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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)

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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

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.

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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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7.1.3.2 Injection Moulding 108 7.1.4 Screw Injection Machine for Thermosets 109 7.1.5 Mould 109 7.1.6 Guide Values for Cylinder and Mould Temperature Settings 109 7.1.7 The Injection Unit for Granulated Thermosets 111 7.1.8 The Injection Unit for Processing Moist Polyester 111 7.1.9 Nozzle Temperature (if nozzle heating is applied) 111

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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