



DFM REPORT

Part number: plc-kbr80-00.00.001 _shell

2D/ 3D Date:

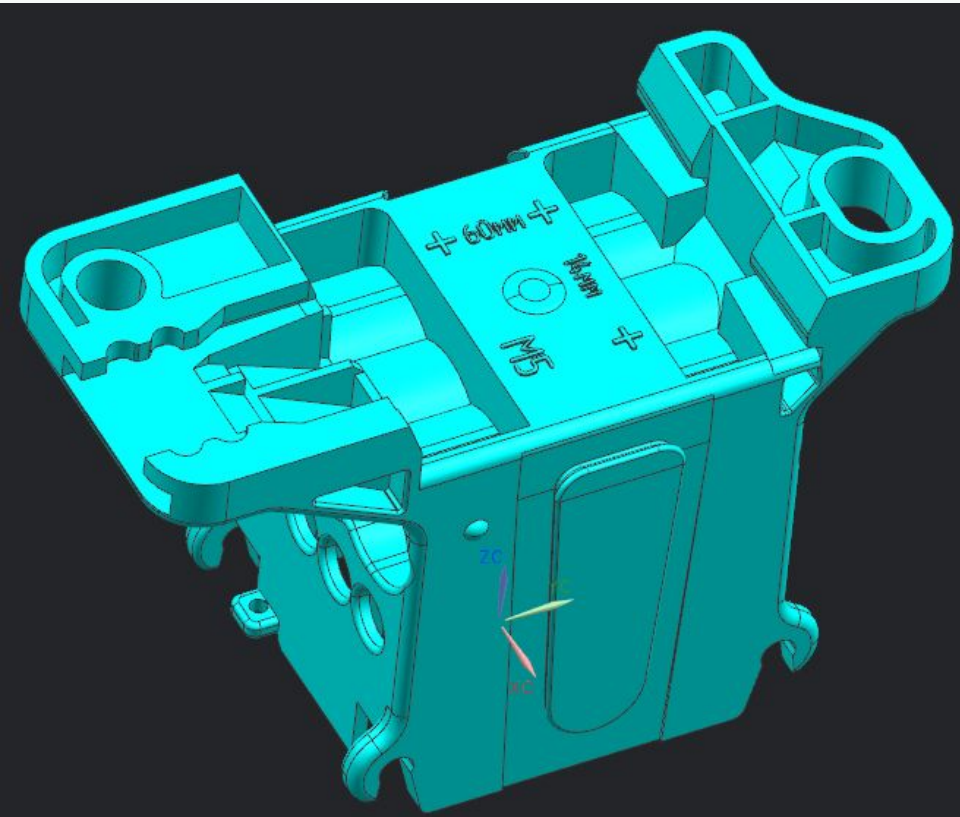
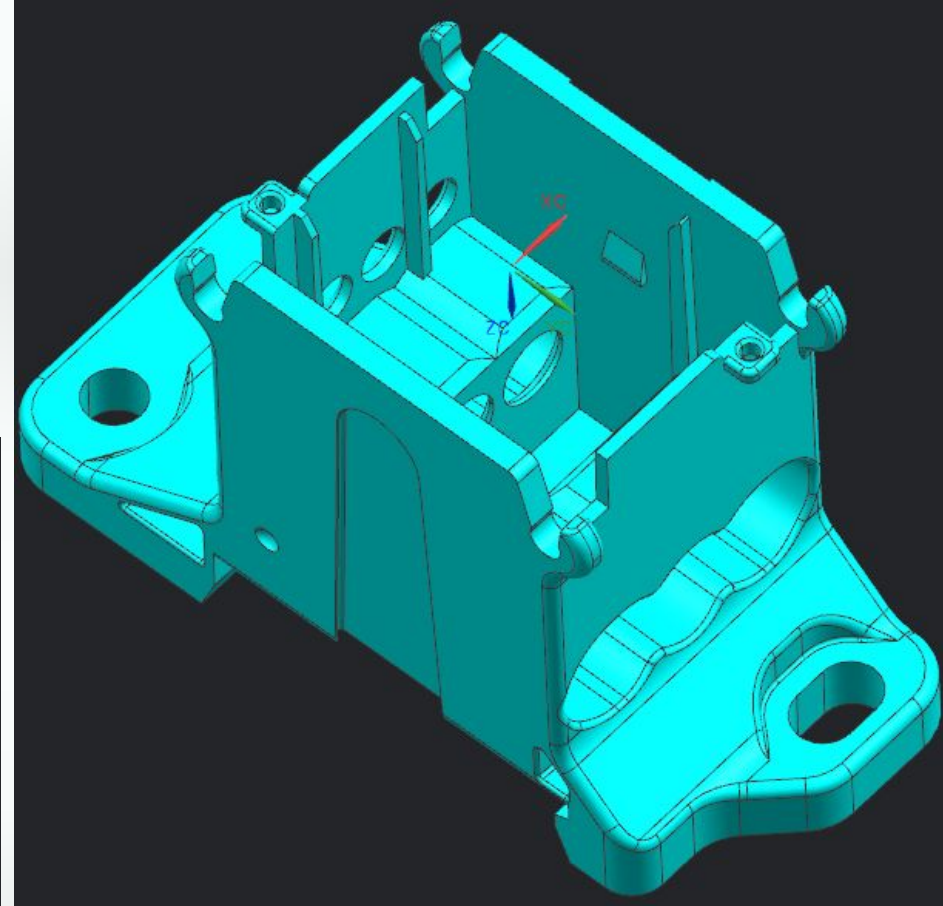
 plc-kbr80-00.00.001 #shell#.pdf

 plc-kbr80-00.00.001 #shell#.STEP

Project:

Date: 20220711

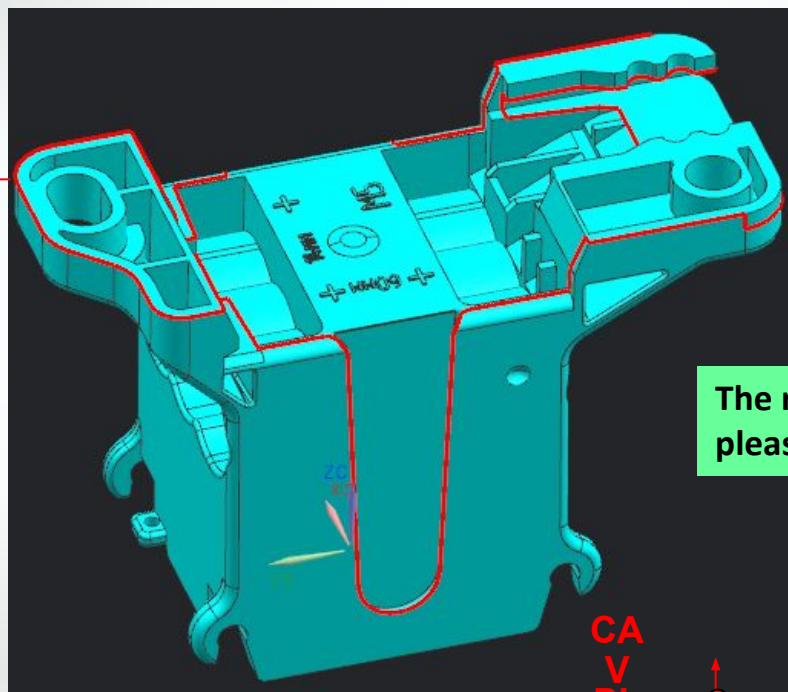
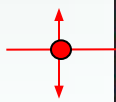
TM tooling No.: Torch-22415



GENERAL INFORMATION

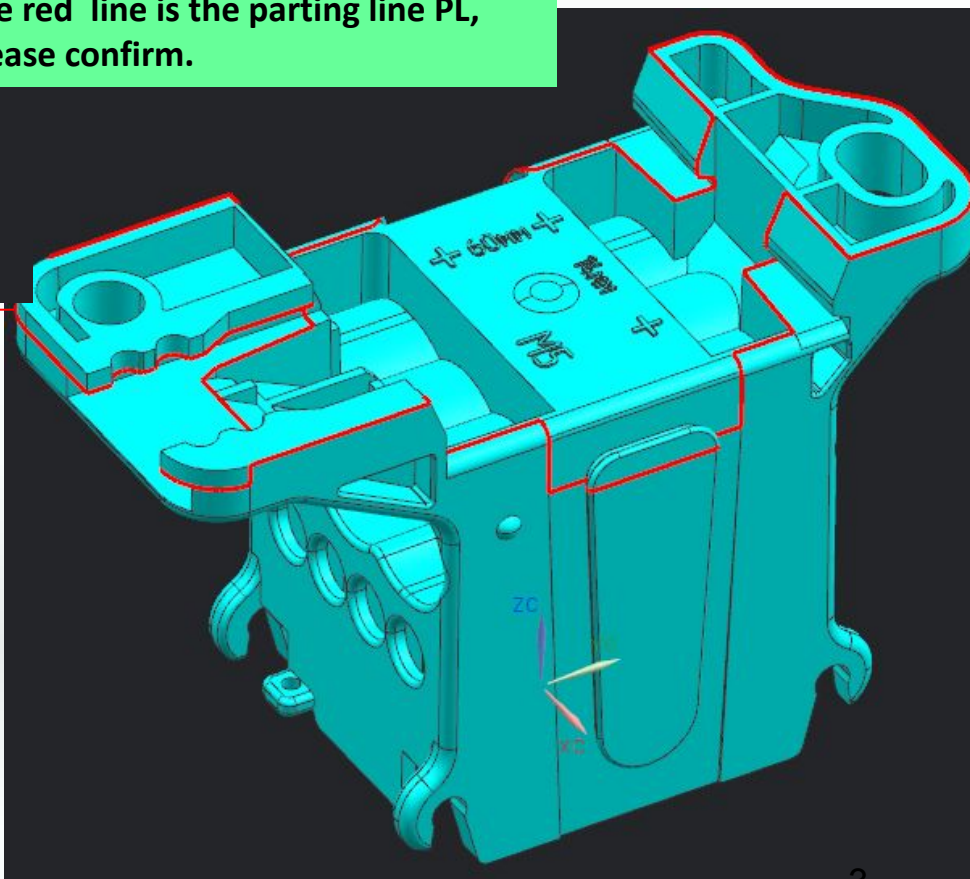
Project /Part 项目/产品ma		
Cavity number/ 模穴	1X2	
Material/shrinkage 原材料/缩水率	Material: PA66-GF25 Shrinkage: 1.005	
Part weight 产品重量	16.4g	
Tool type 模具种类	Two plate tool: Y /three plate tool: /Hot runner system tool:	
Injection concept 进胶方式	Hot runner: /cold runner: Gate type: /edge gate: Y /sub gate: /film 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: /English: Y ; Type: /PT: /NPT : Y	
Surface finished 外观面要求	VDI xx (core: /cavity:) Texture (core: /cavity: Y) Polish (core: Y /cavity:)	
	High gloss (core: /cavity:) Transparent (core: /cavity:)	
Release method 取件方式	Fall freely: /manual: Y /by robot:	
Injection machine Type/ 注塑机	Haitian Mars MA1600III/570	
Insert material/模仁材料	H13葛利兹	

