

Troubleshooting Guide for INJECTION MOLDING Phenolic & Granular Polyester

PROBLEM	CORRECTIONS											
	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

Troubleshooting Guide For Injection Molding Bmc Corrections

Marco Cascella



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SPI/CI 52nd Annual Conference and Exposition 1997 Technomic, Spi, Institution of Civil Engineers, 2022-01-26 This book is a collection of the marketing technical regulatory sessions of the Composites Institute s International Composites EXPO 97 held at Nashville Tennessee on January 27 29 1997 **Plastics Technology** ,1988 *Applied Science & Technology Index* ,1984 **Thomas Register of American Manufacturers** ,2003 Vols for 1970 71 includes manufacturers catalogs

Thomas Register ,2004 **Injection Molding Advanced Troubleshooting Guide** Randy Kerkstra, Steve Brammer (Chemical engineer), 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 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](#) ,1996 **Troubleshooting Injection Molded Parts** William J. Tobin, 1996 **Compression**

Molding Bruce Allen Davis, Paul J. Gramann, 2003 The compression molding process is well known for its ability to produce highly complex high strength parts This book not only covers the advantages and disadvantages of the molding operation with SMC BMC thermosetting and GMT LFT thermoplastic materials it also provides the reader with relatively simple models for monitoring troubleshooting and quality control of their processes **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 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

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

On the Road with Bob Hatch Bob Hatch, 1997 **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 *Handbook of Molded Part Shrinkage and Warpage* Jerry Fischer, 2012-12-31 How easy life would be if only moldings were the same size and shape as the mold But they never are as molders toolmakers designers and end users know only too well Shrinkage means that the size is always different warpage often changes the shape too The effects are worse for some plastics than others Why is that What can you do about it The Handbook of Molded Part Shrinkage and Warpage is the first and only book to deal specifically with this fundamental problem Jerry Fischer's 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 explains why you never can have a single correct shrinkage value It goes on to demonstrate how to alleviate the problem through 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 Authoritative and rooted in extensive industrial experience the expert guidance contained in this handbook offers practical understanding to novices and new insights to readers already skilled in the art of injection molding and mold making Contains the answers to common problems and detailed advice on how to control mold and post mold shrinkage and warpage Case Studies illustrate and enrich the text Data tables provide the empirical data that is essential for success but hard to come by Plastics Technician's Toolbox Allison R. Calhoun (Chemiker.), Jerry Golmanavich, 2002 **Total Quality Process Control for Injection Molding** M. Joseph Gordon, Jr., 2010-03-25 The all encompassing guide to total quality process control for injection molding In the same simple easy to understand language that marked the first edition Total Quality Process Control for Injection Molding Second Edition lays out a successful plan for producing superior plastic parts using high quality controls This updated edition is the first of its kind to zero in on every phase of the injection molding process the most commonly used plastics manufacturing method with an all inclusive strategy for excellence Beginning with sales and marketing then moving forward to cover finance purchasing design tooling manufacturing assembly decorating and shipping the book thoroughly covers each stage to illustrate how elevated standards across individual departments relate to result in the creation of a top notch product This Second Edition Details ways to improve plastic part design and quality Includes material and process control procedures to monitor quality through the entire manufacturing system Offers detailed information on machinery and equipment and the implementation of quality assurance methods content that is lacking in similar books Provides problem analysis techniques and troubleshooting procedures Includes updates that cover Six Sigma ISO 9000 and TS 16949 which are all critical for quality control computer guided process control techniques and lean manufacturing methods With proven ways to problem solve increase performance and ensure customer satisfaction this valuable guide offers the vital information today's managers need to plan and implement quality process control and produce

plastic parts that not only meet but surpass expectations *Meat and Potatoes of Plastic Injection Moulding* Danny Kerridge, 2014-12-28 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 *Practical Guide To Injection Blow Molding* Samuel L. Belcher, 2007-03-05 Taking a straight forward approach the Practical Guide to Injection Blow Molding explores the entire industry from conception design costing tooling and machinery to trouble shooting testing and daily production With information for both the novice investor and the plastic industry expert this concise text is reinforced with pictures charts and figures The author a highly knowledgeable industry insider and a member of The Plastics Hall of Fame discusses the history of the industry as well as its daily workings He instructs in product and tooling design as well as material and machine selection explaining advantages and disadvantages elaborating on efficiencies that can be realized

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