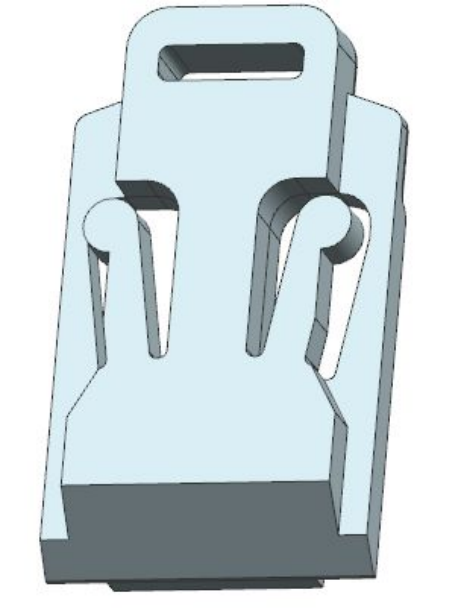
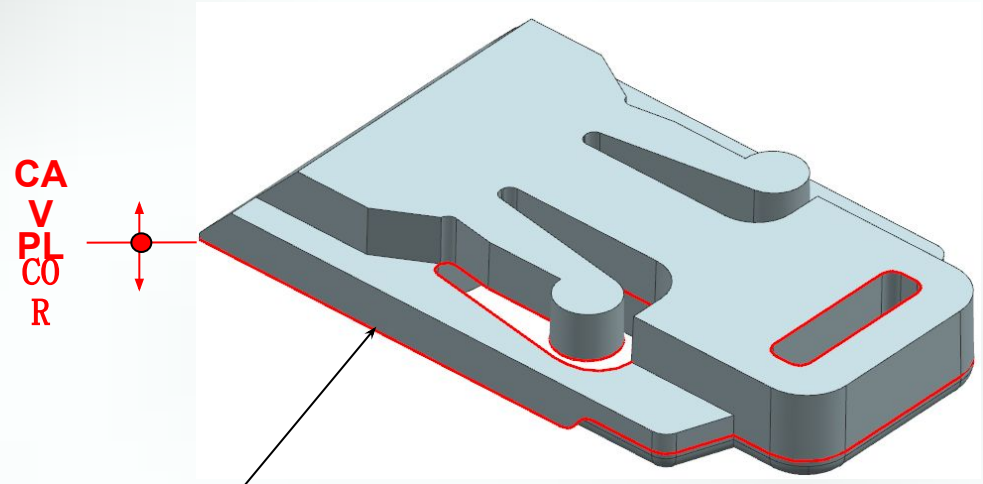
DFM REPORT

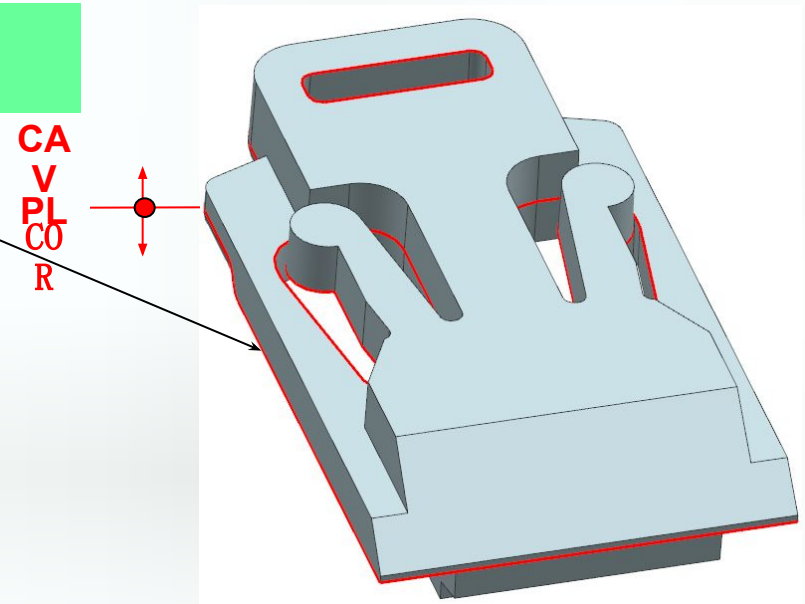
Part number：plc-kbr80-00.00.003 #latch#
2D/ 3D Date: plc-kbr80-00.00.003 #latch#.STEP
Project:
Date: 20220729
TM tooling no: TORCH-22419



