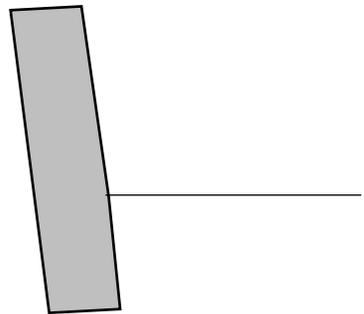
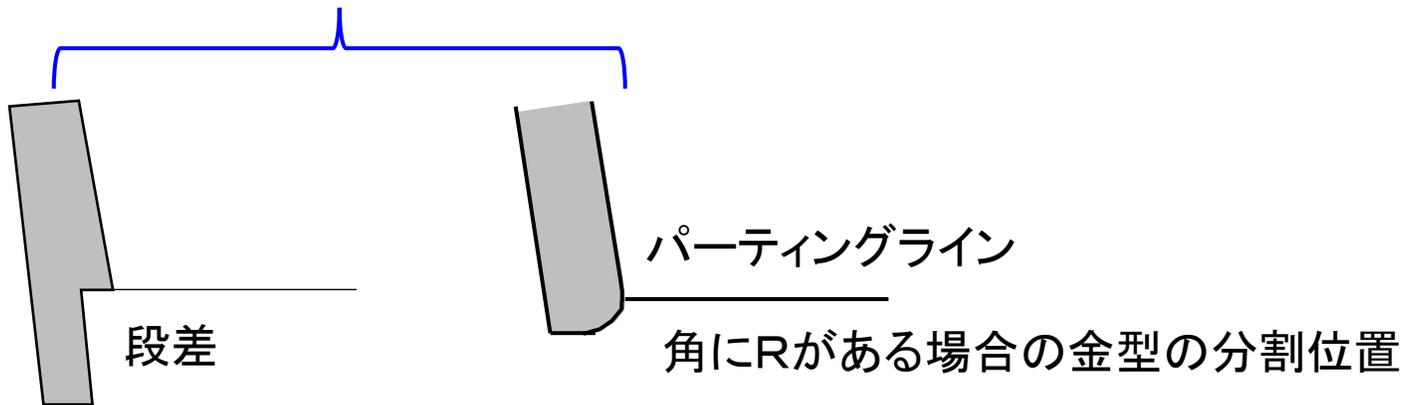


× 分割線が出る



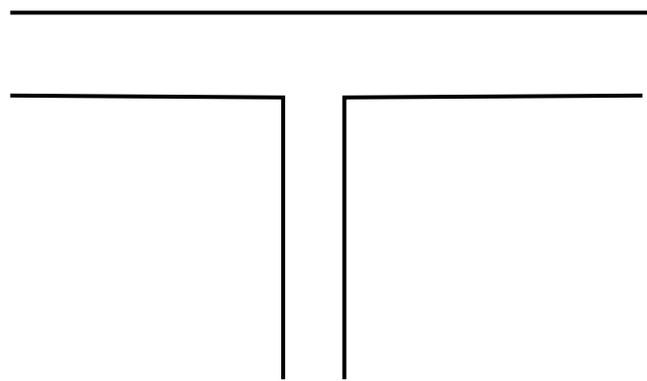
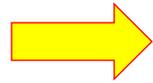
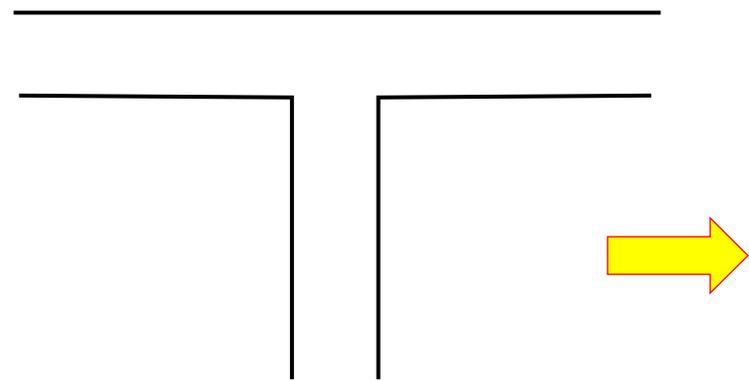
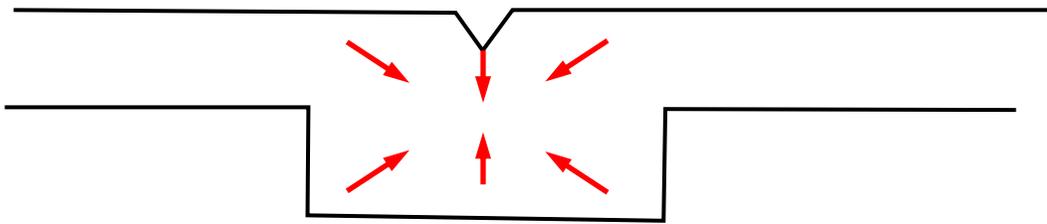
○ 分割線が目立たない



