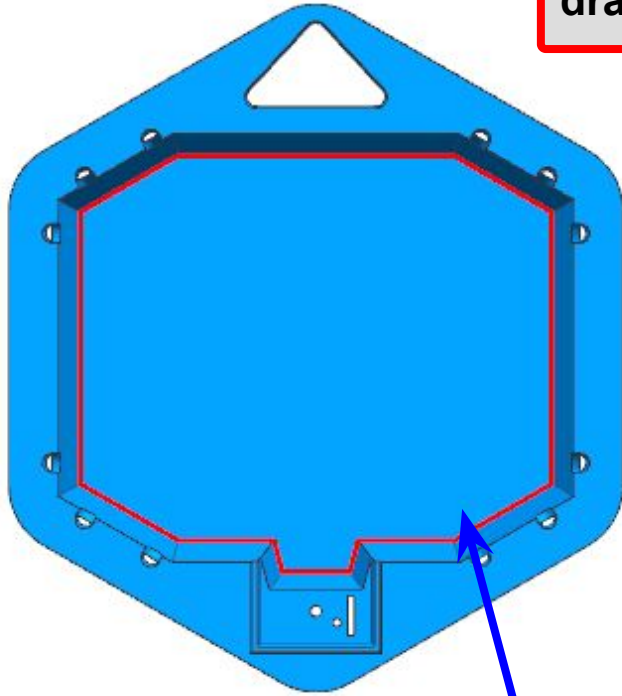


1.问题点Question

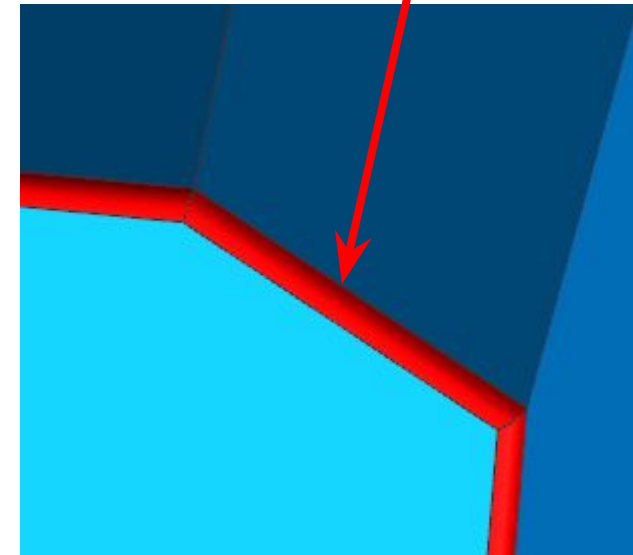
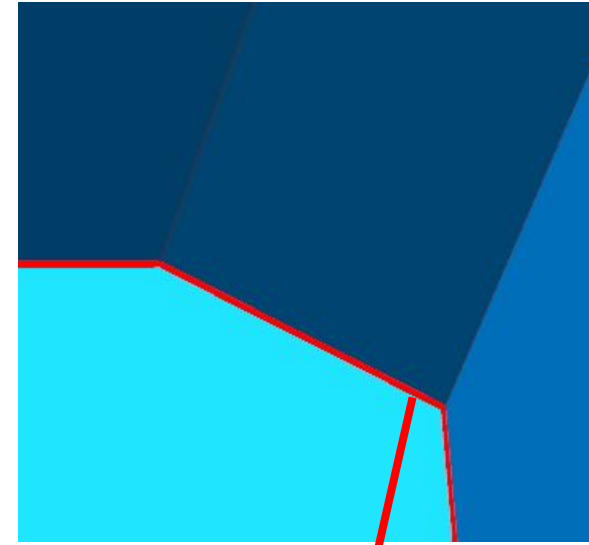
please refer to 3D drawing

before modification



The red line of the product is a sharp corner, the product is not easy to produce, it is recommended to add a round corner of R2mm as shown in the figure. please confirm if it is okay?

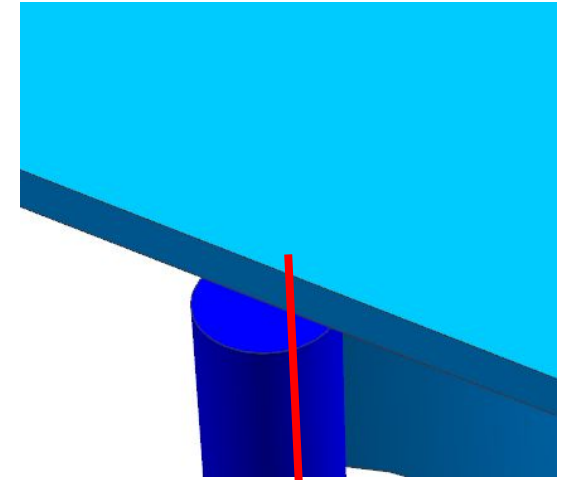
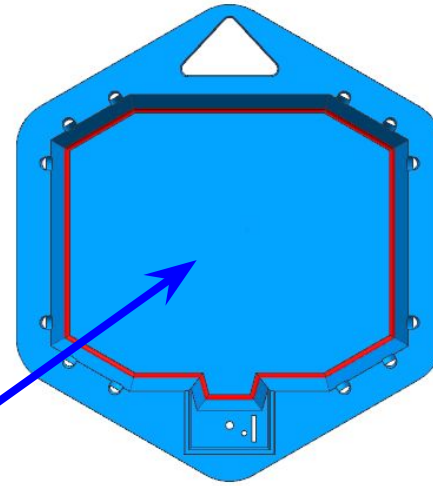
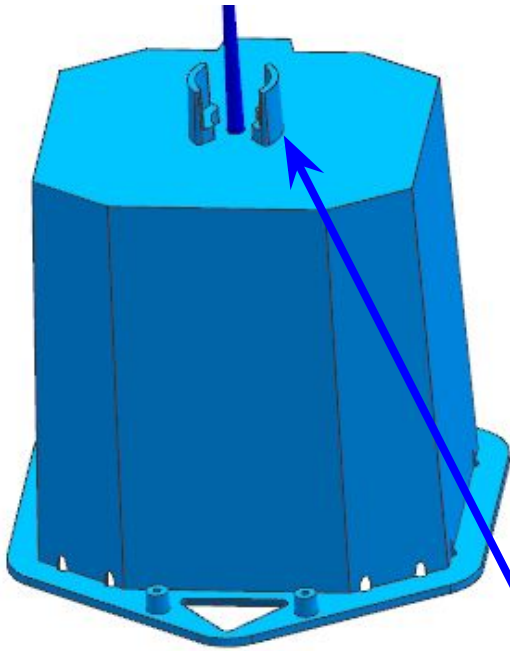
after modification



