Product Information

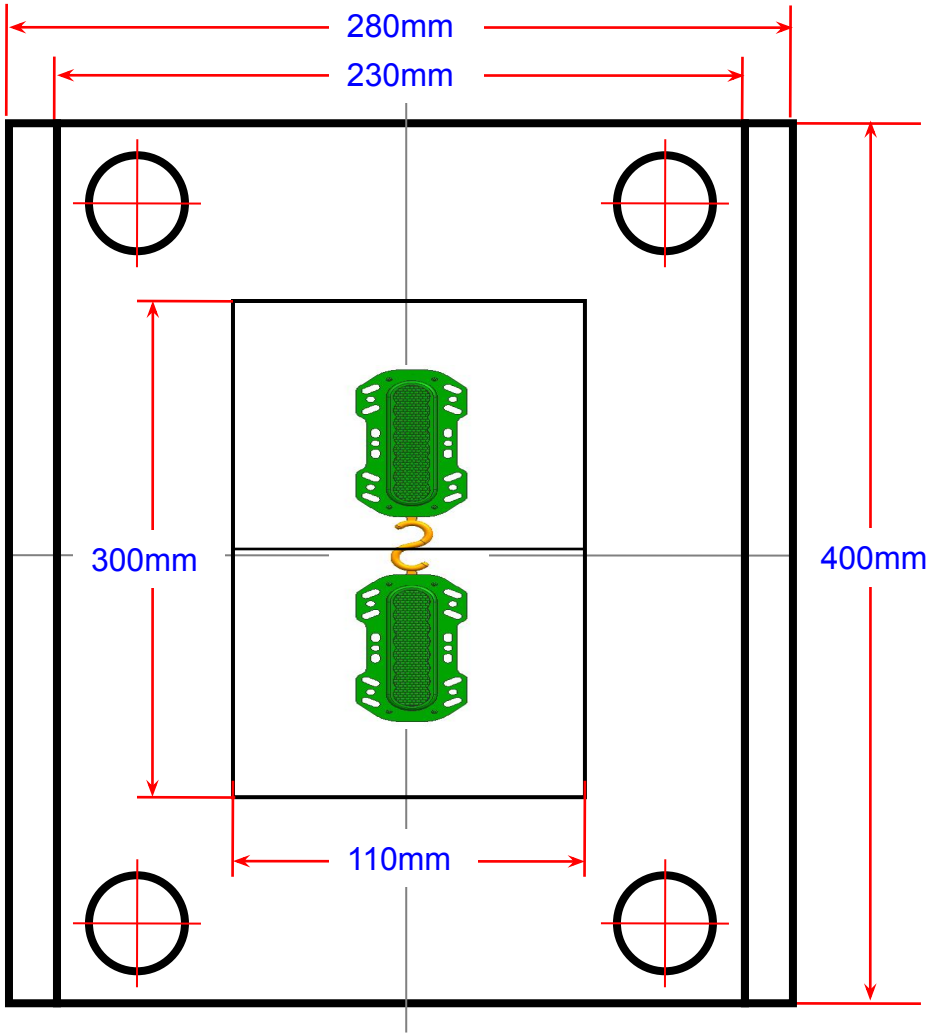
Project		Part	IBPM.756170.074
Dimension	49.1x100.1x16.1	Weight	16.8g
Material	PC 2180T	Shrinkage	1.005
Even Thickness	1.5mm	Marks	-
Finishing	SPI A2	Color	SPI A2

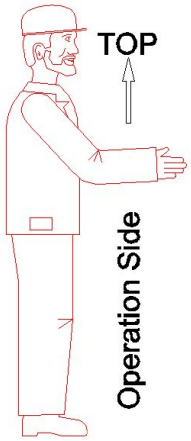
Mold Information

Supplier	TTM	Mold No.	TTM-2340
Mold Type	2 plate mold	Runner Type	Side Gate
Cavity	1*2	Mold Standard	Mold base LKM components is imitated HASCO
Location Ring	Ø125	Sprue Radius	SR15.5
Nozzle Type	HASCO Z80HT	Mold Life	500000 shots
Slider	-	Lifter	-
Cavity	S136 HRC48-52	Core	S136 HRC48-52
Slider material	-	Lifter Material	-

