Document part defects before diagnosis

Collect reproducible defect context without prematurely assigning a cause.

Audience: Process, quality, maintenance and engineering personnel.

INSTRUCTIONS

1. Identify the part, revision, resin and exact grade, lot, mold, cavity and sampling time. Mark unknown data.

2. Photograph the complete part and a close-up with orientation and scale. Retain an identified sample if permitted.

3. Record cavity distribution, location, observed frequency and sample size. Distinguish startup from stable operation.

4. Record setpoints and measured values with units, source and time. Include drying and recent changes only when documented.

5. Consult the manufacturer's guidance for the grade and application. Propose checks under change control; do not adjust settings based solely on a visual defect name.

LIMITS

Visually similar defects can have different causes. No process recipes or universal pressure, temperature or speed settings are provided.

ORIGINAL EXAMPLE

FICTIONAL: 3 of 20 observed parts have a visible depression in the same area of cavity DEMO-C1. Recorded as a possible sink mark, pending validation. No production defect rate is extrapolated and no mold or process cause is assigned without further evidence.

RECORD FORM

Complete one copy per record. Attach sheets if more space is needed. Avoid ambiguous blanks: state unavailable or not applicable.

Part / revision / resin / grade / lot
Mold / cavity / date / production phase
Visual description / location / orientation
Photos / scale / retained sample / custody
Parts observed / defective parts / cavities
Parameter / setpoint or measured / unit / source / time
Documented drying / regrind / missing data
Recent changes / unconfirmed hypotheses
Proposed check / authorization / result

SOURCES AND USE

General guidance and original VYRCO form. Sources support the context; they do not certify this template.

BASF · Injection Molding Troubleshooter

Defect terminology and initial guidance; consult grade- and application-specific information.

https://plastics-rubber.basf.com/southamerica/en/performance_polymers/services/product_support_troubleshooting/injection_moulding_troubleshooter

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