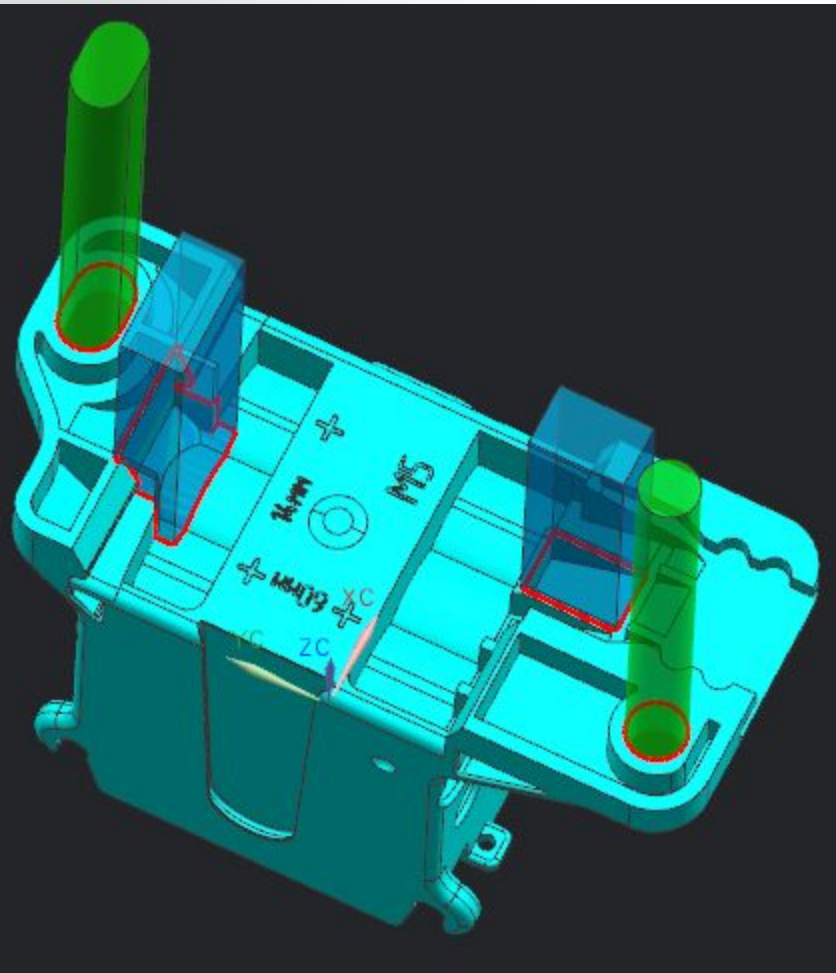
CA
V
PL
CO
R



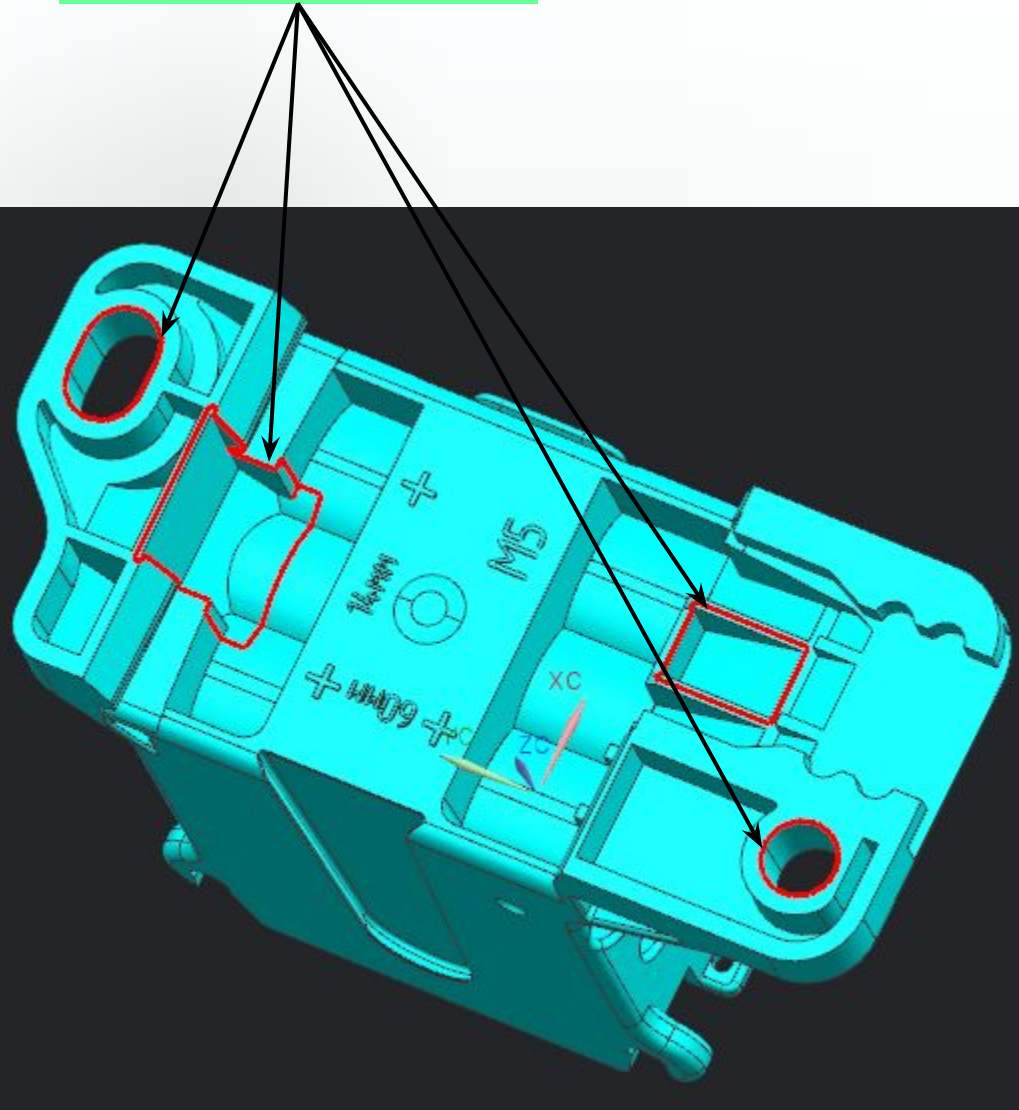
The red line is the parting line PL, please confirm.

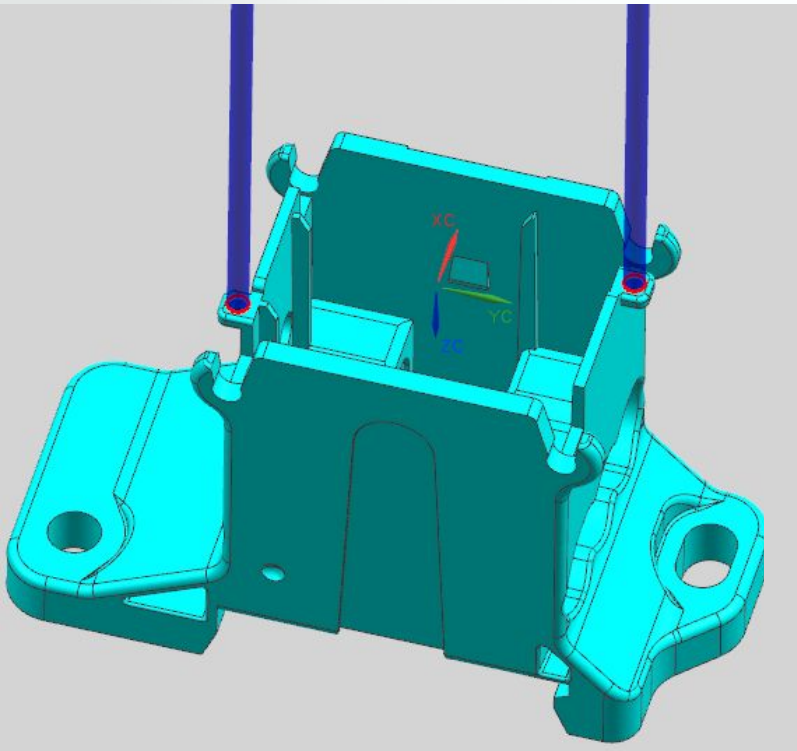
CA
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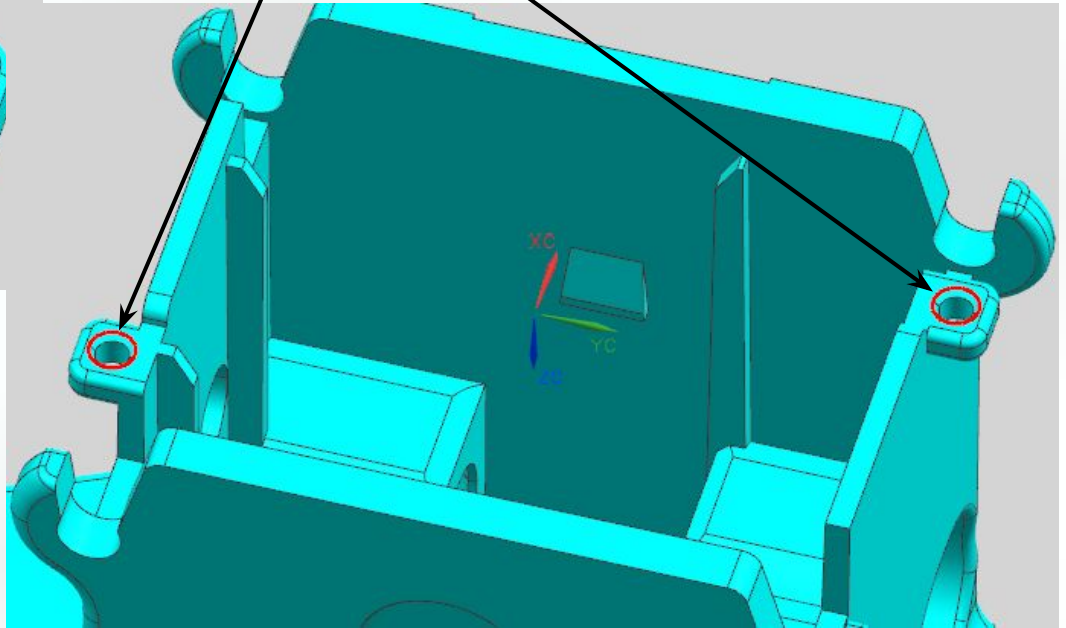


