
































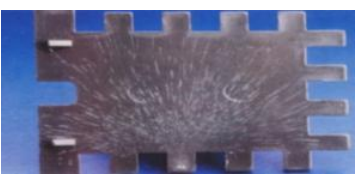















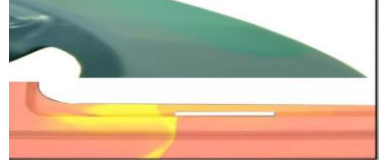




INJECTION TROUBLE SHOOTING GUIDE

INCREASE  DECREASE 		INJECTION PARAMETERS														MOULD			MATERIAL		
PROBLEMS	PHOTOS	MELT TEMP.	NOZZLE TEMP.	BARREL TEMP.	INJECTION PRESSURE	BACK PRESSURE	CLAMP PRESSURE	HOLD PRESSURE	HOLD TIME	INJECTION SPEED	SHOT VOLUME	MOULD COOLING TIME	MOULD TEMPM.	CYCLE TIME	SCREW SPEED	GATE DIAMETER	MOULD SURFACE	AIR VENT. CHECK	MATERIAL DRYING	MELT FLOW	REGRIND AMOUNT
SHORT MOULDING		 3	 4		 2	 8			 9	 6	 1		 5			 10	 7				
FLASH				 2	 1	 5	 3	 5		 6			 7								
SINK MARKS				 5	 2	 7		 3		 6	 1		 4		 8	 9	 10			 11	
FLOW LINES		 3	 1	 4						 5			 2			 6					
BURNT MARKS				 2	 4					 1			 3			 5	 7				

INJECTION TROUBLE SHOOTING GUIDE

INCREASE ↗ ↘ DECREASE		INJECTION PARAMETERS														MOULD			MATERIAL		
PROBLEMS	PHOTOS	MELT TEMP.	NOZZLE TEMP.	BARREL TEMP.	INJECTION PRESSURE	BACK PRESSURE	CLAMP PRESSURE	HOLD PRESSURE	HOLD TIME	INJECTION SPEED	SHOT VOLUME	MOULD COOLING TIME	MOULD TEMPM.	CYCLE TIME	SCREW SPEED	GATE DIAMETER	MOULD SURFACE	AIR VENT. CHECK	MATERIAL DRYING	MELT FLOW	REGRIND AMOUNT
WARPAGE				↕ 5	↕ 4				↗ 3			↗ 2	↕ 1			↗ 6					
WELD LINES				↗ 2	↗ 1				↗ 3	↗ 5			↗ 4					↗ 6			
DISCOLOURATION			↘ 3	↘ 2		↘ 4								↘ 5				↗ 7			↗ 6
SILVER STREAKS			↘ 5	↘ 3						↘ 4			↗ 6	↘ 7	↘ 2			↗ 6	1		
DELAMINATION				↗ 2						↕ 4			↗ 1						1		↘ 6

