

# INJECTION MOLDING TROUBLESHOOTING REFERENCE GUIDE

Problem / Effect	Injection Pressure	Cycle Time	Injection Hold Time	Recirculation Gate Size	Gate Last Length	Recirc Opening	Adjust Feet	Clamp Pressure	Back Temp	Hot Temp	Injection Speed	Injection Time	Gate Pressure	Gate Temp	Recirc Weighted Feed	Control Action
Wash at Gate	▲			▲					◆	▲	▼					
Wrinkles									▼	▲	▼	▼	▼	▲		⊗
Gate Sticking				▲	▼				◆	▲	▼	▼	▲		⊗	⊗
Flash	▼		▼					▲	▼	▼	▼	▼	▼			
Jacking				▲	▼	▲			◆	▲	▼				⊗	
Distortion	▼				▼	▲			▲	▲	▼					⊗
Part Shrink, Stability	▲		▲	▲					◆	◆						
Part Surface Finish	▲			▲					▼	▲						
Short Shots	▲	▲		▲	▼		◆		▲	▲	▲					
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

**S Marginson**



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force acting on an object work done on an object transfers energy to the object the translational kinetic energy of an object of mass  $m$  moving at speed  $v$  is  $\frac{1}{2}mv^2$  the work energy theorem states that the net

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web mar 10 2023 the rate at which work is performed is known as power this is a measure of energy consumed per unit of

time formula  $p = \frac{w}{t}$  where  $p$  power  $w$  work done  $t$  time taken definition of work energy theorem the work done on a body by applying force is equal to the change in kinetic energy of the body this is defined as work

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