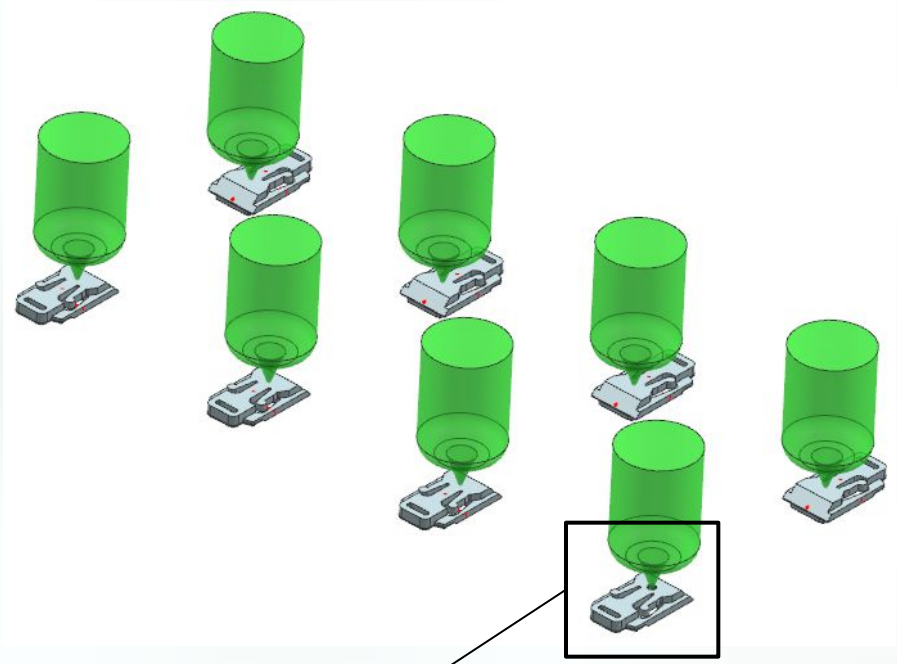
Project /Part 项目/产品ma		
Cavity number/ 模穴	1*8	
Material/shrinkage 原材料/缩水率	Material: PA66-GF25 Shrinkage: 1.005	
Part weight 产品重量	1.8g	
Tool type 模具种类	Two plate tool: /three plate tool: /Hot runner system tool: Y	
Injection concept 进胶方式	Hot runner: Y /cold runner: Gate type: /edge gate: /sub gate: /film gate: /tunnel gate: /banana gate:	
Number of slider/lifter 行位/斜顶	Number of slider: /Number of lifter:	
Connector / plug 水嘴/ 喉塞	DME: Y /HASCO: /Local: Spec: /1/8: /1/4: Y /3/8: /1/2:	
	Metric: Y /English: ; Type: /PT: Y /NPT :	
Surface finished 外观面要求	VDI xx (core: /cavity:) Texture (core: /cavity:) Polish (core: Y /cavity: Y)	
	High gloss (core: /cavity:) Transparent (core: /cavity:)	
Release method 取件方式	Fall freely: Y /manual: /by robot:	
Injection machine Type/ 注塑机	160T	
Insert material/模仁材料	H13	

