

The numbers stand for the sequence in which operations should be tried, and the arrows indicate either an increase or the setting, a decrease in the setting, or the necessity to balance the setting.

MACHINE DEFECTS							PART DEFECTS																						
Numbers indicate sequence of making corrective steps. Arrows indicate: ↑ - Increase ↓ - Decrease ± - Balance/Vary							Excessive Flash	Overfilled Part	Part Sticking	Short Shot	Sprue Sticking	Underfilled Part																	
													Black Spots, Brown Streaks	Blinders	Brittleness	Burn Marks	Cracking, Cratering	Delamination	Distortion	Flow Marks	Jacking	Poor Surface Finish (Gloss)	Poor Weld Lines	Shore Breaks, Spring, Splash	Sink Marks	Voids	Warping		
MACHINE VARIABLES	Backpressure	5			6			1	2	3						4								7					
	In. Forward (Booster) Time		2	3		2	3			4																			
	Clamp Pressure	2	8																										
	Cylinder Temperature	2	5	6							2		2	1		2					3								
	Holding Pressure		4	3																			3	3					
	Injection Hold Time	4		7	9	2	5														3						3		
	Injection Pressure	1	3	1	2	1	2									4	5	5			2	1		2	2	4			
	Injection Speed	6	1	8	6	8	5	1			1	1	4			5	1	1	4	5	5	4	6	6	6				
	Shot Size (Material Feed)					1																		1	1				
	Melt Temperature					3												2			2			5	5	5			
	Mold Cooling Time			4			4	9																		3			
	Mold Temperature	7	6	5	5		7							2		3	4	1			2	3	1	4	6	4	1		
	Nozzle Temperature					4	6																						
	Overall Cycle Time		7																					7					
MOLD VAR.	Screw Speed														1	3								8					
	Change Gate Location														6						5	7	7		13	11	7		
	Size of Gate					11		8													6	4		8	10	9	6		
	Size of Sprue/Runner					10																		9	8				
OTHER ACTION	Size of Vent	10				7									7		8				5	6							
	Check for Material Contamination													2		7				3	6				2				
	Check Fit of Mold Faces	9																											
	Clean Cavity Surface																						6						
	Clean Mold Faces	8																											
	Clean Vents					12																				7			
	Dry Materials														5	5		6	5					8	1	11	10		
	Regrind Quantity															6			6							12			
Purge/Clean Screw & Barrel														1						1									

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