

The numbers stand for the sequence in which operations should be tried, and the arrows indicate either an increase in the setting, a decrease in the setting, or the necessity to balance the setting.

MACHINE DEFECTS							PART DEFECTS																				
Numbers indicate sequence of making corrective steps. Arrows indicate: ↑ - Increase ↓ - Decrease ± - Balance/Vary							Excessive Flash	Overfilled Part	Part Sticking	Short Shot	Sprue Sticking	Undersized Part															
													Black Spots, Brown Streaks	Blinders	Brittleness	Burn Marks	Cracking, Cratering	Delamination	Distortion	Flow Marks	Jacking	Poor Surface Finish (Gloss)	Poor Weld Lines	Shore Breaks, Spring, Splash	Sink Marks	Voids	Warping
MACHINE VARIABLES	Backpressure	5			6			1	2	3						4								7			
	In. Forward (Booster) Time		2	3		2	3			4																	
	Clamp Pressure	2	8																								
	Cylinder Temperature	2	5	6							2		2	1		2		3									
	Holding Pressure		4	2																			2	3			
	Injection Hold Time	4		7	9	2	5																			3	
	Injection Pressure	1	3	1	2	1	2								4	5	5			2	1		2	3		4	
	Injection Speed	6	1	8	6	8	5	1			1	2	4		5	1	1	4	5	5	4	6	6				
	Shot Size (Material Feed)					1																		1	1		
	Melt Temperature					2								3	4	1	2		2				5	5	5		
	Mold Cooling Time			4			4	9																		2	
	Mold Temperature	7	6	5	5		7							2		3	4	1		2	2	1	4	6	4	1	
	Nozzle Temperature					4	8																				
	Overall Cycle Time		7											4										7			
MOLD VAR.	Screw Speed													1	3									8			
	Change Gate Location													6							5	7	7		13	11	7
	Size of Gate					11		8								6				6	4			8	10	9	6
	Size of Sprue/Runner					10																		9	8		
OTHER ACTION	Size of Vent	10				7								7		8		7					5	6			
	Check for Material Contamination												2		7				3	6				2			
	Check Fit of Mold Faces	9																									
	Clean Cavity Surface																						6				
	Clean Mold Faces	8																									
	Clean Vents					12																				7	
	Dry Materials													5	5		6	5					8	1	11	10	
	Regrind Quantity														6			6							12		
Purge/Clean Screw & Barrel													1					1									

Injection Molding Troubleshooting Guide

Rachel S Tattersall



Injection Molding Troubleshooting Guide:

Injection Molding Troubleshooting Guide Book Review: Unveiling the Power of Words

In a world driven by information and connectivity, the power of words has become more evident than ever. They have the ability to inspire, provoke, and ignite change. Such could be the essence of the book **Injection Molding Troubleshooting Guide**, a literary masterpiece that delves deep in to the significance of words and their affect our lives. Compiled by a renowned author, this captivating work takes readers on a transformative journey, unraveling the secrets and potential behind every word. In this review, we will explore the book is key themes, examine its writing style, and analyze its overall impact on readers.

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