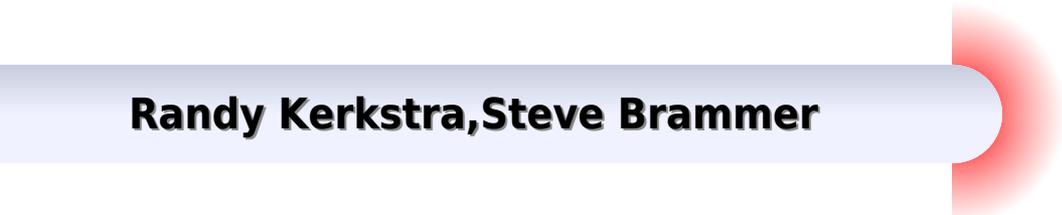


| Injection Molding Defect | Common Causes | Possible Solutions |
|--------------------------|--|--|
| Splay | <ul style="list-style-type: none"> Moisture in Molding Materials Excessive Temps During Injection Process Excessive Injection Speed | <ul style="list-style-type: none"> Test and Dry Molding 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

Randy Kerkstra, Steve Brammer



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

Injection Molding Troubleshooting Guide, 1996

Troubleshooting Injection Moulding Vanessa Goodship, 2004 Annotation Injection moulding is one of the most commonly used processing technologies for plastics materials Proper machine set up part and mould design and material selection can lead to high quality production This review outlines common factors to check when preparing to injection mould components so that costly mistakes can be avoided This review examines the different types of surface defects that can be identified in plastics parts and looks at ways of solving these problems Useful flow charts to illustrate possible ways forward are included Case studies and a large b257 of figures make this a very useful report

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

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 Handbook Dominick V. Rosato, Donald V. Rosato, Marlene G. Rosato, 2000 Provides reference information concerning the injection molding operation and each of its aspects It examines considerable technological advancements especially those in computer methods that have been made since the second edition was published

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

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

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The Business of Injection Molding Clare Goldsberry, 1998

Meat & Potatoes of Plastic Injection Moulding Danny Kerridge, 2019-07-18 At Last a ready reference guide to troubleshooting Plastic Injection Moulding with the reasons WHY we make those adjustments and what the adjustments affect As with my other books this is a simple step by step list of remedies to any injection moulding issue These step by step instructions have a cross reference to a section in the book that describes in detail exactly what you are doing and WHY

SPI Plastics Engineering Handbook of the Society of the Plastics Industry, Inc. Society of the Plastics Industry, 1991-08-08 The Plastics Engineering

Handbook provides a thorough description of all major plastics processing methods including theory and practice It offers a guide to materials selection product design and testing **Injection Molds and Molding** Joseph B. Dym,1979 Practical Guide to Plastics Applications Edward G. Crosby,Stephen N. Kochis,1972 **National Educators' Workshop. Update 1999: Standard Experiments in Engineering, Materials Science and Technology** ,2000

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