

SPLAY

Splay is a surface condition, which appears mainly on glossy Webb moldings. It is not acceptable on most products due to its appearance and surface porosity. Splay is a process problem,

- **It can appear when the material contains moisture and has not been dried sufficiently.**
- **Or some structural regrind found its way into the material.**
- **Or it could come from excessive process heat.**

Splay is a light porosity of the skin, which can appear in various sizes.



Elephant Skin

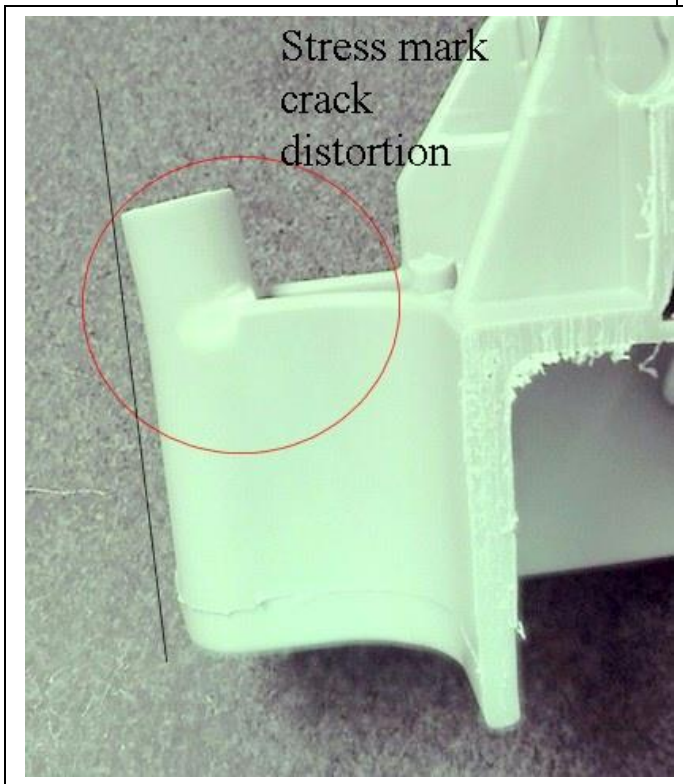
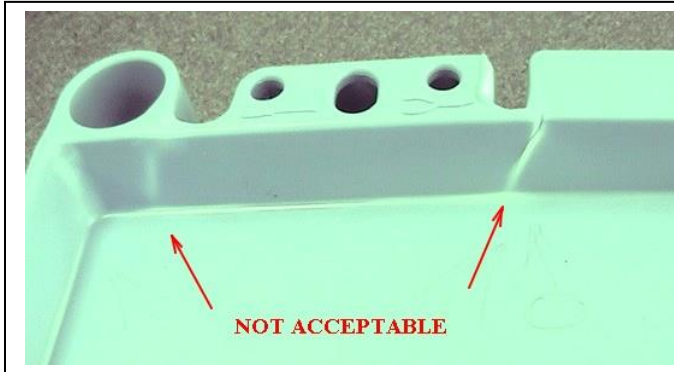
Elephant skin is not a reason for rejection, unless:

- entire part exhibits this condition
- folds are too deep
- or QA specification stating that Elephant skin are not acceptable in certain areas before scraping parts for elephant skin.