2.问题点Question 2

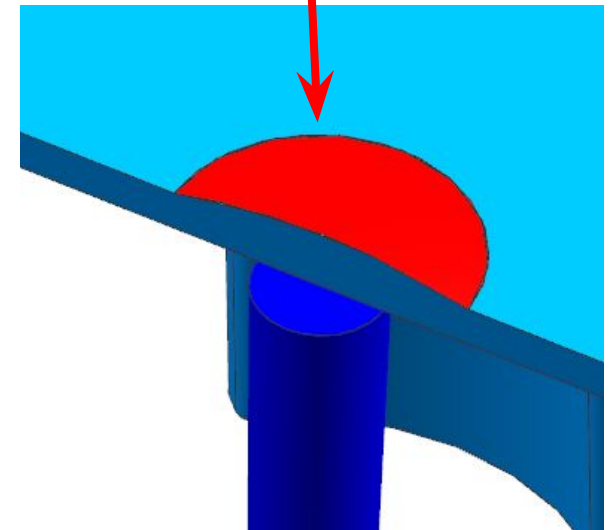
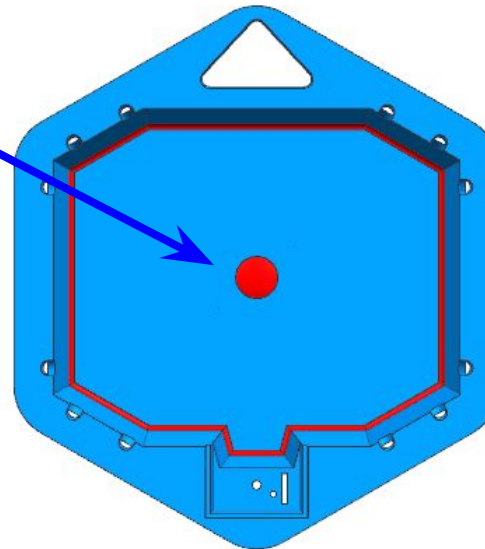
please refer to 3D drawing

before modification



The blue shape is the position of the glue point, it is recommended to add a 14X1mm diameter boss in the red area of the product as shown in the figure to facilitate product production. please confirm if it is okay?

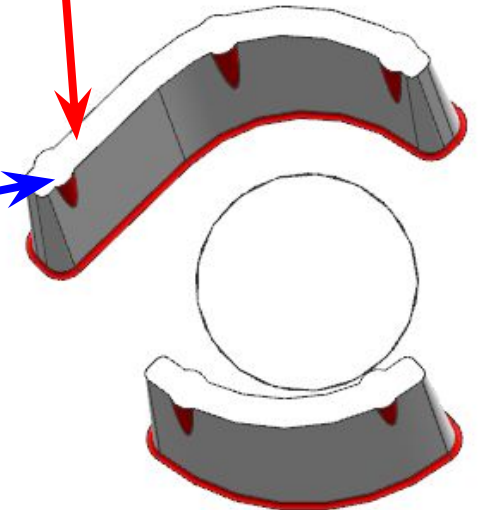
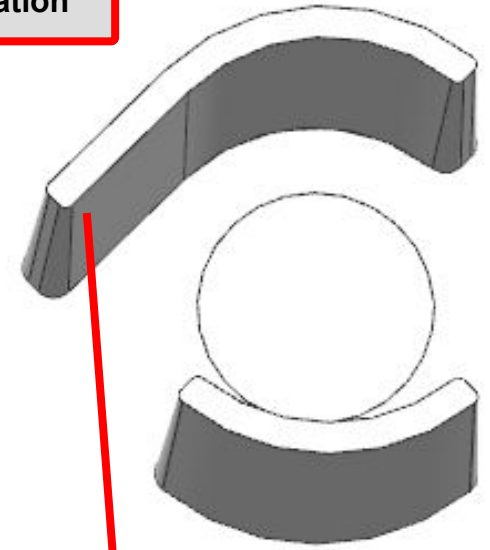
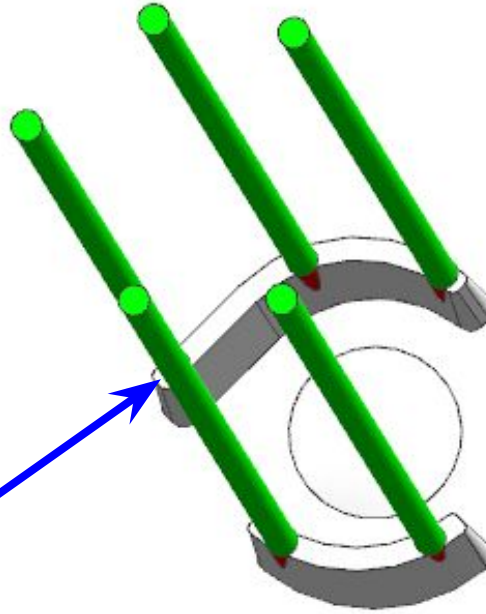
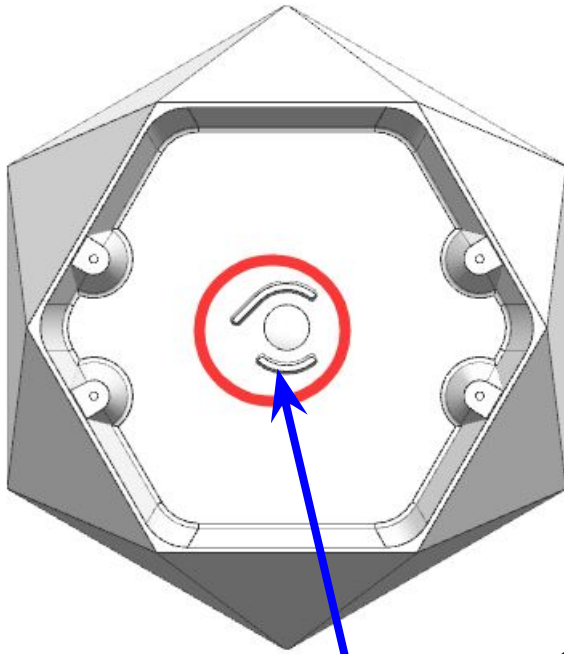
after modification



