### PROSPECTOR\*

# TROUBLESHOOTING CHART (UL)

	MACHINE DEFECTS										PART DEFECTS													
Numbers indicate sequence of making corrective steps; Arrows indicate 1 - Increase 2 - Decrease 2 - Balance/Vary		Expressive Flash	Oversignal Part	Pet Skiking	Short Shot	Sprue Stoking	Understand Part	But forts from Strain	Bishes	Billiness	Burn Marts	Cucking Coaing	Defamination	Distribution	Flow Marks	Anny	Paor Sorbers Finish (Stone)	Page Weld Lines	Hear Dresdes, Spiny, Spinsh	Sink Marks	Veids	Maraina		
	Backgressure	51			81			154	211	24				4.1						77				
	inj. Forward (Booster) Time.		25	34		34	37				40													
	Clamp Pressure	131	MT.																					
	Cylinder Temperature	125	164	65			47					20		25	17		31		35					
23	Holding Pressure		44	25			47													37	31			
展	Injection Hold Time	44		25	97	21	157											37				31		
1000	Injection Pressure	114	34	111	25	15	25			41	54	50			41		71	31		75	25	42		
	Injection Speed	164	11	8.	47	16.1	11				11.	31	41		16.5	34	47	67	44	167	184			
X	Shot Size (Material Feed)	T-			10																17			
園	Melt Temperature			100	37	- 112	1.00	54	45	11	25		31			311		31		54	54	181		
100	Mold Cooling Time			40		4	36										-87					21		
	Mold Temperature	77	61	54.	197		7.		35		34	41	41		27	31	11	47	47	4.	41	Ti		
	Nozzie Temperature			100	47	6.3						35		34	35				34					
Ш	Overall Cycle Time		75			1.00		44						54					75	100				
	Screw Speed								15	34										87				
10	Change Gate Location	$\equiv$							-6							5.	7	7			11			
18	Size of Gate				317		87				67				47	47			87	101	40	87		
2	over or oppositionner				10										77					97	81			
36	Size of Vert	103			71				77		67			71			97	6"						
	Check for Material Contamination							2.		7			-3	-6					2					
	Check Fit of Mold Faces	15																						
5	Clean Cavity Surface																-6							
151	Clean Mold Faces	1.																						
2	Clean Vents				12						7										7			
18									.5			6-	5					- 8	-10	111		11		
8										6.			64							125				
	PurgerClean Screw & Barrel							1 1						1										

## **Injection Molding Troubleshooting Guide Pvc**

**R Sandford** 

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