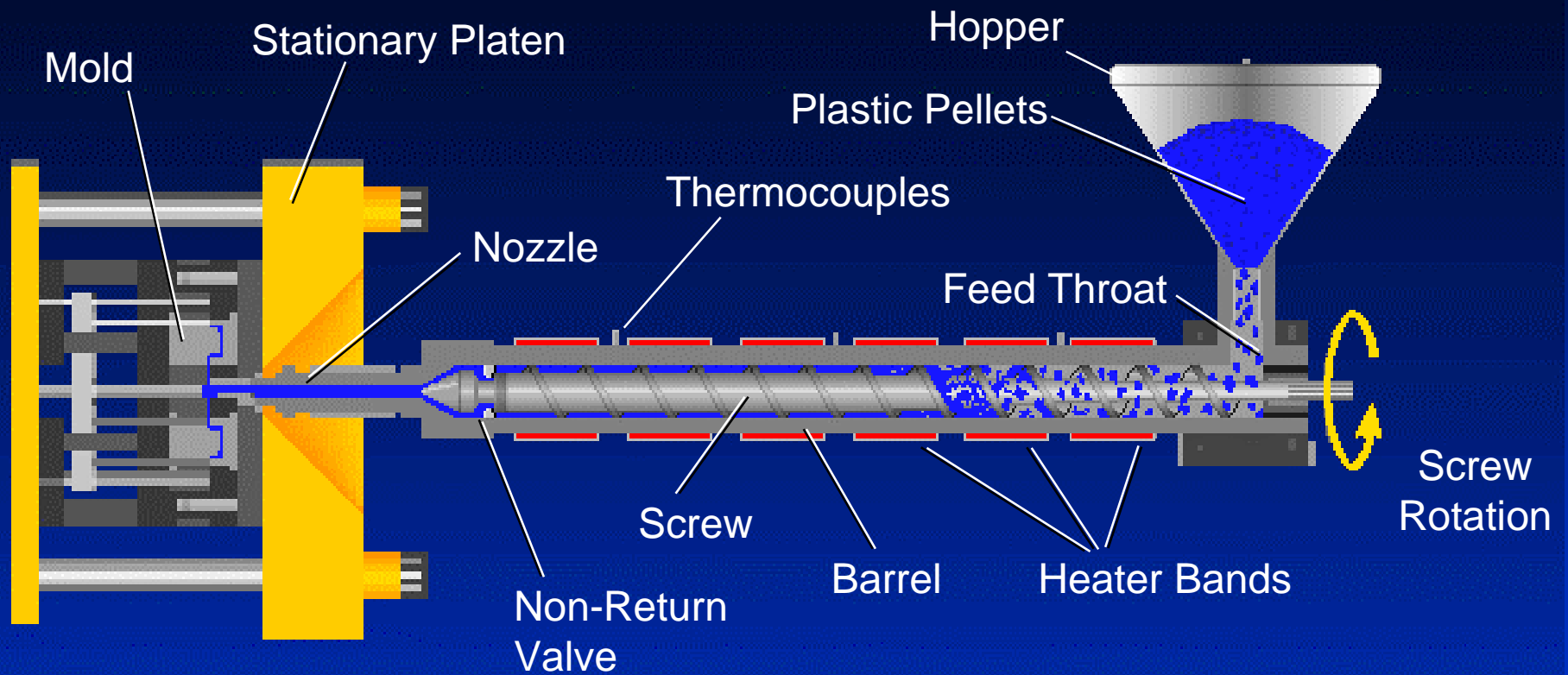


# Injection End Parts and Their Functions

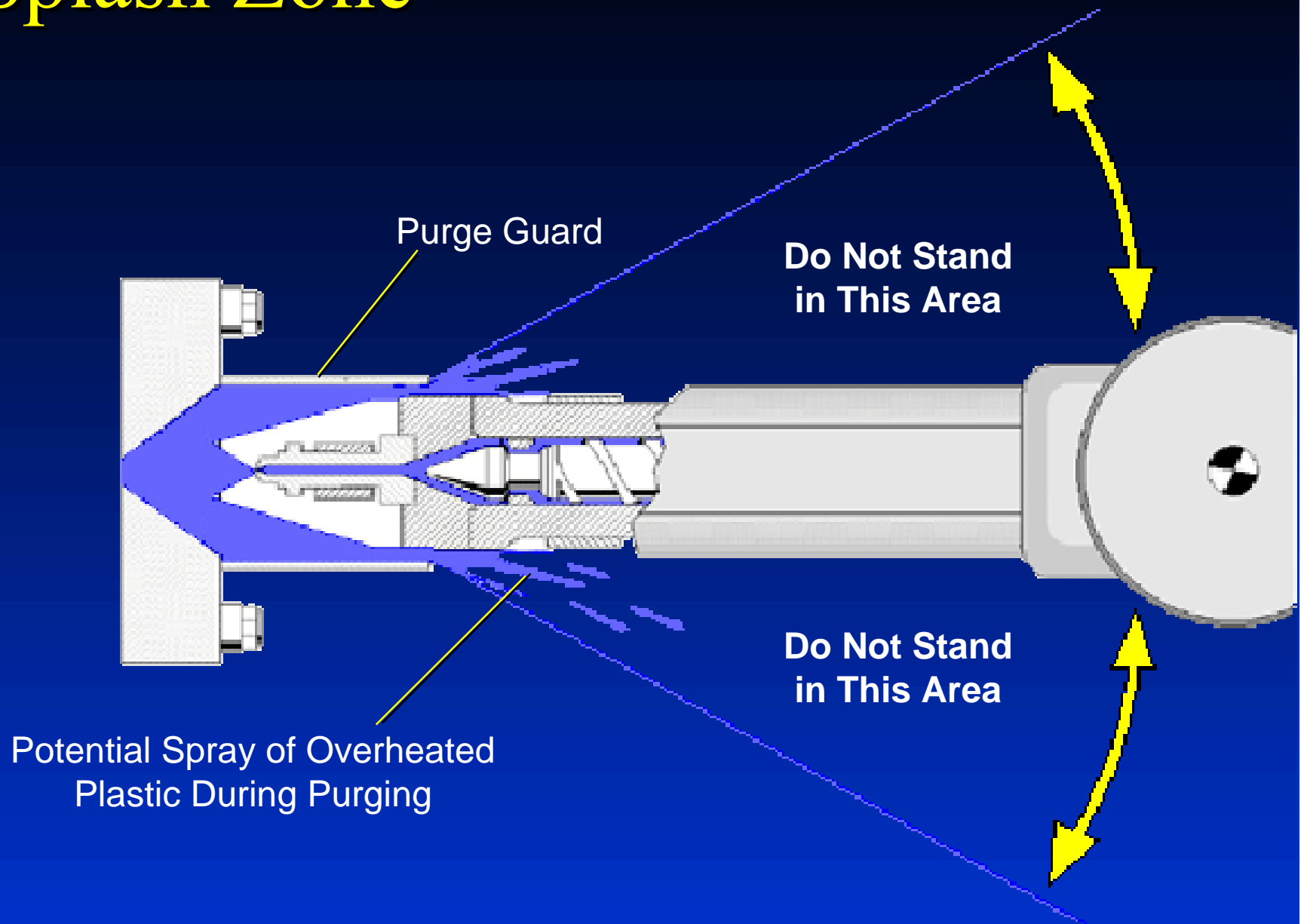


## The Screw and Barrel



Play Animation

# Splash Zone



## Re-Start Check