3.问题点Question 3

please refer to 3D design

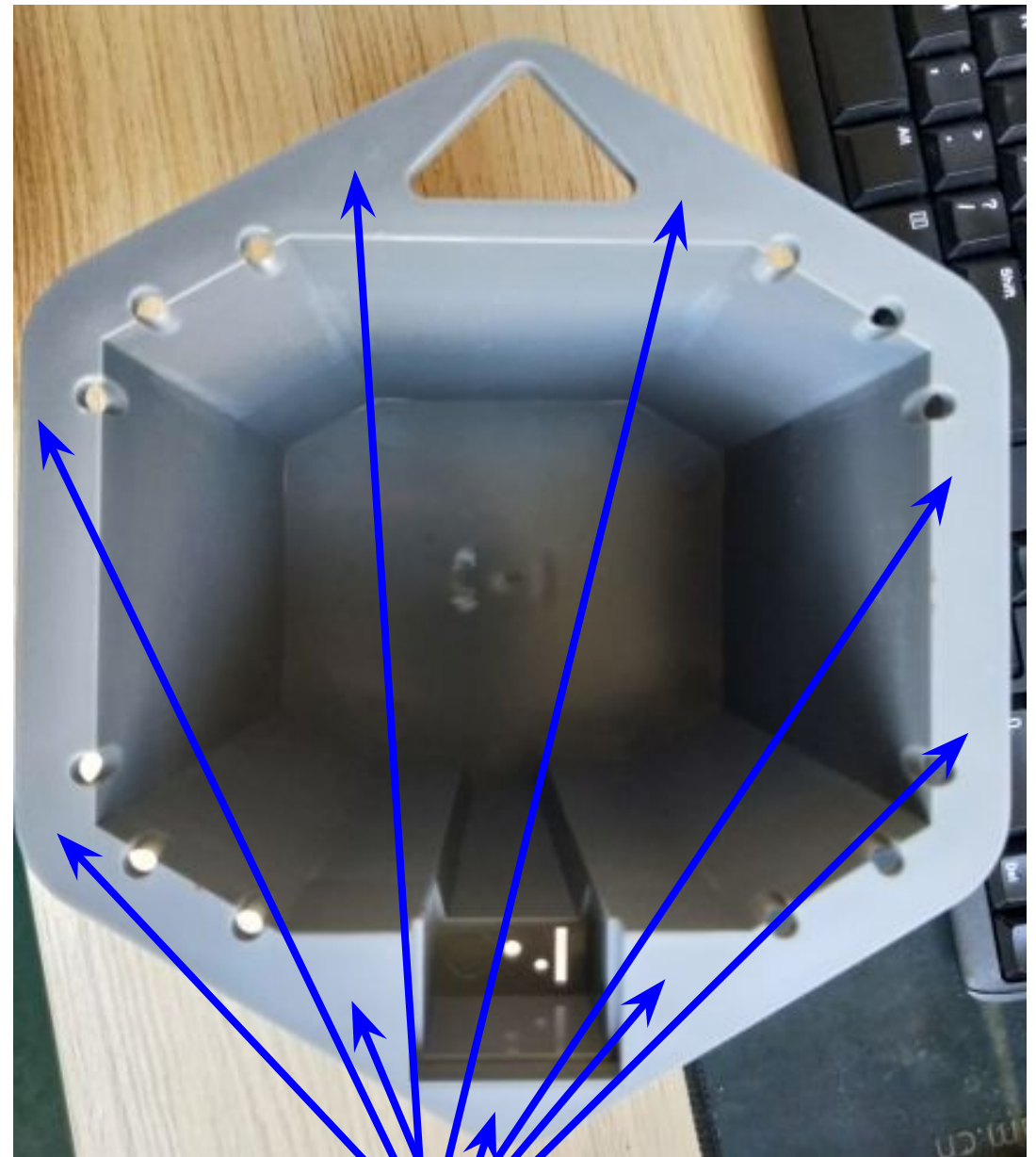
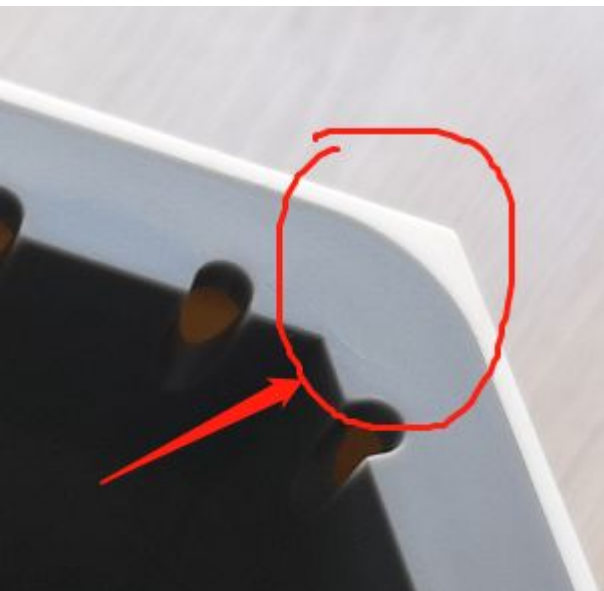
before
modification



The shape inside the red circle is easy to break and difficult to eject. It is recommended to add R0.5mm at the bottom and add 5 pieces 3mm eject pin. The product is suggested to add thickness in the red area as shown, please confirm if it is okay?