ヒケ

製品の表面がくぼむ現象

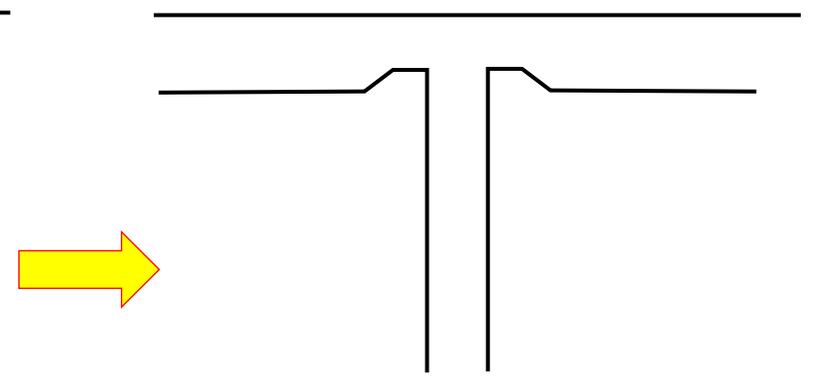
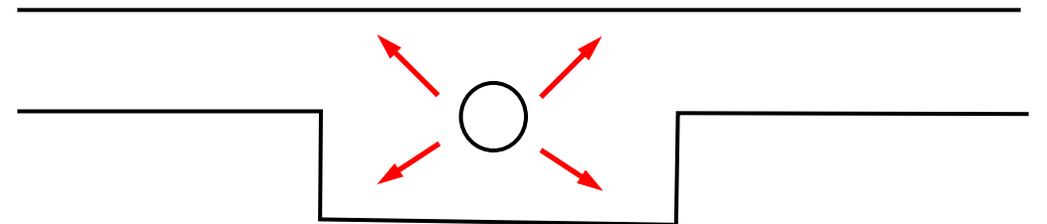
厚肉部分、リブ・ボスが裏側にあると発生しやすい



リブの薄肉化

ボイド

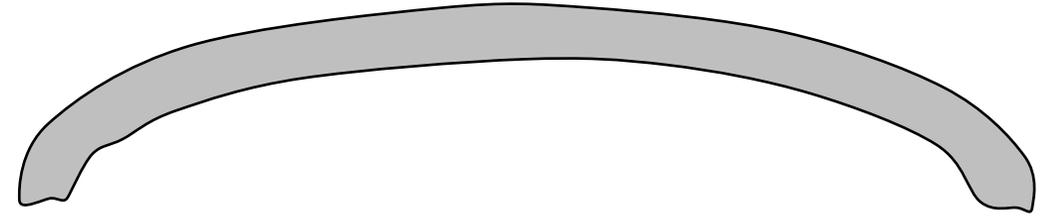
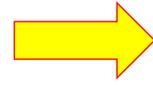
製品の内部に気泡ができる現象



