Composites International Europe

TROUBLESHOOTING - COMPRESSION

COMPRESSION

PROBLEMS \ POSSIBLE CAUSES	Non uniform thickness	Poor surface tool	Tool not chromed	Undercut	Ejector Area too low	Ejector quantity too low	Ejection speed too fast	Parallelism or deflection problem	Temperature heterogeneity	Temperature too low	Temperature too high	Temperature differential between core and cavity too low	Mold closure speed too low	Mold closure speed too high	New tool	Cure time too low	SMC exposition to the air too long	SMC charge pattern too big	SMC charge pattern too small	Bas SMC charge pattern locating	SMC charge pattern with separate charges	Moulding pressure too low	Moulding pressure too high	SMC to old	Design hole	Molding on stop pads	Pollution in workshop	Shear edges too tight	Stop pads to be cleaned	Inversion core and cavity	Unsuited SMC quantity
Abrasion		2	1																3												
Mold adhesion		2	1	3					4					1	4	5															5
Arrachement		1		1				2																							
Too much flashes																										1					
Blisters (smaal & big)									2			3			2		1		1	2								3			
Non complete curing								2	1						1																
Distorsion Warpage		1											2					2				3									
Rib read-out sinkmarks																					2			1				1			
Delamination									2			3			2		1		1									3			
Deposit on mould surface scumming		1							2												2										
Dieseling					3	3							1				2									2					
Surface cracks	4			3	1	1	1	3														3									
Fracture cracks	4			3	1	1	1	3														3									
Gloss heterogeneity		1						2																2			2				
Colour heterogeneity												2					1	1	2												
Dull surface		2	3						1							2					2		2								
Nonfill												3				3		1	1		1		2		2		3				2
Cracks ejector				1		2	2	1			2																2				
Twisted part									2		1				2		2	2	2												
Porosity												3	3				1		1	2	2			2		2	2				
Sticking		1	1	1					2					1	2																3
knit lines flow fronts										2			3			2			1	1											
Flow marks	4									2		2					1	1	2												
Pregel										1		1					2	2													

1 ... 5 Chronological order of actions

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