1. Please confirm above detail information.

Mold Layout / Structure



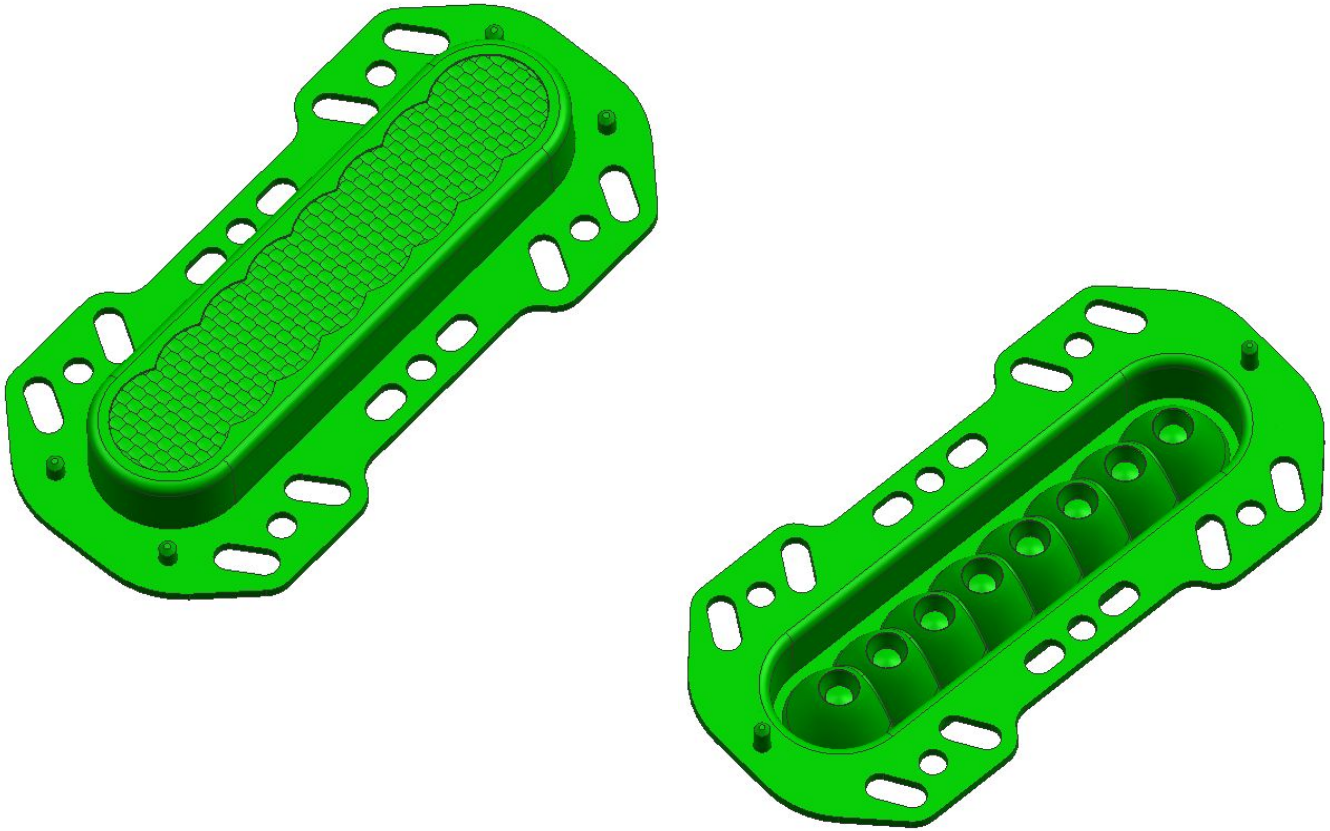


Item		Injection machine Tonnage	Mold information
Will you offer the injection machine tonnage?	Yes	ENGEL 500/90	
Clearamce between Tie Bars			280*400
Shot Weight/ Part weight		N/A	33.6 g
Mold thickness		N/A	
Location ring		125	124.8
Nozzle R		N/A	SR20

2.Please confirm the mold structure.

