

Our commitment to servicing our customers with quality product at competitive price and on-time delivery is backed by our continued investment in our equipment. Our employees and in our systems . ABIS is a full service molding that a 12 000 square foot facility housing our molding department in-housing mold making , quality control. Warehousing secondary operations and offices , If we find a client's product concept would be too costly to manufacture . We will assist the customer in designing parts that not only can be manufacture but one that can be made cost-effectively from prototype to production. With our extensive experience we are confident . We have the solution to your next injection molding application.





Product Description

Part Name	Making Plastic Lunch Box Mould
Description	Household Appliance
Country of Original	ShenZhen, China (Mainland)

Brand Name	ABIS
Lead Time	25-30Days

Payment Terms

1. T/T: 40% Deposit,30% upon T1 Sample,30% Balance before shipment
2. L/C: irrevocable 100% L/C at sight.

General Information

Item#	Item	Description
1	Product Name	Making Plastic Lunch Box Mould
2	M o l d b a s e	LKM;HASCO;DME
3	Mould material	NAK80, S136, 2316, 2738, H13, 5CrNiMo, 718H, P20, 4Cr, 60#, 45# etc
4	Plastic Material	PP, PC, PS, PE, PU, PVC, ABS, PMMA, ect.
5	Sprue gate	Hot runner, Cold runner, Pin-point gate, Submarine gate etc
6	Main process	Milling, grinding, CNC, EDM, wire-electrode cutting, carving, d, electrospark, lathe, etc
7	Surface treatment	Words corrosion, mirror polish ,frosted surface or texture surface
8	Design software	UG,PROE,CAD,SOLIDWORK
9	Runner	Hot Runner\ Cold Runner
10	Mold life	300,000-3,000,000 shots
11	Lead time	25-30Days
12	Transportation	By sea, by air or by land as you request
13	Package	According to clients requirement
14	Cavity	Single or multi

Processing Equipment

NAME OF MACHINE	BRAND	Q'TY	PLACE OF ORIGIN
CNC	DMG	1	Germany
CNC	YCM-FP66A	2	Taiwan
EDM AQ35L	SODICK	3	Japan
Wire EDM AQ327L	SODICK	2	Japan
EDM	CHARMILLES-35P	2	Swiss
EDM	TAIWAN NUMERIC CONTROL	6	Taiwan
Wire cutting machine	QIGNYUAN	4	Shanghai
digital display milling machine	YINGSHUN	8	Taiwan
digital display grinding machine	SUHRE	8	Taiwan
Injection molding machine	HAITIAN	11	China
3 Dimension Coordinate	DABAO	1	Taiwan
JD 12-300digital display projection apparatus	PROJECTOR	1	China

Dimension Report and Sampling Parameter

Dimension Inspection Report

Customer	SMR	Mold Trial#	T1	Unit	Metric	Picture	
Project #	Phase 2	Trial date	2014.12.29	Inspection date	2015.01.08		
Part Name	B876_SCAIP without TS_RH	Mold number	ABIS 2014128	Inspector	Mr. Li		
Part / Draw #	60063006D #2	Material	ABS MP 0160R	Manager	/		

Inspection Tools: Block gauge (BG), Caliper (CP), Coordinate Measuring Machine (CMM), Height gauge (HG), Mikrometer (MM), Projector (PJ), Pin gauge (PG), Rad (RG), Thickness gauge (TG)

Dimension spec				Shot 1		Shot 2		Shot 3		Shot 4		Judgment	
Dim #	Dimension	Tolerance	Inspection Tool	1	2	1	2	1	2	1	2	OK / NG	Remark
1-1	1.20	+ 0.20 - 0.20	CP	1.19	1.23	1.22	1.24	1.22	1.23	1.20	1.21	OK	
1-2	1.20	+ 0.20 - 0.20	CP	1.21	1.22	1.20	1.20	1.21	1.23	1.22	1.20	OK	
2-7	1.50	+ 0.20 - 0.20	CP	1.51	1.52	1.52	1.53	1.51	1.50	1.49	1.52	OK	
2-8	1.50	+ 0.20 - 0.20	CP	1.52	1.52	1.52	1.52	1.51	1.53	1.49	1.51	OK	
2-9	1.50	+ 0.20 - 0.20	CP	1.51	1.52	1.52	1.52	1.51	1.50	1.49	1.50	OK	
3-1	1.70	+ 0.20 - 0.20	PJ	1.72	1.69	1.70	1.69	1.70	1.71	1.73	1.70	OK	
3-2	1.70	+ 0.20 - 0.20	PJ	1.71	1.72	1.69	1.70	1.71	1.72	1.71	1.72	OK	
3-3	1.70	+ 0.20 - 0.20	PJ	1.71	1.72	1.71	1.70	1.69	1.70	1.69	1.71	OK	
3-4	1.70	+ 0.20 - 0.20	PJ	1.69	1.70	1.70	1.71	1.72	1.71	1.73	1.71	OK	
3-5	1.70	+ 0.20 - 0.20	PJ	1.71	1.71	1.72	1.73	1.71	1.71	1.72	1.73	OK	
3-6	1.70	+ 0.20	PJ	1.71	1.72	1.73	1.71	1.72	1.71	1.71	1.72	#REF!	
Prepared		Mr. Lillian		Checked		Mr. Li		Approved		Mr. Zhang			
Date		2015.01.10		Date		2015.01.08		Date		2015.01.08			

