

OEM Plastic Auto Plastic Injection Mould



ABIS Mold was found in 1996 in Shenzhen, adjacent to HK, China. and we moved to Long gang District in 2010. With the advanced facilities from Germany, Switzerland and Japan, and a highly experienced design and engineering team. Our molding press machine ranges from 40T to 650T, 300+ molds capacity each year, and 70 % are exported to Europe and North America.

In addition to our plastic mold and molding specialties, we also can provide you the services such as die casting, stamping /punching, blowing mold, as well as the secondary process.

Product Description

<i>Part Name</i>	<i>OEM Plastic Auto Plastic I njection Mould</i>
<i>Description</i>	<i>Plastic Injection Mould /Pla stic Auto Mould</i>
<i>Country of Original</i>	<i>China (ShenZhen)</i>
<i>Current Export Markets</i>	<i>North America</i>
<i>Lead Time</i>	<i>30 Days</i>

Key Specification

- 1. Plastic Injection Over Mould*
- 2. Cold Runner Mould*
- 3. Plastic Injection Connector Mould*
- 4. 1*4 Cavity , Ultramid A3K PA66 Material*
- 5. H13 Steel*
- 6. Two - Plate Mould*
- 7. DME Standard Accessories*
- 8. Cycle Time 45s*
- 9. Press 350 Tons*

General Information

Item#	Item	Description
1	Mold standard	DME or HASCO
2	Mold Base	LKM,DME, HASCO, FUTABA
3	Cavity/Core Steel	H13,S-7,S136,SS420,NAK80,P20
4	Hot Runner:	MOULD MASTER, MASTER TIP, HUSKY, HASCO, DME, YUDO, INCOE, THERMOPLAY, SYNVENTIVE .
5	Hydraulic Cylinder	PARKER, TAIYO, STAUBLI, JUFAN
6	Mold Components	DME, Progressive, PCS, Punch, Royal, etc
7	Steel Treatment	Heat Treatment, Nitriding, Chrome Plating
8	Surface Finish:	SPI standard, VDI EDM, Texture, etc
9	Texture:	Mold-tech, Yick Sang, Ni Hong ,Tanazawa etc
10	Plastic Material	PP, PC, ABS, PE, HDPE, PET, POM, PMMA, PA(GF), PBT(GF), PVC, PPS, PEI, PEEK, LCP, PSU
11	Design Software:	CAD,UG, Pro E, Solidworks
12	Value-added Service:	Dust-free Spraying, Silk-screen Printing, Ultrasonic Welding, Thermal Bonding, Assembly, Prototype
13	Export Country:	Europe, USA, Canada, Mexico, Brazil, Australia ,Middle-east , India etc
14	Our Capability:	Auto, Aerospace, Household, Electrical, Industrial, Medial, Toys, Office, Cosmetic, OA Equipment etc

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
digital display projection apparatus		1	China

Dimension Report and Sampling Parameter

 ABIS Tooling & Molding				TEL: +86-755-89984896 EXT:821 • FAX: +86-755-28960682 • Building B, Ying-Ke-Li Industrial Area, Long-Gang District, Shenzhen City, Guang-Dong Province, China P.C: 518116									
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_SCA LP without TS_RH		Mold number	ABIS 2014128		Inspector		Mr. Li					
Part / Draw #	60063006D #2		Material	ABS MP0160R		Manager		/					
Inspection Tools: Block gauge (BG), Caliper (CP), Coordinate Measuring Machine (CMM), Height gauge (HG), Micrometer (MM), Projector (PJ), Pingauge (PG), Radi (RG), Thickness gauge (TG)													
Dimension spec				Shot 1		Shot 2		Shot 3		Shot 4		Judgment	
Dim #	Dimension	Tolerance	Inspection Tools	1	2	1	2	1	2	1	2	OK / NG	Remarks
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			

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	试模次数 Test times		
模腔数量 N Cavity	塑胶原料 Raw Material	颜色 Color	项目负责人 Project Manager		
产品总重量 Gross Wt(g)	机台型号 Press Type	试模数量(模数) Shot Qty	设计工程师 Design Engineer		
试模日期 Test Date	上机时间 Beginning Time	完成时间 Finish Time	审核 Reviewed /日期 Date		

***试模前的准备:** 试模单、产品图纸、物料表、卡尺、模温计、油温机、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	射嘴温度 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 Side Temp. Setup		
		二段 2nd Stage		射胶速率一段 Injection Speed1		
		三段 3rd Stage		射胶速率二段 Injection Speed2		
	储料压力 Charge Pressure			原料干燥 Raw Material	射胶速率三段 Injection Speed3	
背压 Back Pressure		射胶速率四段 Injection Speed4				
		保压速率一 1st Holding Speed				
		保压速率二 2nd Holding Speed				
		保压转换 Turn Hold(time/pos.)				
		熔胶速率 Charge Speed				
位置 Position(mm)	射胶位置 1st Inj. End Position		实际模温 Actual Temperature (°C)	干燥温度 Drying Temp(°C)		
	射胶位置 2nd Inj. End Position			干燥时间 Drying Time(H)		
	射胶位置 3rd Inj. End Position			前模表面 Cavity Surface	机水 Normal Water	
	射胶终止位置 Inj. End Position				热油 Hot Oil	
	熔胶终止位置 Melt End Position				凉水 Cool Water	
	射退位置 Suck Back End Position				后模表面 Core Surface	机水 Normal Water
		热油 Hot Oil				
		凉水 Cool Water				
		行位表面 Side Surface				
		顶出 Ejection (%)	托模进 Forward	压力 Pressure	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		行位表面 Side Surface			

