

RTP Company Trouble-Shooting Guide

English/Standard

SUGGESTED REMEDIES Perform in numerical order by column	PROBLEM												
	Blisters	Excessive Brittleness	Gas Flash	Oversized Part	Poor Surface Finish	Poor Weld Lines	Short Shots	Silver Streaking	Sink Marks	Undersized Part	Voids	Warping	
Change Gate Location							8					6	
Clean Mold Faces			4	5	6								
Clean Vents	5			2			5	11				12	
Check for Material Contamination	6	4							4				
Check for Uneven Mold Temperature												1	
Check Mold Faces for Proper Fit			5										
Dry Material	1	6	6	6		7			1			11	
Increase Amount of Material							4	1		8	7	10	
Increase Back Pressure						5		6			6		
Increase Clamp Pressure			2										
Increase Cooling Time									10			9	
Increase Holding Pressure						8		12		11	1		
Increase Injection Hold Time							2			2	2	2	
Increase Injection Pressure						2	1	2		1		1	2
Increase Injection Speed						3	9	3	2		8		
Increase Injection Time									12	5			
Increase Mold Temperature		7			5	1	3	7			9	8	3
Increase Size of Gates								8	6	4	10	4	
Increase Size of Runners								9		5	11	5	
Increase Size of Sprue								10		6		6	
Increase Size of Vent				4			6	4					
Locate Gates Near Heavy Cross Sections										7		7	
Raise Material Temperature					7	4	10	5			4		
Redesign Ejection Mechanism												10	
Reduce Amount of Regrind		5											
Reduce Back Pressure		2							7				
Reduce Cylinder Temperature	2	1	8	3	4				3			7	
Reduce Holding Pressure			7		3							8	
Reduce Injection Pressure			3		2								
Reduce Injection Speed	3		1	1	1	9	7		8	3		3	
Reduce Mold Temperature										9	3	9	4
Reduce Molded Stress		8											5
Reduce Overall Cycle Time					6								
Reduce Screw Speed	4	3							5				

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Manufacturing Locations:

Winona, MN
 South Boston, VA
 Dayton, NV
 Beaune, France



Fort Worth, TX
 Indianapolis, IN