

INJECTION MOLDING TROUBLESHOOTING REFERENCE GUIDE

| Problem / Effect | Injection Pressure | Cycle Time | Injection Hold Time | Recirculation Gate Size | Gate Last Length | Nozzle Opening | Adjust Feet | Clamp Pressure | Back Temp | Heat Temp | Injection Speed | Injection Time | Gate Pressure | Gate Temp | Nozzle Heating Band | Control Action |
|------------------------|--------------------|------------|---------------------|-------------------------|------------------|----------------|-------------|----------------|-----------|-----------|-----------------|----------------|---------------|-----------|---------------------|----------------|
| Wash at Gate | ▲ | | | ▲ | | | | | ◆ | ▲ | ▼ | | | | | |
| Wrinkles | | | | | | | | | ▼ | ▲ | ▼ | ▼ | ▼ | ▲ | | ⊗ |
| Gate Sticking | | | | ▲ | ▼ | | | | ◆ | ▲ | ▼ | ▼ | ▲ | | ⊗ | ⊗ |
| Flash | ▼ | | ▼ | | | | | ▲ | ▼ | ▼ | ▼ | ▼ | ▼ | | | |
| Jacking | | | | ▲ | ▼ | ▲ | | | ◆ | ▲ | ▼ | | | | ⊗ | |
| Distortion | ▼ | | | | ▼ | ▲ | | | ▲ | ▲ | ▼ | | | | | ⊗ |
| Part Shrink, Stability | ▲ | | ▲ | ▲ | | | | | ◆ | ◆ | | | | | | |
| Part Surface Finish | ▲ | | | ▲ | | | | | ▼ | ▲ | | | | | | |
| Short Shot | ▲ | ▲ | | ▲ | ▼ | | ◆ | | ▲ | ▲ | ▲ | | | | | |
| Sink Marks | ▲ | | ▲ | ▲ | ▼ | | ◆ | | ▼ | ▼ | | | ▲ | ▲ | | |
| Spoke Sticking | ▼ | ▲ | ▼ | | | | | | | ▼ | | | | | ⊗ | ⊗ |
| Shrink in Cavity | ▼ | ▲ | ▼ | | | | ◆ | | ▼ | ▼ | | | | | | |
| Warpage | ▼ | ▲ | | | | | | | ▼ | ▼ | ▼ | | ▼ | | | |
| Weld Marks | ▲ | | ▲ | | | | ◆ | | ▼ | ▼ | | | | ▲ | | |
| Weld Mark | ▲ | | ▲ | ▲ | | | | | ▲ | ▲ | ▲ | | | ▲ | | |
| Weld Marks | ▼ | | | ▲ | | ▲ | | | ◆ | | ▼ | ▼ | ▼ | ▲ | | |

Check the key variables in the order indicated by the numbers.



Plastic Injection Molding Troubleshooting Guide

David Kirk



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