List

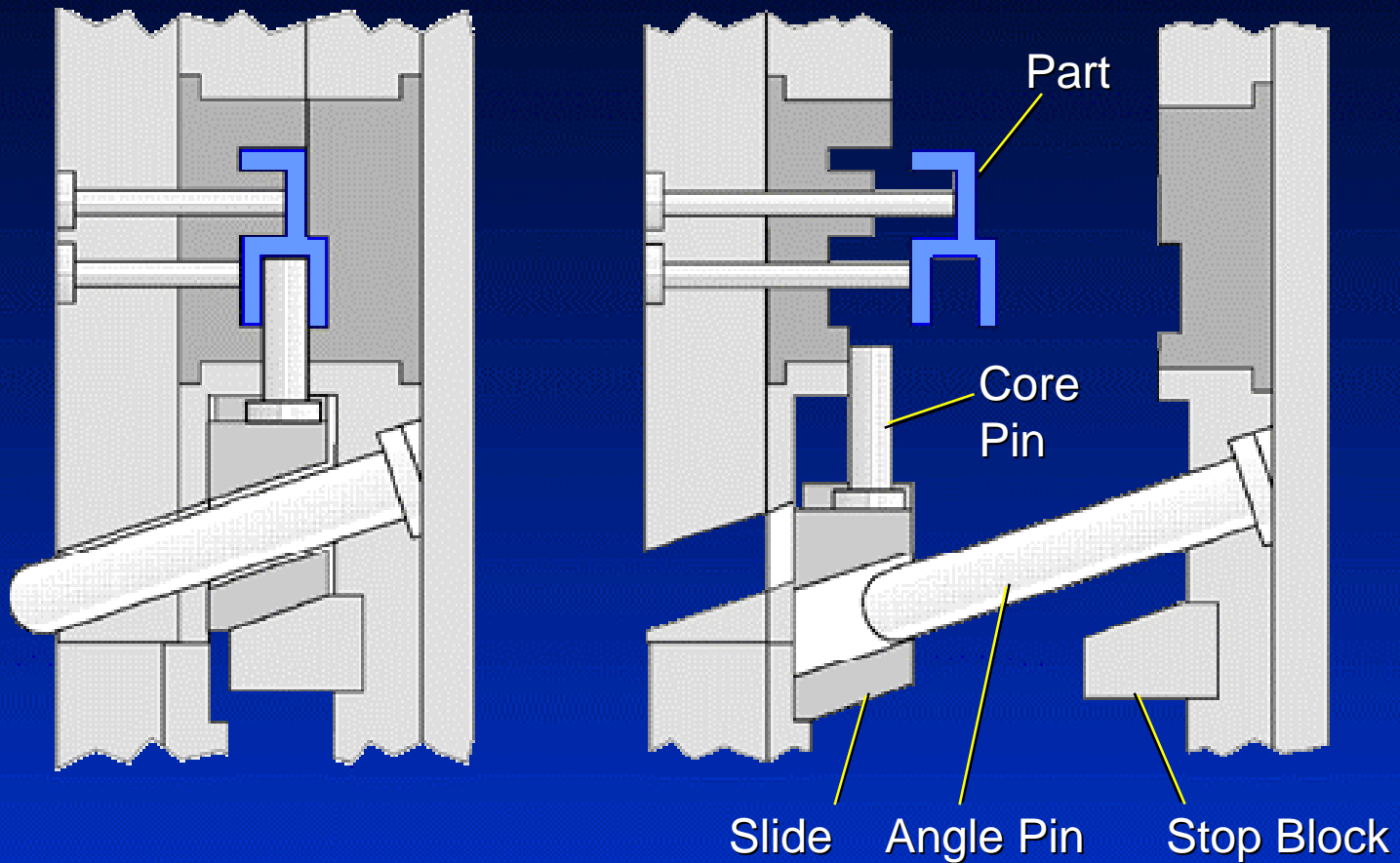
- ✔ The temperatures are at their set points
- ✔ The screw is at its shot-size position setting
- ✔ The mold is at its open limit
- ✔ The ejector pins are in their retracted position
