

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
Block at Gate	▲			▲					◆	▲	▼					
Brittleness									▼	▲	▼	▼	▼	▲		⊗
Color Streaks				▲	▼				◆	▲	▼	▼	▲		⊗	⊗
Flash	▼		▼					▲	▼	▼	▼	▼	▼			
Jacking				▲	▼	▲			◆	▲	▼				⊗	
Overcontamination	▼				▼	▲			▲	▲	▼					⊗
Part Shrink, Stability	▲		▲	▲					◆	◆						
Part Surface Finish	▲			▲					▼	▲						
Short Shots	▲	▲		▲	▼		◆		▲	▲	▲					
Sink Marks	▲		▲	▲	▼		◆		▼	▼			▲	▲		
Spoke Missing	▼	▲	▼							▼					⊗	⊗
Striving to Empty	▼	▲	▼				◆		▼	▼						
Warpage	▼	▲							▼	▼	▼		▼			
Weld Marks	▲		▲				◆		▼	▼				▲		
Weld Mark	▲		▲	▲					▲	▲	▲			▲		
Weld Marks	▼			▲		▲			◆		▼	▼	▼	▲		

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



Plastic Injection Molding Troubleshooting Guide

L Cohen



Plastic Injection Molding Troubleshooting Guide:

Uncover the mysteries within Crafted by is enigmatic creation, Embark on a Mystery with **Plastic Injection Molding Troubleshooting Guide** . This downloadable ebook, shrouded in suspense, is available in a PDF format (PDF Size: *). Dive into a world of uncertainty and anticipation. Download now to unravel the secrets hidden within the pages.

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