

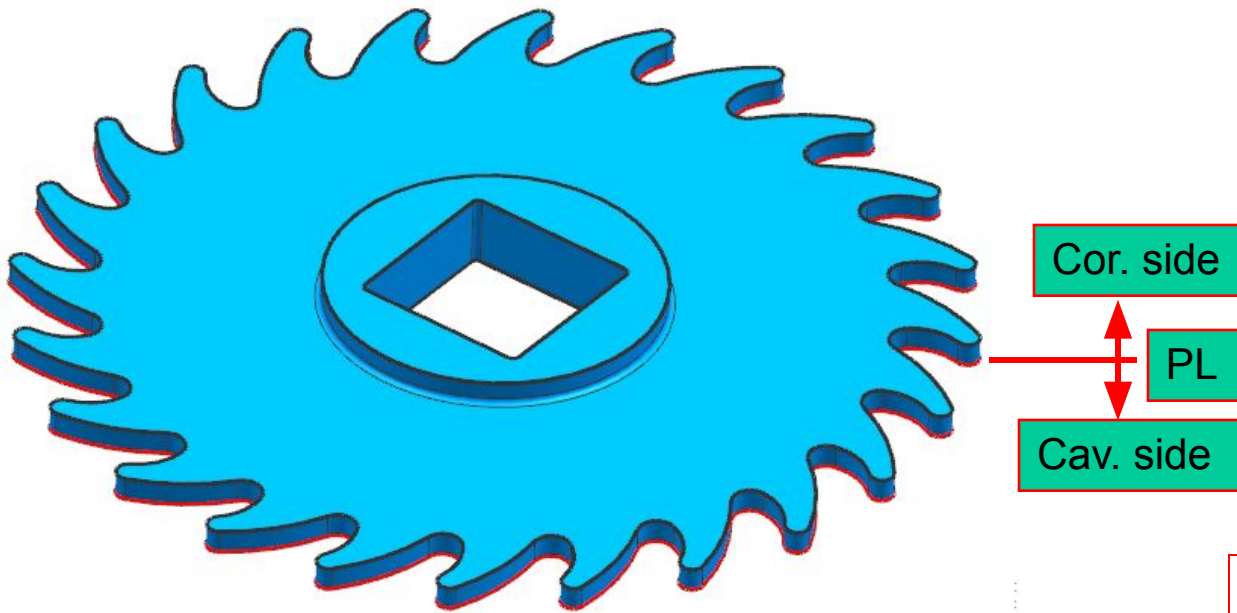
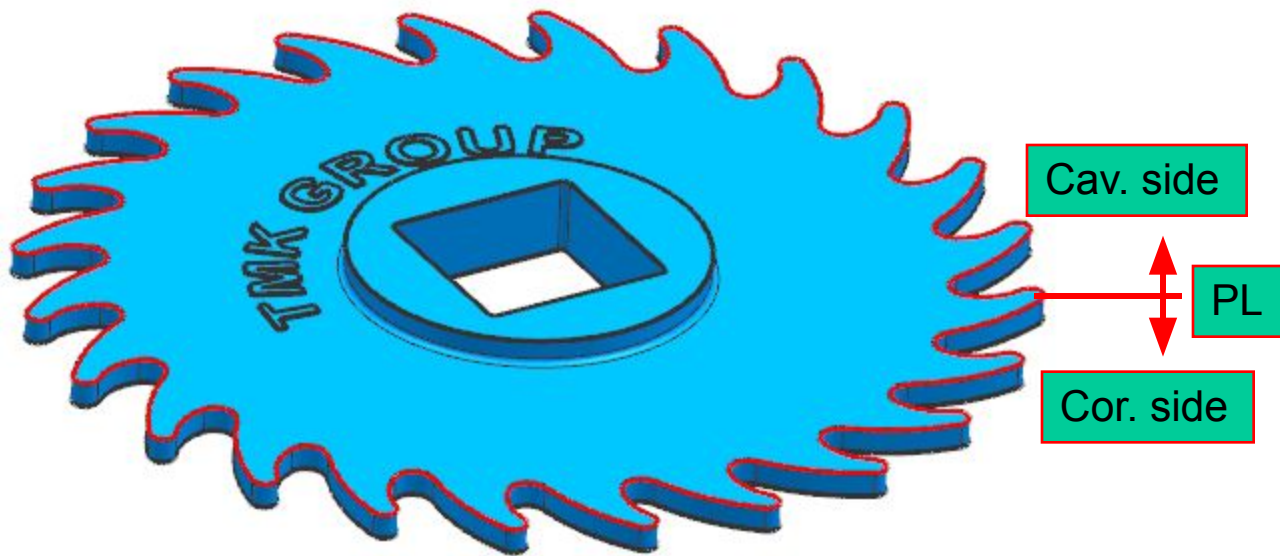
DFM FOR Star_10TMK+Star_20TMK