To be completed by customer:

Signature: _____

Result:	☒ Pass	☐ Fail	☐ Special Acceptance
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ABIS MOLD INJECTION PARAMETER REPORT

> 类型 Shot Type:		☒ 单色 One shot mold	☐ 双色第一次 1st shot of 2-shot	☐ 双色第二次 2nd shot of 2-shot
模具编号 Tool No.		产品名称 Part Name		模具规格(mm) Tool L*W*H
模腔数量 N° Cavity		塑胶原料 Raw Material		颜色 Color
产品总重量 Gross Wt(g)		机台型号 Press Type		试模数量(啤数) Shot Qty
试模日期 Test Date		上机时间 Beginning Time		完成时间 Finish Time
				试模次数 Test times
				项目负责人 Project Manager
				设计工程师 Design Engineer
				审核 Review ed /日期 Date

***试模前的准备:** 试模单、产品图纸、物料表、卡尺、模温计、注温机、温控箱、电子天平、照相机、打磨机(用于调整浇口直径)等工具

备注 Comments:

> 成型参数表 Molding Parameter Sheet:

时间 Time(s)	周期时间 Cycle Time			温度设定 Temp(°C) Setup	喷嘴温度 Nozzle Temp °C		
	填充时间 Filling Time				一段温度 Zone 1 Temp °C		
	保压时间 Holding Time				二段温度 Zone 2 Temp °C		
	冷却时间 Cooling Time				三段温度 Zone 3 Temp °C		
压力 Pressure (Bar) (1Mpa=10Bar =145Psi)	射胶压力 Injection Pressure	一段 1st Stage		速度或速率 Percent of Speed(mm/s) or Flow Rate(g/s)	四段温度 Zone 4 Temp °C		
		二段 2nd Stage			热流道温度 Hot Runner Temp °C		
		三段 3rd Stage			前模设定温度 Cavity Temp. Setup		
		四段 4th Stage			后模设定温度 Core Temp. Setup		
	保压压力 Holding Pressure	一段 1st Stage			行位设定温度 Slide Temp. Setup		
		二段 2nd Stage			射胶速率一段 Injection Speed 1		
	储料压力 Charge Pressure				射胶速率二段 Injection Speed 2		
背压 Back Pressure			射胶速率三段 Injection Speed 3				
位置 Position(mm)	射胶位置 1st Inj. End Position			原料干燥 Raw Material	射胶速率四段 Injection Speed 4		
	射胶位置 2nd Inj. End Position				保压速率 1st Holding Speed		
	射胶位置 3rd Inj. End Position				保压速率 2nd Holding Speed		
	射胶终止位置 Inj. End Position				保压转换 Turn Hold(time/pos.)		
	熔胶终止位置 Melt End Position				熔胶速率 Charge Speed		
	射退位置 Suck Back End Position				干燥温度 Drying Temp(°C)		
模具 Tool	锁模压力 Clamp Pressure			实际模温 Actual Temperature (°C)	前模表面 Cavity Surface	机水 Normal Water	
	开模压力 Opening Pressure					热油 Hot Oil	
	顶出行程 Ejection Stroke					凉水 Cool Water	
	顶出次数 Count of Ejection				后模表面 Core Surface	机水 Normal Water	
	抽胶机构 Side Action(组Unit)					热油 Hot Oil	
顶出 Ejection (%)	托模进 Forward	压力 Pressure				行位表面 Slide Surface	机水 Normal Water
		速度 Speed			热油 Hot Oil		
	托模退 Backward	压力 Pressure			凉水 Cool Water		
		速度 Speed					

> 产品外观问题/Product Appearance Faults:

