

## Troubleshooting Guide for INJECTION MOLDING Phenolic & Granular Polyester

| PROBLEM                       | CORRECTIONS      |                    |                  |                 |                    |             |                     |                |           |           |           |                        |
|-------------------------------|------------------|--------------------|------------------|-----------------|--------------------|-------------|---------------------|----------------|-----------|-----------|-----------|------------------------|
|                               | 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

**Charles A. Harper**



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web apr 3 2023 1 keep the introduction under 1 minute remember that you are there to introduce the guest speaker and that your introduction is just the precursor to the main talk keep your piece to about 30 to 40 seconds a minute at most a few short paragraphs are usually enough to set the stage

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