| | | | |
|---------------------|-----------------------|--------------------|----------------------------------|
| Mould No.: | / | Mould standard.: | LKM Mold base + HASCO components |
| Customer mould No.: | / | Runner Typ.: | Cold runner point gate |
| Parting No.: | Star_10TMK+Star_20TMK | Plastic Material : | ABS black / 50% PP and 50% TPE |
| Drawing Rev./Date: | 220726 | Shrinkage : | 1.005 / 1.016 ? |
| Part size : | / | Cavities : | 1+1 |
| Part weight: | 75g / 130g | Steel Material : | P20 |
| Mold Typ.: | Three plate | Nozzle SR: | SR15.5 |
| Locating Ring(Φ): | Φ125 | K.O Screw | M16 |

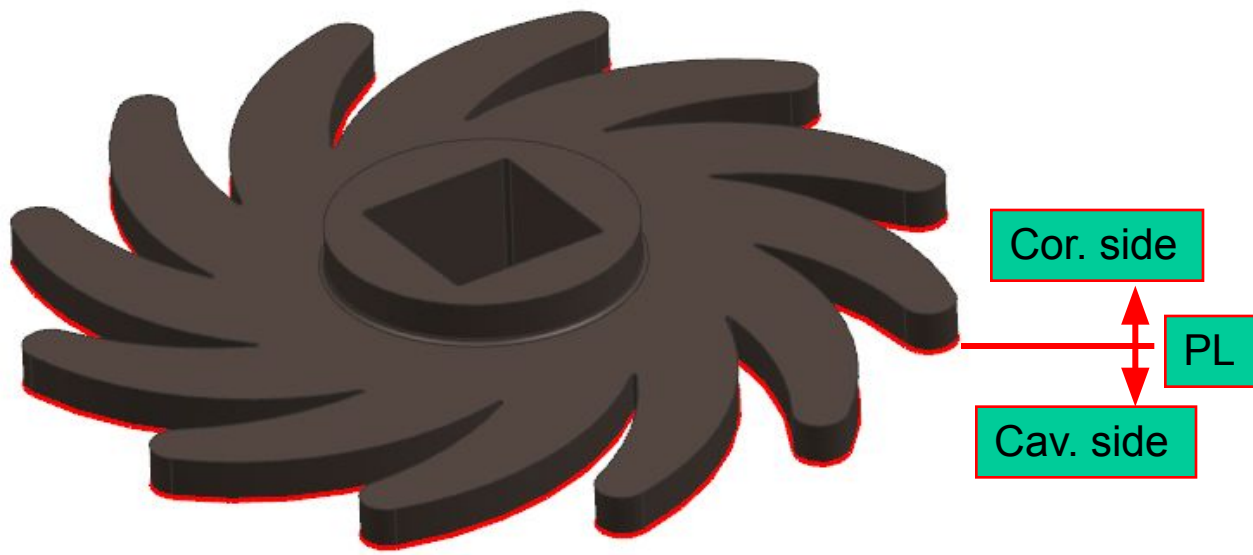
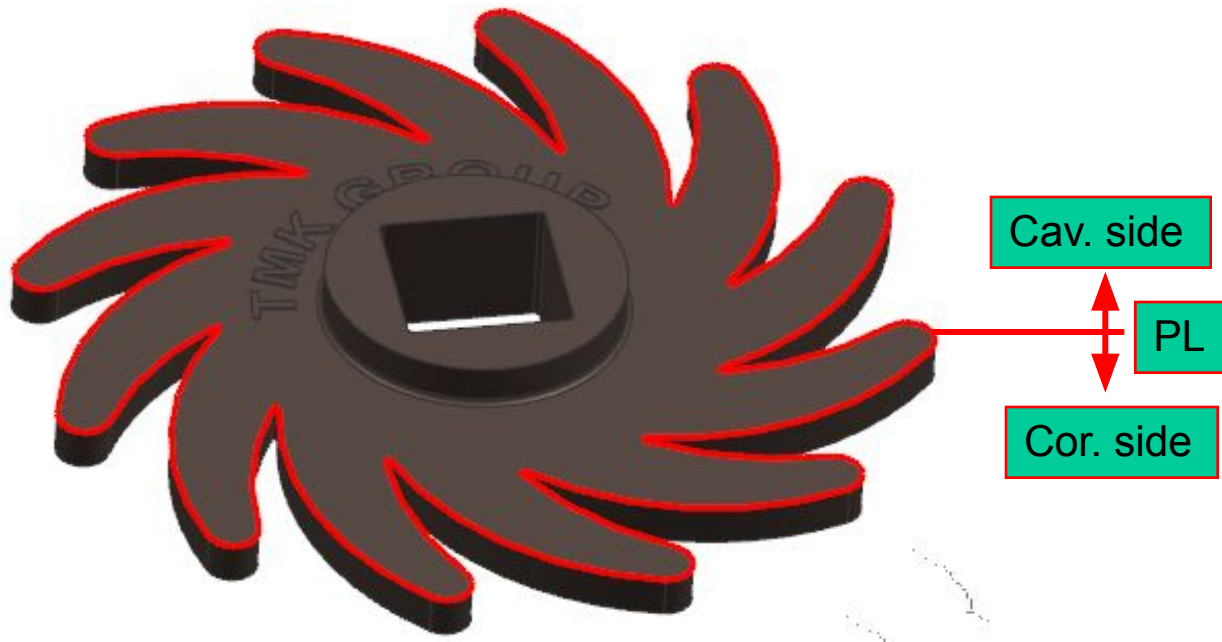
Water fitting (50010/40/44 (G 1/4"))

