



Trouble shooting guidelines

COIM LARIPUR Production Site
 Via Ricengo 21/23 I - 26010 Offanengo (CR)
 Phone: +39-0373-2481 Fax: +39-0373-244343
 www.coimgroup.com

Trouble found	Possible reasons													
	moisture content	barrel temperature	cooling and cycle time	injection speed	back pressure	melt cushion	mould temperature	residence time	clamping pressure	gate size	demoulding agent	material contamination	venting	feeding hopper
blisters	↓	↓					↓				↓			
internal bubbles	↓	↓	↑	↓	↓		↓		↑			↑		
short shot		↑		↑		↑	↑	↑		↑		↑		
distorsion/shrinkage		↓	↑			↓			↑					
flow lines	↓	↓		↕			↓			↓	↓			
splay marks		↓		↓		↓	↓	↑				↑		
difficult demoulding		↓	↑	↓		↕	↓			↑				
irregular surface	↓	↕		↕		↑	↓			↓	↓			
difficult screw loading		↑			↓									↓
difficult screw moving forward		↑							↑			↑		
stratification/exfoliation presence		↓					↓			↓	↓			
too yellow/foaming melt		↓			↓		↓				↓			
incomplete plastification		↑			↑		↑							

↑ increase ↕ increase or decrease ↓ decrease

The information presented herein are given in good faith but without warranty. They are based on our experience, indicate our laboratory work results and do not necessarily indicate final product performance. We cannot be held liable for the results obtained with our products and for any loss or accident that may result from its use. Our suggestions do not release you from the obligation to check its validity and to test our products for both their process and end use application. COIM assumes no obligation or liability for the description, data and information given or result obtained as production testing and end product performance are the responsibility of the user. All our products are sold in accordance with our General Conditions of Sale. We don't make any warranties, express or implied, including, but not limited to the merchantability and fitness for a particular purpose.