after modification

4.问题点 Question 4

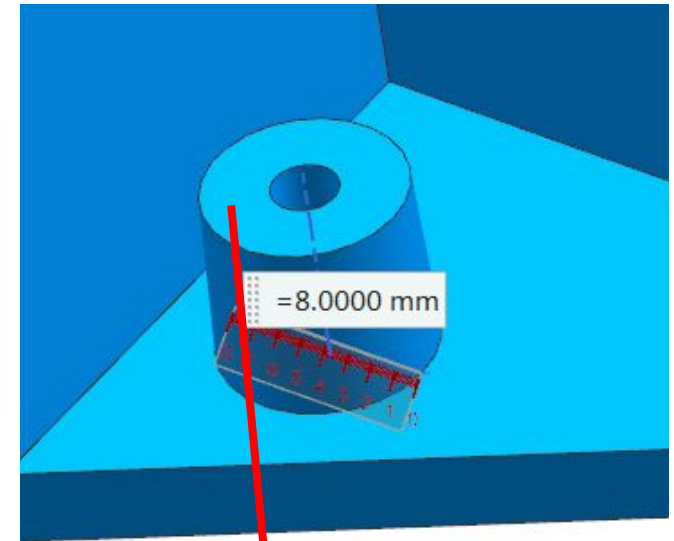
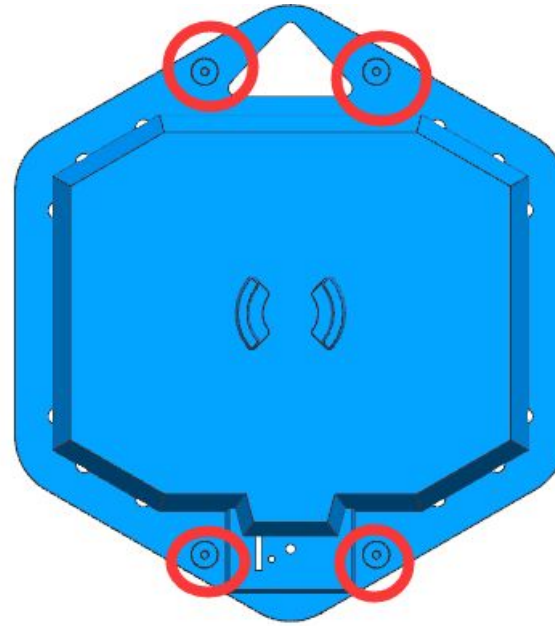
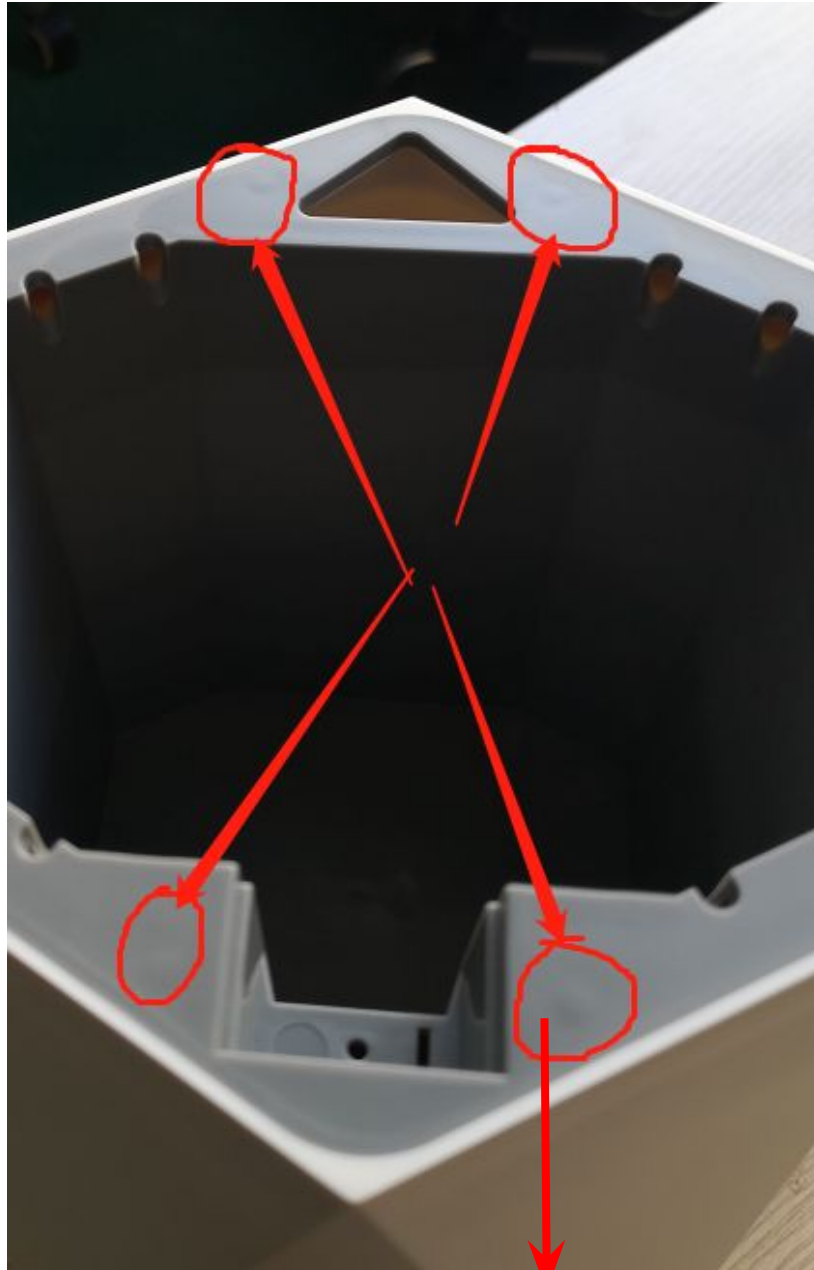


The product has the problem of welding trace and pin mark . Corresponding to the mold position, it needs to be dug out and re-welding.

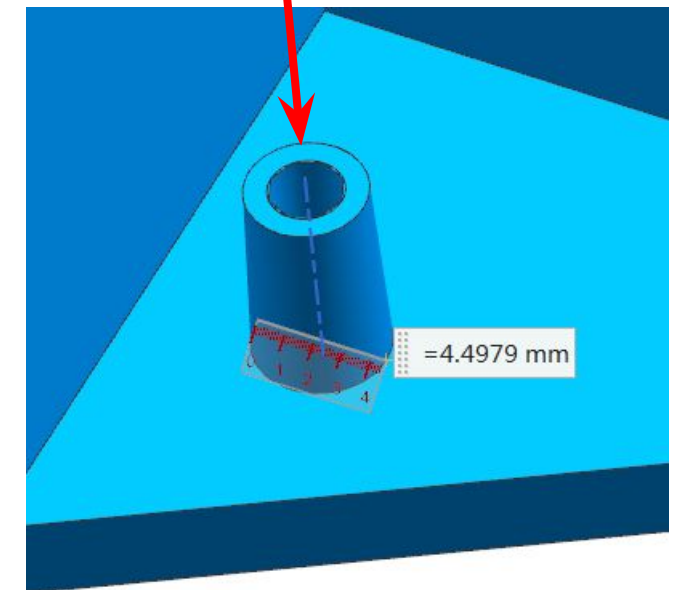
5.问题点Question 5

please refer to 3D drawing

before modification



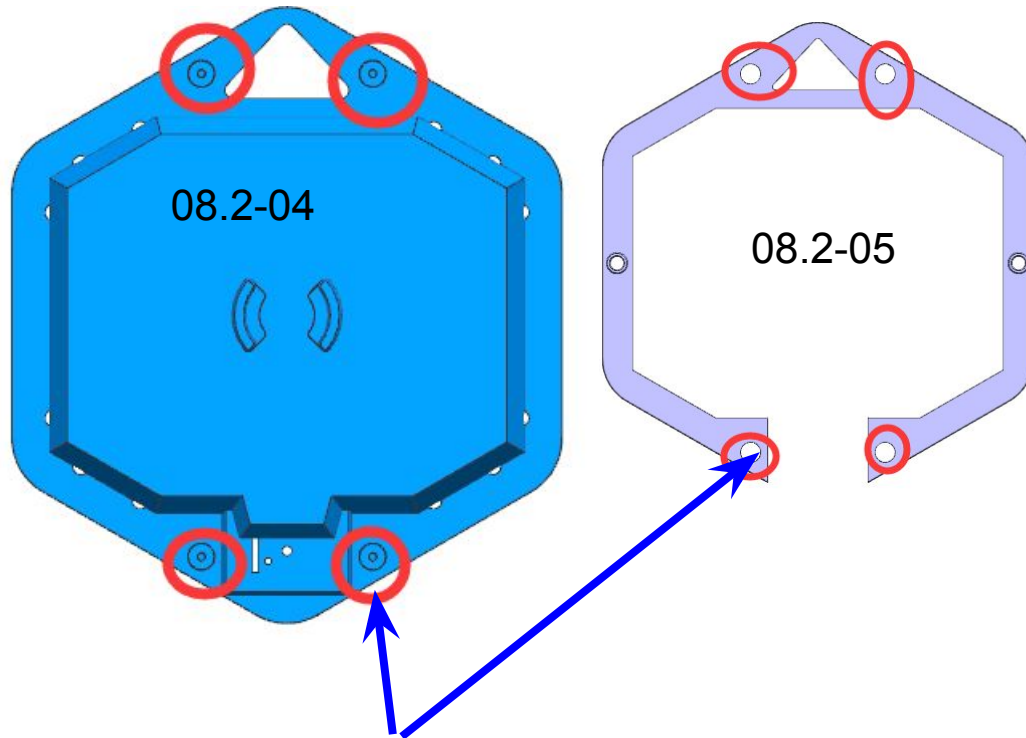
after modification



There is shrinkage at 4 places of the product. It is recommended that the diameter of the cylinder be changed from 8mm to 4.5mm to reduce shrinkage. if it is okey ?