Irrigation machine (VC 220 90 Tech)

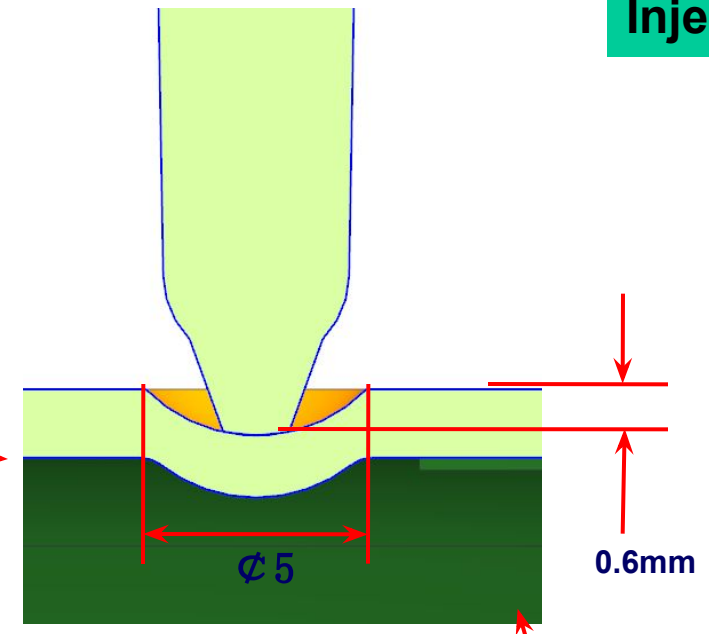
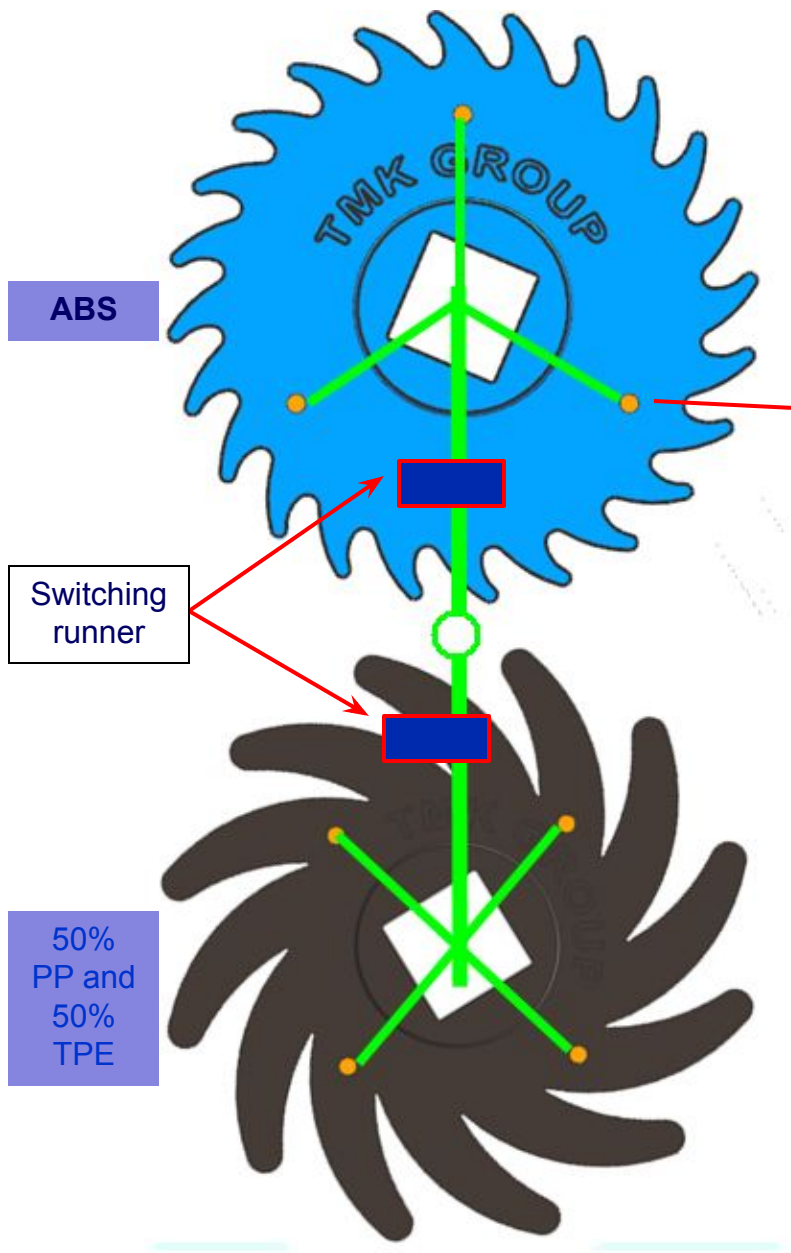




The red line is parting line.