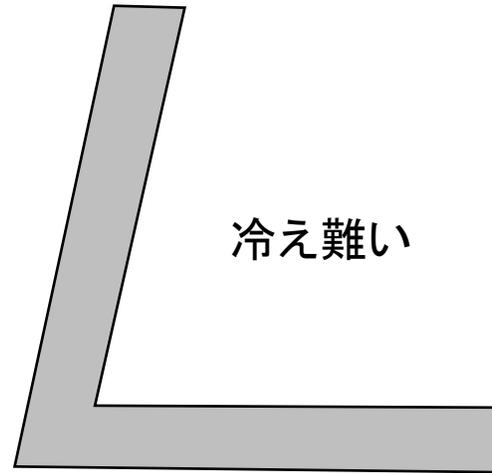
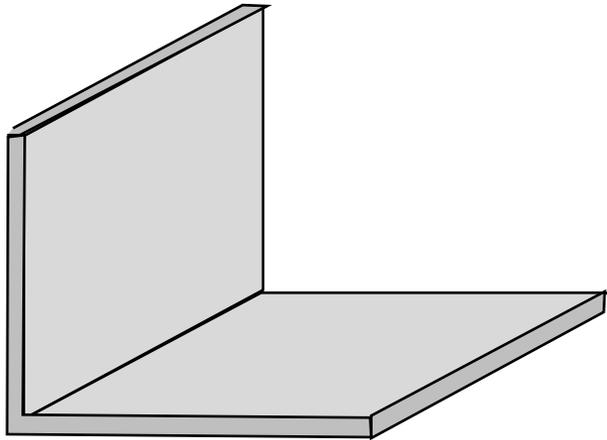
肉盗み

ソリ

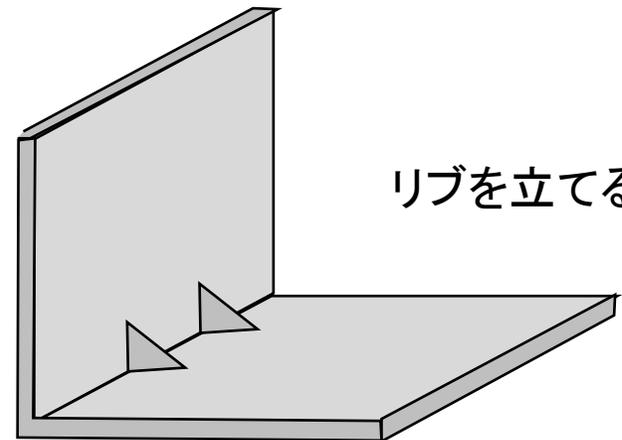
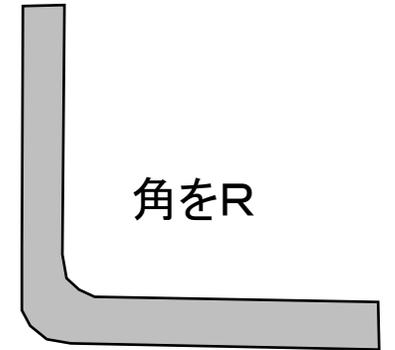
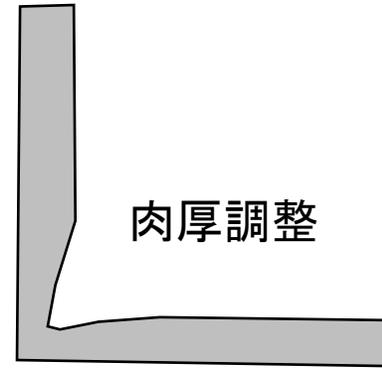
低温側 → 収縮小さい



