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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

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Decrease peak cavity  
pressure (decrease fill rate  
and/or use profile  
injection)

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system Contamination of  
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bands or thermocouples  
Defective nozzle shutoff  
mechanism Inefficient

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injection conditions

Cracked injection  
cylinder or pitted screw

Oil ...

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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 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

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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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### Molding Trouble

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Molding

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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

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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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Materials, Design,

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Training 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.

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Process- Insufficient  
injection pressure/  
injection rate insufficient  
material feed Excessive  
cooling of the melt  
Mould- Unbalanced

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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

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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

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

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etc.

The IM Troubleshooting Guide was originally prepared in 1996 as a 48 page convenient pocket sized resource for use in Injection Molding. This information is most useful by personnel who

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work in the injection molding field including press operators, technicians, engineers, etc. This 3rd ED is at 104 pages and includes selected extra pages from other APEBOOKS that are helpful in process set up and troubleshooting. This book includes many useful definitions and tips for troubleshooting molding problems --

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both process and tooling related. The book was written based on many years of process engineering. The solutions for correcting process problems are listed in the best order to solve the problem based on factors such as ease & timeliness to perform versus cost to implement and always considering effectiveness to solve

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problem. It is also useful to identify a common set of definitions for each department to use when discussing these common molding defects. Tips are often provided as to which defects may be process correctable versus those requiring product or mold changes. An introduction to DOE and dimensional nominalization is made,

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but discussed in greater detail in some of the other booklets written by this author for injection molding ... these are listed later in this book ... a total of six books have been written for injection molding.

This highly practical troubleshooting guide solves problems at the machine systematically

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and quickly. Drawing on a wealth of hands-on experience from the authors, who have built strong reputations in the field, the book is structured by type of problem/solution. Thus, it is an ideal reference to be consulted at the machine. Included is valuable information on robust process windows, cycle time evaluations,

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scrap savings, and runners/gates with no existing standard in the industry. No other book provides the unique insights found here--

This highly practical troubleshooting guide solves injection molding problems systematically and quickly. The rigorous but user-friendly approach

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employs the authors' proven » STOP « methodology, considering molding process, mold, machine, and material (4M 's) as possible sources of part defects. Importantly, the interaction between tooling, processing, and material is emphasized, allowing successful resolution of difficult problems where » by-



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the-books « approaches fail. Starting from troubleshooting methodology and tools, there is a focused discussion of key areas impacting troubleshooting, in particular the 4M 's, followed by an in-depth troubleshooting guide for various molding defects, structured logically by type of problem /

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solution. Insightful case studies throughout show the strengths of the STOP method to get real processes to run smoothly and reliably, producing quality parts with optimal cycle time and cost. Drawing on a wealth of hands-on experience, this book serves as an ideal reference to be consulted at the machine, or as a

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learning and training manual, suitable for both beginners and experienced molders.

With valuable information on robust process windows, cycle time evaluations, scrap savings, and runners / gates with no existing standard in the industry, no other book provides the unique insights found here. The 2nd edition is

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updated with new discussion and case studies on topics including additive manufactured inserts, unmelts, buildup, burns, cycle time, gloss variation, and read-through.

This third edition has been written to thoroughly update the coverage of injection

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molding in the World of  
Plastics. There have been  
changes, including  
extensive additions, to  
over 50% of the content  
of the second edition.

Many examples are  
provided of processing  
different plastics and  
relating the results to  
critical factors, which  
range from product  
design to meeting  
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requirements to reducing costs to zero-defect targets. Changes have not been made that concern what is basic to injection molding. However, more basic information has been added concerning present and future developments, resulting in the book being more useful for a long time to come. Detailed explanations and

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interpretation of individual subjects (more than 1500) are provided, using a total of 914 figures and 209 tables.

Throughout the book there is extensive information on problems and solutions as well as extensive cross referencing on its many different subjects. This book represents the **ENCYCLOPEDIA** on

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IM, as is evident from its extensive and detailed text that follows from its lengthy Table of CONTENTS and INDEX with over 5200 entries. The worldwide industry encompasses many hundreds of useful plastic-related computer programs. This book lists these programs (ranging from operational training to product design to



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molding to marketing) and explains them briefly, but no program or series of programs can provide the details obtained and the extent of information contained in this single sourcebook.

The Injection Molding Handbook provides engineers, professionals and other involved in this important industry sector

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with a thorough up-to-date overview of injection molding processing equipment and techniques, including the basic fundamental information on chemistry, physics, material science and process engineering. It covers all components of the injection molding machine and the various process steps. Topics

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directly affecting injection molding, such as material selection, process control, simulation, design and troubleshooting complete this reference book for the injection molder. The updated second edition handbook presents a well-rounded overview of the underlying theory governing the various

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injection molding  
processes without losing  
its practical flavor.

## shooting Guide

This book details the  
factors involved in the  
injection moulding  
process, from material  
properties and selection  
to troubleshooting faults,  
and includes the  
equipment types  
currently in use and  
machine settings for

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different types of plastics.

Material flow is a critical parameter in moulding and there are sections covering rheology and viscosity. High temperature is also discussed as it can lead to poor quality mouldings due to material degradation. The text is supported by 74 tables, many of which list key properties and

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processing parameters,  
and 233 figures; there are  
also many photographs  
of machinery and  
mouldings to illustrate  
key points.