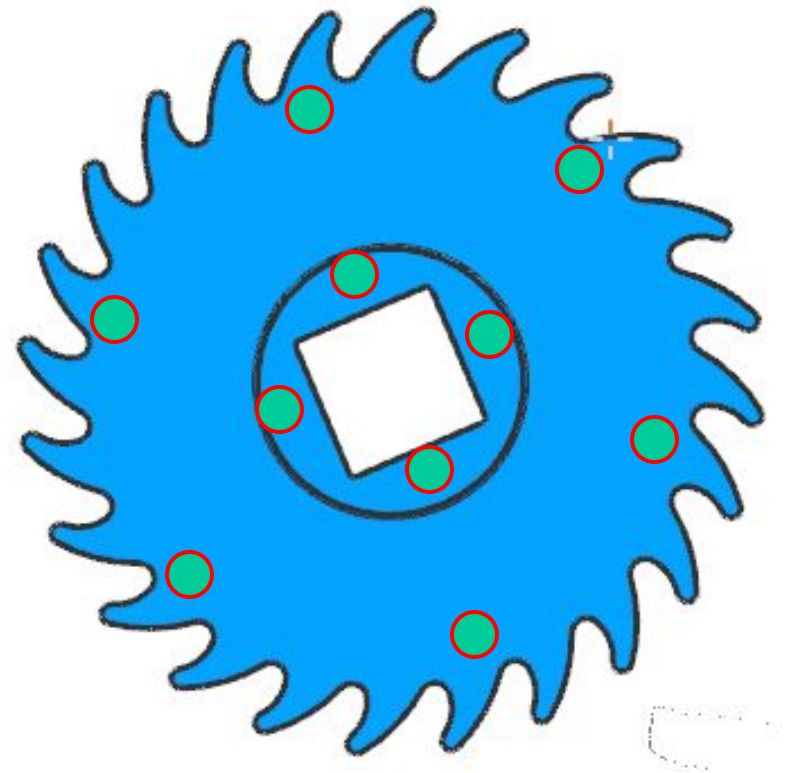
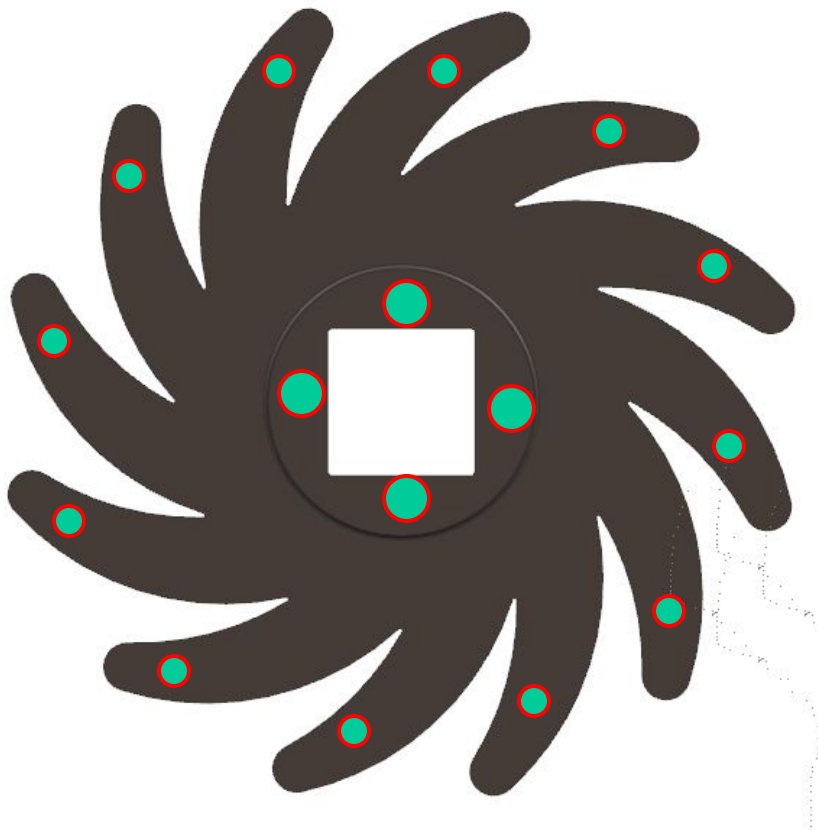


