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- Solutions for

Common Injection

Molding Defects

Common Plastic

Injection

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to remove
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in injection

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in injection

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TROUBLESHOOTING

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~~molding process~~

~~of plastics~~

~~explained in~~

~~Tamil | Mano~~

~~sadasivam~~

~~Machining a DIY~~

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~~Injection Mold!~~

~~WW114 Plastic~~

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Molding \u0026

Overmolding -

ASH Solutions

for Molding

Undercuts Rubber

Sole Making

Machine **Plastic**

Processing

Overview

~~Injection~~

~~Molding Overview~~

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Molding - How

It's Made \u0026

How It Works -

Spyker Workshop

Troubleshooting

Defects

(excerpt) *Single*

Colour T.P.R

\u0026 *P.V.C*

Sole Injection

Moulding Machine

7 Ways to Save

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on Injection Trouble

Molding

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How to

troubleshoot

short molding

detailed in

????? | Short

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molding defects

DROULING Problem

in Injection

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Moulding Machine

?? Solve
Drouling problem
in injection

Moulding. Shoe
sole injection
moulding
machines TPR,
TPU, PVC pvc
sole injection
machine

Introduction to
Mold Design

(Part-1) | Skill-

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Designing of
Plastic Products
for Injection
Moulding -

Lecture Undercut

Injection

Molding

Troubleshooting

Guide - Pvc

Solution Guide

Injection

molding machine

1. Plastic is so

hot. Reduced

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Injection

melt

temperature. 2.

Mold filling

speed is too

fast. Reduce the

injection speed

3. Back pressure

is too high. 1.

Reduced back

pressure. 2.

Check a screw

surface speeds

are correct. 4.

Melting volatile

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Injection

in excess. 1.

Ensure that the
air not incident
with tank and

plastic. 2.

~~Plastic~~

~~Injection~~

~~Molding~~

~~Troubleshooting~~

~~Guide~~

Troubleshooting

Guide for

Injection

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Molding Trouble

Troubleshooting

is the art and

science of

remedying

defects after

the process has

demonstrated the

ability to

produce

acceptable

production

parts. Most

defects respond

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Injection

to one of a
variety of
process and/or
material

changes. The
goal is to
correctly
identify which
problem

~~Troubleshooting~~
~~Guide for~~
~~Injection~~
~~Molding~~

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Injection Trouble

Molding

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Troubleshooting

Pvc

Guide. This

information is

intended to be

used only as a

guideline for

designers and

processors of

modified

thermoplastics

for injection

molding. Because

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Injection mold design and processing is complex, a set solution will not solve all problems.

Observation on a “trial and error” basis may be required to achieve desired results.

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~~Molding Trouble~~

~~Molding~~

~~Troubleshooting~~

~~Guide — RTP~~

~~Company~~

Every injection-
moulding machine

has built-in

electrical,

hydraulic and

mechanical

safety devices.

Find out where

they are located

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Moulding Trouble

Shooting Guide

they are

operational, as

operator on an

earlier shift

may have

disabled some of

them. Clothing

and Safety

Glasses

~~Basic Injection~~

~~Moulding Trouble~~

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~~Shooting Guide~~

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

Shooting Guide

temperature. 2.

Pvc

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~~

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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

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Injection

Molding, machine

setup, mould

type and

complexity,

materials and

manufacturing

environment.

Specific

conditions

cannot be

anticipated.

~~Injection~~

~~Moulding~~

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Injection

~~Troubleshooting~~

~~+ HMC Polymers~~
shooting Guide

For injection

molding, this

means there are

several items on

the mold and

press that

should be

checked before

troubleshooting

any molding

problem. If

problems are

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Injection

found they
should be
corrected and
the parts re-
evaluated before
proceeding.

~~Philosophy of
Troubleshooting
Injection
Molding Problems
Molding
Troubleshooting
Guide Bond~~

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Injection

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

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panel and Trouble

adhesive • Shooting Guide

Incompatible

Pvc thermal

expansion

coefficients

between the SM

and the adhesive

~~TROUBLESHOOTING~~

~~MOLDING PROBLEMS~~

Reciprocating

screw injection

molding machine.

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A shot weight of 60% to 80% of the barrel capacity (rated in PVC) is recommended. 2 to 3 tons per square inch of total part area including runners.

Smearhead type recommended but check ring types

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Injection

also work.

Locate near the last area of the cavity to be filled.

~~PVC Injection~~

~~Molding Process~~

~~+ Vinyl~~

~~Injection~~

~~Molding ...~~

At Teknor Apex,
we ensure our
customers have

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Shooting Guide

the resources
they need to run
efficiently and
effectively. On

our Technical
Guides &

Literature page,
you can find

comprehensive
data and

processing
guides specific

to our
compounds.

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Brittleness

Contamination

Bubbles (cont.)

Source(s)

Cause(s) Mold

(cont.) Improper

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Injection

runners or gates

Mold temperature

too low Material

Excessive

moisture

Operator

Inconsistent

cycle Machine

Excessive

injection speed

or pressure

Excessive back

pressure Screw

speed too high

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Improper Troubleshooting Guide

compression
ratio of screw

Pvc

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~~Molding~~

~~Troubleshooting~~

~~Guide~~

Increase

injection speed.

Raise mould

temperature.

Increase

injection

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pressure. Trouble

Increase
injection time. Shooting Guide

Raise material
temperature. Pvc

Ensure adequate
venting. Purge
gates, runners
or vents Enlarge
gates, runners
or sprue and
balance where
necessary.

Inadequate melt

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flow rate, Use
higher MFI
grade.

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~~molding~~

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Molding on in

harmful

downloads.

Rather than

enjoying a fine

PDF as soon as a

mug of coffee in

the afternoon,

otherwise they

juggled similar

to some harmful

virus inside

their computer.

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molding machine

- Injection

unit. Clamping

unit. Prior to

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the injection of the molten plastic into the mold, the two halves of the mold must first be securely closed by the clamping unit. When the mold is attached to the injection molding machine, each half is

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fixed to a large
plate, called a
platen. The
front half of
the mold, called
...

~~Injection~~

~~Molding Process,~~

~~Defects, Plastic~~

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Molding

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Materials,

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Molding Process

Optimization,
Shooting Guide

Troubleshooting

Pvc
and Other

Practical

Information from

the Experts at

Routsis Training

Plastics is a

sophisticated

and diverse

discipline. To

excel, you need

a good grasp of

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a wide range of
concepts and
data. That's
what this

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is all about.

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~~Training~~

7.3.3.2

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Instructions for

the Most

Important

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Compounds 139

8.1 Pre-Drying

Material 139

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~~Practical Guide~~

~~to Injection~~

~~Moulding~~

~~Dynaecure~~

Injection

molding

processpoints of

PVC are stated

as below:

(1)Drying Due
the existence of
chlorine ions,
the PVC material
absorbs moisture

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Injection

slightly, so it
has to be dried
under 75 - 90°C
temperature

conditions for
about 1.5 - 2.5h
before
production
starts.

(2) Melting
Temperature

~~PVC Plastic
Injection~~

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~~Molding Process~~

~~— MoldChina.com~~

shooting Guide

Increase the

Pvc injection speed

or prelong the

injection time;

Improve the

insulation of

the gate. Short

fill or welt

line on the neck

of PET preform :

Poor venting;

eccentric gate

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Injection

position. Trouble

Enlarge the
venting groove;

Clean the screw
neck; Lower the
injection speed;

Fix the gate :

Uneven wall
thickness of PET
preform : Poor
quality of PET
preform mold;

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