Customer comment. (please give your approval and comments)			
OK or NG	**Remark**	**Approval by:**	**Date**

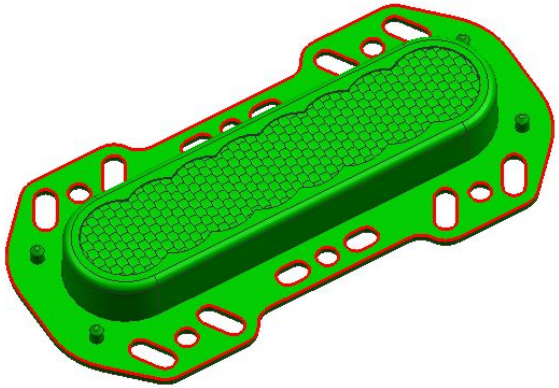
Product Image

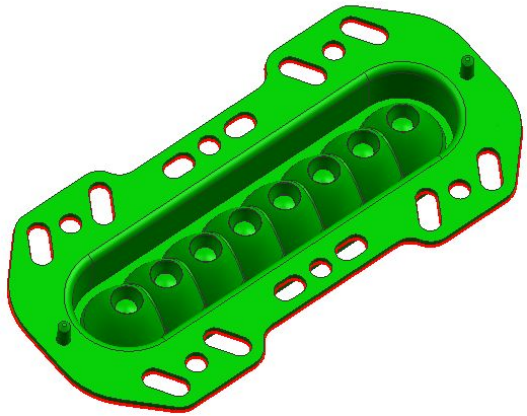


Customer comment. (please give your approval and comments)			
OK or NG	Remark	Approval by:	Date

3.Part size: 49.1x100.1x16.1

Parting Line

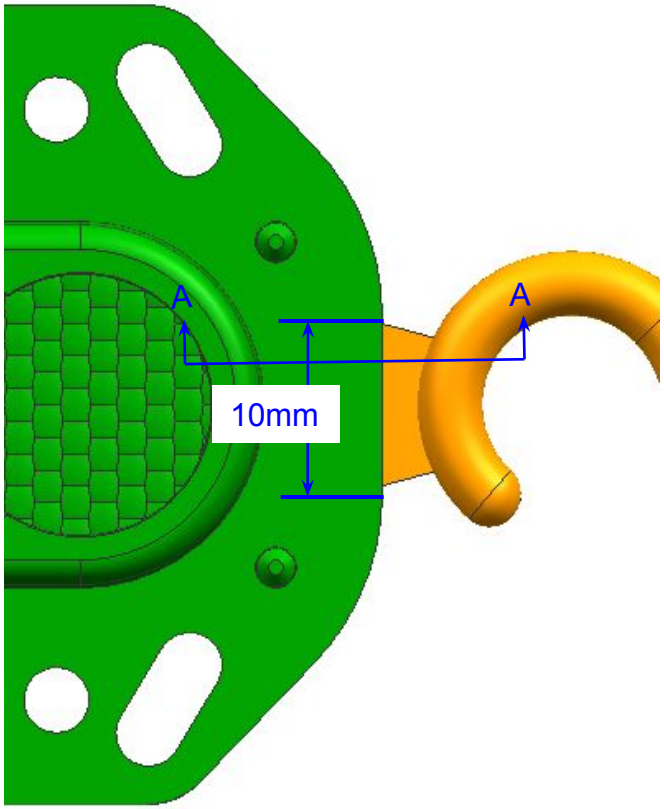


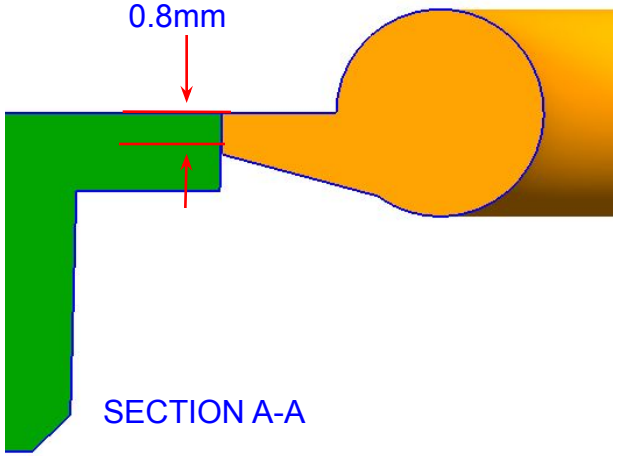


Customer comment. (please give your approval and comments)			
OK or NG	Remark	Approval by:	Date

