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White Spots

A general light or whitened area on a pigmented surface that occurs as a result of thermoplastic separation. The problem is associated with pitting occurring in the white spotted area.	
Probable Cause	
<i>Material</i>	<ul style="list-style-type: none"> • Low viscosity builds of SMC through maturation • Thermoplastic incompatibility with SMC formulations • Flow restrictions
<i>Process</i>	
<i>Tooling</i>	
Corrective Action	
<i>Material</i>	<ul style="list-style-type: none"> • Verify day 1 viscosity • Record occurrence and roll yardage when problem occurs • Record material rates and lot number when problem occurs • Verify spiral flow of material
<i>Process</i>	<ul style="list-style-type: none"> • Verify load pattern is correct according to engineering specification • Reduce die coverage to allow for increased flow
<i>Tooling</i>	