Cavity Insert parting line

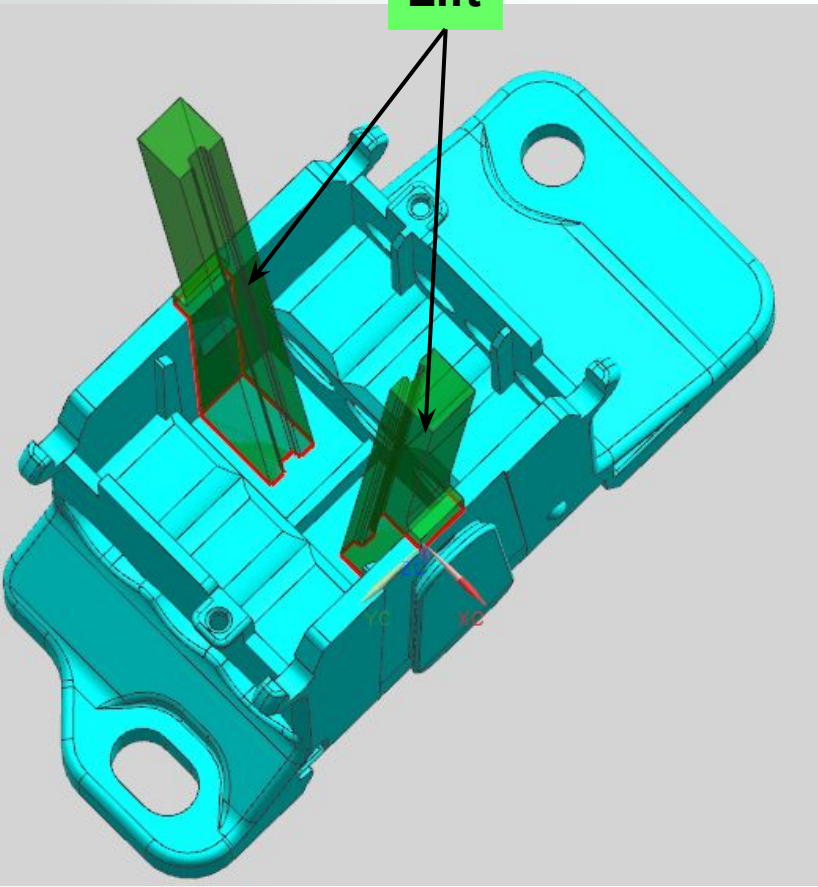




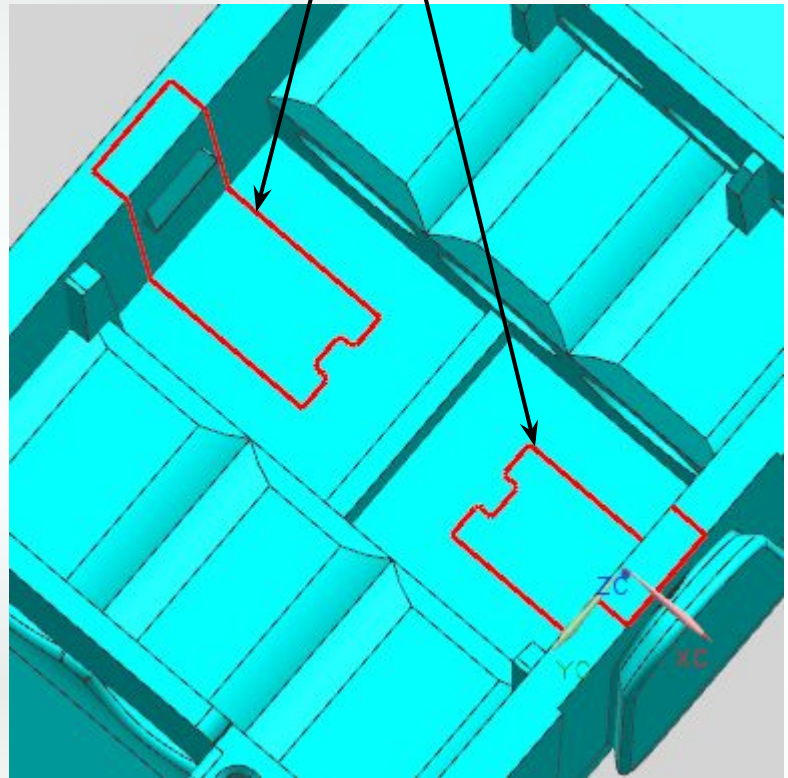
Core Insert Pin parting line



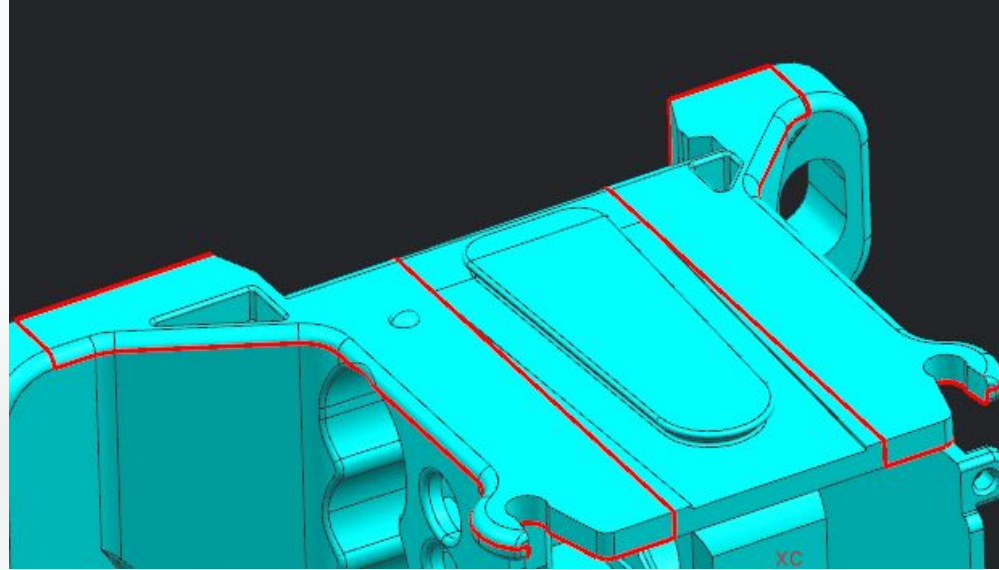
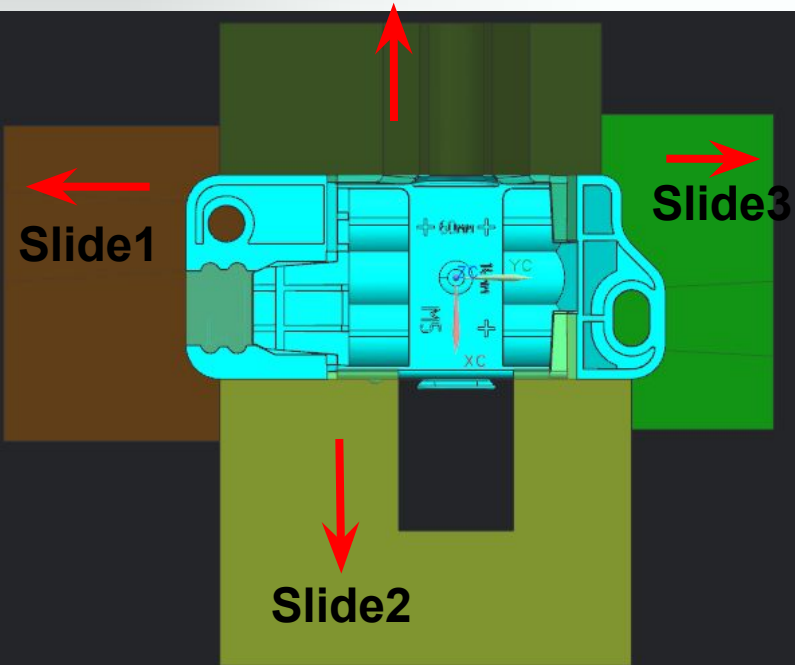
Lift



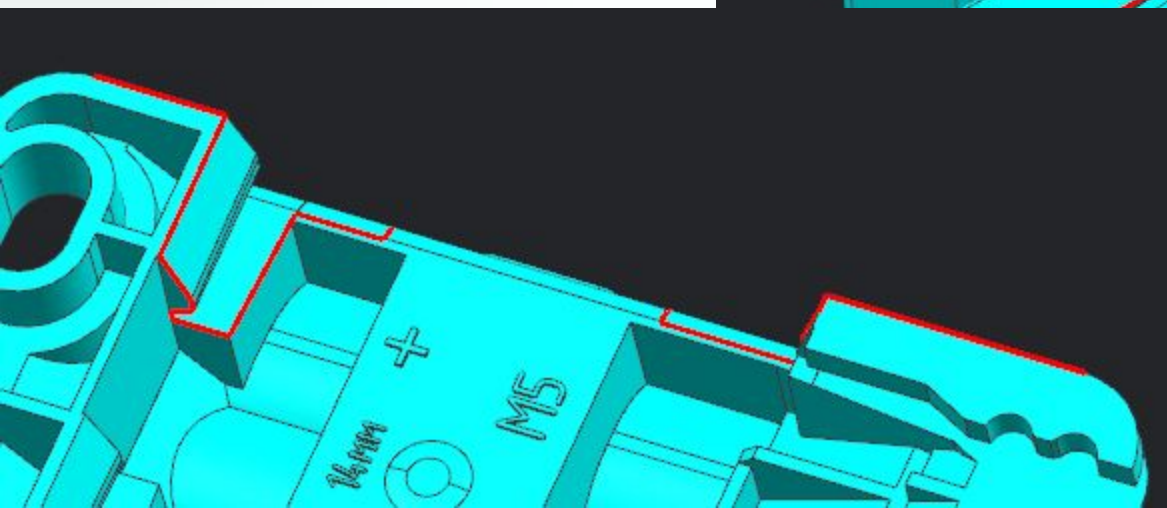
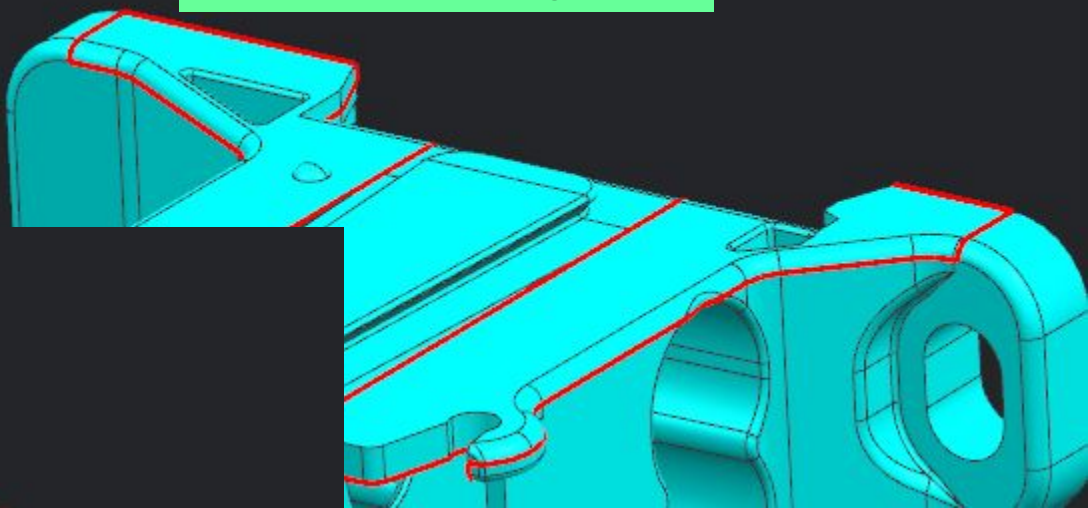
Lift Insert parting line

