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insufficient gates Change gate location 6.  
Burning Compressed air in the mold  
degrades resin Decrease peak cavity pressure  
(decrease fill rate and/or use profile  
injection)

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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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Process: (1) Increase injection pressure and injection speed to enhance shear heat (2) Increase the amount of injection (3) Increase material cylinder temperature and mold temperature. 2. Air Traps. Air traps is that air is trapped in the cavity to create bubbles in the part.



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## 13 Plastic Injection Molding Defects and How to Fix Them

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.

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Temperature (if nozzle heating is applied)

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Molding Troubleshooting Guide 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 compliance between outer panel, inner panel and adhesive •

Incompatible thermal expansion coefficients

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Process- Insufficient injection pressure/  
injection rate insufficient material feed  
Excessive cooling of the melt Mould-  
Unbalanced multi-cavity mould Insufficient  
air venting blocks resins flow Runners, gates,

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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 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 marks. Gas trapping/ poor venting. Improve venting

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and/or relocate to burned area.

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personnel who work in the injection  
molding field including press operators,  
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