

Problem	Cause	Solution
Parts adhere to tool.	<ol style="list-style-type: none"> 1. Improper application or curing of release agent 2. Release agent is inadequate. 3. Compound or process change. 4. Dirty tool surface. 	<p>Follow recommended procedure for application of release agent</p> <p>Check release agent for contamination and stability.</p> <p>Insure original testing parameters.</p> <p>Insure the tool surface is clean and properly rinsed and neutralized if a chemical cleaner is used.</p>
<p>Excessive transfer of release agent to molded parts (knit lines, flow lines, non-fills). Release agent transfers to injected rubber thereby preventing rubber to rubber bonding.</p> <p>Note: If using sacrificial release agent, evaluate a semi-permanent.</p>	<ol style="list-style-type: none"> 1. Over application of mold release. 2. Improperly cured mold release 3. Dirty tool surface 4. Incorrect dilution ratio. 	<p>Apply less release agent to mold surface.</p> <p>Insure proper tool temperature and application of mold release. Consult the TDS.</p> <p>Insure the tool surface is clean and properly rinsed and neutralized.</p> <p>Insure proper dilution of mold release on concentrated materials</p>
Inability to achieve proper number of multiple releases.	<ol style="list-style-type: none"> 1. Improper application or curing of release agent 2. Dirty tool surface 3. Compound or process change 	<p>Follow recommended procedure for application of release agent (base coat and touch up).</p> <p>Insure the tool surface is clean and properly rinsed and neutralized.</p> <p>Insure original testing parameters are being used.</p>
Localized sticking. Molded parts tear; rubber sticks in the mold.	<ol style="list-style-type: none"> 1. Uneven or non-uniform application of release agent 2. Dirty tool surface 	<p>Follow recommended procedure for application of release agent.</p> <p>Insure the tool surface is clean and proper maintenance is followed.</p>
<p>Build-up on molding surface (release agent or rubber). Overall tool cleanliness.</p> <p>Note: If using sacrificial release agent, evaluate a semi-permanent.</p>	<ol style="list-style-type: none"> 1. Over application of release agent. 2. Poor release of molded part. 	<p>Follow recommended procedure for application of release agent.</p> <p>Refer to solutions above.</p>
Parts Cosmetics. Defects associated with appearance and/or part design.	<ol style="list-style-type: none"> 1. Uneven or non-uniform application of release agent 2. Dirty tool surface 	<p>Follow recommended procedure for application of release agent (base coat and touch up).</p> <p>Insure the tool surface is clean and properly rinsed and neutralized.</p>