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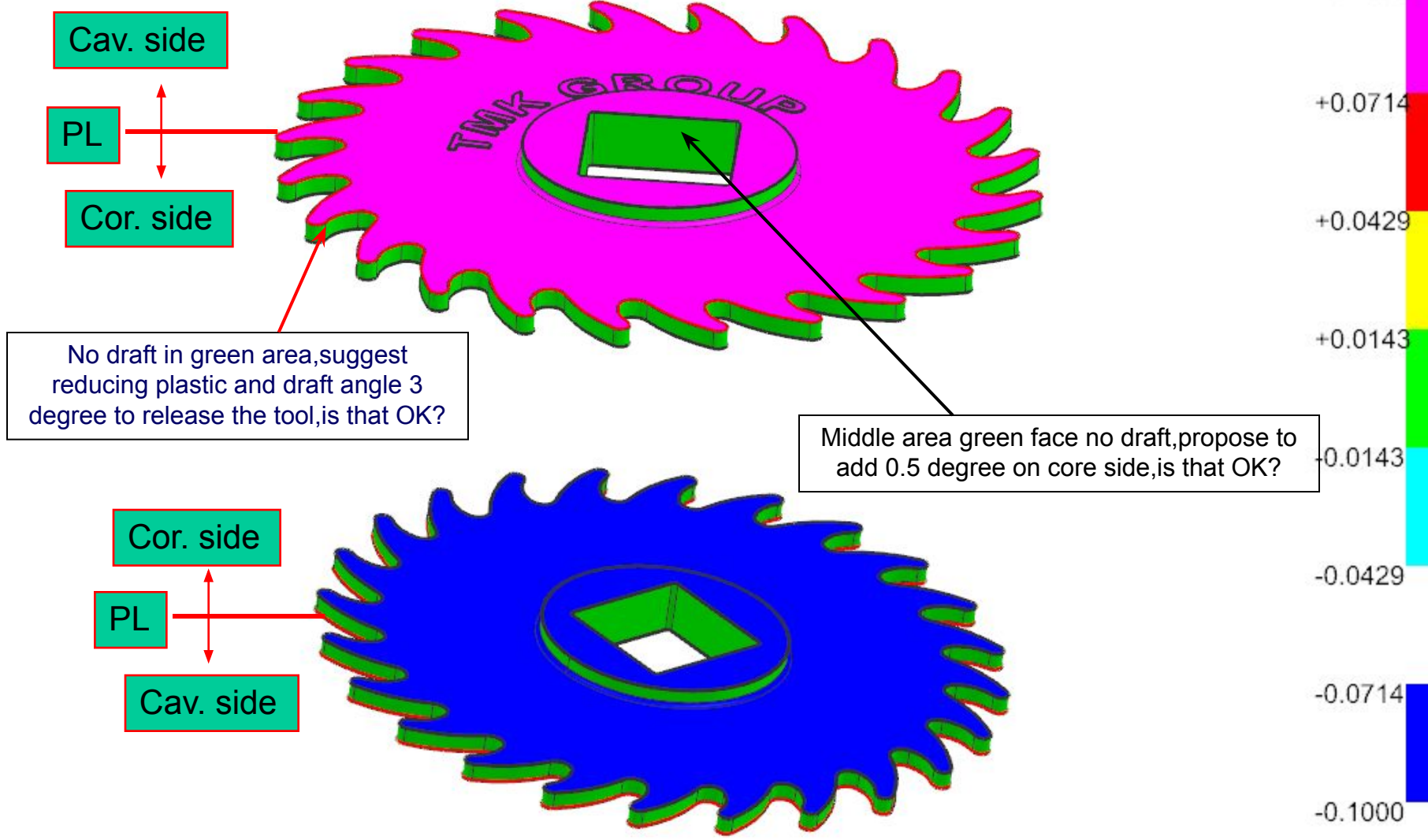