4. Pls confirm the parting line.

Injection Gate

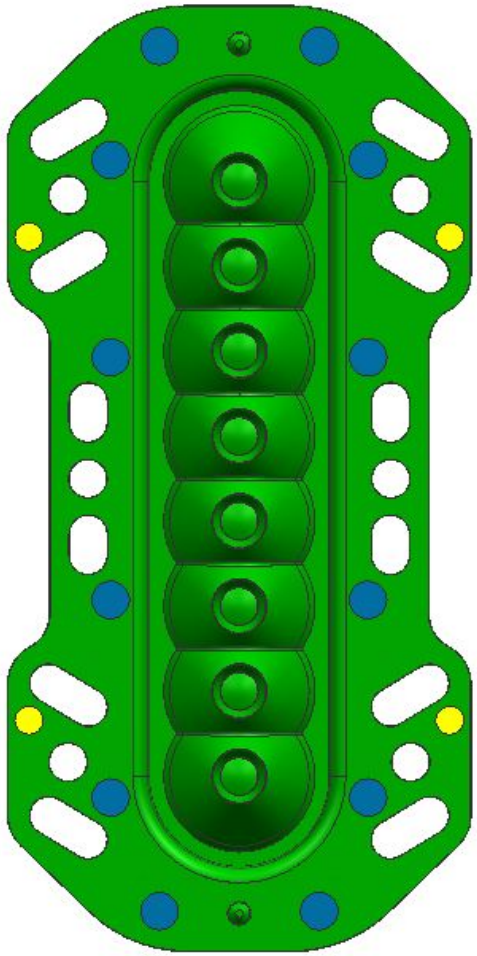


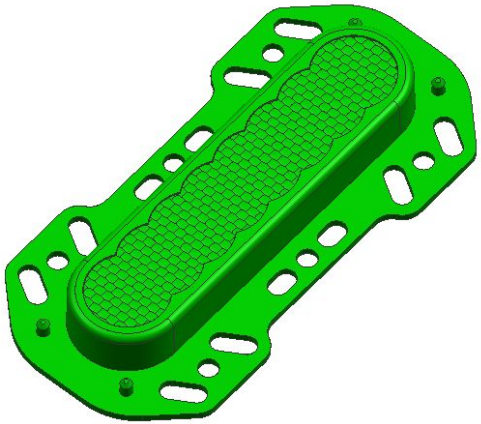


5. injection gate is side gate, pls check.

Customer comment. (please give your approval and comments)			
OK or NG	**Remark**	**Approval by:**	**Date**

Ejector Type





Ø3 Ejector Pin (4PCS)

