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## Thermoplastic Elastomers WFTE Trouble Shooting Guide

**Decrease Mold Temperature (Cavity)** 

**Gate in Thickness Cross Section** 

**Decrease Shot Size** 

**Incompatible Materials Increase Amount of Gates** 

**Increase Back Pressure** 

**Increase Hold Pressure Increase Injection Pressure** 

**Increase Injection Speed** 

Increase Shot Size

**Move Gate Location** 

**Increase Material Temperature** 

**Increase Mold Temperature** 

**Increase Substrate Support** 

Redesign Ejection Mechanism

Dry Material

SUGGESTED REMEDIES Perform in numerical order by column	$\setminus$	PRO Non-Ulling	DBL Mold Breaks Tormed Chines	$ egthinspace{1.5em} olimits = 1.5em of the content of the conten$	SMILESHOTE	Parts Surface Slinks	Sticking in Caspial	Poor Adric	inosion in	Marp
Add Mechanical Interlocks									6	
Add Surface Texture								6		
Add Pneumatic Air Poppets								8		
Check for Material Contamination				8			2		6	
Check Mold Shut-Off	6									
Check Vent Depth	6		6				6			
Clean Mold Surface			0				4			
Decrease Back Pressure										
Decrease Injection Pressure					2					
Decrease Injection Speed	4	0			0		3			
Decrease Hold Pressure	0							0		6
Decrease Material Temperature	8				8	2		2		

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