always considering effectiveness to solve problem It is also useful to identify a common set of definitions for each department to use when discussing these common molding defects Tips are often provided as to which defects may be process correctable versus those requiring product or mold changes An introduction to DOE and dimensional nominalization is made but discussed in greater detail in some of the other booklets written by this author for injection molding these are listed later in this book a total of six books have been written for injection molding Handbook of Plastic Processes Charles A. Harper, 2006-08-28 An outstanding and thorough presentation of the complete field of plastics processing Handbook of Plastic Processes is the only comprehensive reference covering not just one but all major processes used to produce plastic products helping designers and manufacturers in selecting the best process for a given product while enabling users to better understand the performance characteristics of each process The authors all experts in their fields explain in clear concise and practical terms the advantages uses and limitations of each process as well as the most modern and up to date technologies available in their application Coverage includes chapters on Injection molding Compression and transfer molding Sheet extrusion Blow molding Calendering Foam processing Reinforced plastics processing Liquid resin processing Rotational molding Thermoforming Reaction injection molding Compounding mixing and blending Machining and mechanical fabrication Assembly finishing and decorating Each chapter details a particular process its variations the equipment used the range of materials utilized in the process and its advantages and limitations Because of its increasing impact on the industry the editor has also added a chapter on nanotechnology in plastics processing *Injection Molding Troubleshooting Guide* ,1996 **Plastics Institute of America Plastics Engineering, Manufacturing & Data**

Handbook D.V. Rosato, Nick R. Schott, Marlene G. Rosato, 2001-11-30 This book provides a simplified practical and innovative approach to understanding the design and manufacture of plastic products in the World of Plastics The concise and comprehensive information defines and focuses on past current and future technical trends The handbook reviews over 20 000 different subjects and contains over 1 000 figures and more than 400 tables Various plastic materials and their behavior patterns are reviewed Examples are provided of different plastic products and relating to them critical factors that range from meeting performance requirements in different environments to reducing costs and targeting for zero defects This book provides the reader with useful pertinent information readily available as summarized in the Table of Contents List of References and the Index

Handbook of Molded Part Shrinkage and Warp Jerry Fischer, 2003-12-31 The handbook explains in plain terms why moldings shrink and warp shows how additives and reinforcements change the picture sets out the effect of molding process conditions and tells why you never can have a single correct shrinkage value But that s not all The handbook shows how to alleviate the problem by careful design of the molded part and the mold and by proper material selection It also examines computer aided methods of forecasting shrinkage and warpage And most important of all the handbook gives you the data you need to work with This is the most complete collection of shrinkage data ever made and includes an extensive compilation of hard to find multi point information on how processing part design mold design material and post mold treatment affect the part s final dimensions Manufacturers figures for thousands of grades along with an exhaustive search of magazines journals conference papers books web sites and brochures combine to make this a powerful resource A lot depends on a dimensionally correct molding Quality speed to market profit margins for the molder and toolmaker the efficiency of secondary and assembly operations reputation all these are on the line The Mold Shrinkage and Warpage Handbook is the book for people who have to live with shrinkage and warpage It is the only book for people who have to commit themselves

Injection Molding Advanced Troubleshooting Guide Randy Kerkstra, Steve Brammer, 2018 This highly practical troubleshooting guide solves problems at the machine systematically and quickly Drawing on a wealth of hands on experience from the authors who have built strong reputations in the field the book is structured by type of problem solution Thus it is an ideal reference to be consulted at the machine Included is valuable information on robust process windows cycle time evaluations scrap savings and runners gates with no existing standard in the industry No other book provides the unique insights found here

Injection Molding Handbook Donald V. Rosato, D.V. Rosato, 1995 This is an extensively revised and reorganized edition of the acknowledged standard work in the field of injection molding

Plastics Technician's Toolbox Allison R. Calhoun (Chemiker.), Jerry Golmanavich, 2002

Plastics World , 1997

Modern Plastics Encyclopedia , 1970

Plastics Materials and Processes Seymour S. Schwartz, Sidney H. Goodman, 1982

Thermoplastic Troubleshooting for Injection Molders Douglas M. Bryce, 1991

Troubleshooting Injection Molded Parts William J. Tobin, 1996

Plastics A. Brent Strong, 2000 An introduction to

plastics for a wide range of students who need to either gain improve or refresh their knowledge of plastic materials and manufacturing The text discusses both materials and manufacturing processes in a logical presentation While providing a fundamental overview of a broad spectrum of topics the text s high level of detail makes it valuable as both an introductory text and later a professional reference manual This edition features more logical organization dividing the previous tooling and testing chapters into tooling sections that appear within each of the processing chapters and testing sections that appear within each of the plastics properties chapters It shifts coverage of design to follow the chapters on properties giving an immediate example of how properties can be used and should allow students to flow more efficiently and effectively through the texts contents without digressions and interruptions

Engineers' Guide to Composite Materials John W. Weeton, Dean M. Peters, Karyn L. Thomas, 1987 *NASA Conference Publication* ,2000 **National Educators' Workshop. Update 1999: Standard Experiments in Engineering, Materials Science and Technology** ,2000 **Directory of Plastics Education and Training Programs in the U.S. and Canada** ,1998 *The Business of Injection Molding* Clare Goldsberry,1998

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