



Troubleshooting Guide for INJECTION MOLDING Phenolic & Granular Polyester

PROBLEM	CORRECTIONS											Refer to Comment Sheet
	Mold Temperature	Injection Pressure	Holding Pressure	Injection Speed	Barrel Temperature	Screw Speed	Screw Back Pressure	Clamp Pressure	Shot Size	Hold Time	Cure Time	
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					3I
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

Plastic Injection Molding Troubleshooting Guide

M Lipman



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Table of Contents Plastic Injection Molding Troubleshooting Guide

1. Understanding the eBook Plastic Injection Molding Troubleshooting Guide
 - The Rise of Digital Reading Plastic Injection Molding Troubleshooting Guide
 - Advantages of eBooks Over Traditional Books
2. Identifying Plastic Injection Molding Troubleshooting Guide
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Plastic Injection Molding Troubleshooting Guide
 - User-Friendly Interface
4. Exploring eBook Recommendations from Plastic Injection Molding Troubleshooting Guide

- Personalized Recommendations
 - Plastic Injection Molding Troubleshooting Guide User Reviews and Ratings
 - Plastic Injection Molding Troubleshooting Guide and Bestseller Lists
5. Accessing Plastic Injection Molding Troubleshooting Guide Free and Paid eBooks
 - Plastic Injection Molding Troubleshooting Guide Public Domain eBooks
 - Plastic Injection Molding Troubleshooting Guide eBook Subscription Services
 - Plastic Injection Molding Troubleshooting Guide Budget-Friendly Options
 6. Navigating Plastic Injection Molding Troubleshooting Guide eBook Formats
 - ePub, PDF, MOBI, and More
 - Plastic Injection Molding Troubleshooting Guide Compatibility with Devices
 - Plastic Injection Molding Troubleshooting Guide Enhanced eBook Features
 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Plastic Injection Molding Troubleshooting Guide
 - Highlighting and Note-Taking Plastic Injection Molding Troubleshooting Guide
 - Interactive Elements Plastic Injection Molding Troubleshooting Guide
 8. Staying Engaged with Plastic Injection Molding Troubleshooting Guide
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Plastic Injection Molding Troubleshooting Guide
 9. Balancing eBooks and Physical Books Plastic Injection Molding Troubleshooting Guide
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Plastic Injection Molding Troubleshooting Guide
 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
 11. Cultivating a Reading Routine Plastic Injection Molding Troubleshooting Guide
 - Setting Reading Goals Plastic Injection Molding Troubleshooting Guide
 - Carving Out Dedicated Reading Time
 12. Sourcing Reliable Information of Plastic Injection Molding Troubleshooting Guide

- Fact-Checking eBook Content of Plastic Injection Molding Troubleshooting Guide
 - Distinguishing Credible Sources
13. Promoting Lifelong Learning
- Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
14. Embracing eBook Trends
- Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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materialvorlagen zu ganz unterschiedlichen themenbereichen und gestaltungstechniken die projekte sind