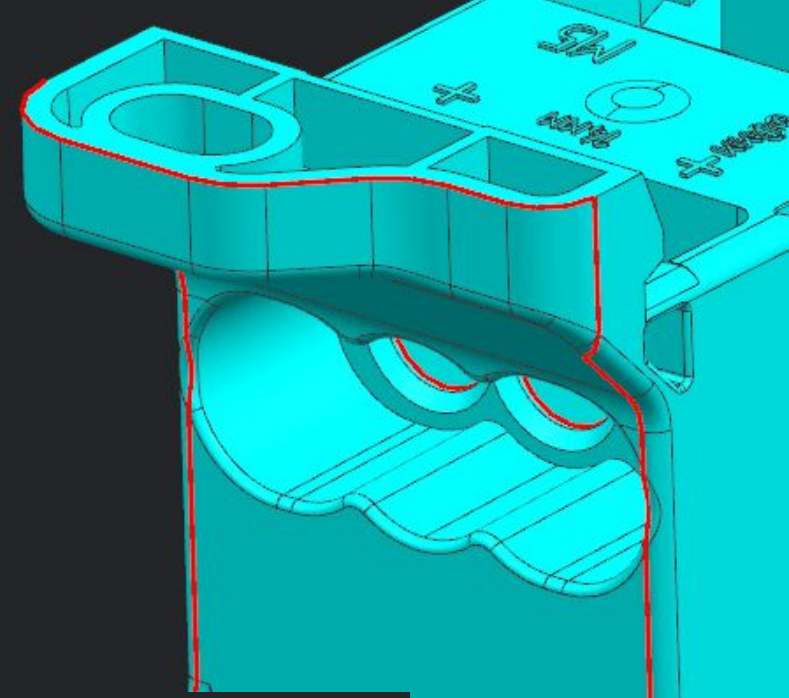
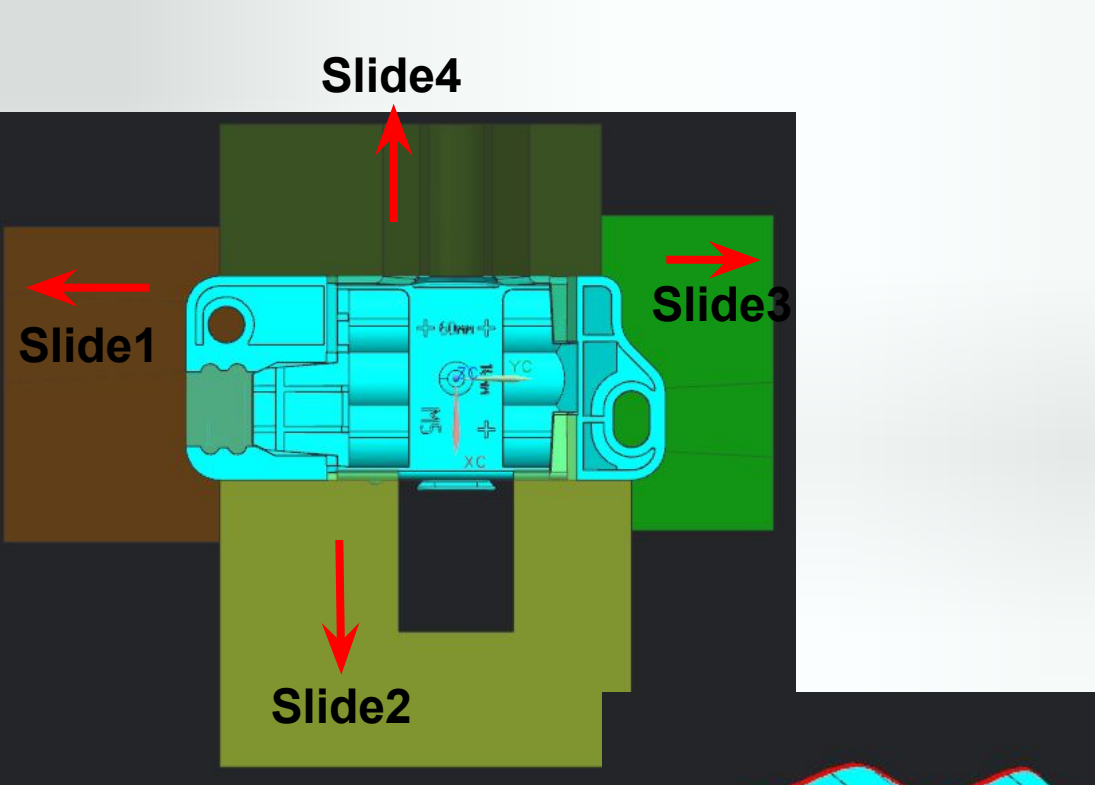


Slide4

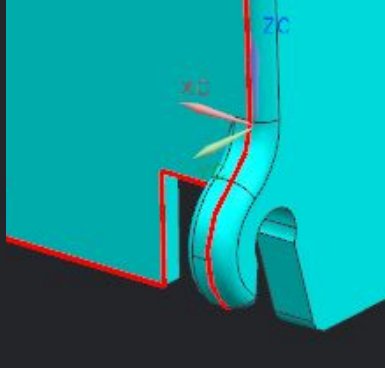
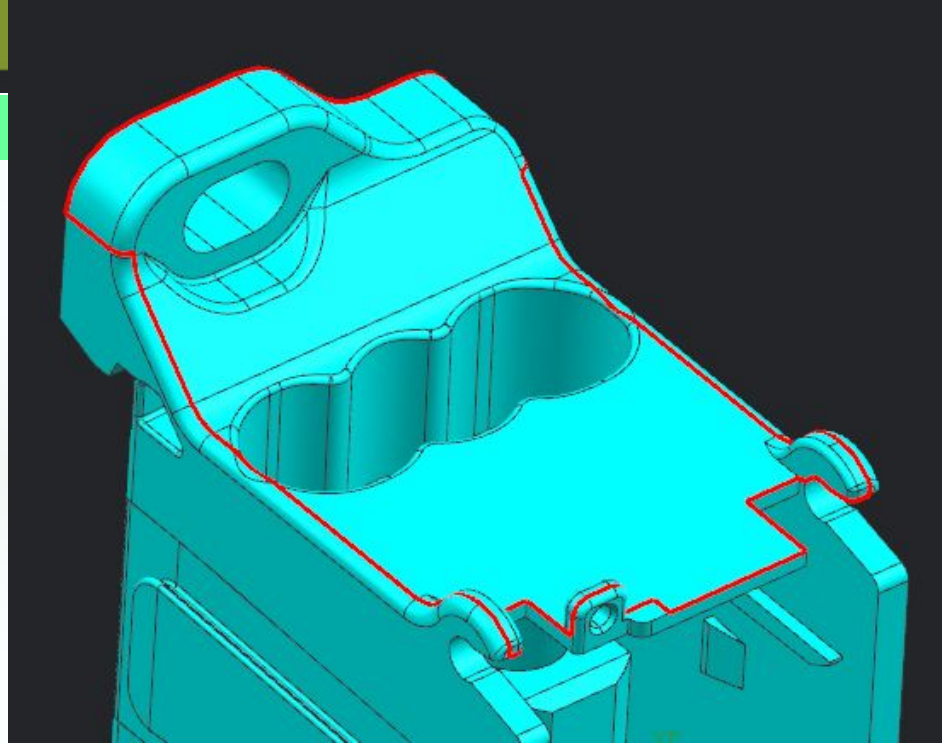


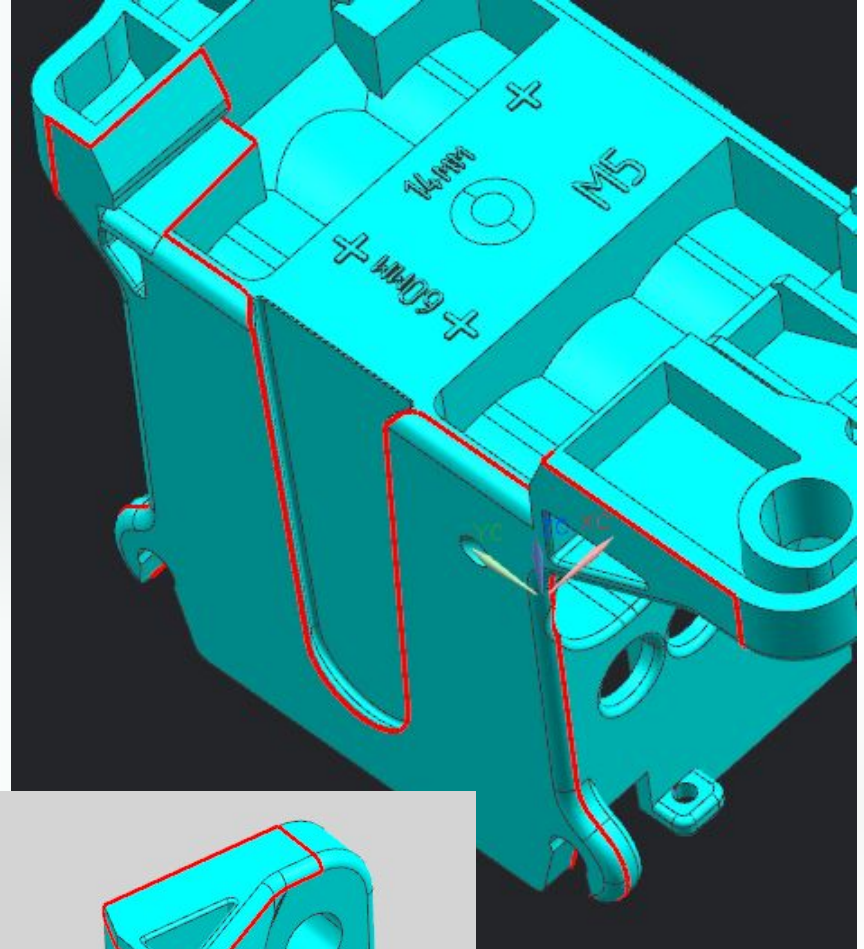
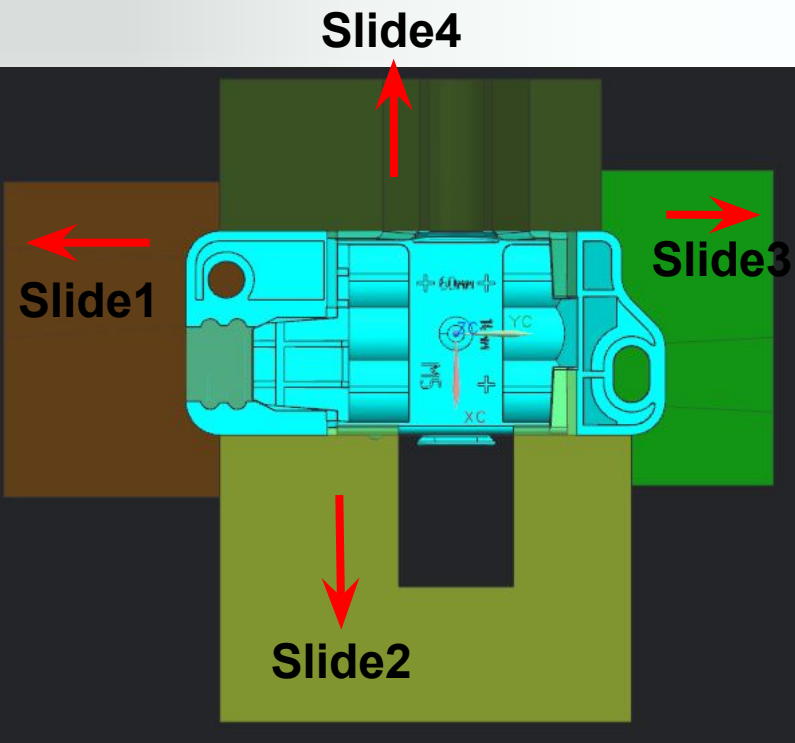
Slide 2 Insert parting line



