

**Troubleshooting Guide for INJECTION MOLDING Phenolic & Granular Polyester**

| CORRECTIONS                   | PROBLEM          |                    |                  |                 |                    |             |                     |                |           |           |           |                        |  |
|-------------------------------|------------------|--------------------|------------------|-----------------|--------------------|-------------|---------------------|----------------|-----------|-----------|-----------|------------------------|--|
|                               | Mold Temperature | Injection Pressure | Holding Pressure | Injection Speed | Barrel Temperature | Screw Speed | Screw Back Pressure | Clamp Pressure | Shot Size | Hold Time | Cure Time | Refer to Comment Sheet |  |
| Ball & Socket                 | 3D               | 2I                 | 2I               | 1D              |                    |             |                     |                |           |           |           | 4A                     |  |
| Bulge Opposite Insert         | 3I               |                    |                  |                 | 4I                 |             | 4I                  |                |           |           |           | 1B & 2C                |  |
| Cure Blister                  | 2I               |                    |                  | 4D              | 1I                 |             | 1I                  |                |           |           | 3I        |                        |  |
| Dull Appearance               | 1I               |                    |                  |                 | 2I                 |             | 2I                  |                |           |           |           | 3E & 4Y                |  |
| Flash - Excessive             | 4I               | 2D                 | 2D               |                 | 3I                 |             | 3I                  | 6I             | 1D        |           |           | 5F                     |  |
| Flow Lines                    | 4D               | 2I                 | 2I               | 1I              | 5D                 |             | 5D                  |                |           | 3I        |           | 6A                     |  |
| Hard Spots                    | 4D               | 2D                 | 2D               | 3D              | 1D                 |             | 1D                  |                |           |           |           | 5H                     |  |
| Injection Too Slow            |                  | 1I                 |                  | 2I              | 3I                 |             | 3I                  |                |           |           |           | 4K                     |  |
| Mold Staining                 | 4I               | 5D                 | 5D               | 6D              | 3I                 |             | 3I                  | 7D             |           |           |           | 1U & 2Y                |  |
| Mottled Surface Appearance    | 3D               |                    |                  |                 | 2D                 |             | 2D                  |                | 1I        |           |           |                        |  |
| Nonfills or Short Shots       | 4D               | 3I                 | 3I               |                 | 2I                 |             | 2I                  |                | 1I        |           |           | 5U & 6G                |  |
| Nozzle Freezes Up             | 1D               |                    |                  |                 | 2D                 |             | 2D                  |                |           |           |           | 3H                     |  |
| Orange Peel                   | 3I               | 1I                 | 1I               | 4D              | 2I                 |             | 2I                  |                |           |           |           |                        |  |
| Rubbery Parts or Runner       | 1I               |                    |                  |                 | 2I                 |             | 2I                  |                |           |           |           | 3AA                    |  |
| Screw Does Not Go "Home"      |                  | 2I                 | 2I               |                 | 5D                 |             | 5D                  |                | 3D        |           |           | 1J, 4W & 6K            |  |
| Screw Pickup is Erratic       |                  |                    |                  |                 | 1I                 | 2D          | 1I                  |                |           |           |           | 3M & 4G                |  |
| Screw Pickup is Too Slow      |                  |                    |                  |                 | 2D                 | 1I          | 2D                  |                |           |           |           | 3T                     |  |
| Part Shrinkage - Excessive    | 2I               | 1I                 | 1I               |                 | 3I                 |             | 3I                  |                |           |           | 5I        | 4U                     |  |
| Part Shrinkage - Insufficient | 1D               |                    | 2D               |                 |                    |             |                     |                |           |           | 4D        | 3V                     |  |
| Sink Marks                    | 2I               | 3I                 | 3I               | 4D              |                    |             |                     |                | 1I        |           |           | 5U                     |  |
| Skin Blisters                 | 3D               |                    |                  | 1D              |                    |             |                     |                | 2D        |           |           | 4U                     |  |
| Sprue Sticking                |                  | 3D                 | 2D               |                 |                    |             |                     |                |           |           |           | 1N, 4H & 5X            |  |
| Sticking in Mold              | 3I               |                    | 2D               |                 |                    |             |                     |                | 4D        |           | 6I        | 1P & 5E                |  |
| Subgates Sticking in Mold     |                  |                    |                  |                 |                    |             |                     |                |           |           |           | 1BB, 2CC & 3DD         |  |
| Trapped Gas                   | 6D               | 5D                 | 5D               | 4D              | 3D                 |             | 3D                  | 7D             |           |           |           | 1EE 2U & 8Z            |  |
| Warpage When Ejected          |                  |                    |                  |                 |                    |             |                     |                |           |           |           | 1P, 2E, 3R & 4V        |  |
| Warpage After Cooling         | 1I               |                    |                  | 3D              | 2I                 |             | 2I                  |                |           |           | 5I        | 4U, 6S & 7A            |  |
| Wood Screwing                 |                  |                    |                  |                 | 2D                 | 3D          | 1I                  |                |           |           |           |                        |  |

Legend: Number = Priority I = Increase D = Decrease Other Letters = Comment ID

# Injection Molding Troubleshooting Guide

**Judd E. Hollander**



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