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~~MOLDING! | Bench-~~

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~~molding. Simple~~

~~Silicone Rubber Molds~~

~~(no parting line)-~~

~~Updated How to~~

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Cracking Crazing Black

Specks or Streaks.

Problem. Delamination.

Problem. Gloss (Low)

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Blisters Blush Bowing

Bubbles. Source(s)

Cause(s) Machine

Excessive residence time

in barrel Hang-up of

molten material in

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runner system

Contamination of ...

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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 Decrease peak
cavity pressure (decrease

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fill rate and/or use
profile injection)

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in barrel Hang-up of

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Contamination of

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Degradation due to

malfunctioning heater

bands or thermocouples

Defective nozzle shutoff

mechanism Inefficient

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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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Molding 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

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encountered with this 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.

Injection Moulding

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HMC Polymers

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Randy Kerkstra Steve

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Dynacure
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

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Probable Cause

Material Process •

Mismatch of compliance
between outer panel,

inner panel and
adhesive •

Incompatible thermal
expansion coefficients
between the SM and the
adhesive

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PROBLEMS

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sophisticated and

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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, or vents
too small Material flow
length too long.

Material- Material
viscosity too high

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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.

Basic Injection

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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 and/or relocate to burned area.

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