

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

Clemens Wendtner



Plastic Injection Molding Troubleshooting Guide:

Eventually, you will utterly discover a supplementary experience and attainment by spending more cash. nevertheless when? get you consent that you require to acquire those all needs taking into consideration having significantly cash? Why dont you attempt to get something basic in the beginning? Thats something that will lead you to comprehend even more with reference to the globe, experience, some places, next history, amusement, and a lot more?

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lathe machine are as follows bed lead screw guideways prime mover transmission system headstock spindle chuck feed gearbox thread chasing dial split nut carriage slideways with saddle compound rest toolpost

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