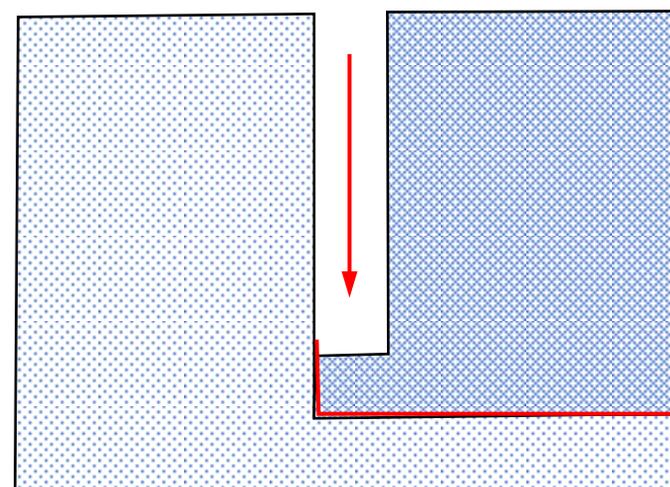
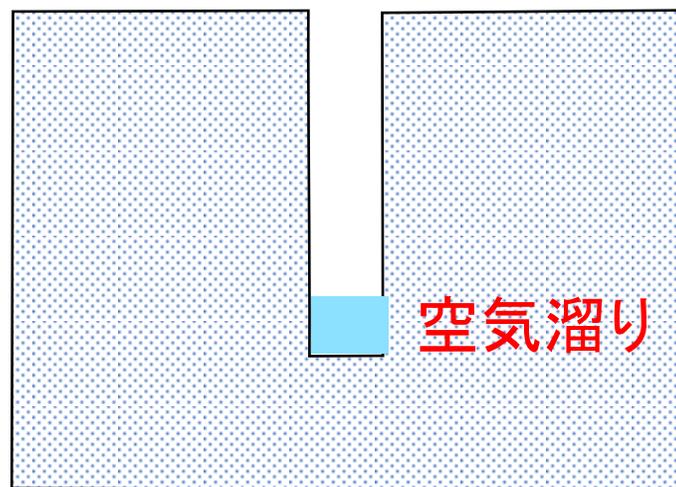
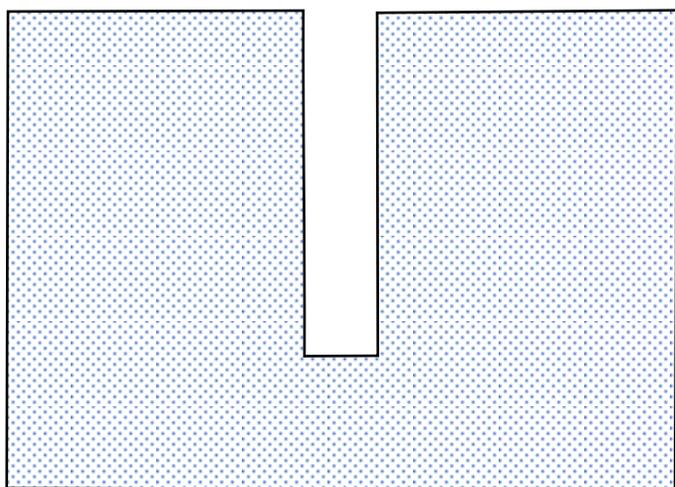
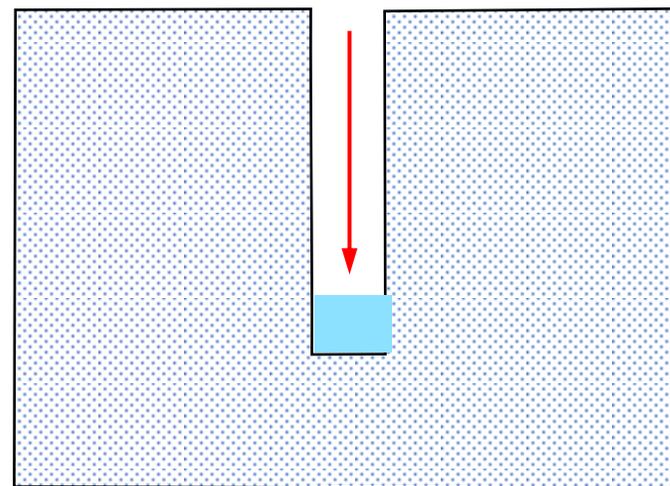
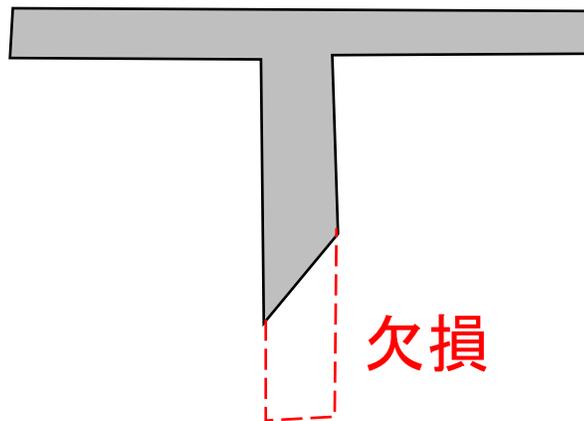
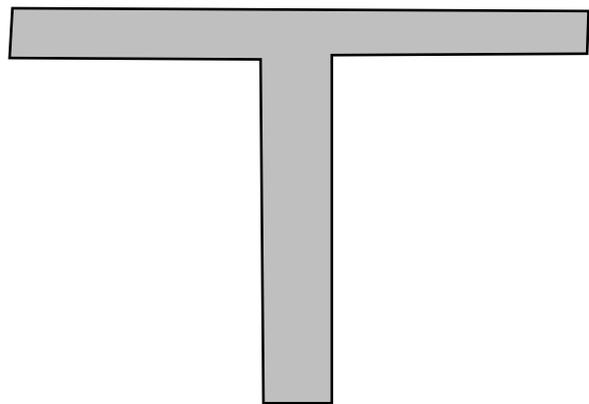
高温側 → 収縮大きい