6.问题点Question 7

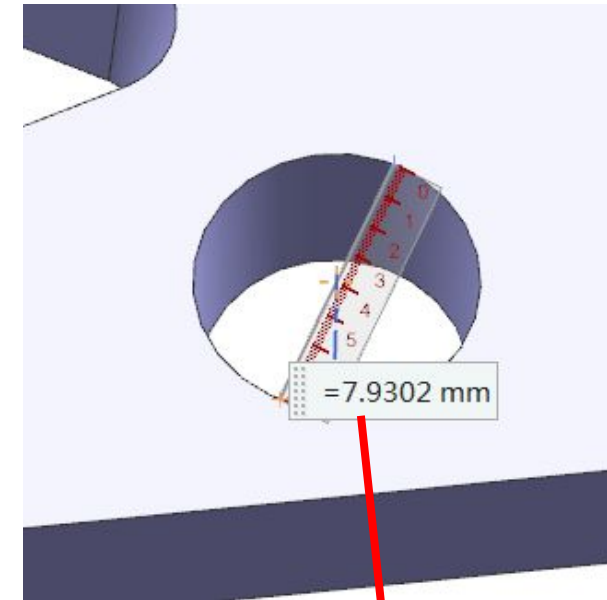
please refer to 3D drawing



08.2-04, if the position of the cylinder is modified, and the size of the circular hole corresponding to 08.2-05 must also be modified together, as shown in the figure. if it is okay?

Solve the above 3-6 points: add eject pin, welding, modifying BOSS hole, the cost: 380USD, please refer to the quotation for details.

before modification



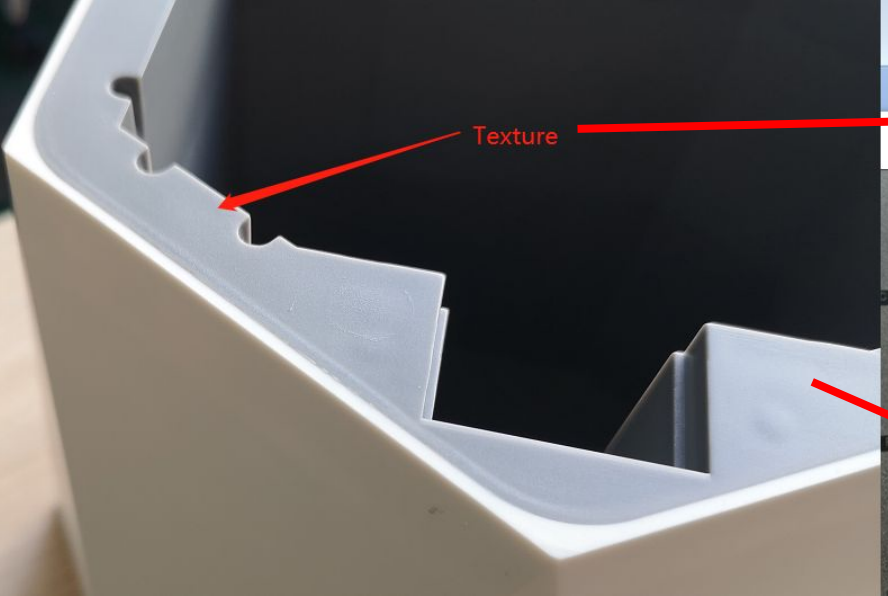
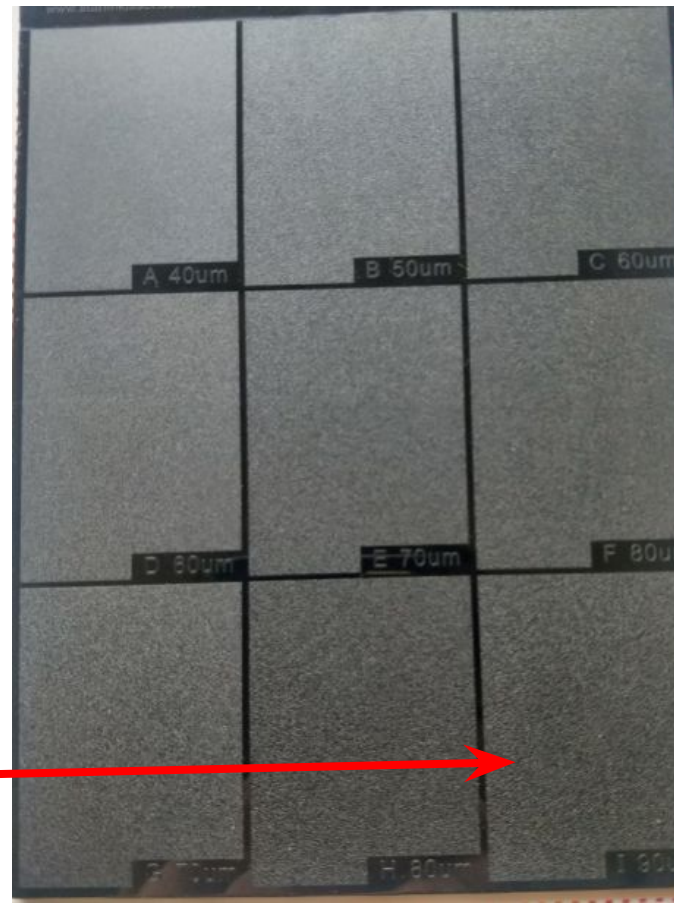
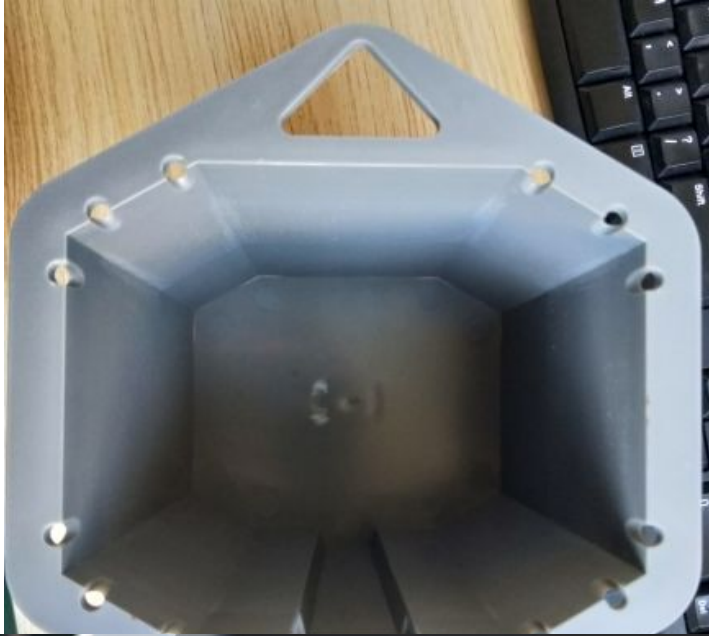
after modification



