

## 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

**Charles A. Harper**



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