☐ 粘前模 Sticking in Cav	☐ 抛光不良 Poor Polishing	☐ 披锋 Flash	☐ 裂痕 Stress Crack	☐ 结合线 Weld L
☐ 粘后模 Sticking in Core	☐ 顶出不顺 Uneven Eject	☐ 顶台 Ejector Marks	☐ 喷射痕 Jetting	☐ 黑点 Dark Spot
☐ 水纹 Water Wave Marks	☐ 拖花 Scratch Marks	☐ 变形 Deformation	☐ 缺胶 Short Filling	☐ 烧焦 Burn Mark
☐ 冷料流痕 Cold Slug Marks	☐ 困气 Gas Trap Effect	☐ 缩水 Sink Marks	☐ 胶纹 Gap	☐ 气泡 Air Bubble

> 试模过程检查/Tryout Process Check:

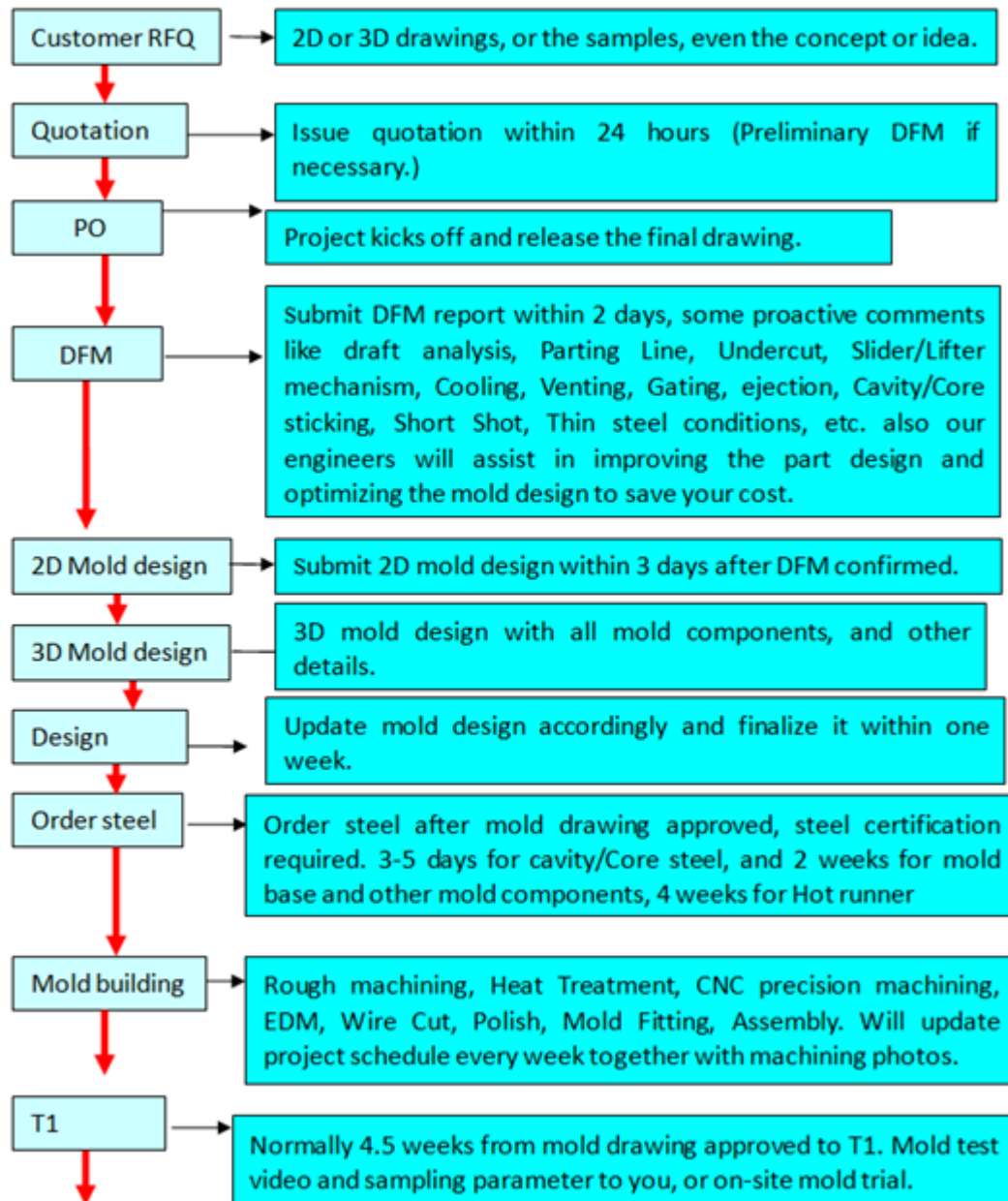
开合模动作检查	模具漏水检查	流动平衡检查, 填充30%、60%、90%
模具顶出动作检查	快速填充检查模具排气	填充99%检查毛边、缩水与变形