7.问题点 Question 7

before modification

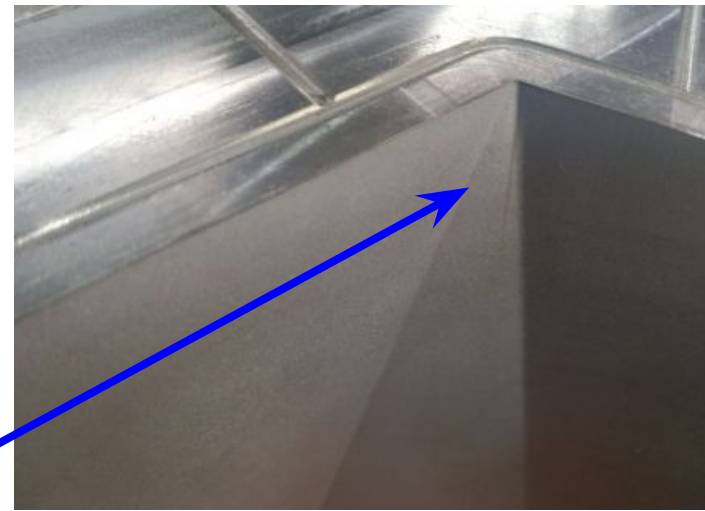
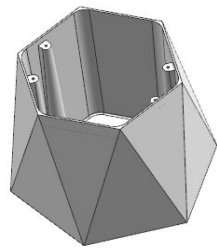
after modification



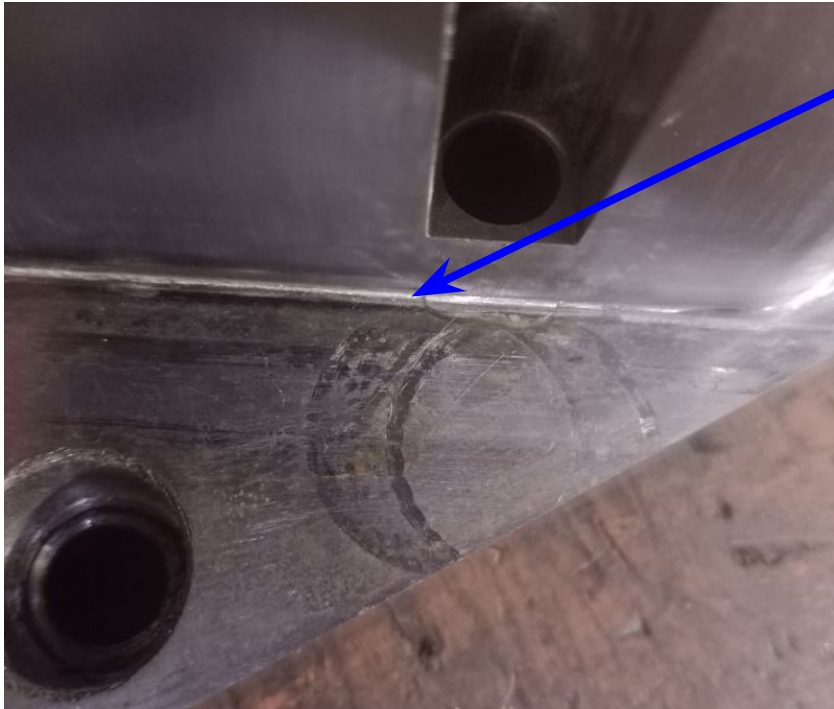
There is a eject pin mark on the surface of the product. It is recommended that the surface treatment of the product be changed from VDI24 to I90UM. It will

In order to solve the eject pin mark left by the previous mold welding, we will remake the matte surface, the cost: 530USD, please refer to the quotation for details. (Note: It may not be completely no trace, but it will improve.) If it is okey ?

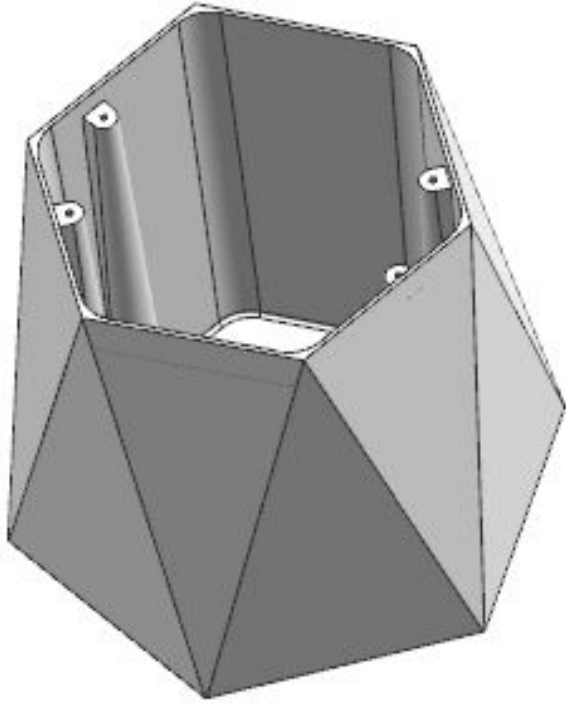
1.问题点 Question



There are many places where the mold has been welded by RJC before of another half mould. There will be marks on the surface of the product. Please know and confirm?

