



Injection Molding Troubleshooting Guide

Problem	Possible Causes	Possible Solutions
Short Shot	Low injection pressure; low melt temperature; slow injection speed; blocked gate; insufficient material feed	Increase injection pressure; raise melt temperature; increase injection speed; enlarge gate; verify material feed
Flash	Excessive injection pressure; mold not clamping fully; worn mold surfaces; melt temperature too high	Reduce injection pressure; increase clamp force; repair mold; lower melt temperature
Sink Marks	Thick sections cooling unevenly; low packing pressure; insufficient hold time	Increase packing pressure; increase hold time; redesign part for uniform wall thickness
Burn Marks	Air trapped in mold cavity; injection speed too high; melt temperature too high	Improve mold venting; reduce injection speed; lower melt temperature
Splay (Silver Streaks)	Moisture in resin; contamination in material; excessive shear heating	Dry material properly; purge machine; reduce injection speed and shear
Warping	Uneven cooling across part; mold temperature imbalance; internal stresses during cooling	Balance cooling channels; adjust mold temperature; modify part design
Flow Lines	Melt cooling too quickly during fill; injection speed too slow	Increase melt temperature; increase injection speed
Jetting	High injection speed through a small gate causing material to jet	Reduce injection speed; modify gate design or size
Weld Lines	Multiple melt fronts meeting at low temperature or pressure	Increase melt temperature; increase injection speed; modify gate location
Delamination	Material contamination; incompatible resins mixed	Clean machine; verify correct material