



# Process Trouble-Shooting Guidelines

Problem	Crystalline Materials		Amorphous Materials	
	Lower/Reduce	Raise/Increase	Lower/Reduce	Raise/Increase
Splay	Injection Pressure	Melt Temp	Melt Temp	Mold Temp
	Holding Pressure Time	Mold Temp	Moisture Content	Gate Size
	Injection Speed	Gate Size	Injection Pressure	
	Mold Release Spray		Screw Speed	
			Hold Pressure Time	
Flash	Melt Temp	Clamp Pressure	Melt Temp	Clamp Pressure
	Mold Temp		Mold Temp	
	Injection Pressure		Injection Pressure	
	Hold Pressure Time		Injection Speed	
	Injection Speed			
Voids	Melt Temp	Mold Temp	Melt Temp	Mold Temp
	Moisture Content	Gate Size	Moisture Content	Gate Size
	Cooling Time	Injection Pressure	Cooling Time	Injection Pressure
		Back Pressure	Injection Speed	Back Pressure
		Hold Pressure Time		Hold Pressure Time
Warpage	Melt Temp	Cooling Time	Melt Temp	Hold Pressure Time
	Mold Temp	Injection Speed	Mold Temp	Cooling Time
	Injection Pressure		Injection Pressure	
Sinks	Mold Release Spray		Back Pressure	
	Mold Temp	Melt Temp	Mold Temp	Gate Size
		Gate Size		Injection Pressure
		Injection Pressure		Hold Pressure Time
		Hold Pressure Time		Injection Speed
		Injection Speed		Venting
		Cushion		
	Venting			
Short Shot		Melt Temp		Melt Temp
		Mold Temp		Mold Temp
		Gate Size		Gate Size
		Injection Pressure		Injection Pressure
		Hold Pressure Time		Hold Pressure Time
		Injection Speed		Injection Speed
Glossiness	Mold Release Spray	Melt Temp	Mold Release Spray	Melt Temp
		Mold Temp		Mold Temp
		Injection Pressure		Injection Pressure
		Injection Speed		Hold Pressure Time
		Venting		Injection Speed
Parts Sticking			Venting	
	Melt Temp	Mold Release Spray	Melt Temp	Mold Release Spray
	Mold Temp		Mold Temp	
	Injection Pressure		Injection Pressure	
	Hold Pressure Time		Hold Pressure Time	
	Cooling Time		Cooling Time	
	Injection Speed		Injection Speed	
Brittleness	Melt Temp	Gate Size	Moisture Content	Gate Size
	Moisture Content	Venting	Injection Pressure	Venting
	Injection Pressure		Back Pressure	
	Back Pressure		Screw Speed	
	Screw Speed		Hold Pressure Time	
	Hold Pressure Time		Cushion	
	Cushion		Regrind	
	Regrind		Mold Release Spray	
	Mold Release Spray			
Burn Marks	Injection Pressure	Venting	Melt Temp	Gate Size
	Injection Speed		Injection Pressure	Venting
Delamination	Melt Temp	Mold Temp	Moisture Content	Mold Temp
	Injection Speed	Gate Size		Gate Size
Weld Lines	Moisture Content	Melt Temp	Moisture Content	Melt Temp
		Mold Temp		Mold Temp
		Gate Size		Gate Size
		Injection Pressure		Injection Pressure
		Hold Pressure Time		Hold Pressure Time
		Injection Speed		Injection Speed
		Venting		Venting
Jetting	Injection Speed	Melt Temp	Injection Speed	Melt Temp
	Hold Pressure Time	Mold Temp		Mold Temp
	Injection Pressure	Gate Size		Gate Size

# IMS MicroMax Air Cooled Mold Chillers

*BIG cooling / SMALL footprint*



Our fractional tonnage MicroMax Air Cooled Mold Chillers command a lot of attention for their compact size and powerful cooling capabilities. These chillers are ideal for use with smaller applications and molding machines. Select from a range of BTUs, reservoir and pump size to suit your process. MicroMax Chillers free up floor space, while providing the cooling power you need to keep your presses running efficiently.



Electronic Control Panel

Stainless steel and copper plumbing

Photo representative

### Purchasers also order:

- Mold Chiller Flushing Fluid, page 736

MicroMax 180			MicroMax 250			MicroMax 500		
Chiller Rating	60° F & 95° F Ambient		Chiller Rating	60° F & 95° F Ambient		Chiller Rating	60° F & 95° F Ambient	
BTUs per Hour	1690		BTUs per Hour	3760		BTUs per Hour	5040	
Dimensions	22L x 19W x 25H		Dimensions	22L x 21W x 27H		Dimensions	22L x 21W x 27H	
Voltage	115/1/60	N/A	Voltage	115/1/60	N/A	Voltage	115/1/60	230/1/60
Item #	147701	N/A	Item #	147702	N/A	Item #	147703	147704
Price	\$2,477	N/A	Price	\$2,842	N/A	Price	\$3,270	\$3,270
Casters	Included		Casters	Included		Casters	Included	
Pipe Diameter	1/2"		Pipe Diameter	1/2"		Pipe Diameter	1/2"	
Pump HP	1/4		Pump HP	1/4		Pump HP	1/4	
Pump GPM	2		Pump GPM	4		Pump GPM	4	
Pump PSI	50		Pump PSI	50		Pump PSI	50	
Tank Size	5 Gal		Tank Size	5 Gal		Tank Size	5 Gal	
Unit Weight	160 lbs.		Unit Weight	210 lbs.		Unit Weight	210 lbs.	

MicroMax 750			MicroMax 1000			MicroMax 1500		
Chiller Rating	60° F & 95° F Ambient		Chiller Rating	60° F & 95° F Ambient		Chiller Rating	60° F & 95° F Ambient	
BTUs per Hour	7230		BTUs per Hour	11360		BTUs per Hour	17000	
Dimensions	29L x 26W x 32H		Dimensions	29L x 26W x 32H		Dimensions	29L x 26W x 32H	
Voltage	N/A	230/1/60	Voltage	230/1/60	460/3/60	Voltage	230/1/60	460/3/60
Item #	N/A	147705	Item #	147706	147707	Item #	147708	147709
Price	N/A	\$3,687	Price	\$3,854	\$4,248	Price	\$4,325	\$4,756
Casters	Included		Casters	Included		Casters	Included	
Pipe Diameter	1/2"		Pipe Diameter	1"		Pipe Diameter	1"	
Pump HP	1/3		Pump HP	1/3	1	Pump HP	.33	1
Pump GPM	4		Pump GPM	4	10	Pump GPM	4	10
Pump PSI	50		Pump PSI	50	35	Pump PSI	50	35
Tank Size	10 Gal		Tank Size	10 Gal		Tank Size	10 Gal	
Unit Weight	235 lbs.		Unit Weight	260 lbs.	450 lbs.	Unit Weight	500 lbs.	550 lbs.



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= Industry Standard Quality Products



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