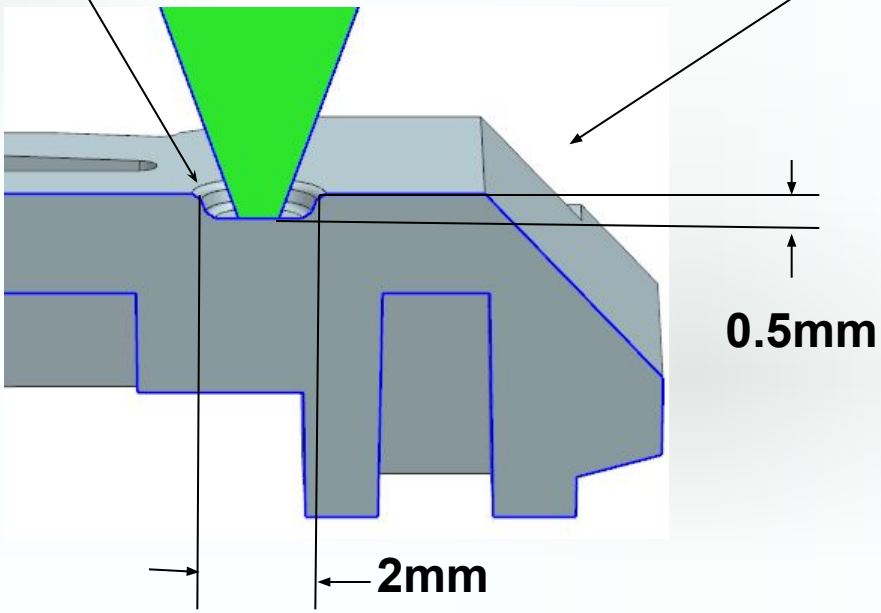


The red line is the parting line PL, please confirm.



尖点热嘴进胶，进胶处做图示凹槽
Hot nozzle injection as picture shows.



