

Thermoforming Trouble Shooting Guide

Thermoforming Troubleshooting Guide*

Contents

- Blister or bubbles
- 2. Incomplete forming, poor detail
- 3. Sheet scorched
- 4. Blushing or change in color intensity
- Whitening of sheet
- Webbing, bridging or wrinkling.
- Nipples on mold side of formed part
- Too much sag
- 9. Sag variation between sheet blanks
- 10. Chill marks or "Mark-Off" lines on part
- Bad surface markings
- 12. Shiny streaks on part
- 13. Excessive post shrinkage or distortion of partafter removing from mold
- 14. Part warpage
- Poor wall thickness distribution and excessivethinning in some areas
- Non-uniform pre-stretch bubble
- 17. Shrink marks on part, especially in corner areas(inside radius of molds)
- Too thin comers in deep draws
- 19. Part sticking to mold
- Sheet sticking to plug assist
- 21. Tearing of part when forming
- 22. Cracking in corners during service

"Adapted from "Plastics Engineering Handbook" of the Society of the Plastics Industry, Inc.

Thermoforming Troubleshooting Guide

Padhraic Smyth

Thermoforming Troubleshooting Guide:

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