- ✔ There are no parts or flash in the mold

### *Cycle Activation*

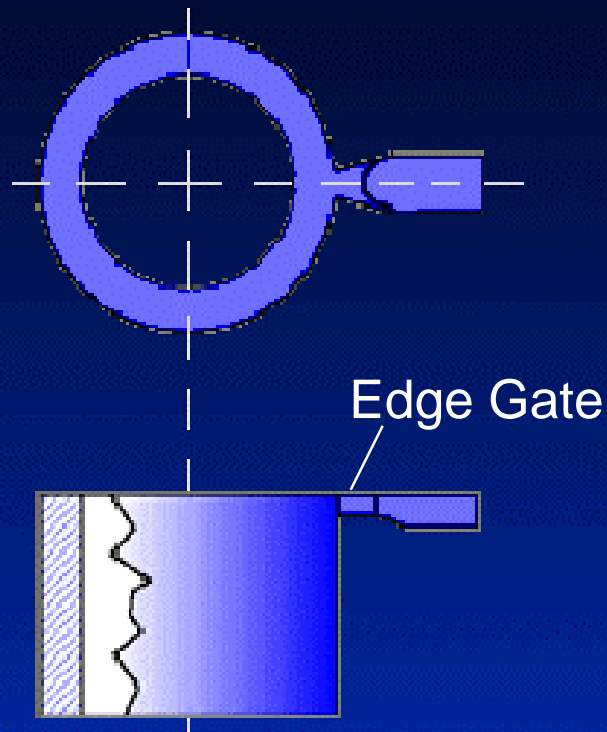
1. Start the pumps
2. Seat the nozzle against the mold
3. Reactivate the cycle