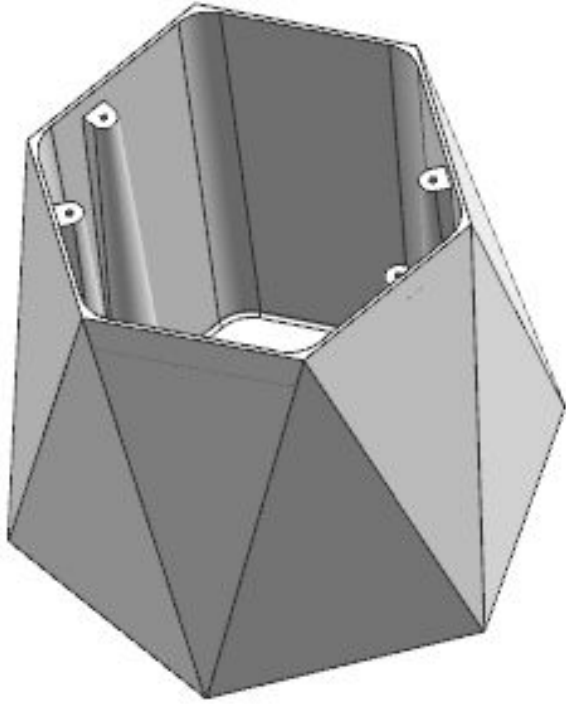


2.问题点question 2

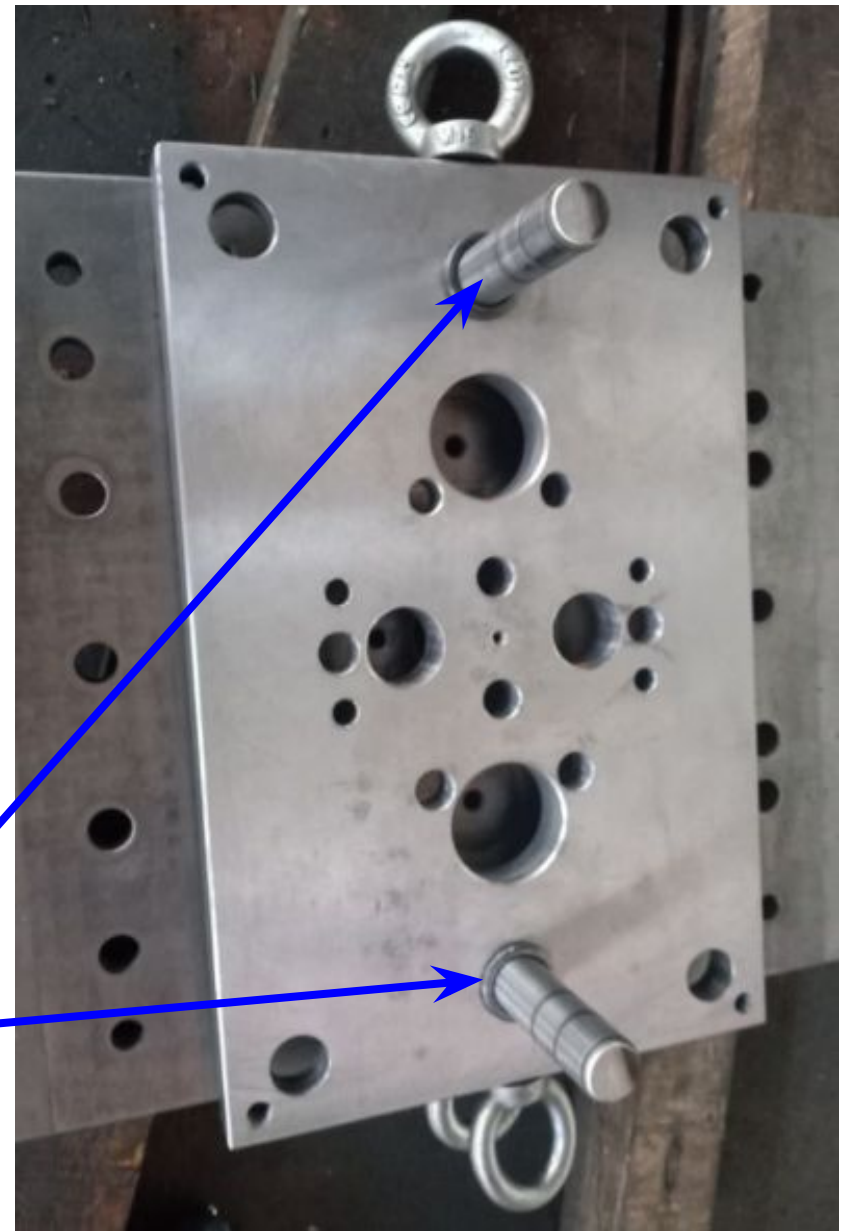


The template on the mold is very thin and deformed before, and the product is prone to burrs. We have replaced new template. Please know.

3.问题点question



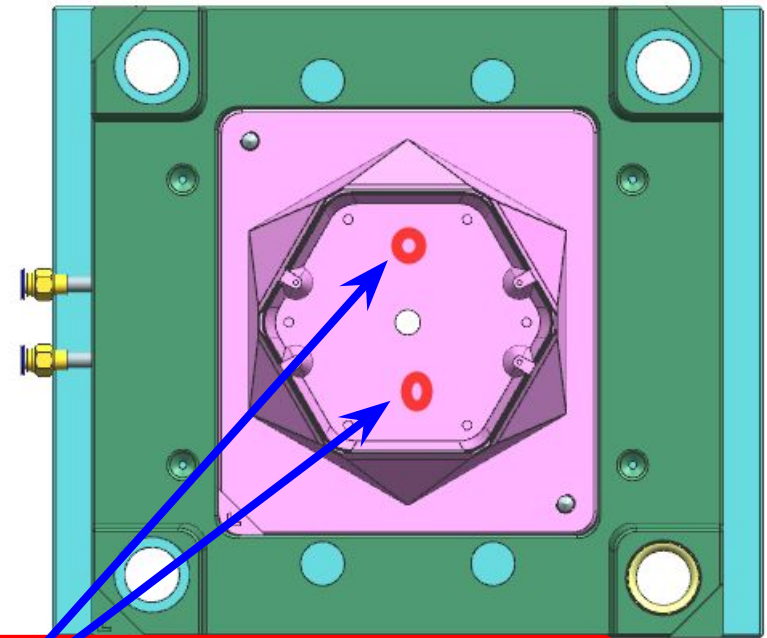
There was no EGP on the mold before, and the mold ejection was unbalanced. We have added 2 EGPs. Please know.



