

<i>Possible Causes</i>	<i>Actions</i>
1. Gates too small	1. Verify and request a gate redesign.
2. Poorly localized gate	2. Request a redesign.
3. Injection speed too high	3. Slow down the injection rate.
4. Small nozzle hole	4. Replace nozzle.

Surface delamination – Layer separation on the surface of the pieces

<i>Possible Causes</i>	<i>Actions</i>
1. Contaminated material	1. Check the material and replace, if necessary.
2. Low melt temperature	2. Adjust to a suitable barrel temperature profile.
3. Melt mixture is not uniform	3. Increase backpressure.
4. Low mold temperature	4. Increase mold temperature.
5. Low injection rate	5. Increase speed. Injection time should be significantly reduced.

Incomplete Shot - Parts are not completely filled

<i>Possible Causes</i>	<i>Actions</i>
1. Low hold pressure	1. Increase hold pressure.
2. Short hold time	2. Increase hold time.
3. Unbalanced cavities	3. Balance the fill and redesign the mold, if necessary.
4. Low melt temperature	4. Increase the melt temperature by adjusting to an appropriate temperature profile.
5. Small runners/gates	5. Request a redesign of runners and/or gates.
6. Low mold temperature	6. Increase mold temperature.
7. Low recovery position	7. Verify that the transfer position is adequate, and then increase the recovery position.

Silver lines - Imperfections on the surface of the parts

<i>Possible Causes</i>	<i>Actions</i>
1. Moisture in the resin	1. Dry the material properly.
2. Obstruction in the nozzle	2. Clean the nozzle.
3. High injection speed	3. Slow down the injection rate.
4. High melt temperature	4. Lower the melt temperature with an appropriate barrel temperature profile.
5. Nozzle is too hot	5. Lower nozzle temperature.
6. Contaminated resin	6. Check the material; replace it if necessary.
7. Gates are too small	7. Increase gate size.