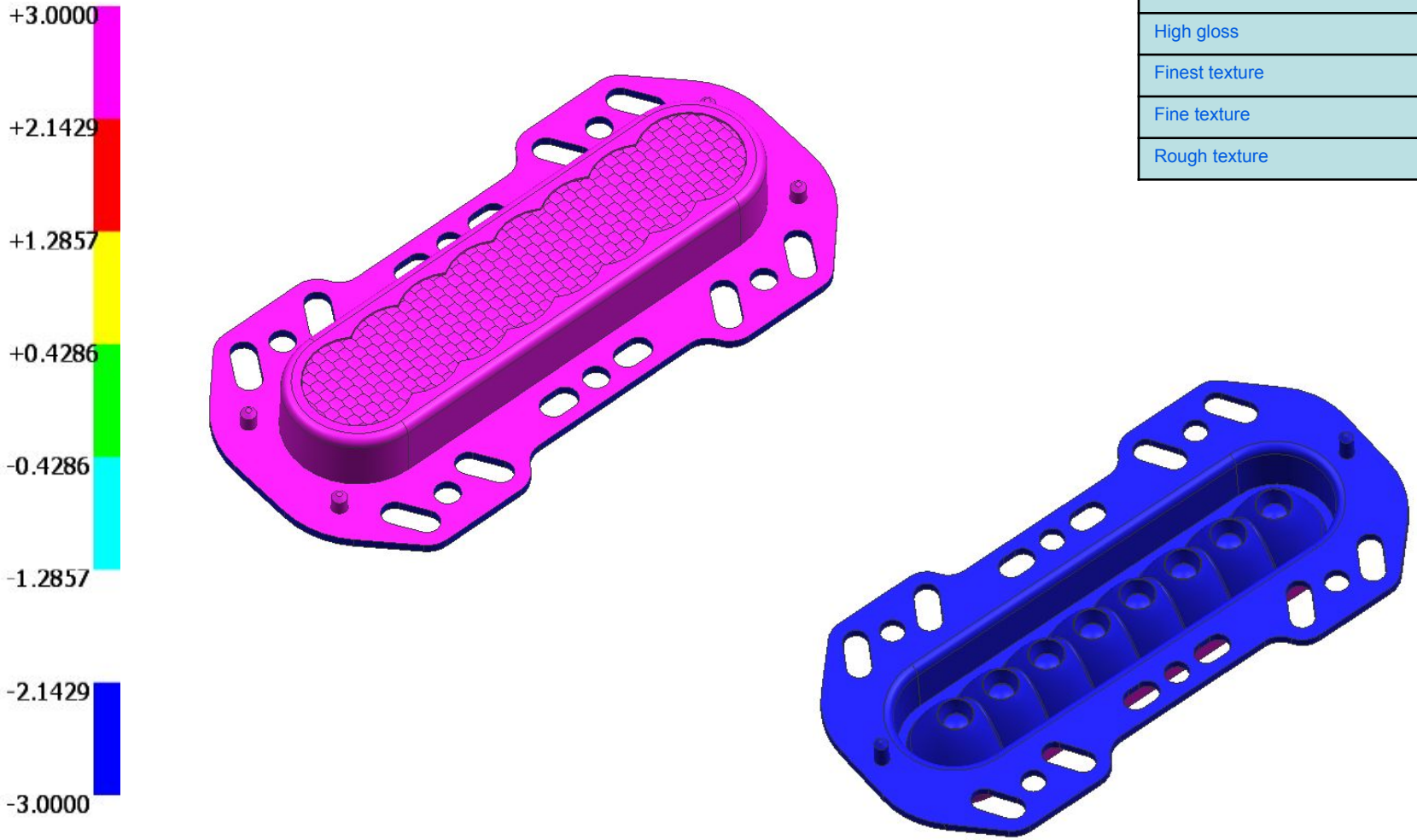
Ø4 Ejector Pin (12PCS)

Customer comment. (please give your approval and comments)			
OK or NG	Remark	Approval by:	Date

6. pls confirm the ejector pin size and location.