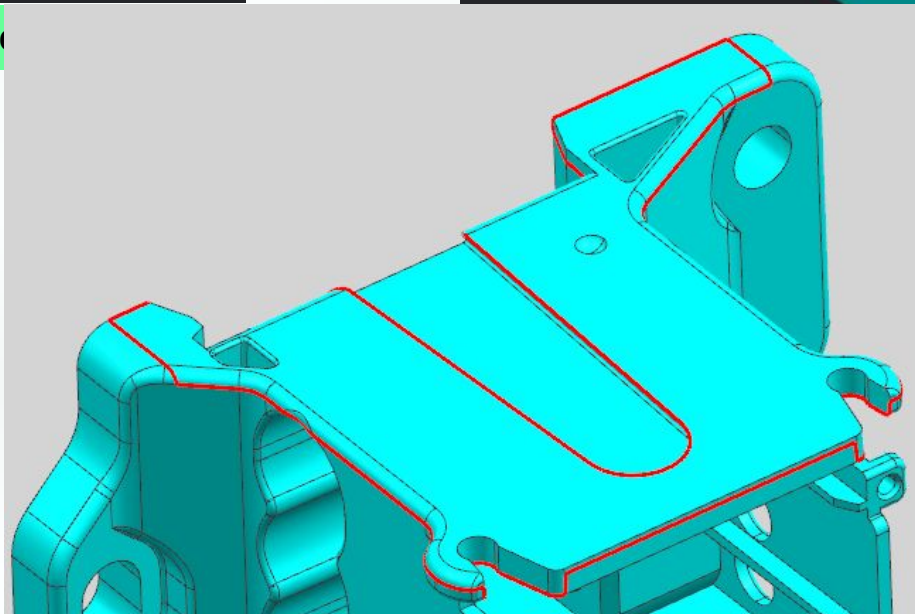


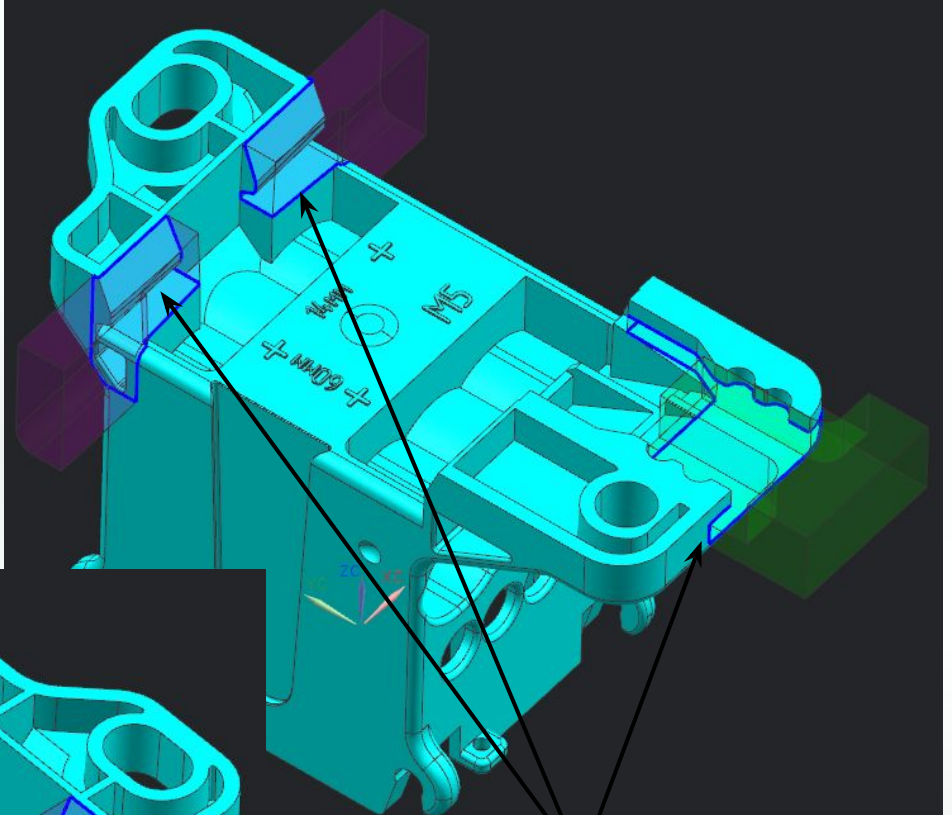
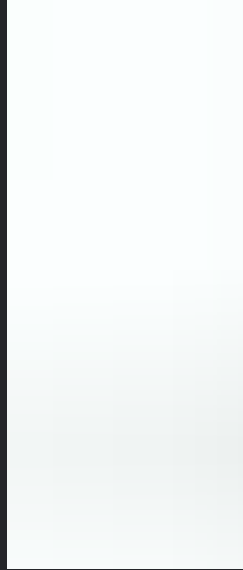
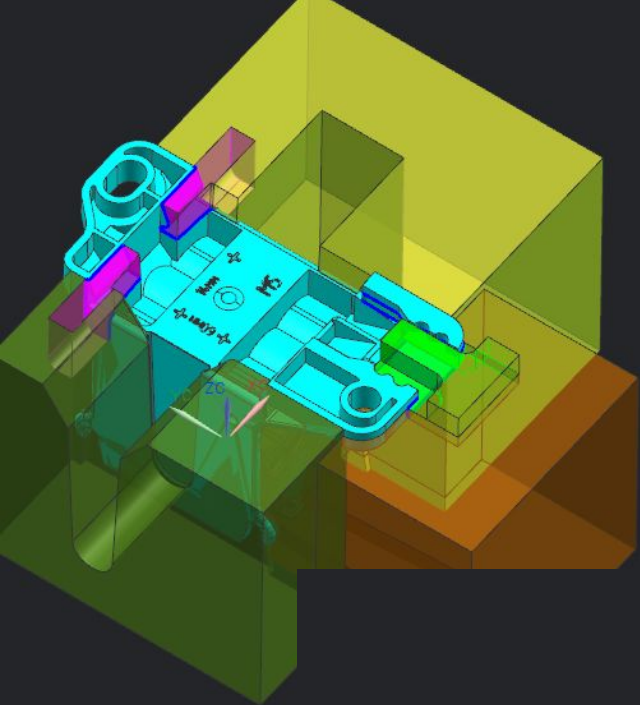
Slide 3 Insert parting line