冷え易い

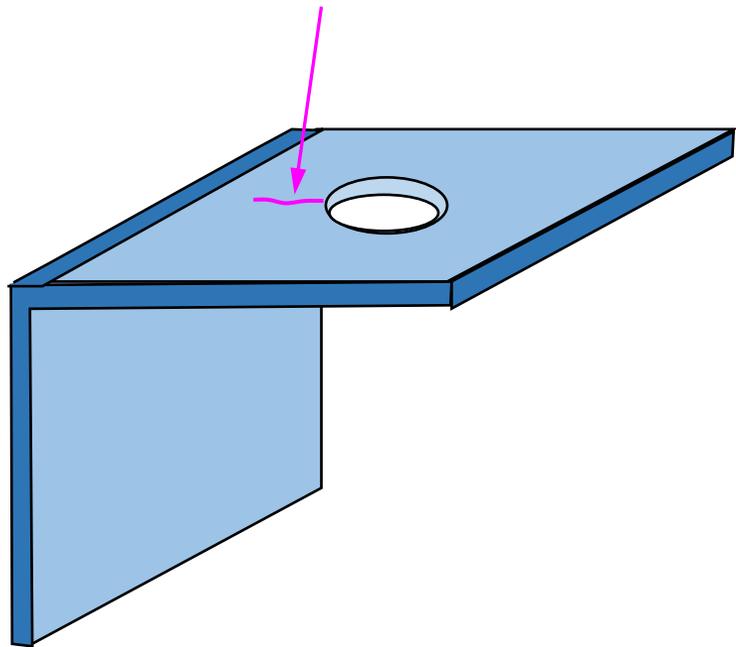


ショートショート

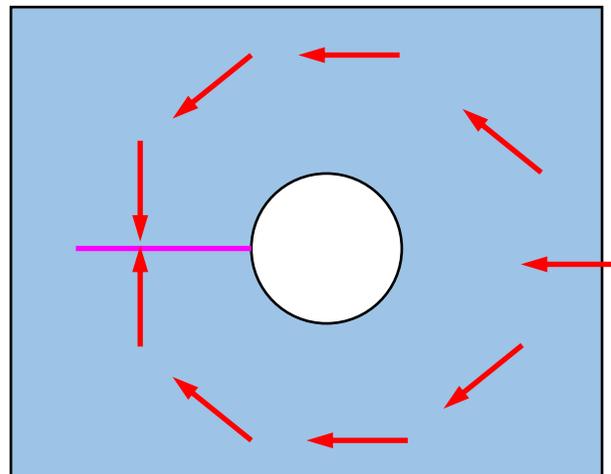


ガス抜き

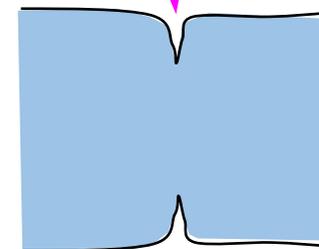
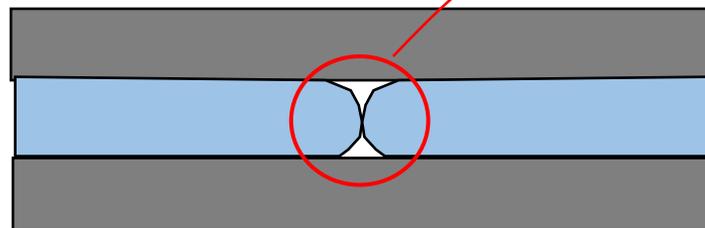
ウェルドライン



上から見た図



ウェルドライン



側面から見た図

バリ

発生原因

1. 金型の摩耗
2. 成形金型の締め力不足
3. パーティングラインが複雑