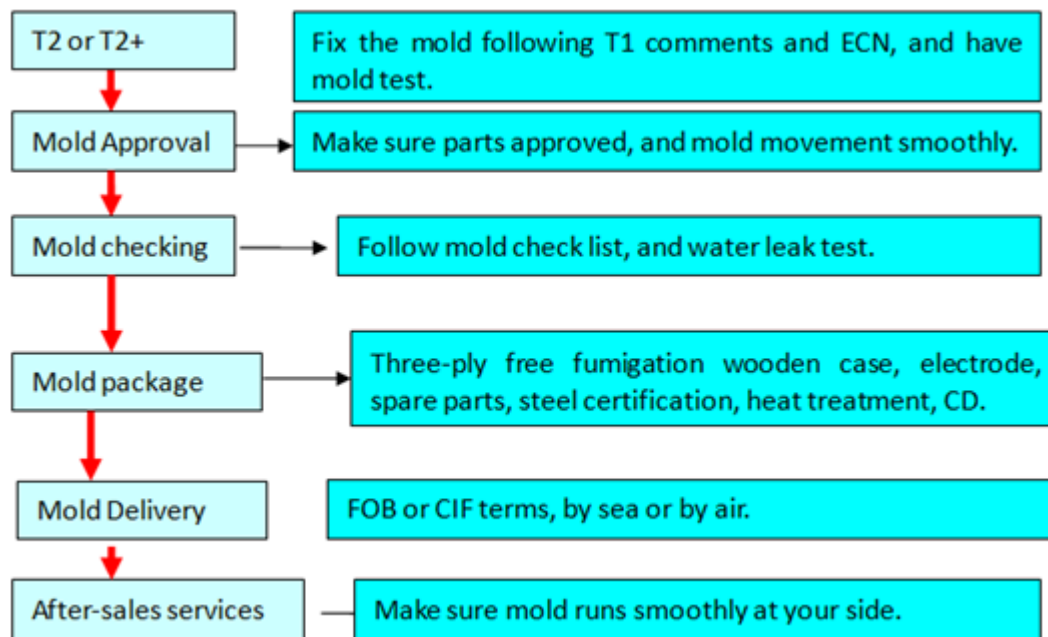
> 试模问题点描述及建议/Comments:

问题: 产品毛边/破折纹
对策: 飞模/流道加大/进胶口加大/冷料井加大

记录 Record	日期 Date	审核 Review ed	日期 Date
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Working process:





Company

Information

ABIS was founded in Shenzhen China, adjacent to Hong Kong, in 1996, has its own factory of 12,000 square meters. With the advanced facilities from Germany, Swiss and Japan, and a highly experienced design and engineering team, ABIS builds multi-cavity molds to exacting tolerances, providing the critical structural foundation for leading manufacturing companies to produce high precision mold.

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|-------------|---------|---------------|--------------------|-------------|---|
| ABIS | Mold | which | engaged | in | : |
| 1. Cold&Hot | Runner/ | Single&Multi- | Cavity-Injection | moulding | |
| 2. | | Single&Multi- | | Shot | |
| 3. | Die | | Cast-Aluminum&Zinc | | |
| 4. | | Inserting | | Mold | |
| 5. | | | | Overmolding | |
| 6. | | Prototype | | Tooling | |
| 7 | | Mass | | Production | |

ABIS applies advanced software for mold design-Auto CAD, UG, Solid works and ProE etc. So far, ABIS has received the "ISO 9001", "ROHS" green, SGS certificate.