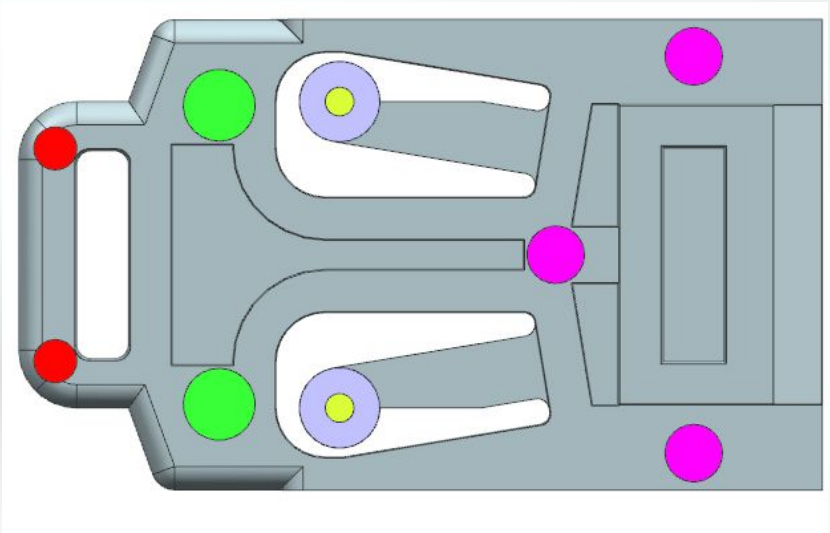


Φ1.5 Ejector Pin

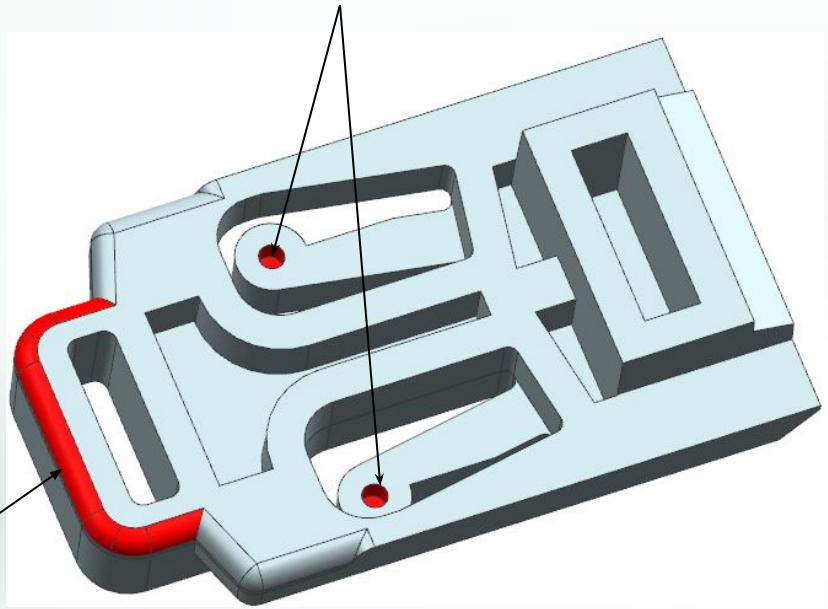
Ø2.8* Ø1 Ejector Sleeve

Φ2.5 Ejector Pin

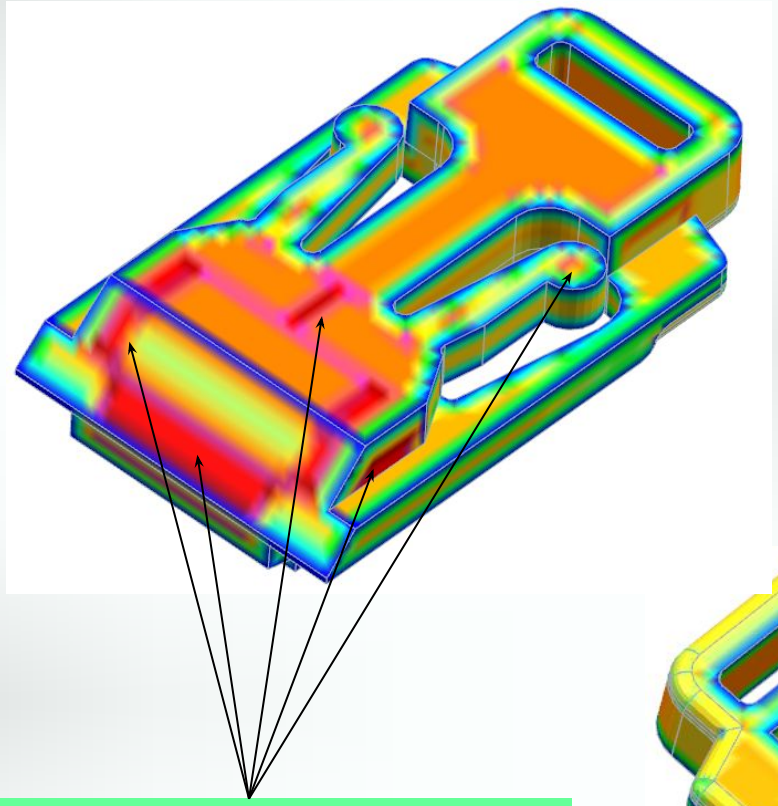
Φ2 Ejector Pin

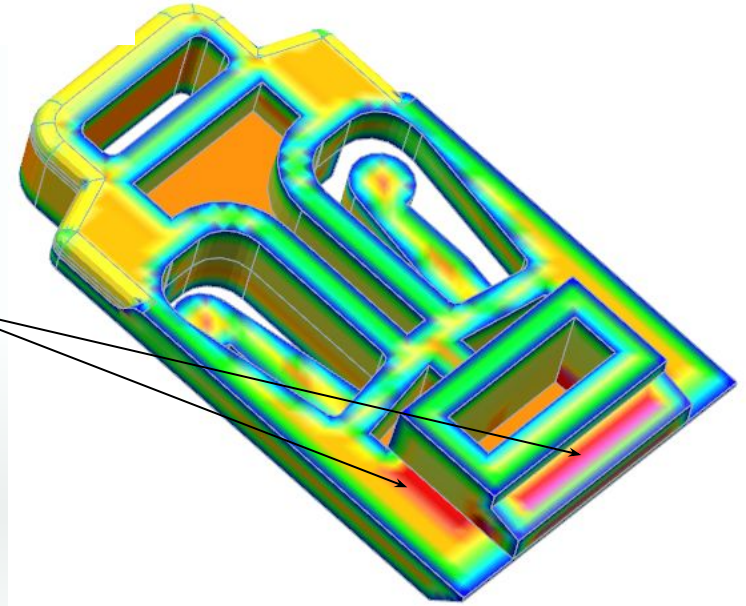