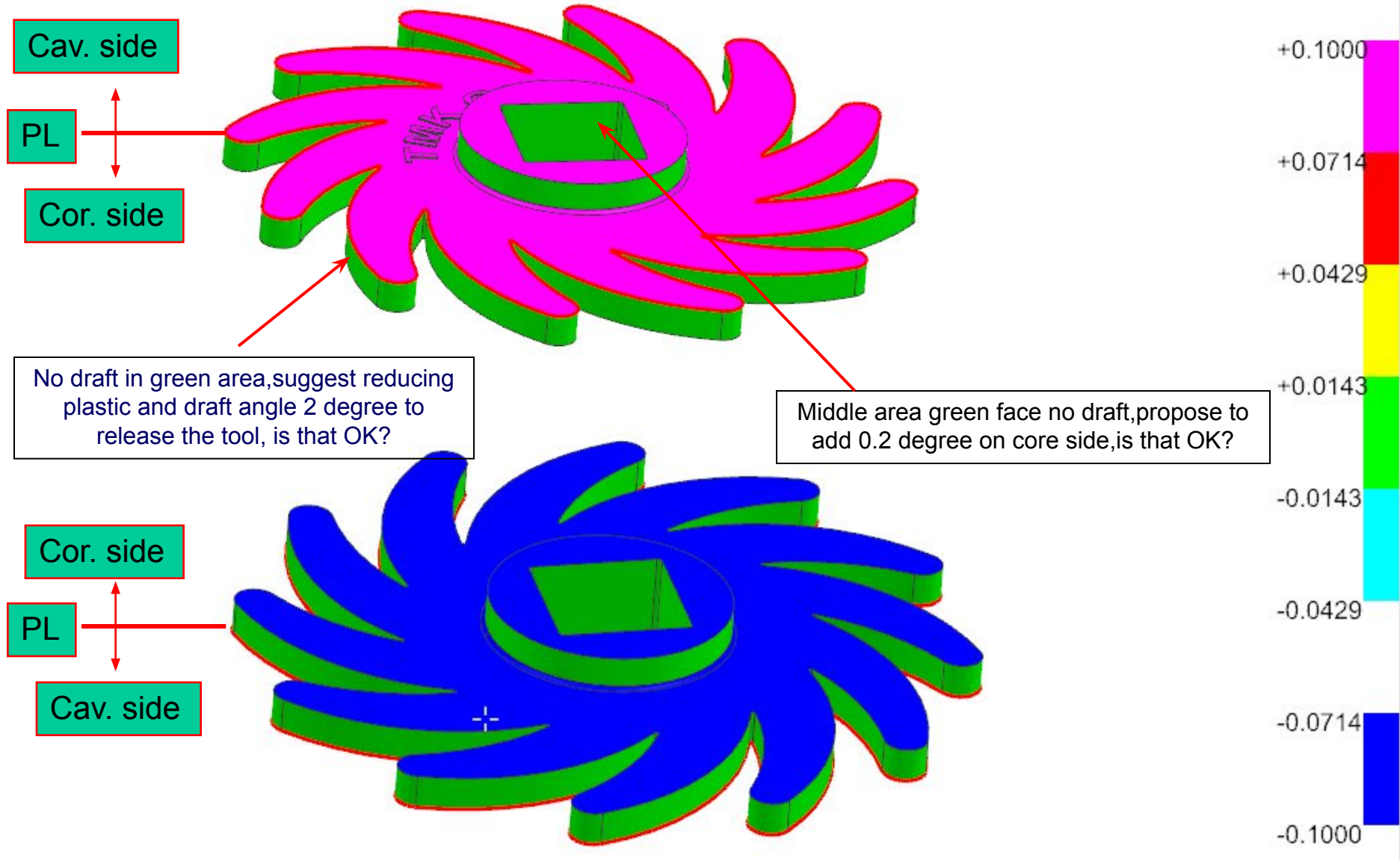
Gate position reduce 0.6mm plastic injection