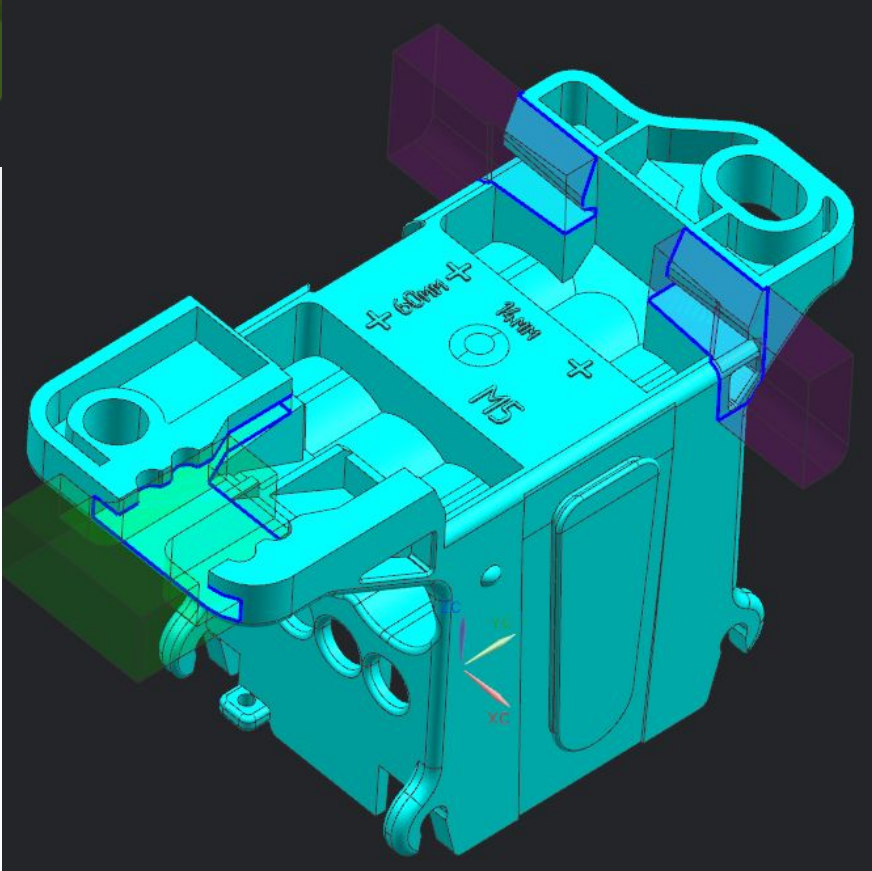


Slide 4 Insert parting line

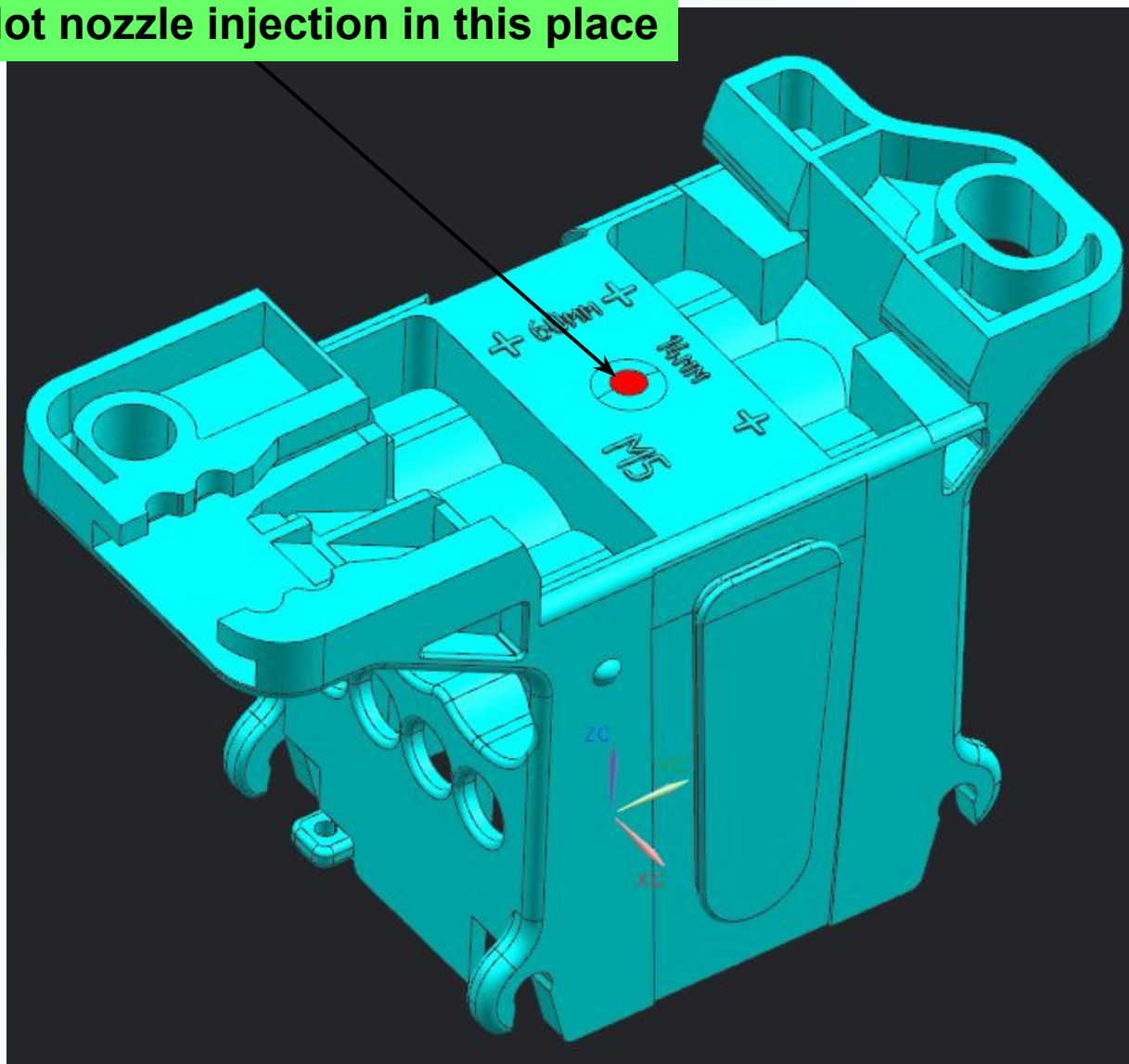


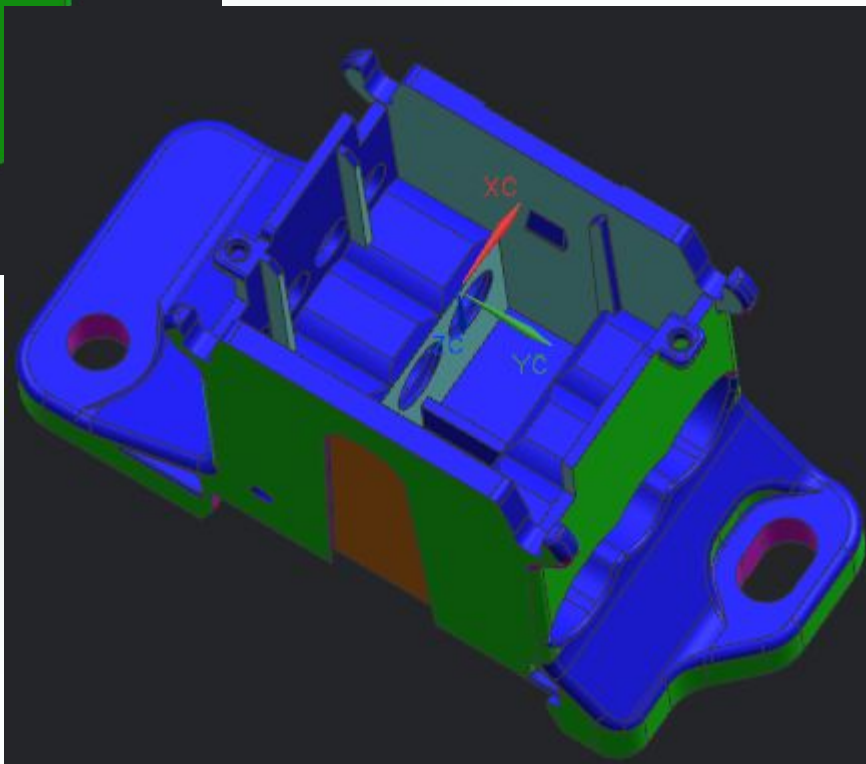
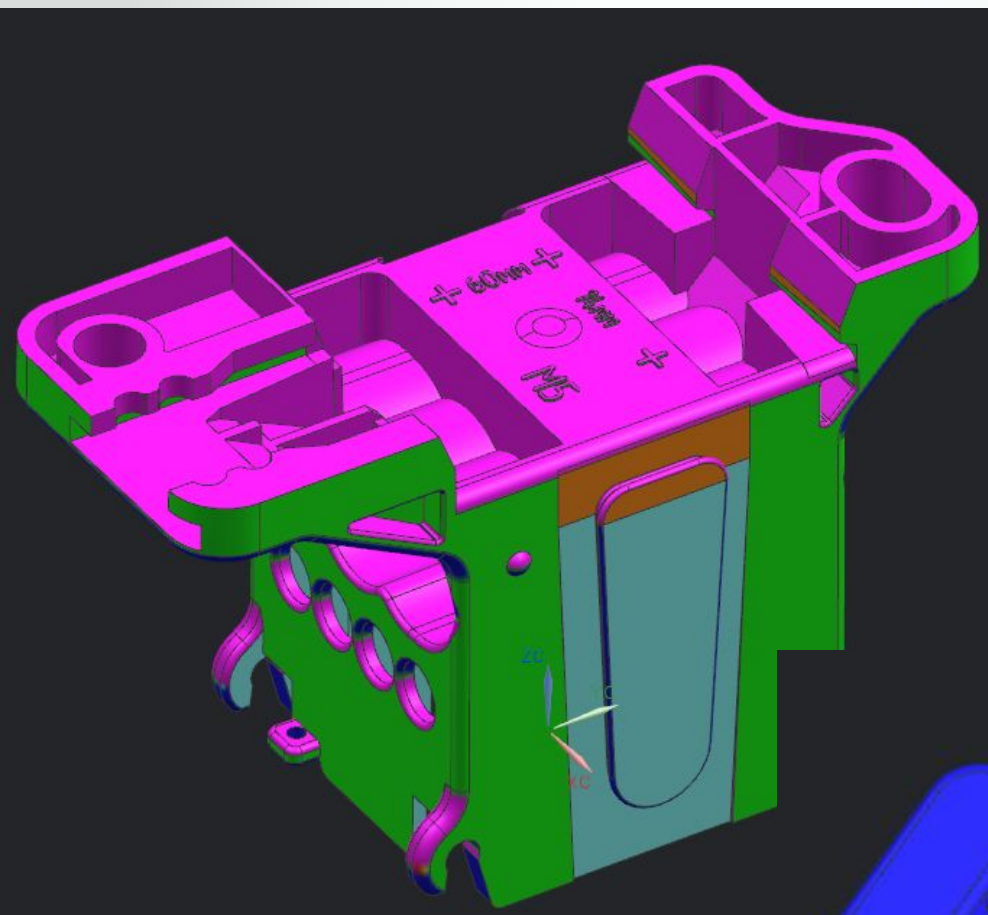


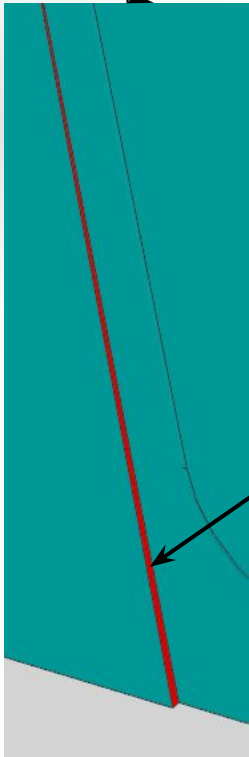
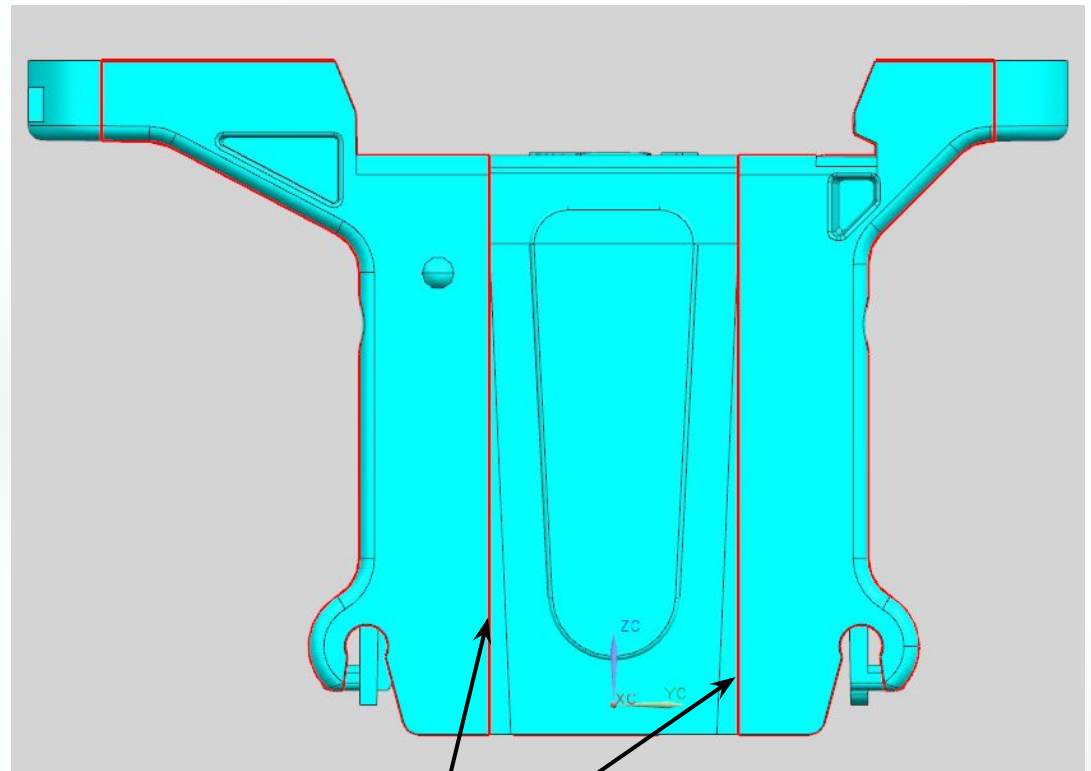
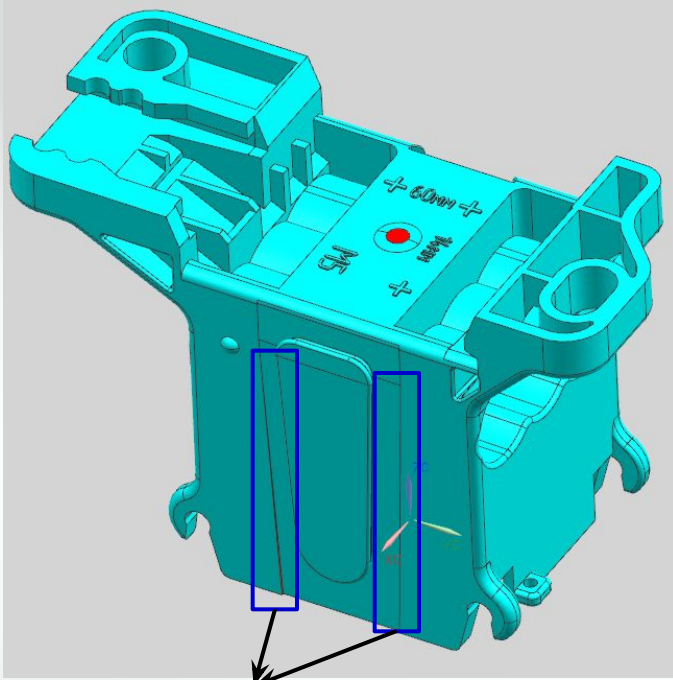
Slide Insert parting line