4.问题点Question

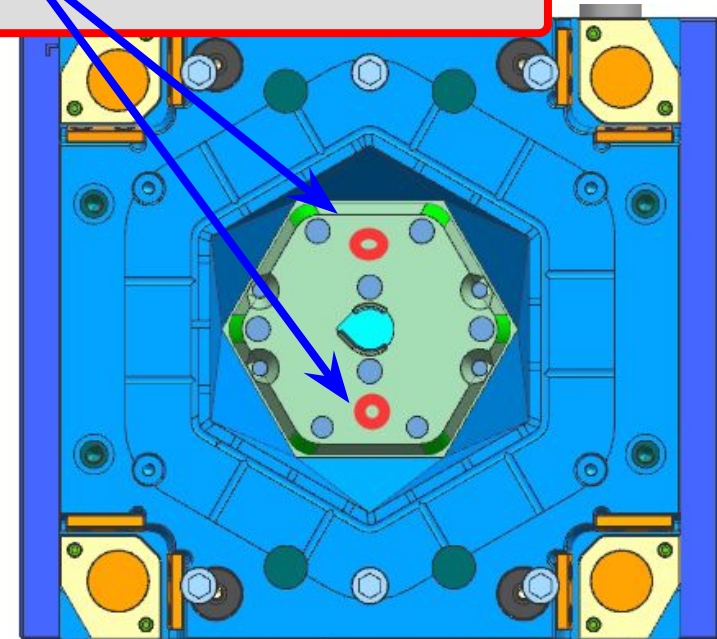


the front mould

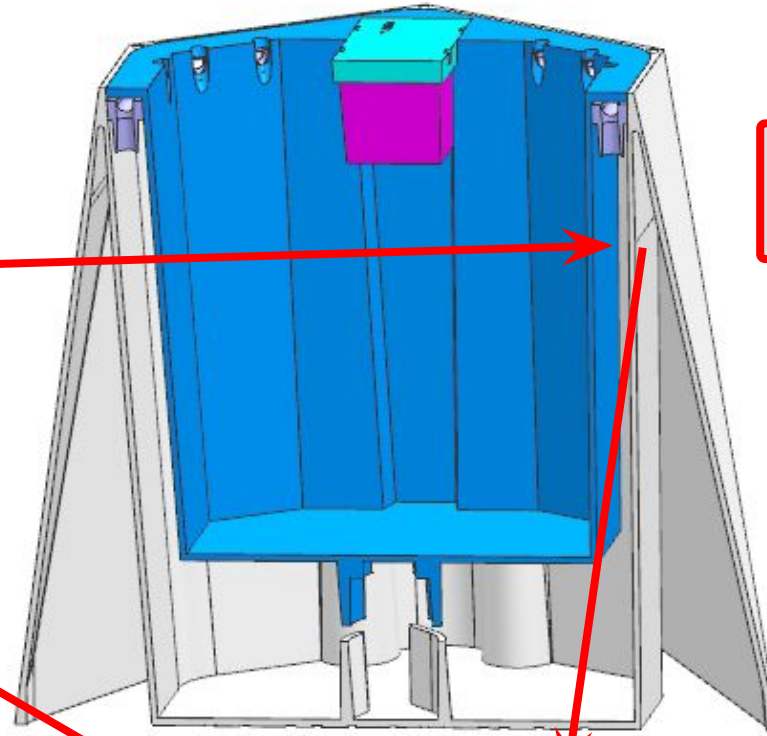
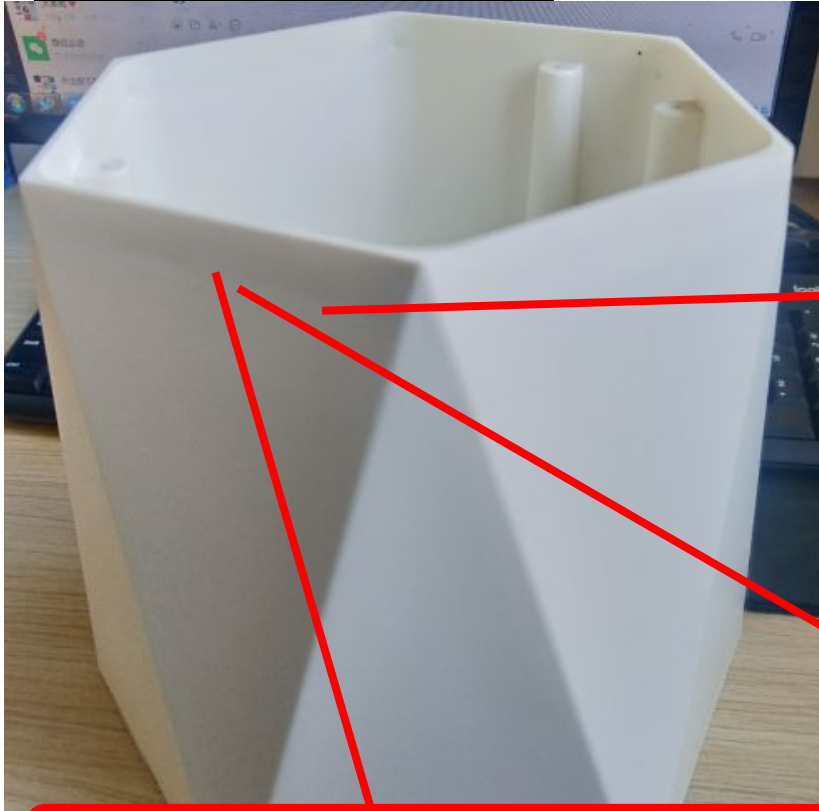


Due to difficulty in ejecting the product, it is recommended to add 2 air pins to the front and rear molds to assist the ejection of the product. (As shown in the red area)

the rear mould

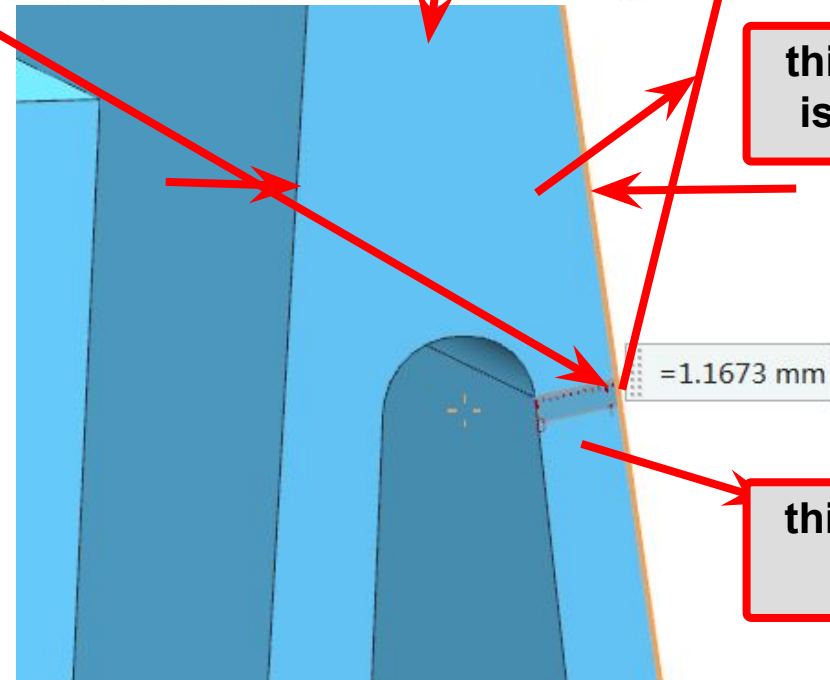


5.问题点 Question



there is line
around of top

We will try to increase the thickness on the side of the product to solve the problem of shadow lines caused by uneven product thickness. However, it cannot be guaranteed to be completely no line, because it cannot be increased too thick, and the outer side may cause shrinkage problems if it is too thick. This is a contradiction question.



this area
is thick

this area is
thin

To solve the above problems from 2-4 points: increase the air pins, replace the template, increase EGP, etc., mold repair cost: 380USD, please refer to the quotation for details.

6.问题点 Question

before modification

after
modification



There is line around the top surface. It is recommended that the surface treatment of the product be changed from VDI24 to I90UM. Will lighten traces of the line.

We suggest to remke the matte surface all over the side, cost: 910USD. Please refer to the quotation for details. (Note: It may not be completely no line, but it will be improved.)