Three plate mold / cold runner pin point gate



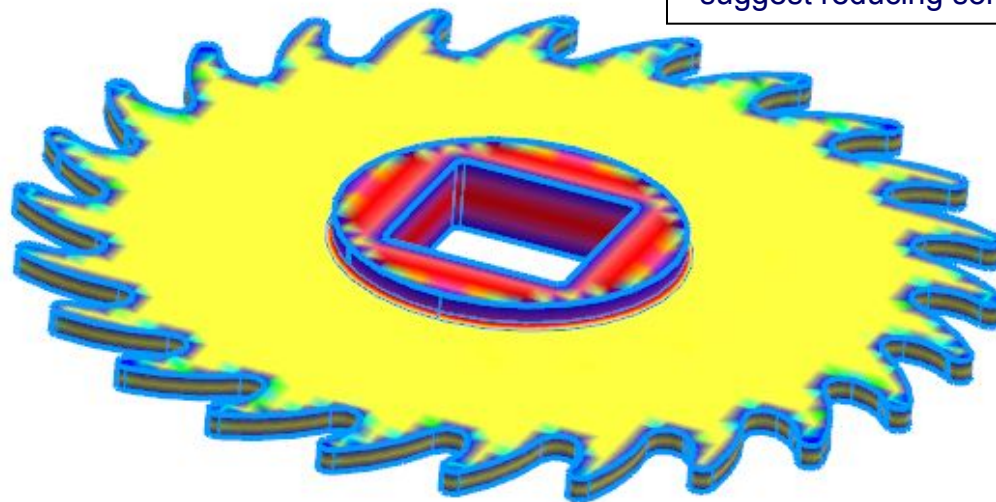
Ejector pin

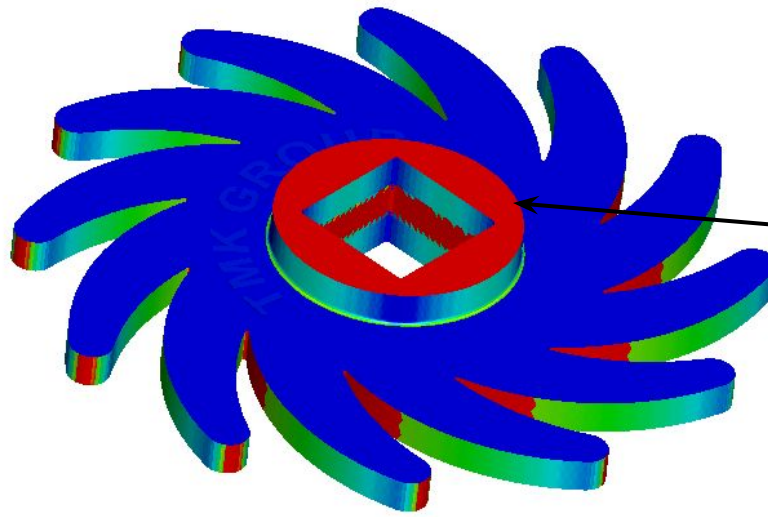




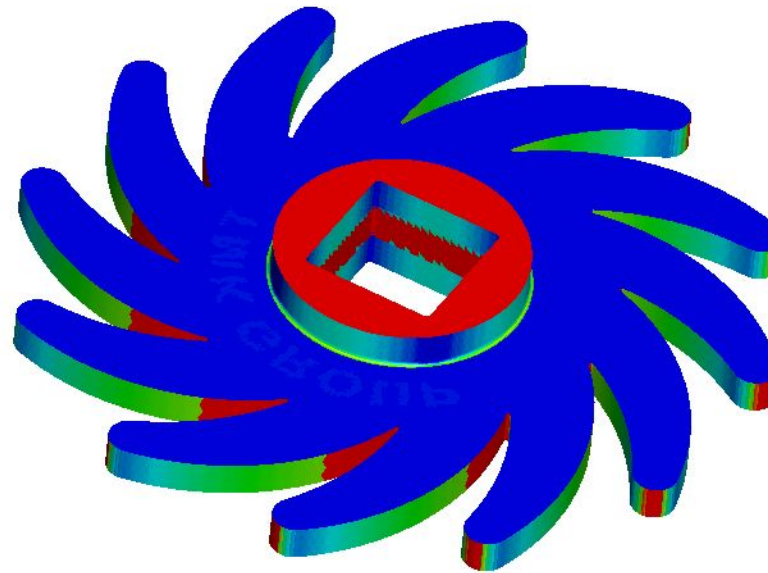
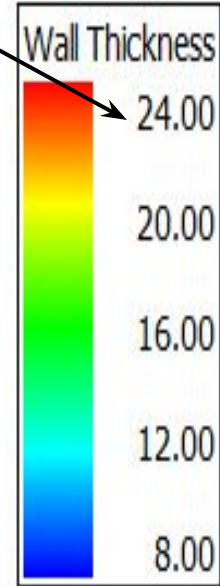


Because of the shrinkage of the thickness, we suggest reducing some wall thickness to improve it.





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Surface Finish: 400#



— THANK YOU —