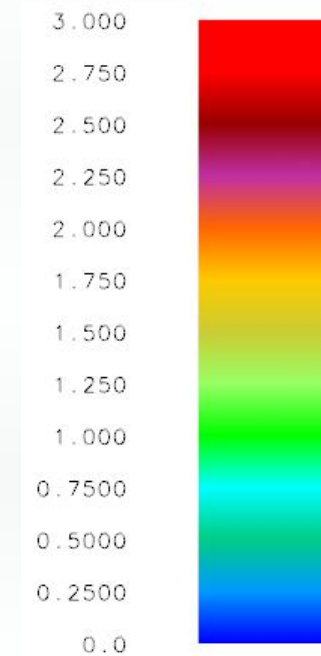
2处做直径1MM，深度1MM内孔，布放司筒针，防止粘前模
2 places diameter 1mm, inside hole depth 1mm, avoid sticking to the cavity.



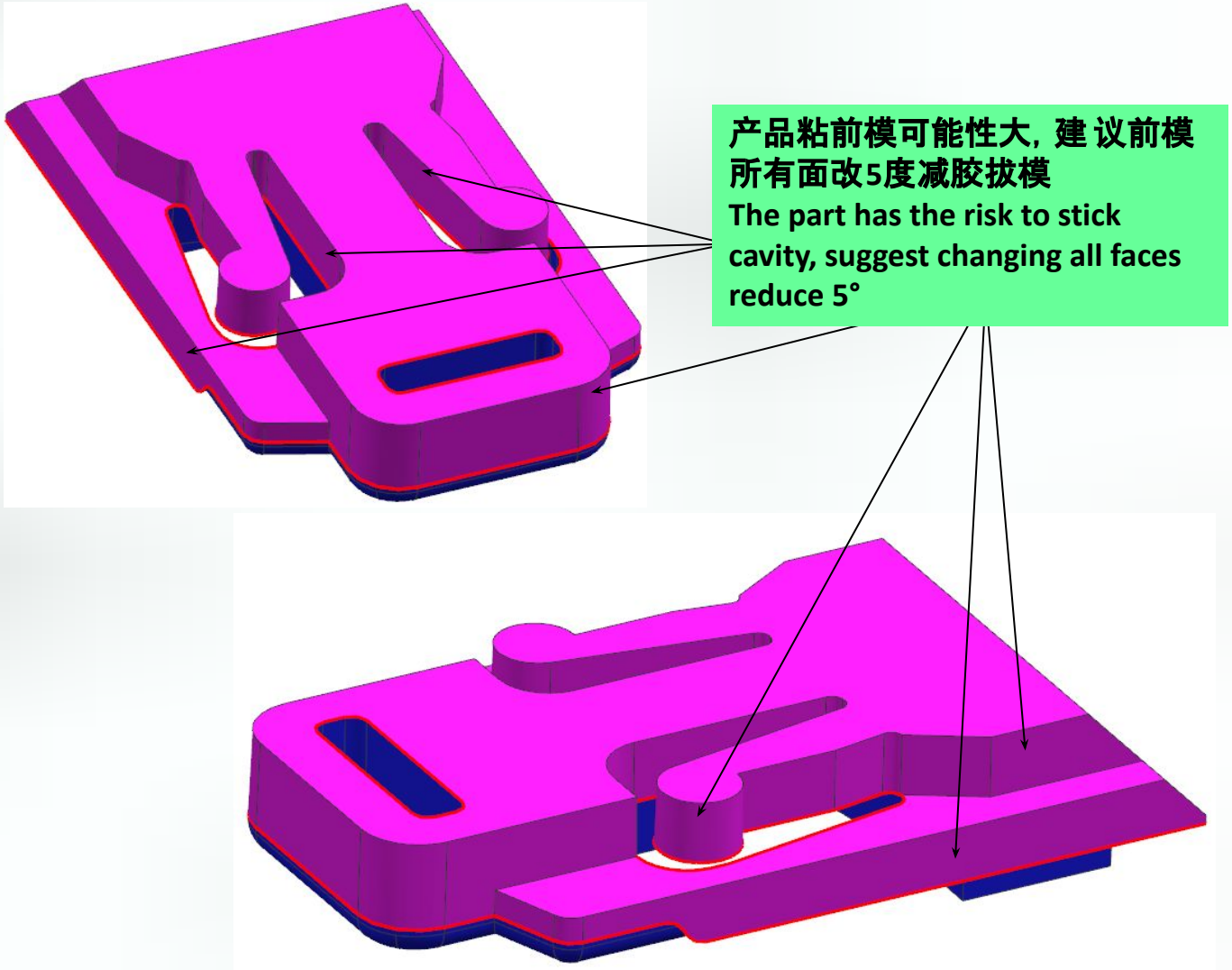
红色面R0.8MM改R0.3MM，便于布放顶针
Red faces R0.8mm changes to R0.3mm, convenience to put ejector pins