# Mechanical Slides

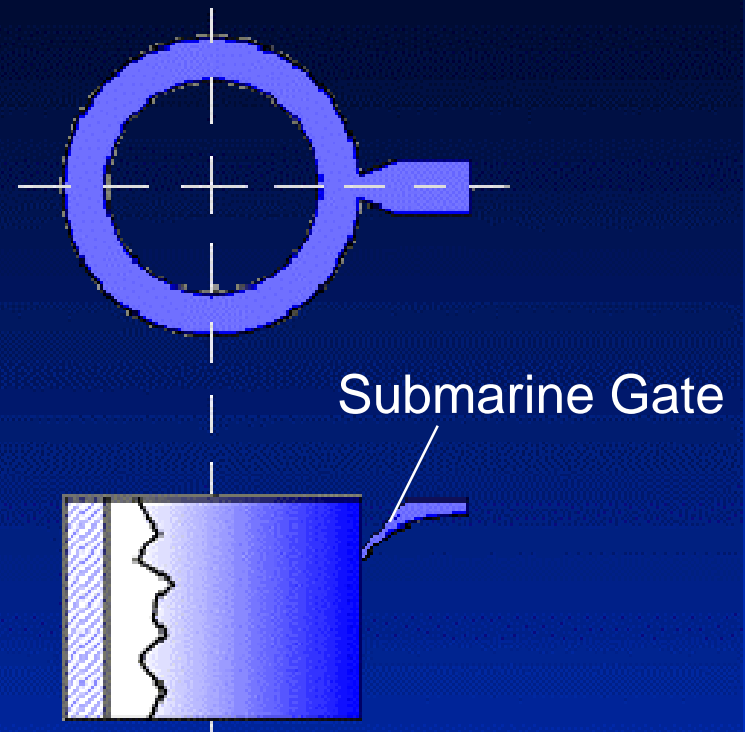
When mold opens, angle pin moves slide and core pin away from part. Part can then be ejected.



