Composites® International Europe

TROUBLESHOOTING - INJECTION

INJECTION — PROBLEMS \ POSSIBLE CAUSES	Dosage	Rotative speed of screw	Back pressure	Injection pressure	Injection speed	Holding pressure (with cushion)	Holding time	Step back of injection unit	Mold temperature	Barrel/ nozzle temperature	Outgazing	Under vaccum	Curing time	Contact time of nozzle on mold	Bad flowing into stuffer	Stuffer pressure	Clamp force	mold opening speed	Cleaning of mold parting surface	Chromium coating of mold	Back draft hanging	Back draft of sprue catcher	Cavities/sprue polishing	Vents	Gate dimension	Ejection speed of part	Cut-gate pressure	Start of cut-gate
Abrasion																			1									
Mold adhesion								1				2							3			3						
Arrachement																		2		1								
Too much flashes	1		3		2											4		5										
Blisters			4					1		3		2											5					
Sticking/hanging of sprue							6	5	2	2		3									4	1						
Non completed curing									2	3		1																
Distortion, ribbing, shrink mark				1	3	2	6			5														4				
Non-conform outgasing					1						4	3						2					2					
Deposit on mold surface									1				4						2			3						
Unstable dosage			1											3	2													
Diesel effect					1				2	2	5	4											3					
Small collapse	2					1																						
Surperficial/through part crack		2				1	7													5				3	4		6	
Heterogeneity/lack of gloss					2				1													3						
Unstable injection profil			1	2						3																		
Bad cavity fulfill	1			4	2	3																						
No dosage														2	1													
Part scrapped during ejection																									1			
Part scrapped during mold opening																	1			3		2						
Cured BMC into barrel/nozzle		3	4						1				2															
Porosities					6	1	7		2		3	5											4					
Problem of degating																										1	2	
Problem of demolding									2				3						1	5		4						
Visible flow line					1				2	3																		
Pre-gel marks					2				1	3																		

Verification
Increment
Reduction
Increment or Reduction
1 … 7 Chronological order of actions

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