



Troubleshooting Guide for INJECTION MOLDING Phenolic & Granular Polyester

CORRECTIONS	PROBLEM												
	Mold Temperature	Injection Pressure	Holding Pressure	Injection Speed	Barrel Temperature	Screw Speed	Screw Back Pressure	Clamp Pressure	Shot Size	Hold Time	Cure Time	Refer to Comment Sheet	
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					3T	
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

Charles A. Harper



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 *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 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 Warpage 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 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

Handbook of Troubleshooting Plastics Processes John R. Wagner, Jr., 2012-09-19 This handbook provides a framework for understanding how to characterize plastic manufacturing processes for use in troubleshooting problems The 21 chapters are authored by well known and experienced engineers who have specialized knowledge about the processes covered in this practical guide From the Preface In every chapter the process is described and the most common problems are discussed along with the root causes and potential technical solutions Numerous case studies are provided that illustrate the troubleshooting process Mark A Spalding The Dow Chemical Company *Plastics Technician's Toolbox* Allison R. Calhoun (Chemiker.), Jerry Golmanavich, 2002 **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

Injection Molding: A Comprehensive Guide to Processing, Materials, and Troubleshooting Pasquale De Marco, 2025-04-24 Injection Molding A Comprehensive Guide to Processing Materials and Troubleshooting provides a comprehensive guide to injection molding covering all aspects of the process from material selection and mold design to process optimization and troubleshooting It offers a valuable resource for engineers technicians and professionals in the manufacturing industry who seek to deepen their understanding of injection molding and improve their skills in this field This book stands out with its focus on troubleshooting injection molding problems It provides a systematic approach to identifying and resolving common issues including material related mold related and process related defects Real world case studies are included to illustrate the troubleshooting process and help readers apply the concepts to practical scenarios In addition to the core injection molding process the book explores advanced techniques such as multi component injection molding insert molding gas assisted injection molding water assisted injection molding and in mold labeling These techniques are gaining popularity due to their ability to produce complex parts with high quality and efficiency One of the key strengths of this book is its focus on the latest developments and trends in injection molding It discusses Industry 4.0 and its impact on the injection molding industry as well as sustainable practices and emerging research areas This information helps readers stay up to date with the latest advancements and challenges in the field With its comprehensive coverage practical insights and focus on troubleshooting and advanced techniques Injection Molding A Comprehensive Guide to Processing Materials and Troubleshooting is an essential resource for anyone involved in injection molding It is a valuable addition to the libraries of engineers technicians and professionals seeking to improve their knowledge and skills in this dynamic and ever evolving industry If you like this book write a review on google books **Injection Molding Handbook** D.V. Rosato, Marlene G. Rosato, 2012-12-06 This third edition has been written to thoroughly update the coverage of injection molding in the World of Plastics There have been changes including extensive additions to over 50% of the content of the second edition Many examples are provided of processing different plastics and relating the results to critical factors which range from product design to meeting performance requirements to reducing costs to zero defect targets Changes have not been made that

concern what is basic to injection molding However more basic information has been added concerning present and future developments resulting in the book being more useful for a long time to come Detailed explanations and interpretation of individual subjects more than 1500 are provided using a total of 914 figures and 209 tables Throughout the book there is extensive information on problems and solutions as well as extensive cross referencing on its many different subjects This book represents the *ENCYCLOPEDIA on IM* as is evident from its extensive and detailed text that follows from its lengthy Table of CONTENTS and INDEX with over 5200 entries The worldwide industry encompasses many hundreds of useful plastic related computer programs This book lists these programs ranging from operational training to product design to molding to marketing and explains them briefly but no program or series of programs can provide the details obtained and the extent of information contained in this single sourcebook *Modern Plastics Encyclopedia*, 2004 *Troubleshooting Injection Molded Parts* William J. Tobin, 1996 *Plastics World*, 1997 *Thermoplastic Troubleshooting for Injection Molders* Douglas M. Bryce, 1991 *Meat & Potatoes of Plastic Injection Moulding* Danny Kerridge, 2014-12-29 This book is more than just a Troubleshooting Card within the boundaries of the book lies insights into Troubleshooting the causes the whys how material flows through a mould and what you can do to influence it This book also includes the Troubleshooters Ultimate guide to Troubleshooting faulty mouldings Although the book includes in depth explanations on moulding faults and how to counteract them it is not designed to explain a complete Die Trialling experience This book is taking for granted that the moulding or process in question has been previously set up and run successfully It WILL give a never before explained insight into what is happening within the process and what you can do to get back on track Do not concern yourself about the speed of the troubleshooting Like everything else the more you format your approach the smoother thereby the speed of the troubleshooting and getting to the root cause of the fault will become evident Frequently peruse these books to rekindle the correct way to conduct yourself thereby showing your boss what you are all about From Confidence Competency is elevated

Plastics Materials and Processes Seymour S. Schwartz, Sidney H. Goodman, 1982 **Basics of Troubleshooting in Plastics Processing** Muralisrinivasan Natamai Subramanian, 2011-04-20 The Basics of Troubleshooting in Plastics Processing is a condensed practical guide that gives the reader a broad introduction to properties of thermoplastics plastics additives the major processes extrusion injection molding rotational molding blow molding and thermoforming as well as troubleshooting The main goal is to provide the plastics processor with an improved understanding of the basics by explaining the science behind the technology Machine details are minimized as the emphasis is on processing problems and the defects in an effort to focus on basic root causes to problems and how to solve them The book s framework is troubleshooting in plastics processing because of the importance it has to the eventual production of high quality end products Each chapter contains both practical and detailed technical information This basic guide provides state of the art information on Processing problems and defects during manufacturing Plastics materials their properties and

characterization The plastics processing techniques Plastics additives Troubleshooting of the 5 main plastics processes
References for further reading

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