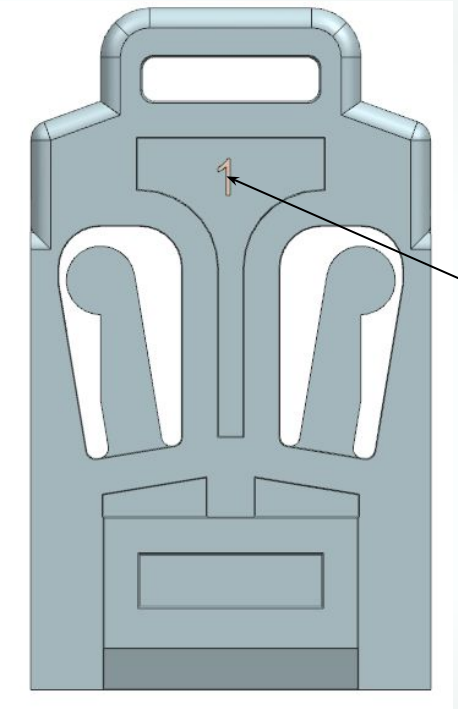






Red area may shrink, please confirm!红色区域可能会缩水，请确认！


产品粘前模可能性大，建 议前模所有面改5度减胶拔模
The part has the risk to stick cavity, suggest changing all faces reduce 5°
+0.1000
+0.0667
+0.0333
0.0
-0.0333
-0.0667
-0.1000

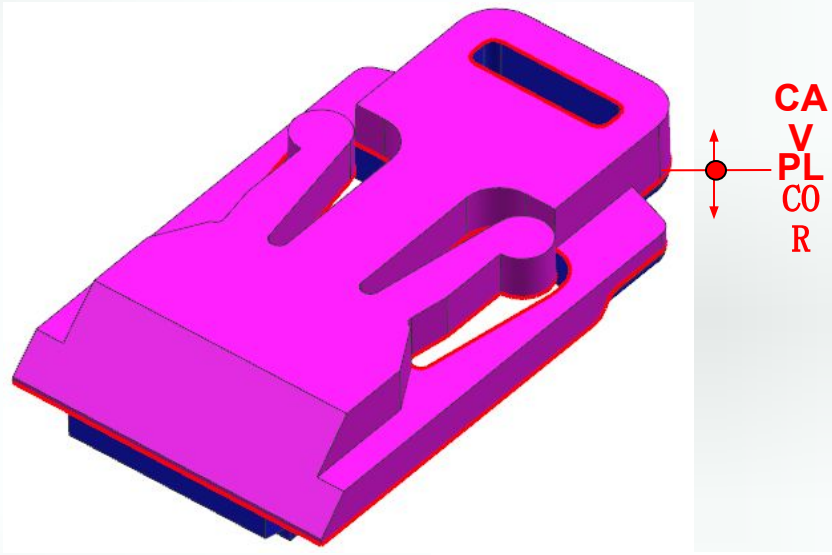


As picture shows, add mold cavity number(1……8).
the text height 1.5mm, text bulge 0.1mm, please confirm.