Troubleshooting flow  
charts are also included  
to indicate what should  
be changed to resolve  
common  
problems. Injection  
moulding in the Western  
World is becoming

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increasingly competitive as the manufacturing base for many plastic materials has moved to the East. Thus, Western manufacturers have moved into more technically difficult products and mouldings to provide enhanced added value and maintain market share. Technology is becoming more critical, together

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with innovation and quality control. There is a chapter on advanced processing in injection moulding covering multimaterial and assisted moulding technologies. This guide will help develop good technical skills and appropriate processing techniques for the range of plastics and products in the marketplace. Every



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injection moulder will find useful information in this text, in addition, this book will be of use to experts looking to fill gaps in their knowledge base as well as those new to the industry. ARBURG has been manufacturing injection moulding machines since 1954 and is one of the major global players. The company prides itself on the

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support offered to clients, which is exemplified in its training courses. This book is based on some of the training material and hence is based on years of experience.

The book introduces the reader to the concepts of Scientific Molding and Scientific Processing for Injection Molding, geared towards

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developing a robust, repeatable, and reproducible (3Rs) molding process. The effects of polymer morphology, thermal transitions, drying, and rheology on the injection molding process are explained in detail. The development of a robust molding process is broken down into two sections and is described

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as the Cosmetic Process and the Dimensional Process. Scientific molding procedures to establish a 3R process are provided. The concept of Design of Experiments (DOEs) for and in injection molding is explained, providing an insight into the cosmetic and dimensional process windows. A plan to release qualified molds

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into production with troubleshooting tips is also provided. Topics that impact a robust process such as the use of regrind, mold cooling, and venting are also described. Readers will be able to utilize the knowledge gained from the book in their day-to-day operations immediately. The second edition includes a

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completely new chapter on Quality Concepts, as well as much additional material throughout the book, covering fountain flow, factors affecting post mold shrinkage, and factor selections for DOEs. There are also further explanations on several topics, such as in-mold rheology curves, cavity imbalances, intensification ratios, gate

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seal studies, holding time optimization of hot runner molds, valve gated molds, and parts with large gates. A troubleshooting guide for common molded defects is also provided.

This reference guide was originally prepared in 1990 as a convenient pocket sized resource for use in Injection Molding.

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This information is most useful by personnel who work in the injection molding field including press operators, technicians, engineers, designers, mold builders, etc. There are many reference data tables regarding plastics data, statistical methods, engineering calculations and valuable training for personnel in the IM



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industry. The book includes basic part design, trig tables, calculations for thermal expansion, thermal expansion coeffs, SHCS data, torque specs, shrink data, cooling time equation, mold debug guidelines, melt index data, resin density data, many tables of process guidelines, process development techniques, calculating

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heat load & water flow requirements, pipe data, conversion factors, transformer & motor current, PM & safety, basic statistics, equip selection guidelines and more. This 4th Edition has been reformatted at 5.5 inches wide x 8.5 inches tall in 2011 for print sales.

The all-encompassing

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guide to total quality process control for injection molding In the same simple, easy-to-understand language that marked the first edition, Total Quality Process Control for Injection Molding, Second Edition lays out a successful plan for producing superior plastic parts using high-quality controls. This updated edition is the

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first of its kind to zero in on every phase of the injection molding process, the most commonly used plastics manufacturing method, with an all-inclusive strategy for excellence. Beginning with sales and marketing, then moving forward to cover finance, purchasing, design, tooling, manufacturing, assembly, decorating,

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and shipping, the book thoroughly covers each stage to illustrate how elevated standards across individual departments relate to result in the creation of a top-notch product. This Second Edition: Details ways to improve plastic part design and quality  
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quality through the entire  
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updates that cover Six Sigma, ISO 9000, and TS 16949, which are all critical for quality control; computer-guided process control techniques; and lean manufacturing methods. With proven ways to problem-solve, increase performance, and ensure customer satisfaction, this valuable guide offers the vital information

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today's managers need to plan and implement quality process control—and produce plastic parts that not only meet, but surpass expectations.

How easy life would be if only moldings were the same size and shape as the mold. But they never are, as molders, toolmakers, designers



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and end users know only too well. Shrinkage means that the size is always different; warpage often changes the shape too. The effects are worse for some plastics than others. Why is that? What can you do about it? The Handbook of Molded Part Shrinkage and Warpage is the first and only book to deal specifically with this

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fundamental problem.

Jerry Fischer 's  
Handbook explains in  
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on to demonstrate how to alleviate the problem through careful design of the molded part and the mold, and by proper material selection. It also examines computer-aided methods of forecasting shrinkage and warpage. And most important of all, the Handbook gives you the data you need to work with. . Authoritative and

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rooted in extensive industrial experience, the expert guidance contained in this handbook offers practical understanding to novices, and new insights to readers already skilled in the art of injection molding and mold making. Contains the answers to common problems and detailed advice on how to control

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mold and post-mold shrinkage and warpage. Case Studies illustrate and enrich the text; Data tables provide the empirical data that is essential for success, but hard to come by.

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