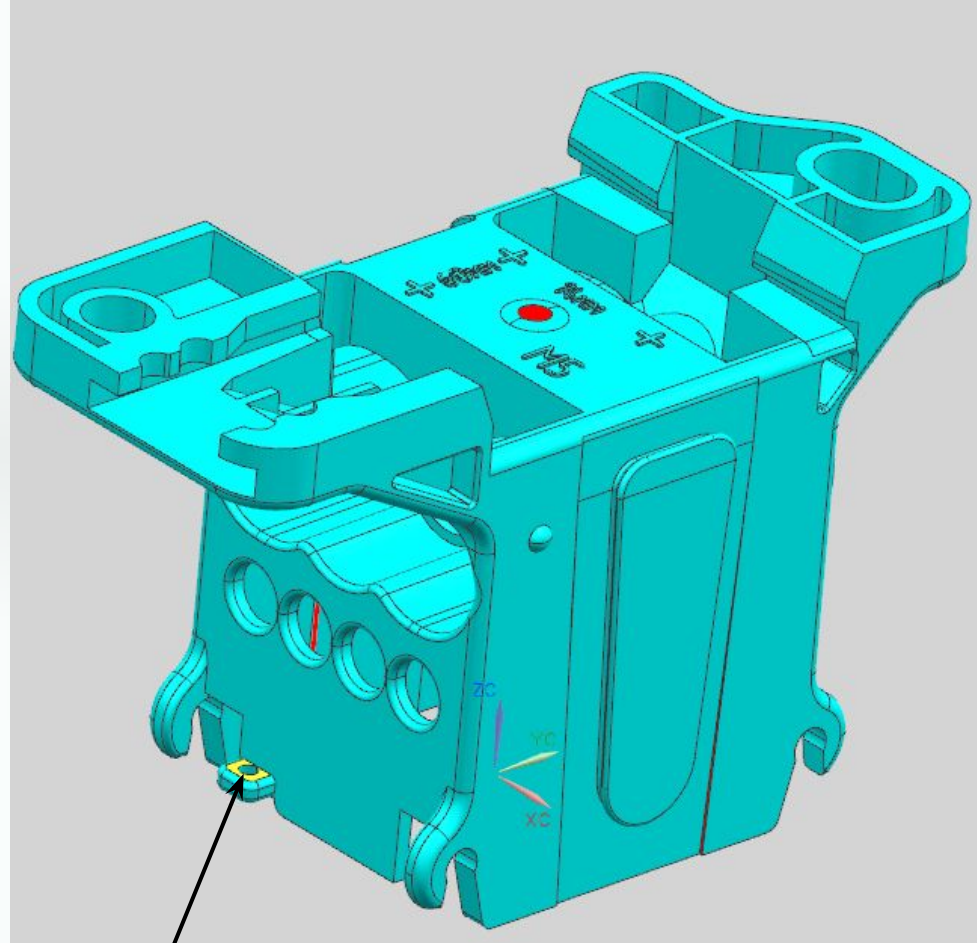
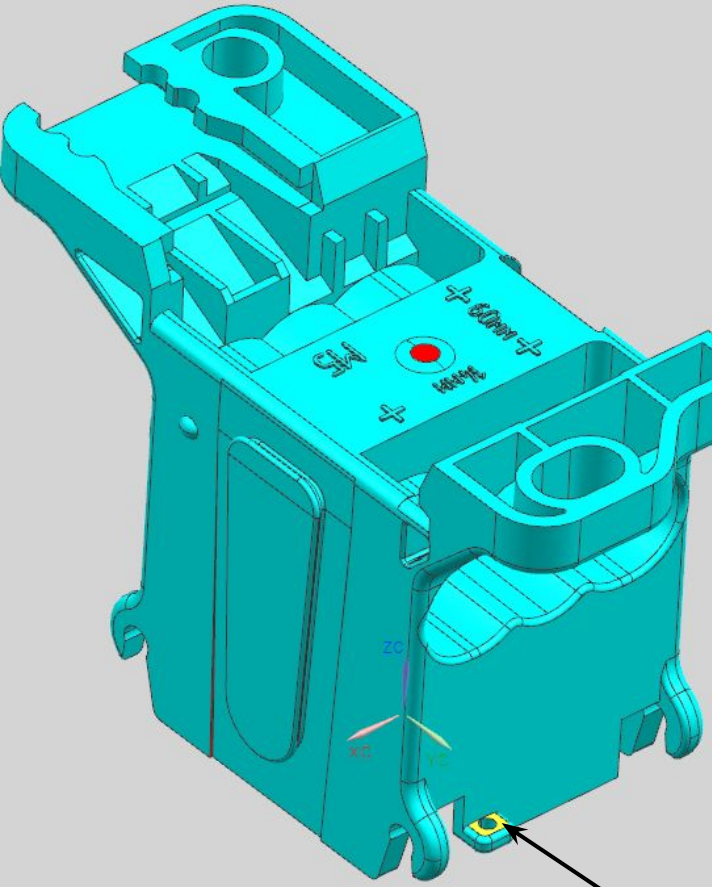
此位置尖点式热咀进胶
Hot nozzle injection in this place





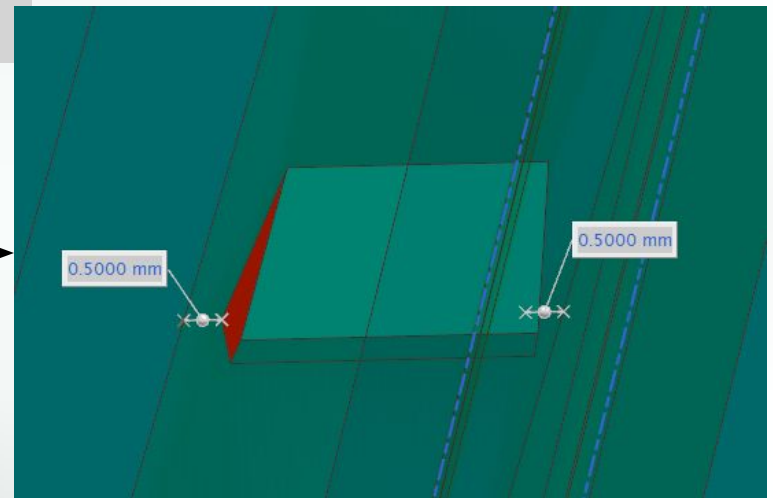
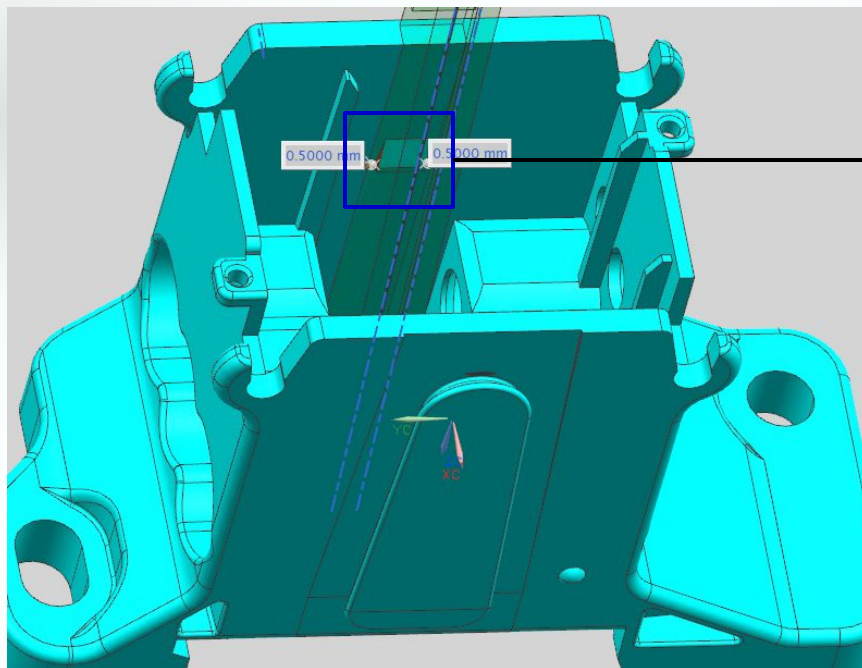
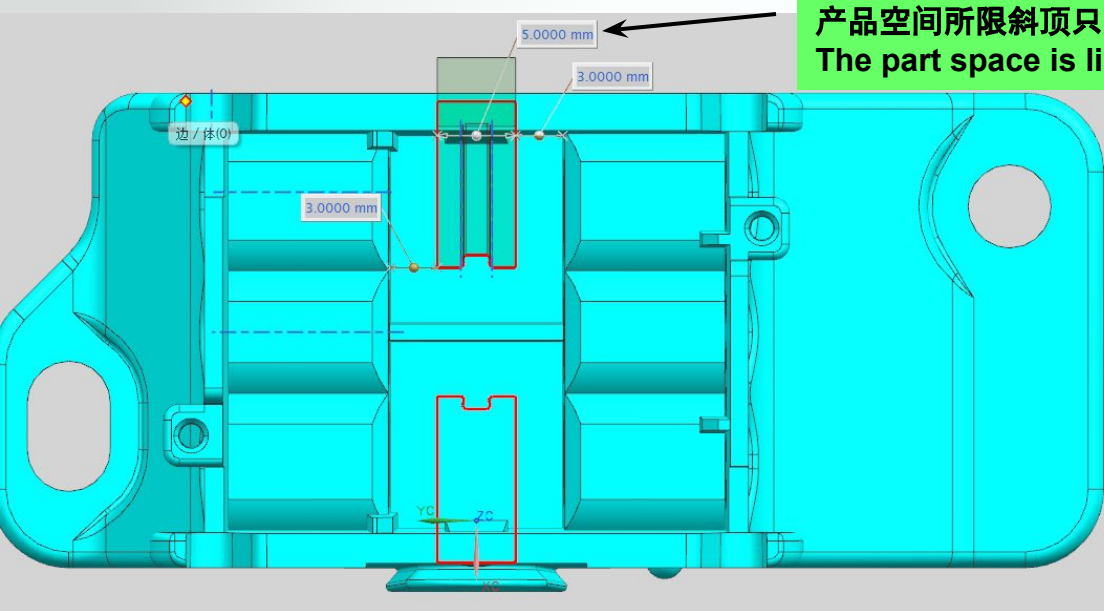


图示红色面出后模是倒扣。
建议超减叫后模做0度与上图箭头指示红色线(行位分型)对齐
We suggest aligning with the red lines indicated by the arrow in the above picture(slider PL) after reducing 0 degree.