BEIJING HANGXIE CERTIFICATION CENTER CO. QUALITY MANAGEMENT SYST CERTIFICATION ABIS MOLD TECHNOLOGY(HK)CO.,L Organization Code: 55388449- No.102, Building B, Ying Keli Industry Area, Longgang District, Shenzhen, China. P.C.518 is in conformity with GB/T19001-2008 (ISO9001:2008) This certificate is covering the following product scope Plastic Mold Development and Manufacturing; Plastic Products P (Not Include the Products With Administrative Licensing Registration No. 03415Q20263R0M The Duration of Validity Feb . 10, 2015—Feb . 09, 2018 MANAGEMENT SYSTEM CNAS CB34-Q BEIJING HAN CERTIFICATION CE General Manager: <i>[Signature]</i> After this certificate is issued, there should be at least 2 surveillance audits within the 3 year period of valid validity of the certificate can be checked on : www.hkxco.com.cn The certificate information is avail official website of the National Certification and Accreditation Administrator : www.cca.gov.cn It is also available by scanning the two dimensional code at the bottom right corner. Address : NO.7 Jingshun Road, Cheoyang District, Beijing, China.	<i>Certificate</i> Certificate No. : 114175 This is to certify that the Occupational Health and Safety Management SHENZHEN ABIS PRECISION HARDW PLASTIC CO., LTD. Unified Social Credit Code: 91440300553884491N Registered/Production/Office Address: Yingkel Industrial District: B Building No. 102, Shabei Longdong Community, Longgang Street, Longgang I Guangdong Province, China Sales Address: Yingkel Industrial District C Building 1/F, Shabei Village, Longdong Commu Street, Longgang District, Shenzhen, Guangdong Province, China Has been audited to conform to the following Occupational Health ; Management System standard GB/T 28001-2011 idt OHSAS 18001:20 This Occupational Health and Safety Management System is valid Development and production of plastic mould; sales plastic parts and related Occupational health and saf management activities of involved sites Initial issued date: May. 16, 2017 Date of issue: May. 15, 2017 Date of expiry: May. 15, 2020 Issued by: <i>Wu Fanyue</i> Beijing East Allreach Certification Cen The certificate will remain valid only if the certified organization accepts surveillance audit at regular intervals and is subject to be audited. Please note the surveillance audit conforming mark on the designated position of the certificate. The information of this certificate is available at EACC website (www.eacc.com.cn) and CNCA website (www.cca.gov.cn) The 1st Surveillance Conforming Mark The 2nd Surveillance Conforming Mark
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Tooling Shop



QC Control

Mold Making QC main steps

Mould Design Control : Design review checklist before submitting to the customer. We will not start the steel purchasing work until get your written approval on our mold drawing.

Incoming quality control: all steel material and outsourcing standard components will be checked to ensure that they are in accordance with the BOM(QTY and material/components name specified).

In process quality control: all the machining and assembling process is under control, we have QC team to check and supervise the tolerance and processed surface to satisfy the requirements. (Mould Steel Hardness Inspection, Mould Electrodes Inspection, Mould Core and Cavity Steel Dimension Inspection , Mould Pre-Assembly Inspection)

Final quality control: within 3 days the completion of the plastic mold, we will have a thorough check for the main size of the molded plastic sample and mold to ensure that the critical or full dimension (if required) are within tolerance.

Mould Pre-Shipment Final Inspection : Free-fumigation three-plywood case packing; make sure the mold is conformity to the approved mold drawing. The spare components and easily broken components and the electrode (if required) are packaged, as well as the mold drawing and some certificated.

Plastic Molding QC main steps

Vernier caliper measurement is performed by trained operators when the first product is produced on our machine, we check the contour dimension and assembly status (if exist) to identify if any problem.

The molded parts are then inspected again by experienced QA department for the full dimensions, especially the critical dimensions set by customer. If a quality result was recorded at the same time. Result will be to our QC Supervisor directly. If any unqualified dimensions (if exist) are caused by uncontrolled factors or our mistakes and we will take the related actions to improve it.

We will trustily report the T1 result to customer and send T1 samples to customers for checking. Sometimes T1 samples need improvement. If more samples are required by customer at first time, we will take actions to improve the mold to make sure the product have 0 defects. No shrinkage, warpage, flash, streak, air bubble, step line, ejector mark, and dimension within tolerance.

Package inspection: make sure QTY/color and weight are correct.

Packaging & Shipping



Our ABIS Family



- Why choose us?:
1. More than 20-years experience.
 2. ISO9001:2008 certificated.
 3. Competitive price with high quality.
 4. More than 50 machines support to run the business.
 5. Custom R&D program coordination.
 6. Expert technicians.
 8. Diligent and loyal workforce.
 9. Up-to-date software.
 10. International standards, SAY, HASCO, DME, MISUMI, etc
 11. Well-rounded after service.

Lynn Xiao

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We will give our best service, quality, price and delivery time !
If you have any question just call me or send E-mail to me please!

FAQ

Q: How can you confirm the plastic injection mold you produce is the one we need?

A: we can provide professional mold analysis reports before mold making .

Q: What can we do if we don't have the mold drawing ?

A: you will only provide the actual sample to us then we can help you to make the design injection mold drawings for your confirmation

Q: Can we test the plastic injection mold?

A: after the mold is ok ,we can help you to test the mold for free.

Q: Can you process the die-casting parts of injection mold?

A: We can help to process die-casting parts for small run or mass production.

Q: What about the plastic products samples are wrong?

A: if you are not satisfied with the plastic sample, we can send the sample to you again for free.