STRESS MARKS

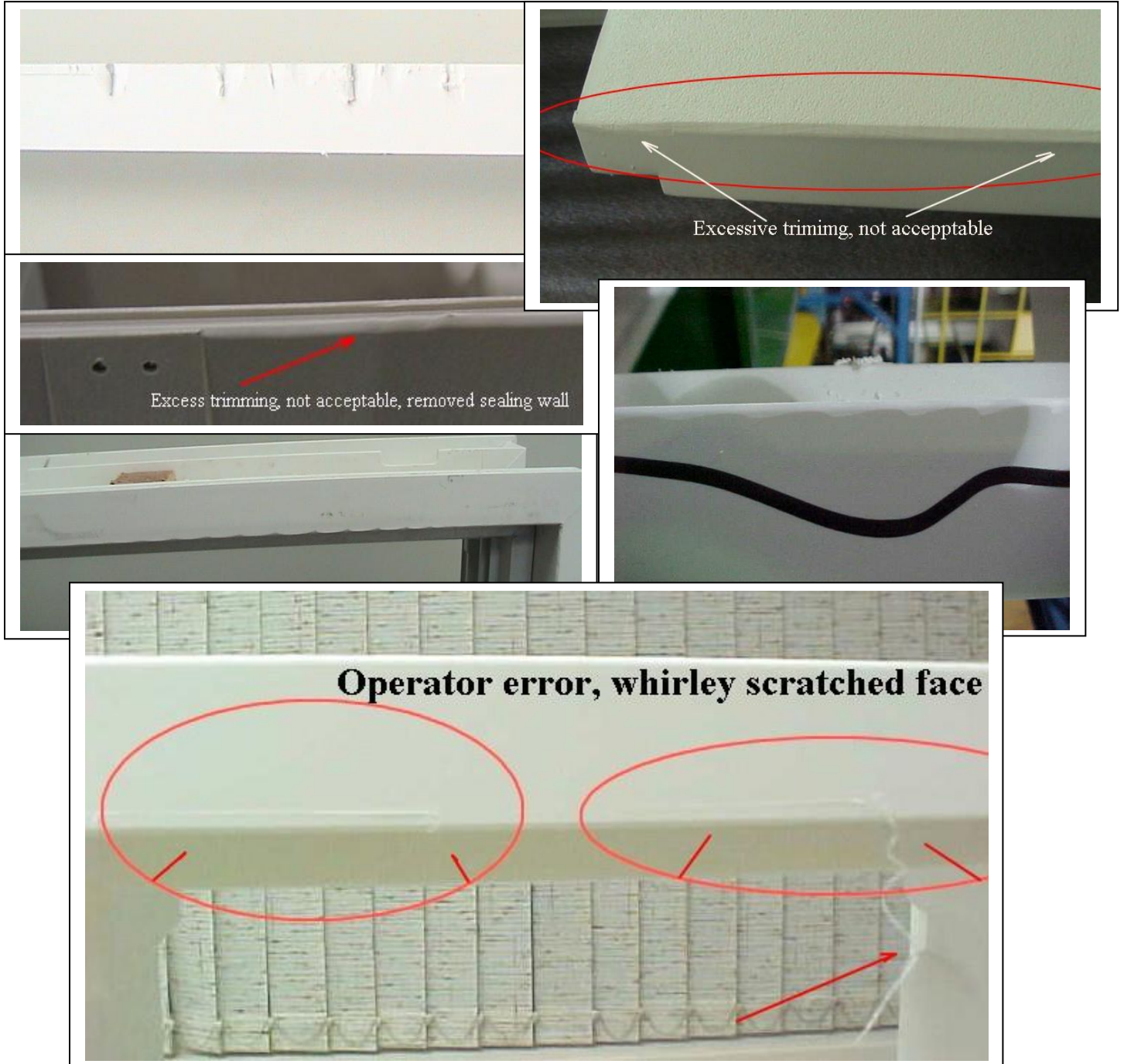
Stress marks appear on a product when the part sticks and lifts uneven out of the cavity during opening of the mold, before ejection. Stretching the part out of shape, leaving stress marks on the skin and distorting part.



TRIMMING

Errors made in trimming that are not acceptable. It is the operators' responsibility to select the correct hand tool for the job, use sharp tool-blades and develop his/her trimming skills that only a minimum of trimming errors occur.