Draft Analysis

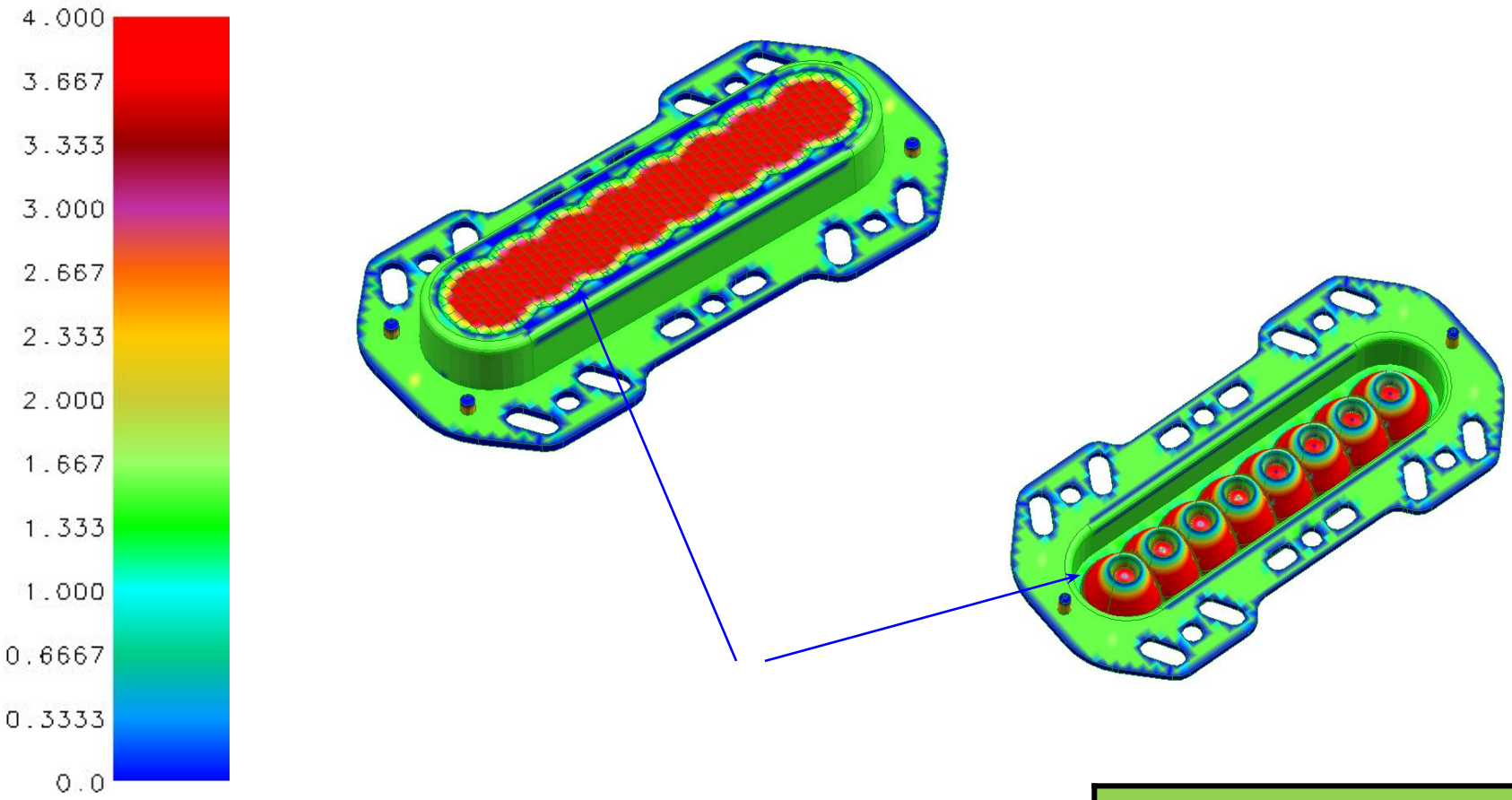
Finishing	Draft angle for reference
Non-appearance surface	>0.5°-1°
High gloss	1.5°-2°
Finest texture	1.5°-2°
Fine texture	2°-3°
Rough texture	2.5 °-3.5°



7. draft angle meets the requirement.

