



Trouble Shooting Guide



Below is a guide to solve some common problems in compression and injection moulding of phenolic moulding compounds.

COMPRESSION Moulding	CORRECTIONS	MOULD TEMP.	PRESS. PRESSURE	MAT'L CHARGE WT.	CURE TIME	MOULD CLOSE SPEED	BREATH Mould	VENT Mould	CLEAN & POLISH Mould	DRAFT ANGLE	K.O. PIN SIZE
	PROBLEMS										
BLISTERING	D	I		I	D	C	C				
POROSITY	D	I	I		I	C	C	C			
MOULD STICKING	I	D		I			C	C	C		
DULL SURFACE	D				D			C			
DIMPLED SURFACE	D	I	I		D						
ORANGE PEEL	D	D	D		D						
WARPED PARTS	D			I					C		
PARTS CRACKING					D			C	C	I	
BURN MARKS	D		D	D	D						
HEAVY FLASH	D	I	D		D						

GET RESULTS WITH SUMIDUREZ PHENOLICS

INJECTION Moulding	CORRECTIONS	INJ. PRESSURE	SCREW RPM	BACK PRESSURE	MAT'L REED ADJ.	NOZZLE TEMP.	BARREL TEMP.	MAT'L TEMP.	INJ. SPEED	MOULD SPEED	SPRUE BUSHING	GATE SIZE	CAVITY VENTS	CURE TIME	MAT'L PLASTICITY	MOULD POLISH	MAT'L SUPPLY
	PROBLEMS																
SCREW WON'T MOVE			D	D	D	D	C							I			
SCREW SQUEAKS		D				I								C			
NOZZLE HARDENS					D		C										
SPRUE STICKS	D				I				C								
ERRATIC INJECTION	I		I		D	D			D					I			
MOULD FLASHES	D		D	D			I	D			I			D			
MOULD STAINS			D					D	D				I				
MAT'L NOT FEEDING		D															C
PARTS STICK	D								D		I		I			C	
NON-FILLS	I		I	I		D	C	C	D	I	I	I	I	I		C	
BLISTERS	I		I			I	I		I		I	I	I	D			
GAS MASKS	I					D	D	D				I		D			
FLOW LINES	D	I	D				C		D		I			D			
DULL SURFACE			D						D			I				C	
POROSITY	I		D	I	D		C		D		I	I		C	C	C	
PARTS WARPS			I				I	I	I				I	D			
SINK MARKS	I		I	I			I		I		C	D		D			

I INCREASE
D DECREASE
C CHECK