


Suggestion Guide For Common Injection Moulding Problems

 Unit 5, Argyle Comm. Centre Argyle Street, Swindon Wiltshire, SN2 8AR. Tel: 01793 – 64 10 40 Moulding Fault ↓	Suggested Remedy ↓																			
	Injection pressure	Barrel temperature	Holding pressure & time	Nozzle temperature	Screw speed	Injection speed	Back pressure	Mould temperature	Gate size	Tool venting	Material Dry ?	Material / Contamination ?	Bridging at throat ?	Machine capacity ?	Back zone temp.	Throat cooling ?	More blending required or Temp. control ?	Heat in feed zone or Usage rate	Screw & barrel ok ?	More heat stable concentrate needed or m/c temp. control ok?
<i>Black streaks or spots</i>		-		-								?							?	?
<i>Brittleness</i>	-	-	-		-	-	?			+	?	?								
<i>Burning</i>	-	-	-	-	-	-			+	+	?	?								?
<i>Cloudy appearance</i>		+						+			?	?								
<i>Colour variation shot to shot</i>		-											?		-		?	-		?
<i>Ejection difficulties</i>	-	-	-			-	-													
<i>Flashing</i>	-	-	-		-	-	-	-	+		?									
<i>Gate Splay</i>	-	-	-			+		+	+	+	?				?					?
<i>Gloss</i>	+	+				+		+		+	?									
<i>Jetting</i>	±	+	±	+		±	+	+	+	+	?	?		?						
<i>Lamination</i>		+		+	+	±	±	+	+		?	?						-		
<i>Loss of colour</i>													?					-		?
<i>Orange skin</i>	+	+	+			+		+	+											
<i>Parts oversize</i>	-	-	-					+				?								
<i>Parts sticking in</i>	-	-	-			-		-												
<i>Parts undersize</i>	+	+	+			+	+	-	+											
<i>Poor distribution</i>		+			-		+				?		?	?	-		?	-		
<i>Screw not returning</i>		±			+		-				?		?		-	?		-		
<i>Screw slip</i>		-					-											-		
<i>Short shot</i>	+	+	+	+		+	+	+	+					?						
<i>Silver streaks</i>		-		-		-			+		?	?								
<i>Sinking & voids</i>	+	±	+	±		-	-	-	+	+				?						
<i>Visible weld lines</i>	+	+	+	+	+	+	+	+	+	+	?	?								
<i>Warpage</i>	-	±	-			+	+	±												

Key: + = Increase - = Decrease ± = Try Increasing or Decreasing ? = Check

Note: Due to the wide range of options and materials available, this information is for use as a guide only and is supplied in good faith without obligation or liability.

For further assistance with any of the following areas, please contact us at the above address or alternatively using :-

- ♦ 3d Cad & Cam Design
- ♦ Toolmaking
- ♦ Injection Moulding
- ♦ Custom & Standard Antistatic Vacuum Formed Parts
- ♦ Mould Filling Analysis
- ♦ Assembly
- ♦ Pad & Hot Foil Printing
- ♦ Ultrasonic Welding

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