Thickness Analysis

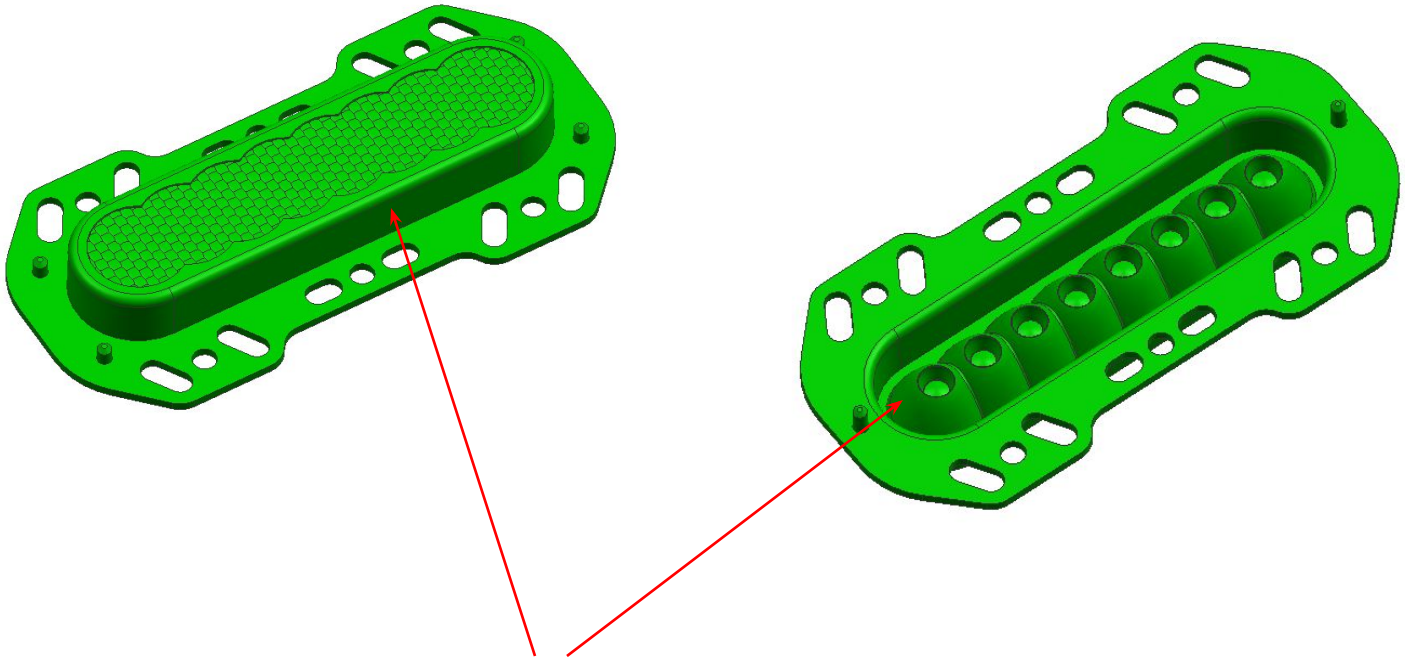
Average Thickness:1.72mm
Maximum Thickness:7.91mm



8. red area is too thick will cause sink mark, suggest to reduce the material, but as the design limitations, we don't have idea to reduce, so will try to improve it by injection parameters, but we cannot ensure it won't have sink mark totally, pls note.

Customer comment. (please give your approval and comments)			
OK or NG	**Remark**	**Approval by:**	**Date**

Part surface finish



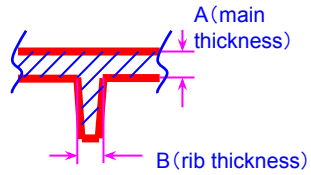
green area SPI A-2

Customer comment. (please give your approval and comments)			
OK or NG	Remark	Approval by:	Date

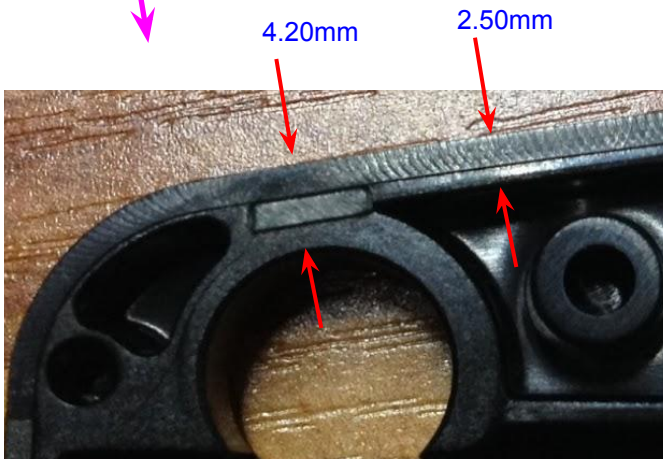
9. pls confirm the surface finish.

Surface defect E
（sink mark）
缩水痕

Problem E：When the thickness is not even, the rib thickness exceeds 60% of the main thickness, it will have sink mark problem. Different proportion will have differnet sink mark.
Solution: Make the thickness even, the rib thickness can not exceeds 60% of the main thickness



B(rib thickness)＝60%*A(main thickness)



As the above show,there is sink mark as the picture of product we made.For reference only.

Thank you very much