指示位置增加模穴号 (1……8)，字高 1.5MM，字凸0.1MM

Cavity

Core



防止产品粘前模，建议产品表面按如下所示处理：

Cavity 前模：SPI-B2

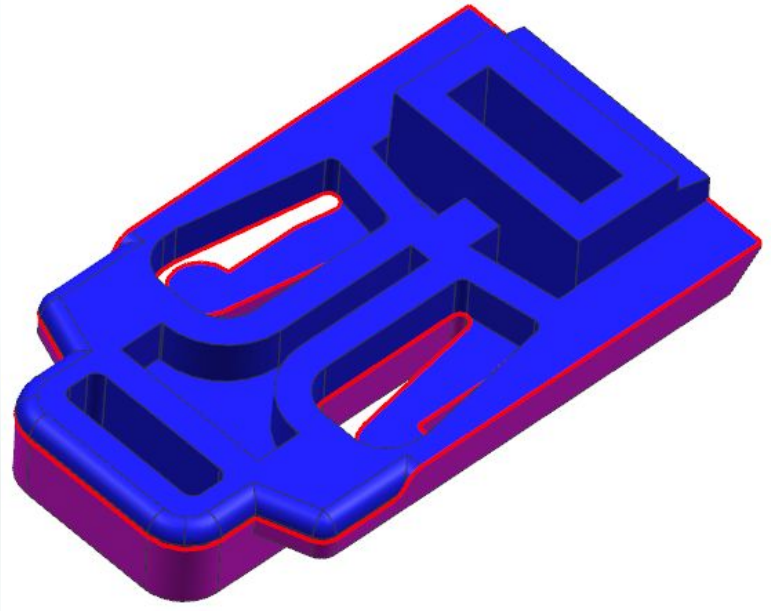
Core 后模：VDI24

To avoid part stick cavity, we suggest part surface make surface treatment as below/l

Cavity：SPI-B2

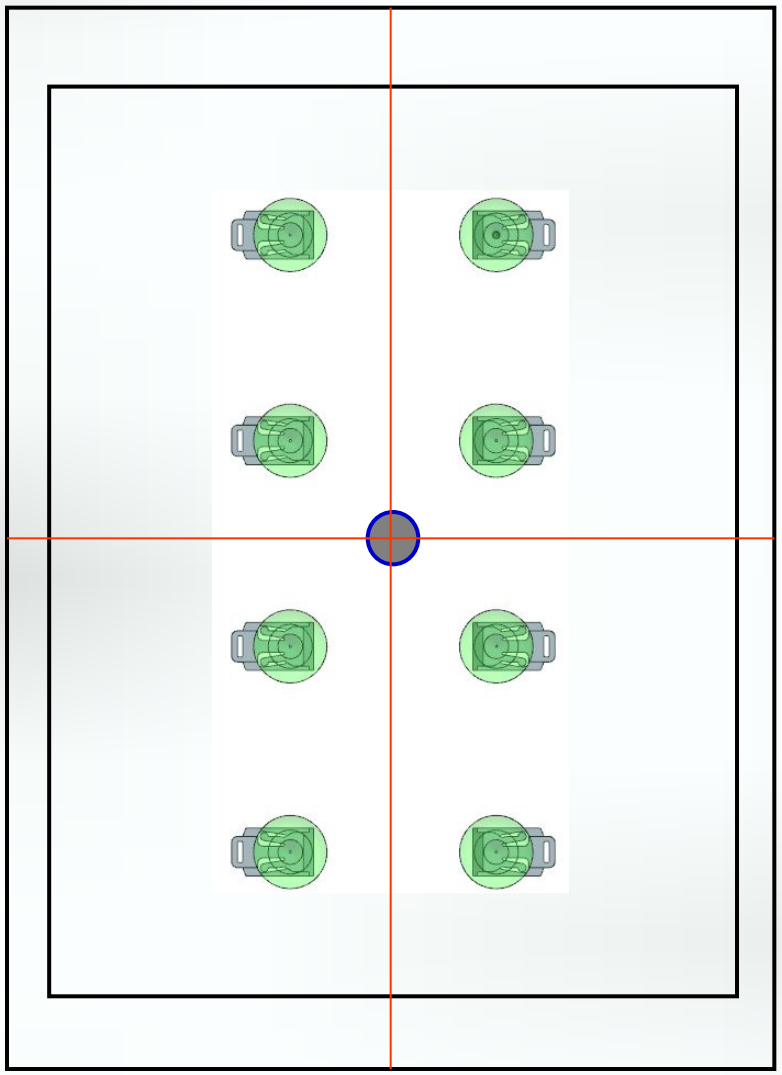
Core：VDI24

Please help confirm.



Mold Layout—option

Tool top



Customer ‘s approval /comments