

Injection Molding Trouble Shooting Reference Guide



Instant checklist of likely remedies for the most common problems on injection molding machines.

**Perform Remedies
in numerical order**

INCREASE

DECREASE

ADJUST UP
OR DOWN

CHECK

Common Problems	Injection Pressure	Cycle Time	Injection Hold-Time	Sprue/Runner Gate Size	Gate Land Length	Nozzle Opening	Adjust Feed	Clamp Pressure	Stock Temp.	Mold Temp.	Injection Speed	Screw RPM	Back Pressure	Gas Vents	Nozzle Heating Band	Contamination
Blush at Gate	4 ↑			5 ↑					3 ↓	1 ↑	2 ↓					
Brittleness									1 ↓	3 ↑	7 ↓	4 ↓	5 ↓	6 ↑		2 ◆
Color Streaks				8 ↑	9 ↓				2 ↓	3 ↑	1 ↓	5 ↓	6 ↑		7 ◆	4 ◆
Flash	1 ↓		8 ↓					2 ↑	4 ↓	5 ↓	3 ↓	7 ↓	6 ↓			
Jetting				6 ↑	5 ↓	4 ↑			2 ↓	3 ↑	1 ↓				7 ◆	
Lamination	7 ↓				6 ↓	5 ↑			3 ↑	2 ↑	4 ↓					1 ◆
Poor Dimens. Stability	3 ↑		2 ↑	5 ↑					1 ↓	4 ↓						
Poor Surface Finish	1 ↑			4 ↑					2 ↓	3 ↑						
Short Shots	2 ↑	7 ↑		6 ↑	8 ↓		1 ↓		4 ↑	5 ↑	3 ↑					
Sink Marks	2 ↑		3 ↑	7 ↑	8 ↓		1 ↓		4 ↓	5 ↓			9 ↑	6 ↑		
Sprue Sticking	6 ↓	3 ↑	2 ↓							1 ↓					4 ◆	5 ◆
Sticking in Cavity	1 ↓	3 ↑	2 ↓				4 ↓		6 ↓	5 ↓						
Warpage	5 ↓	3 ↑							2 ↓	1 ↓	4 ↓		6 ↓			
Wave Marks	4 ↑		3 ↑				1 ↓		5 ↓	2 ↓				6 ↑		
Weak Weld	4 ↑		7 ↑	6 ↑					3 ↑	1 ↑	2 ↑			5 ↑		
Weld Burns	8 ↓			7 ↑		5 ↑			2 ↓		1 ↓	3 ↓	4 ↓	6 ↑		