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~~Part 1 - Scientific Troubleshooting~~

Page 4/41

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FIOW LINES INJECTION

MOLDING ~~WELD LINE IN~~

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Injection Molding with 3D Printing

- How It's Used Injection Molding

Animation ~~First-time INJECTION~~

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~~injection molding. Simple Silicone~~

~~Rubber Molds (no parting line) -~~

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Molding Machines: Sizing the
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Making Injection Molding
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Molding Troubleshooting

Troubleshooting Guide. Cracking
Crazing Black Specks or Streaks.
Problem. Delamination. Problem.
Gloss (Low) Blisters Blush Bowing
Bubbles. Source(s) Cause(s)
Machine Excessive residence time
in barrel Hang-up of molten
material in injection barrel or

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Decrease injection fill rate Molded

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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

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Cracking Craze Black
Specks or Streaks. Problem.
Delamination. Problem. Gloss
(Low) Blisters Blush Bowing
Bubbles. Source(s) Cause(s)
Machine Excessive residence time
in barrel Hang-up of molten
material in injection barrel or

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runner system Contamination of
injection barrel Degradation due to
malfunctioning heater bands or
thermocouples Defective nozzle
shutoff mechanism Inefficient
injection conditions Cracked
injection cylinder or pitted screw
Oil ...

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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

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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,

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materials and manufacturing environment. Specific conditions cannot be anticipated.

Injection Moulding
Troubleshooting | HMC Polymers
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Randy Kerkstra Steve Brammer

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Sample Pages Injection Molding
Advanced Troubleshooting Guide
7.1.3.2 Injection Moulding 108

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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

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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

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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

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**TROUBLESHOOTING MOLDING
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**Injection Molding Reference Guide
Materials, Design, Process
Optimization, Troubleshooting and
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Page 27/41

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Plastics is a sophisticated and diverse discipline. To excel, you need a good grasp of a wide range of concepts and data. That ' s what this Injection Molding Reference Guide is all about.

Scientific Molding Pocket Guide -

Page 28/41

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Injection Molding Troubleshooting
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Process- Insufficient injection

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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

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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.

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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

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Molding Troubleshooting

marks. Gas trapping/ poor venting.
Improve venting and/or relocate to
burned area.

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Troubleshooting Guide Author:
Kerkstra, Randy and Brammer,
Steve Year: 2018 Pages: 511

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personnel who work in the
injection molding field including
press operators, technicians,
engineers, etc.

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information is most useful by personnel who work in the injection molding field including press operators, technicians, engineers, etc.

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