


Plastic Injection Moulding Troubleshooting Guide

 Unit 5, Argyle Comm. Centre Argyle Street, Swindon Wiltshire, SN2 8AR. 01793 – 64 10 40 Moulding Fault ↓	Suggested Remedy ↓																		
	Injection pressure	Barrel temperature	Holding pressure & time	Nozzle temperature	Screw speed	Injection speed	Back pressure	Mould temperature	Gate size	Tool venting	Material Dry ?	Material / Contamination ?	Bridging at throat ?	Machine capacity ?	Back zone temperature	Throat cooling ?	More blending required or Temperature control ?	Heat in feed zone or Usage rate	Screw & barrel ok ?
Black streaks or spots		-		-							?							?	?
Brittleness	-	-	-		-		-	?		+	?	?							
Burning	-	-	-	-	-	-			+	+	?	?							?
Cloudy appearance		+						+			?	?							
Colour variation shot to shot		-											?	-		?	-		?
Ejection difficulties	-	-	-			-		-											
Flashing	-	-	-		-	-	-	-	+		?								
Gate Splay	-	-	-			+		+	+	+	?			?					?
Gloss	+	+				+		+		+	?								
Jetting	±	+	±	+		±	+	+	+	+	?	?		?					
Lamination		+		+	+	±	±	+	+		?	?						-	
Loss of colour													?					-	?
Orange skin	+	+	+			+		+	+										
Parts oversize	-	-	-					+				?							
Parts sticking in	-	-	-			-		-											
Parts undersize	+	+	+			+	+	-	+										
Poor distribution		+			-		+				?		?	?	-		?	-	
Screw not returning		±			+		-				?		?		-	?		-	
Screw slip		-					-											-	
Short shot	+	+	+	+		+	+	+	+					?					
Silver streaks		-		-		-			+		?	?							
Sinking & voids	+	±	+	±		-	-	-	+	+				?					
Visible weld lines	+	+	+	+	+	+	+	+	+	+	?	?							
Warpage	-	±	-			+	+	±											

Key: + = Increase - = Decrease ± = Try Increasing or Decreasing ? = Check

Note: Due to the wide range of options and plastic injection moulding materials available, this information is for use as a guide only and is supplied in good faith without obligation or liability.

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