

Injection Molding Defect	Common Causes	Possible Solutions
Splay	<ul style="list-style-type: none"> Moisture in Molding Materials Excessive Temps During Injection Process Excessive Injection Speed 	<ul style="list-style-type: none"> Test and Dry Molding Materials Monitor / Adjust Temps During Injection Process Monitor / Adjust Injection Speed
Sink	<ul style="list-style-type: none"> Flawed Selection of Plastic Materials Inadequate Part / Mold Design Incorrect Cooling Temperature Excessive Injection Speed or Pressure 	<ul style="list-style-type: none"> Proper Material Selection Optimize Part / Mold Design Monitor / Adjust Cooling Temps Monitor / Adjust Injection Speed & Pressure
Contamination	<ul style="list-style-type: none"> Improper Storage and Handling of Plastic Materials Inadequate Cleaning and Maintenance of Equipment 	<ul style="list-style-type: none"> Proper Methods of Material Storage & Handling Proper Methods for Equipment Cleaning & Maintenance
Delamination	<ul style="list-style-type: none"> Improper Storage and Handling of Plastic Materials Flawed Selection of Plastic Materials Inadequate Cleaning and Maintenance of Equipment 	<ul style="list-style-type: none"> Proper Methods of Material Storage & Handling Proper Material Selection Proper Methods for Equipment Cleaning & Maintenance
Weld Lines	<ul style="list-style-type: none"> Inadequate Part / Mold Design Incorrect Cooling Temperature Excessive Injection Speed or Pressure 	<ul style="list-style-type: none"> Optimize Part / Mold Design Monitor / Adjust Cooling Temps Monitor / Adjust Injection Speed & Pressure
Short Shot	<ul style="list-style-type: none"> Insufficient Material Supply Inadequate Injection Pressure Improper Mold Venting Temps During Injection Process Too Low Injection Speed Too Slow 	<ul style="list-style-type: none"> Use Molding Machine with Optimal Shot Size Optimize Mold Design for Optimal Material Flow Monitor / Adjust Temps During Injection Process Monitor / Adjust Injection Speed & Pressure
Warp	<ul style="list-style-type: none"> Uneven Cooling Rates Ineffective Mold Design Flawed Selection of Plastic Materials 	<ul style="list-style-type: none"> Monitor / Adjust Cooling Temps Optimize Part / Mold Design Proper Material Selection
Burn Marks	<ul style="list-style-type: none"> Insufficient Venting Excessive Injection Speed Overly High Melt Temperature 	<ul style="list-style-type: none"> Insure that Mold has Correctly Sized and Placed Vent Channels Monitor / Adjust Injection Speed Monitor / Adjust Melting Temps
Blush	<ul style="list-style-type: none"> Rapid or Uneven Cooling Excessive Injection Speed or Pressure 	<ul style="list-style-type: none"> Monitor / Adjust Cooling Temps Monitor / Adjust Injection Speed
Scratches	<ul style="list-style-type: none"> Improper Product Handling and Packaging Improper Storage and Handling of Mold Improper Ejection Techniques 	<ul style="list-style-type: none"> Proper Method for Product Handling and Packaging Proper Method for Mold Storage and Maintenance Optimize Ejection Process
Voids	<ul style="list-style-type: none"> Uneven Cooling Inadequate Injection Speed or Pressure 	<ul style="list-style-type: none"> Monitor / Adjust Cooling Temps Monitor / Adjust Injection Speed
Flash	<ul style="list-style-type: none"> Excessive Material Supply Improper Tooling & Maintenance Improper Mold Set Up Inadequate Injection Pressure 	<ul style="list-style-type: none"> Proper Shot Size Selection Proper Mold Storage and Maintenance Proper Mold Setup Monitor / Adjust Injection Pressure

Injection Molding Troubleshooting Guide

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