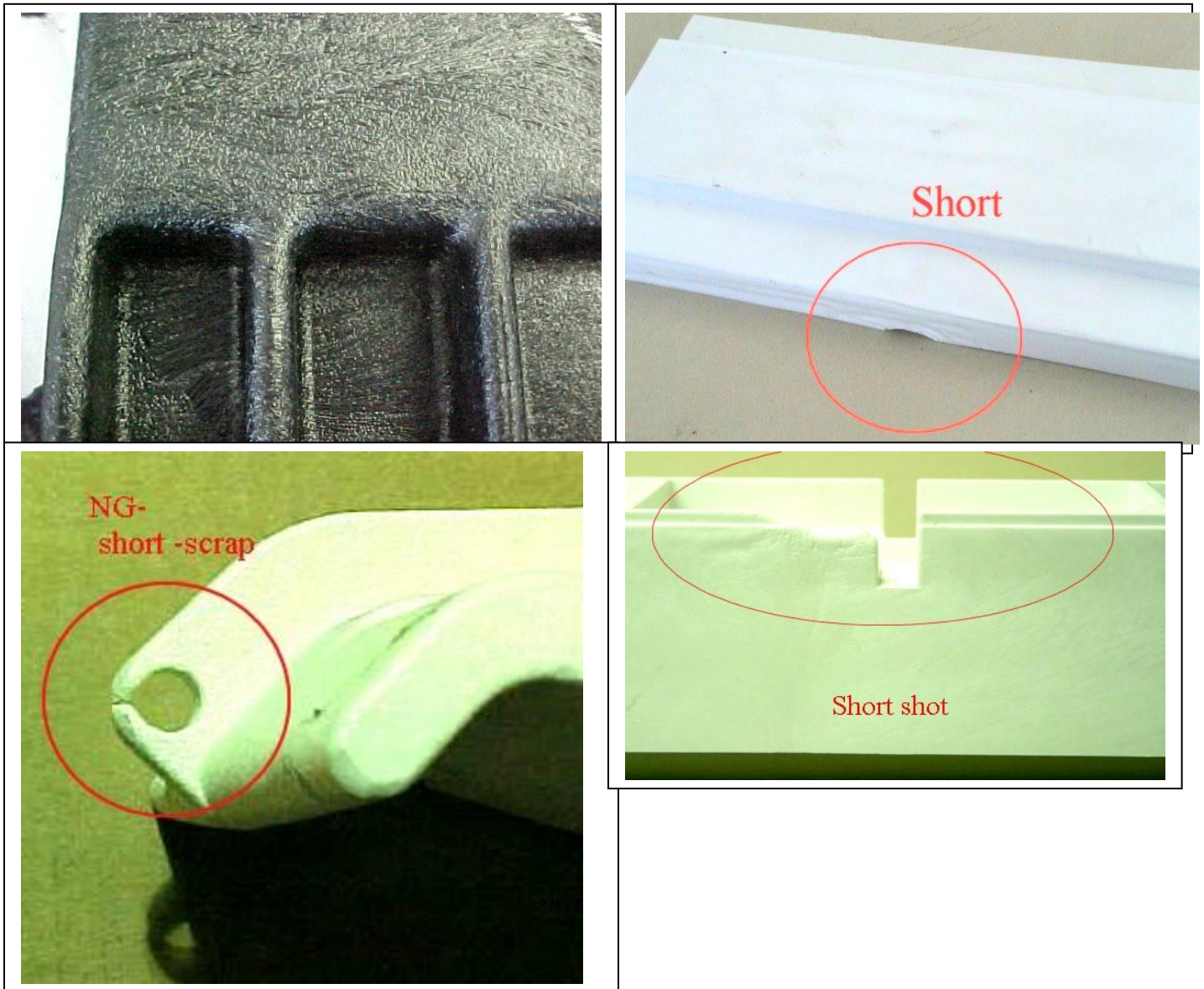
It is the workman-ship of an operator that enhances a molding but can scrap it with the wrong stroke or wrong hand tool.



SHORT SHOT

Short shots are not acceptable. As the name implies, the molding is not fully filled out with material. But then there are weight sensitive products, where the molded part can look perfectly normal but is under weight as per customers weight standard and should not be packaged

Reasons for a process going short are several, but the main reason is when the machine is not cycled consistently by the operator. Consistency is the key for good product.



BLOWING

Blowing can appear as a surface swelling, like a bump or distortion on a part.

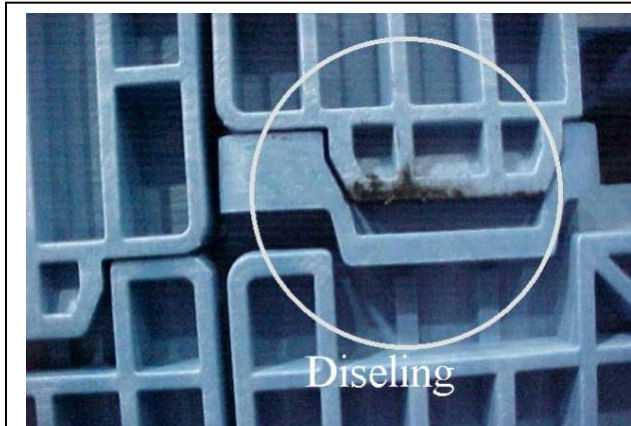
Usually blowing occurs in structural foam molding within thick areas of material, like opposite bosses or ribs. It happens when the material has not cooled enough internally, and is still soft, gases expand and pushing the skin out.

In Webb molding it can blow when the gas ports are plugged after part is ejected, And the gas expands pushing the walls out.



CONTAMINATION

Product material contamination is a process problem, which mostly occurs on light colored products. Where dark dis-colored specs or streaks appear within the molded surface. There are number of possibilities where contamination originate from. As a rule unsightly contaminated product is not acceptable, but there are exceptions, always check the part specifications for acceptance level.



SINKS

Sinks are not always a reason for rejection. It depends on where they are, how deep the sink is, and on the part surface requirements. Have QA set an acceptance level with a signed sample for maximum sinks permissible. Sinks can be a sign of lack of gas or part under weight. Review Boundary sample for acceptance criteria.

