Corrective action when Part defects

M=Modify I=Increase D=Decrease V=Verify C=Clean P=Polish U=Uniform

Part Defect	Corrective Action	Mould Safety / Time / Pressure	Clamping Force	Injection Speed / Pressure	Change-Over Pos. / Time / Pressure	Hold Pressure	Hold Pressure Time / Seal Point	Cooling Time	Mould Temperature	Dosage/ Plasticizing Volume (Stop)	Screw (Peripheral) Speed	Back Pressure	Cylinder Temperature / Melt Temp.	Hopper / Travers Temperature	Decompressing Before / After	Mould Opening Speed	Edjection Speed / Pressure / Stroke	Pause Time	Hydraulic Oil Temperature	Gate Size / Design / Position	Venting of the Cavity	Moisture in the material / Cavity	Master Batch / Pigment / Carrier	Mould Release Agent	Regrind / Regranulated material	Contamination in the material	Melt Residence (Dwell) Time	Nozzle Temperature	Seal Nozzel - Sprue Bushing	Screw Cushion (Size)	Backflow Valve ring / Check Valve	Cavity Surfaces / Seal & Part Lines	Hot Runner Systems / Temperature	Pre Drying/ Heating
Sink Marks, at Gate, Thick material				D	V	I	V		D				D							M	V								V	V		V	
Sink Marks, Thin material				I	V	I	V		I				I							M	V								V	V		V	
Brown (Burn) Streaks				D							D	D	D							V			M	D	D	V	D			V			V	V
Silver Streaks (Moisture/ Damp)														I								V			V									V
Silver Streaks (Trapped Air)											D	I		M	D														V					
Glass Fibre Marbling/ Whitish Surf.				M	V	I	V		I				I							M													I	
Color Defects - Streaks				M							V	I	V							V			M		D	V							C	
Color Defects - Burning				D							D	D	D							I		V	M		D		D			V			D	
Color Defects - Dull /Polished surf.				I					I				I								C	V		D							P	I	
Color Defects - Gloss /Textuerad				M		I	V		M				D								C			D							V	D	
Color Defects - Glossdiff. /Polished				U					U			I	V								C	V		D	D						P	I	
Color Defects - Glossdiff. /Textuerad				U		I	**V**		U			V									C	V		D	D						V	D	
Weld Line - Visible /Weak				I	V	I	V		I				V							M	C		M	D	V	V						I	
Poor Adhesion - TPE/ Elastomer				I	V	D	D		I				I							M				D									
Jetting				D					M				I							M												V	
Burn Marks - Charred Surface			D	D	V	V									D					M	C			D									
Record Grooves Surface				I					I				I								C											I	
Stress Cracking - Amorphous				M	V	D			M				M							V												I	
Stress Cracking - Semi Crystalline				M	V	D			M				M							V												D	
Low Impact Strength /Brittle Parts				M		D					D		V							M		V	V		D	V	D			V			V	V
Dimension Fault - Small				V		I	V	M	M				M							V										V			M	
Dimension Fault - Big				V		D	V	M	M				M							V													M	
Dimension and/or Weight Variations			V				V		V	V		I	V						V					D				V	V	V		I	
Short Shot/ Incomplete Filling				I	V	I			I				I							V	C								V	V	V		I	
Flash - Over Filled Product			I	D	V	D			D				D														V					V		
Warpage - Part Distortion				U	V	D		I	U								D						M		D									
Release Fault - Sticking Cavity/ Core					V	D		D	M				V			M	M			V				M								V	V	
Release Fault - Deformation, Heat								I	D				V			D	D							M								V	V	
Release Fault - Ejector Pin Marks					V	D		M	D								M							M								V		
Release Fault - Rasp Marks					V	D		D	I							M	M							M								V		
Delamination				D	V		V		I		D	D	D							V			M		D	V	D			V			V	
Cold Slug									V				V							V					V	V		I					I	
Unmelted Particles in Product											D	I	V	I									M		V	V							I	
Blisters, Air - Variation Position/ Size										V	V	I	V		D																			
Blisters, Damp - Many & Small													V	V								V			V		V							I
Blisters /Voids, Shrink - Same Pos.				I	V	I	V		M				I							I													I	
Black or Brown Spots / Specks													V												D	V	D			V	C		C	C
Thermal Decomposition				D							D	D	D							I		V	M		D	V	D			V			D	V
Deposit in the Mould				D					D				D							V	C		M	M	D	V	D					C	C	
Gate Blush				D		V			M											V		V	V		D	V	V					V	M	
Gate Blush - Screw Bounce				D	V	I	V													M													D	
Cycle Time - To long		V					V	D	D							I		D		D														
The Screw don't Dosing/ Plasticize											M	D	V	V	M									D	D					V				I
Nozzle Leakage - Stringing/ Thread									D			D	D		I												V	D	V				D	
Sprue/ Runner - Breaks							V	I								M	D			M		V					V						V	
Sprue/ Runner - Thermal Decompos.											D	D	D										M		D		D			V			D	
Sprue/ Runner - Sticks i Mould							V									M	M			V								V	V				D	

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