



Troubleshooting Guide for INJECTION MOLDING Phenolic & Granular Polyester

PROBLEM	CORRECTIONS											Refer to Comment Sheet
	Mold Temperature	Injection Pressure	Holding Pressure	Injection Speed	Barrel Temperature	Screw Speed	Screw Back Pressure	Clamp Pressure	Shot Size	Hold Time	Cure Time	
Ball & Socket	3D	2I	2I	1D								4A
Bulge Opposite Insert	3I				4I		4I					1B & 2C
Cure Blister	2I			4D	1I		1I				3I	
Dull Appearance	1I				2I		2I					3E & 4Y
Flash - Excessive	4I	2D	2D		3I		3I	6I	1D			5F
Flow Lines	4D	2I	2I	1I	5D		5D			3I		6A
Hard Spots	4D	2D	2D	3D	1D		1D					5H
Injection Too Slow		1I		2I	3I		3I					4K
Mold Staining	4I	5D	5D	6D	3I		3I	7D				1U & 2Y
Mottled Surface Appearance	3D				2D		2D		1I			
Nonfills or Short Shots	4D	3I	3I		2I		2I		1I			5U & 6G
Nozzle Freezes Up	1D				2D		2D					3H
Orange Peel	3I	1I	1I	4D	2I		2I					
Rubbery Parts or Runner	1I				2I		2I					3AA
Screw Does Not Go "Home"		2I	2I		5D		5D		3D			1J, 4W & 6K
Screw Pickup is Erratic					1I	2D	1I					3M & 4G
Screw Pickup is Too Slow					2D	1I	2D					3I
Part Shrinkage - Excessive	2I	1I	1I		3I		3I				5I	4U
Part Shrinkage - Insufficient	1D		2D								4D	3V
Sink Marks	2I	3I	3I	4D					1I			5U
Skin Blisters	3D			1D					2D			4U
Sprue Sticking		3D	2D									1N, 4H & 5X
Sticking in Mold	3I		2D						4D			6I 1P & 5E
Subgates Sticking in Mold												1BB, 2CC & 3DD
Trapped Gas	6D	5D	5D	4D	3D		3D	7D				1EE 2U & 8Z
Warpage When Ejected												1P, 2E, 3R & 4V
Warpage After Cooling	1I			3D	2I		2I				5I	4U, 6S & 7A
Wood Screwing					2D	3D	1I					

Legend: Number = Priority I = Increase D = Decrease Other Letters = Comment ID

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Injection Molding Troubleshooting Guide Pvc: Bestsellers in 2023 The year 2023 has witnessed a remarkable surge in literary brilliance, with numerous compelling novels captivating the hearts of readers worldwide. Lets delve into the realm of top-selling books, exploring the captivating narratives that have enthralled audiences this year. The Must-Read : Colleen Hoover's "It Ends with Us" This heartfelt tale of love, loss, and resilience has captivated readers with its raw and emotional exploration of domestic abuse. Hoover expertly weaves a story of hope and healing, reminding us that even in the darkest of times, the human spirit can prevail. Uncover the Best : Taylor Jenkins Reids "The Seven Husbands of Evelyn Hugo" This spellbinding historical fiction novel unravels the life of Evelyn Hugo, a Hollywood icon who defies expectations and societal norms to pursue her dreams. Reids captivating storytelling and compelling characters transport readers to a bygone era, immersing them in a world of glamour, ambition, and self-discovery. Discover the Magic : Delia Owens "Where the Crawdads Sing" This captivating coming-of-age story follows Kya Clark, a young woman who grows up alone in the marshes of North Carolina. Owens spins a tale of resilience, survival, and the transformative power of nature, entrancing readers with its evocative prose and mesmerizing setting. These popular novels represent just a fraction of the literary treasures that have emerged in 2023. Whether you seek tales of romance, adventure, or personal growth, the world of literature offers an abundance of engaging stories waiting to be discovered. The novel begins with Richard Papen, a bright but troubled young man, arriving at Hampden College. Richard is immediately drawn to the group of students who call themselves the Classics Club. The club is led by Henry Winter, a brilliant and charismatic young man. Henry is obsessed with Greek mythology and philosophy, and he quickly draws Richard into his world. The other members of the Classics Club are equally as fascinating. Bunny Corcoran is a wealthy and spoiled young man who is always looking for a good time. Charles Tavis is a quiet and reserved young man who is deeply in love with Henry. Camilla Macaulay is a beautiful and intelligent young woman who is drawn to the power and danger of the Classics Club. The students are all deeply in love with Morrow, and they are willing to do anything to please him. Morrow is a complex and mysterious figure, and he seems to be manipulating the students for his own purposes. As the students become more involved with Morrow, they begin to commit increasingly dangerous acts. The Secret History is a masterful and gripping novel that will keep you wondering until the very end. The novel is a warning tale about the dangers of obsession and the power of evil.

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Table of Contents Injection Molding Troubleshooting Guide Pvc

1. Understanding the eBook Injection Molding Troubleshooting Guide Pvc
 - The Rise of Digital Reading Injection Molding Troubleshooting Guide Pvc
 - Advantages of eBooks Over Traditional Books
2. Identifying Injection Molding Troubleshooting Guide Pvc
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Injection Molding Troubleshooting Guide Pvc
 - User-Friendly Interface
4. Exploring eBook Recommendations from Injection Molding Troubleshooting Guide Pvc
 - Personalized Recommendations
 - Injection Molding Troubleshooting Guide Pvc User Reviews and Ratings
 - Injection Molding Troubleshooting Guide Pvc and Bestseller Lists
5. Accessing Injection Molding Troubleshooting Guide Pvc Free and Paid eBooks
 - Injection Molding Troubleshooting Guide Pvc Public Domain eBooks
 - Injection Molding Troubleshooting Guide Pvc eBook Subscription Services
 - Injection Molding Troubleshooting Guide Pvc Budget-Friendly Options
6. Navigating Injection Molding Troubleshooting Guide Pvc eBook Formats
 - ePub, PDF, MOBI, and More
 - Injection Molding Troubleshooting Guide Pvc Compatibility with Devices
 - Injection Molding Troubleshooting Guide Pvc Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Injection Molding Troubleshooting Guide Pvc
 - Highlighting and Note-Taking Injection Molding Troubleshooting Guide Pvc
 - Interactive Elements Injection Molding Troubleshooting Guide Pvc
8. Staying Engaged with Injection Molding Troubleshooting Guide Pvc

- Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Injection Molding Troubleshooting Guide Pvc
9. Balancing eBooks and Physical Books Injection Molding Troubleshooting Guide Pvc
- Benefits of a Digital Library
 - Creating a Diverse Reading Collection Injection Molding Troubleshooting Guide Pvc
10. Overcoming Reading Challenges
- Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Injection Molding Troubleshooting Guide Pvc
- Setting Reading Goals Injection Molding Troubleshooting Guide Pvc
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Injection Molding Troubleshooting Guide Pvc
- Fact-Checking eBook Content of Injection Molding Troubleshooting Guide Pvc
 - Distinguishing Credible Sources
13. Promoting Lifelong Learning
- Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
14. Embracing eBook Trends
- Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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