

Softflex Troubleshooting Guide - Quick Reference
February 2007

Problem	Potential Cause	Potential Solution
Shorts	Insufficient plastic pressure	Raise the boost cut off pressure, change the transfer position, increase the injection velocity speed.
	Trapped Gas	Check the mold vents - clean or recut vents if needed
	NRV (screw tip) slippage	Lower the front barrel heat temperature - replace the NRV
	Insufficient hold psi /time	Increase the hold/pack pressure - increase the hold/pack injection time
Flash	Plastic stuck in the mold	Clean the mold, check the leader pin holds for plastic
	High of injection pressure	Reduce the injection boost pressure
	High hold/pack pressure	Reduce the hold / pack pressure
	Hold time to long	Reduce the hold / pack injection time
	Injection velocity set to fast	Reduce the injection velocity speed
	Melt temperature to high	Reduce the barrel temperature settings
Softflex Material is Sticky	Melt temperature to high	Reduce the barrel temperature settings
	Moisture content to high	Dry the material - material is wet
Long Cycle Time - Longer then Normal	Moisture content to high	Dry the material - material is wet
Sprue Sticking	Moisture content to high	Dry the material - material is wet
	Polished Surface	Break the vacuum by roughing up the surface
	Nozzle drool	Lower nozzle temp- use screw suckback - check nozzle radius
Material Sticking to Mold	Melt temperature to high	Reduce the barrel temperature settings
	Moisture content to high	Dry the material - material is wet
	Excessive residence time	Reduce the barrel temperature settings and/or length of time material is under the temperature
Poor Bond at Select Areas	Trapped gas	Check venting - install vent pins in substrate at location
	Surface interference	Remove mold spray from operation, wear cotton gloves
Poor Bond on Most of the Part	Surface interference	Remove mold spray from operation, wear cotton gloves
	Low melt temperature	Raise the barrel temperatures
Overmolded Part Sticking in the Mold	Part is overpacked	Reduce the hold / pack time or pressure
	Insufficient draft angle	Redesign part for additional draft angle - coat the mold with a teflon impregnant coating
	Moisture content to high	Dry the material - material is wet
Dimples on Part Surface	Part is overpacked	Reduce the hold / pack time or pressure - part is overpack and swelling
	Part is underpacked	Increase the hold / pack time or pressure - underpacked part
Flow Marks on Part Surface	Low injection speed	Increase injection velocity speed - hesitation flow
	Mold temperature low	Increase mold water temperature - hesitation flow
	Melt temperature low	Raise melt temperature

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