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Decrease injection fill rate Molded in stress due to low stock temperature and cold mold Minimize hot spots in mold Flow too long, insufficient gates Change gate location 6. Burning Compressed air in the mold degrades resin Decrease peak cavity pressure (decrease fill rate and/or use profile injection)

Troubleshooting Guide for Injection Molding

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Injection Molding Troubleshooting Guide

Process: (1) Increase injection pressure and injection speed to enhance shear heat (2) Increase the amount of injection (3) Increase material cylinder temperature and mold temperature. 2. Air Traps. Air traps is that air is trapped in the cavity to create bubbles in the part.

13 Plastic Injection Molding Defects and How to Fix Them

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The Injection Moulding Troubleshooting Guide covers some of the common problems encountered with this process, but is by no means complete. Conditions are variable and include: machine used, machine setup, mould type and complexity, materials and manufacturing environment. Specific conditions cannot be anticipated.

Injection Moulding Troubleshooting | HMC Polymers

Sample Pages Injection Molding Advanced Troubleshooting Guide Randy Kerkstra Steve Brammer ISBN (Book): 978-1-56990-645-3 ISBN (E-Book): 978-1-56990-646-0

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Practical Guide to Injection Moulding - Dynacure

Molding Troubleshooting Guide Bond Readout Bond readout is a surface distortion similar to a hump or sink that occurs over a bond line Probable Cause Material Process • Mismatch of compliance between outer panel, inner panel and adhesive • Incompatible thermal expansion coefficients between the SM and the adhesive

TROUBLESHOOTING MOLDING PROBLEMS

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Process- Insufficient injection pressure/ injection rate
insufficient material feed Excessive cooling of the melt Mould-
Unbalanced multi-cavity mould Insufficient air venting blocks
resins flow Runners, gates, or vents too small Material flow
length too long. Material- Material viscosity too high Foreign
material clogging nozzle and/ or gates Mould temperature too
low Machine- Feed hopper blocked Barrel has no resins left
Undersized cylinder heating capacity Material leaks/ back
flow.

Basic Injection Moulding Trouble Shooting Guide

Place vents at last place to fill and at converging flow fronts.
Increase size of the vents. Too cool a melt. Increase the melt
and/or mold temperature. Increase injection speed. Part
Shorts. and has burn marks. Gas trapping/ poor venting.
Improve venting and/or relocate to burned area.

Injection Molding: Troubleshooting | Avient

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Title: Injection Molding Advanced Troubleshooting Guide
Author: Kerkstra, Randy and Brammer, Steve Year: 2018
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