> 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	☐ 熔合线 Weld L
☐ 粘后模 Sticking in Core	☐ 顶出不顺 Uneven Eject	☐ 顶白 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 Mar
☐ 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	模具送水检查	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

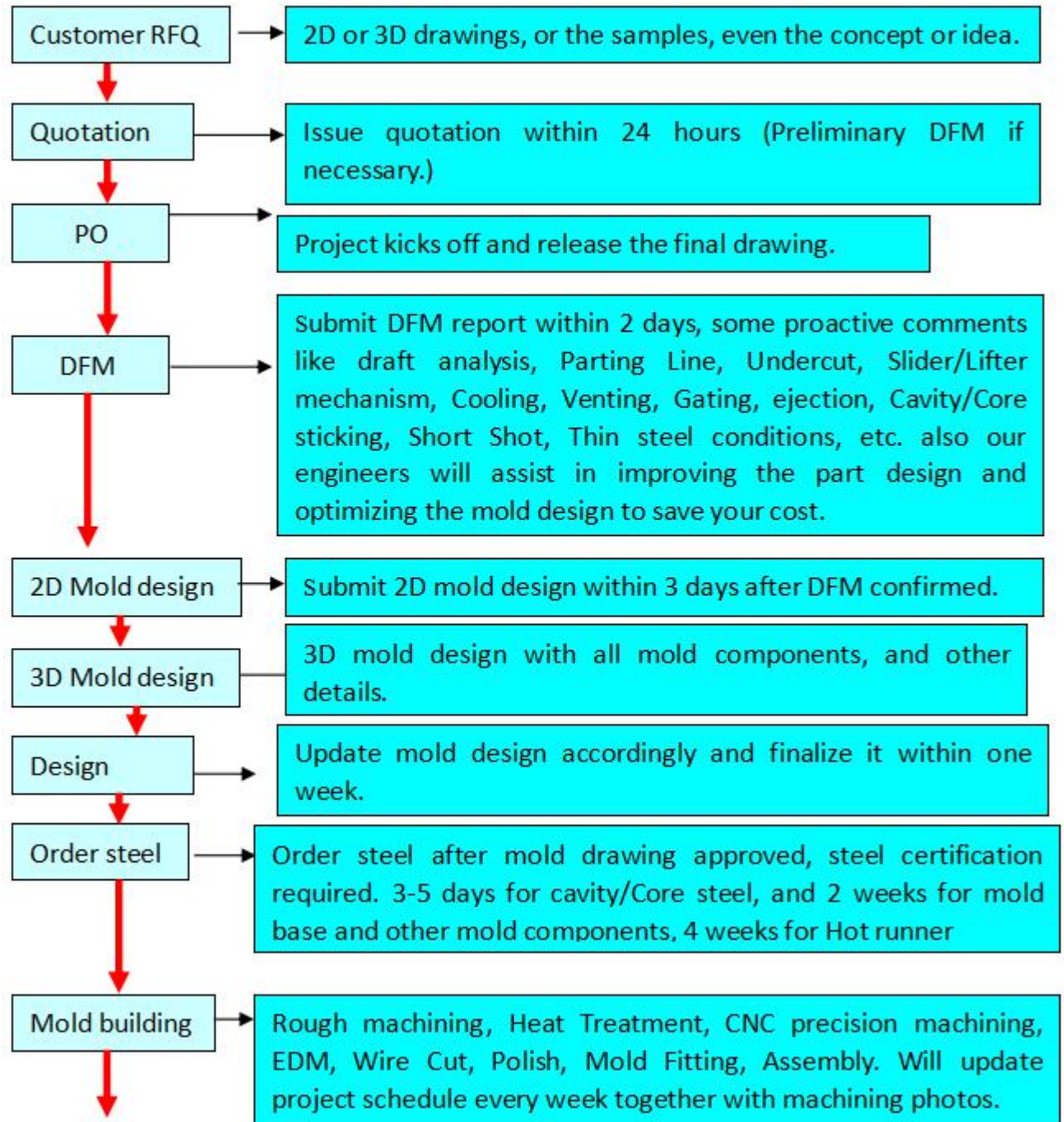
> 试模问题点描述及建议/Comments:

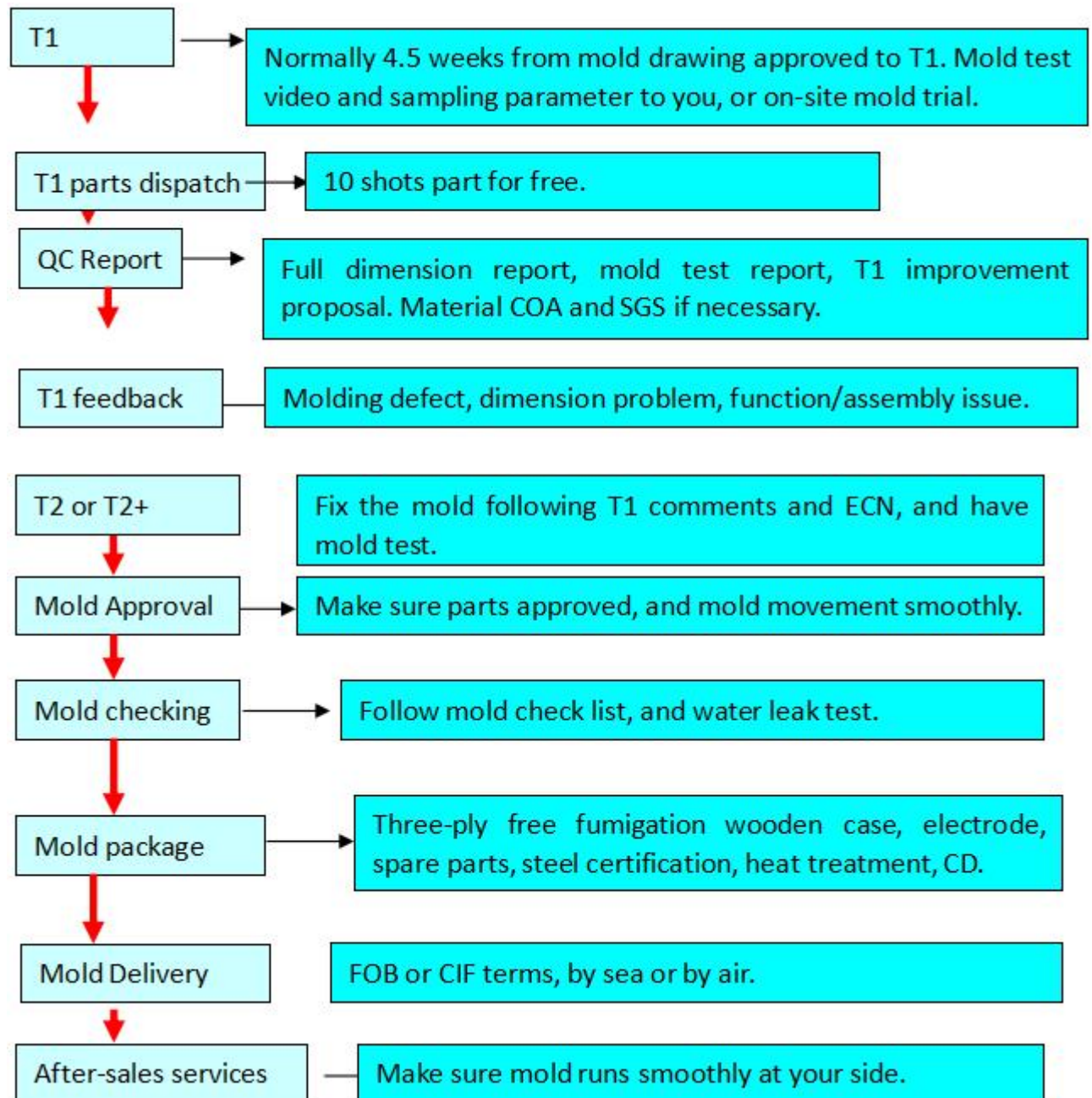
问题: 产品毛边/玻纤纹
对策: 飞模/流道加大/进胶口加大/冷料井加大

记录 Record	日期 Date	审核 Review ed	日期 Date
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Project Procedure

ABIS --Project Procedure





Payment Terms

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

Workshop



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. After our machine, we check the contour dimension and assembly status (if exist) to identify if any.

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

We will trustily report the T1 result to customer. We will send T1 samples to customers for checking. Sometimes T1 samples need improvement. If T1 samples are required by customer at first, we will take actions to improve the mold to make sure the final 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 & Delivery

Packaging Details: Free-Fumigation Three-Plywood case

Delivery Detail: 25-35 days by sea, 3-7 days by air



Our ABIS Family



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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!

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FAQ

Q: Can you do post production?

A:Some customers in addition to plastic injection require post processing, assembly of their products and packaging.

Q:

Is it possible to know how are my products going on without visiting your company?

A:We will offer a detailed production schedule and send weekly reports with digital pictures and videos which show the machining progress.

Q: If you make poor quality goods, will you refund our fund?

A: As a matter of fact, we won't take a chance to do poor quality products. Meanwhile, we manufacture goods quality products until your satisfaction.

Q: What is the software you will use to check the drawing? And what is format of drawing you can check?

A: Our designers and engineers all use VISI and UG to check 2D and 3D drawings.

We can check the drawing with PDF .AI, DWG ,STP or IGS formats.

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.