# Two Major Gate Classifications



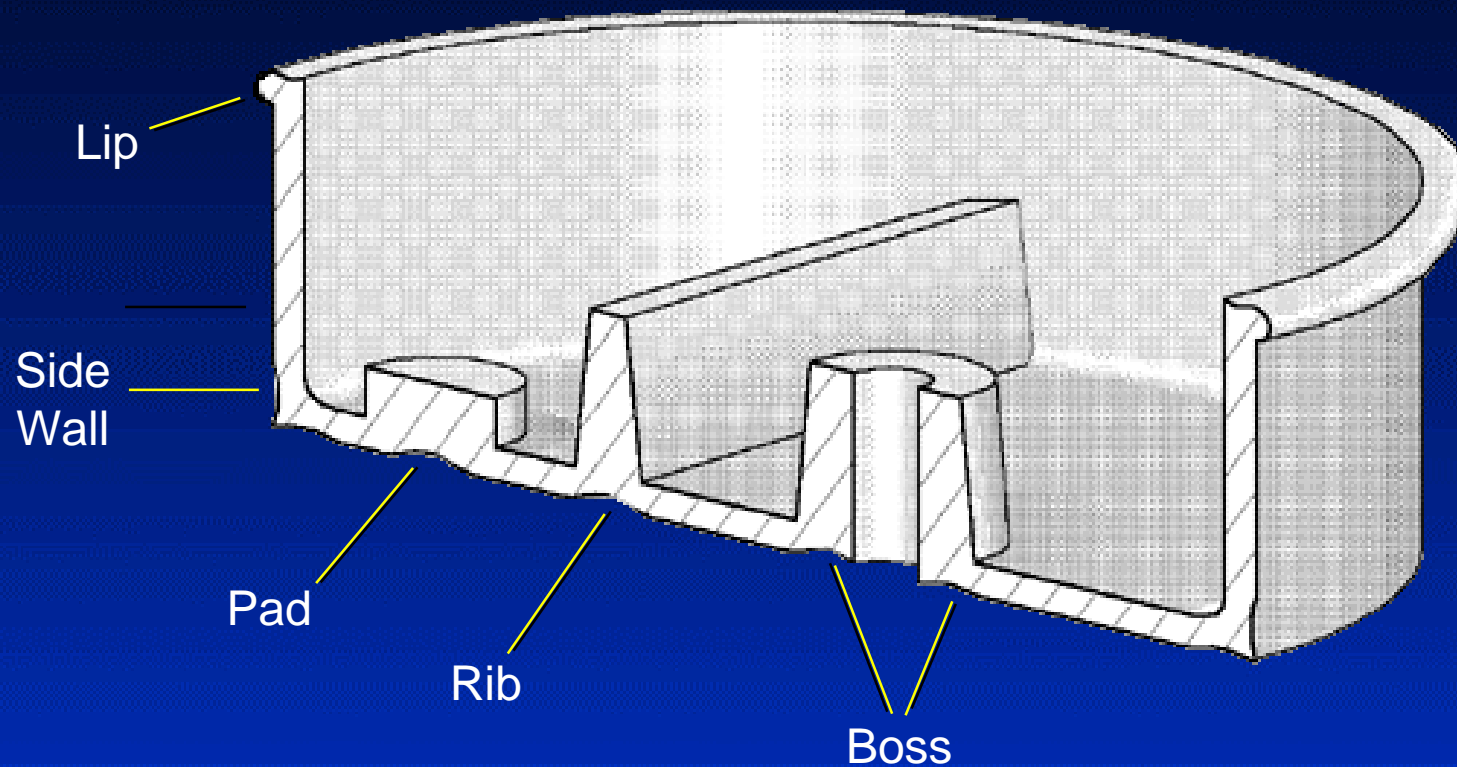
Must be manually degated



Self-Degating type

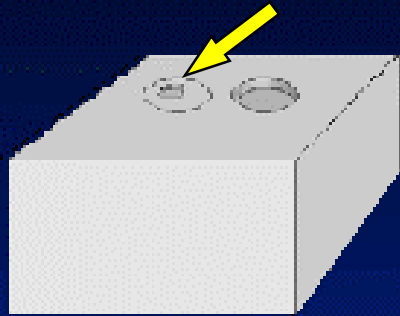
# Surface Defects: Sink Marks

Where sink marks occur

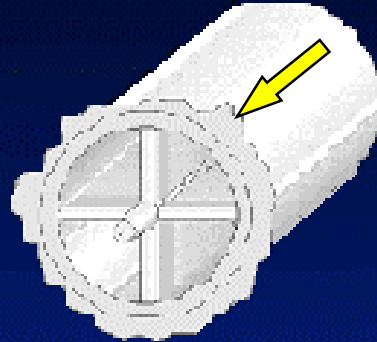


# Defect: Flash

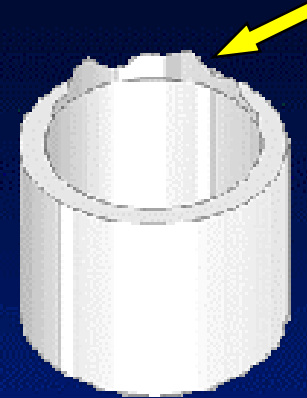
Parting Line Flash from Mold wear



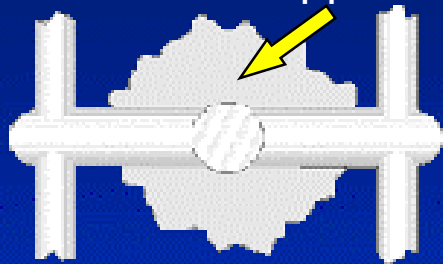
Flash from Mold Separation



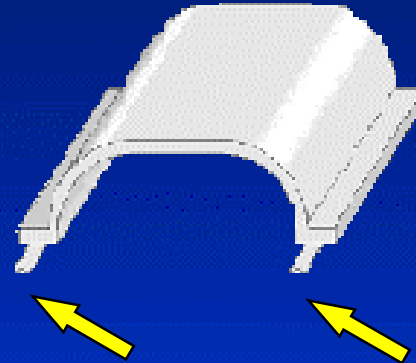
Flash Along Worn Core Pin



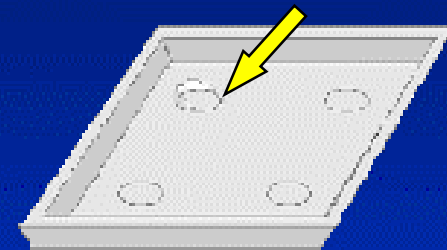
Flash on Runner from Poor Mold Support



Flash at Mold Vents



Flash Along Ejector Pin



## Section 4 Self-Test Review

Question 5:

What type of mold produces a runner that must be removed from the mold each cycle?

- a. hot runner mold
- b. cold runner mold
- c. self-degating mold

# Exercise 5A:

## Plastic Material Identification

### DIRECTIONS

Identify the plastic type and grade number currently being run in five different machines. Determine this information by observing the Set-Up Sheet or Process Sheet at the machine.

	Part Name	Machine Number	Plastic Type	Plastic Manufacturer	Grade Number
1					
2					
3					
4					
5					