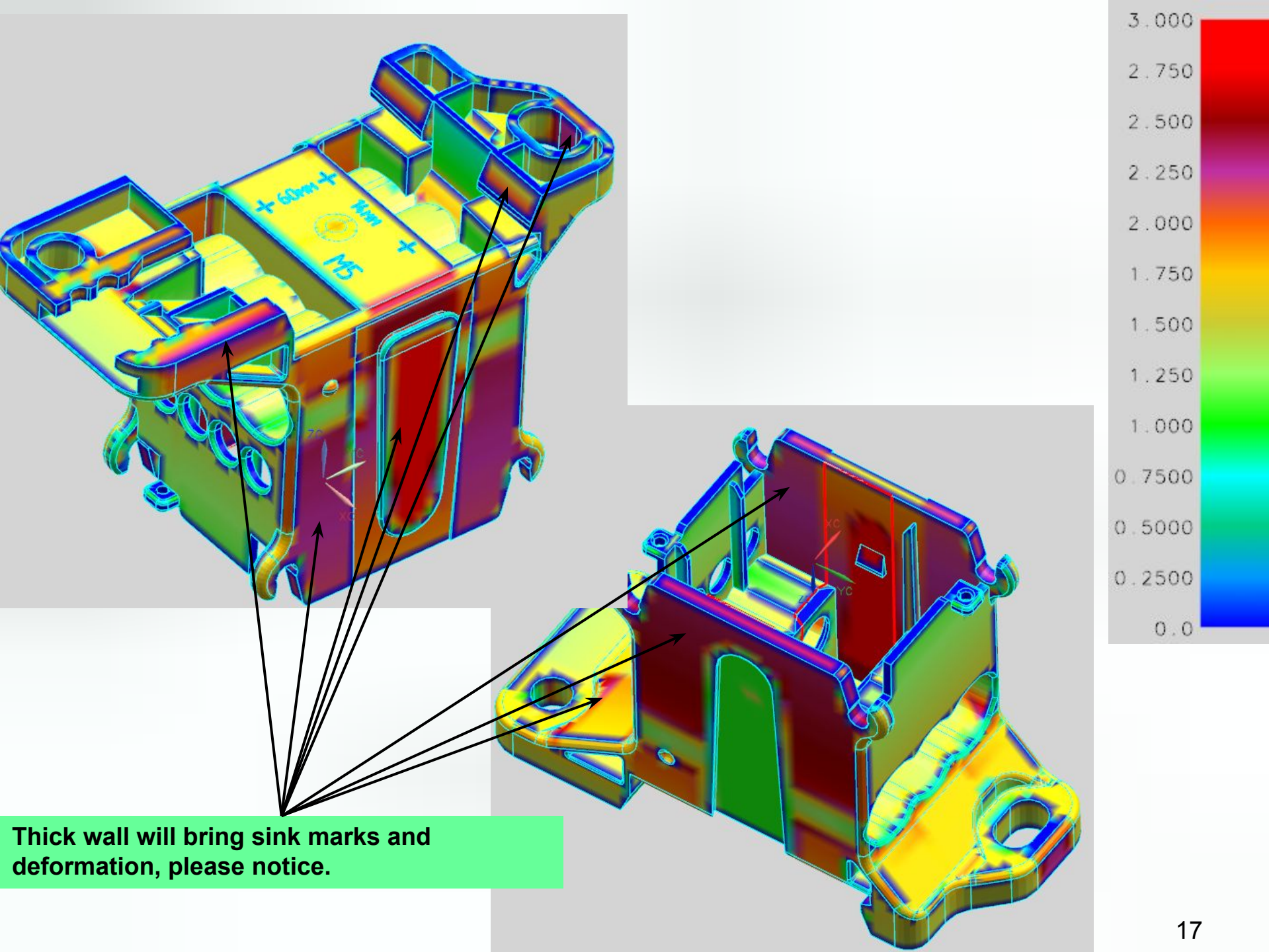


箭头指示黄色面为行位与后模孔位的插穿面。
建议向行位方向做5度减胶拔模
We suggest reducing 5°, please confirm

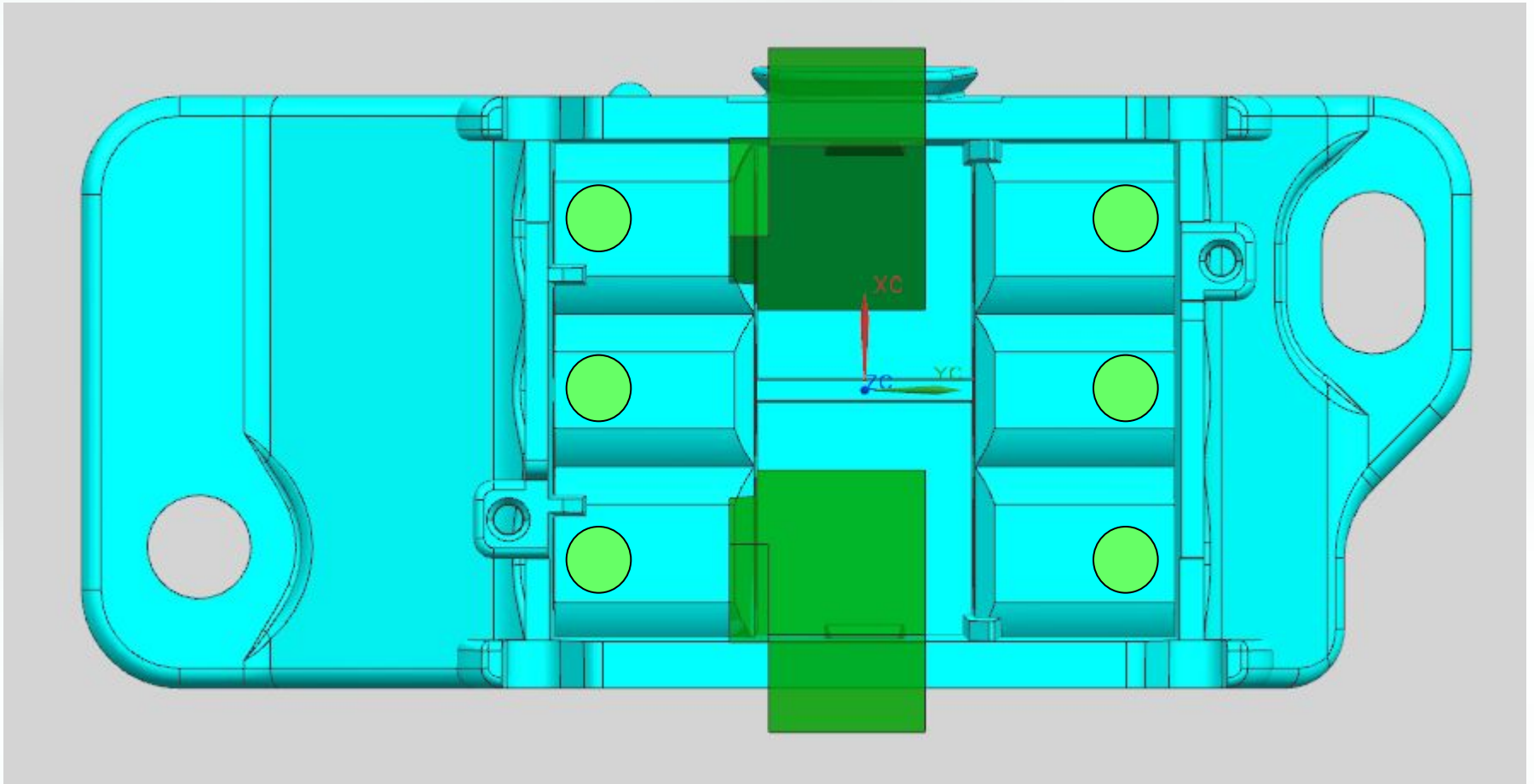
产品空间所限斜顶只能做5mm宽
The part space is limited, the lifter can only be made 5mm wide

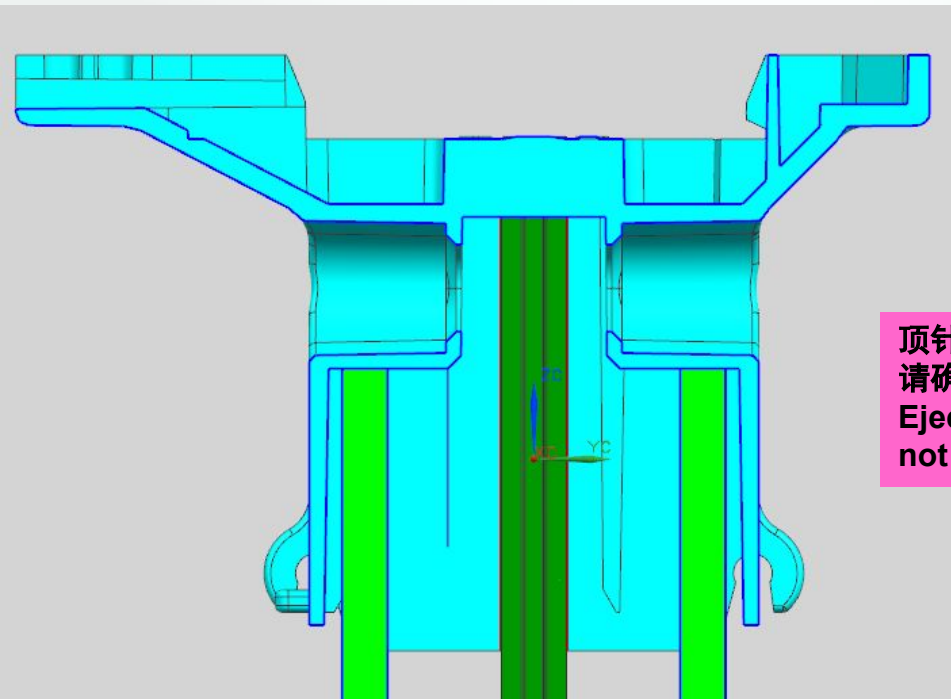
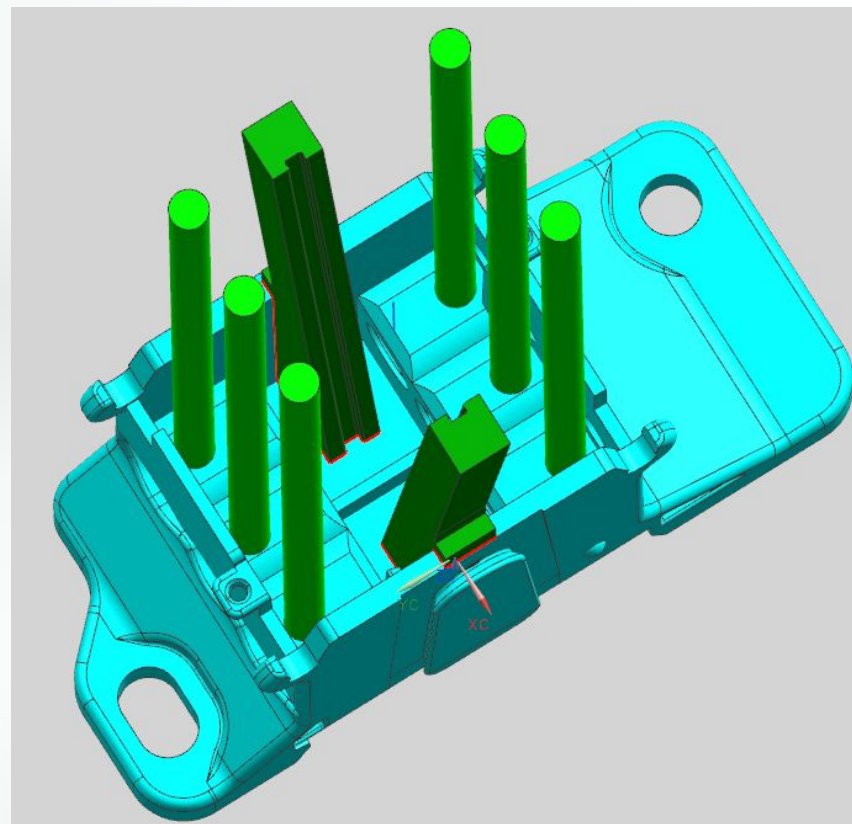
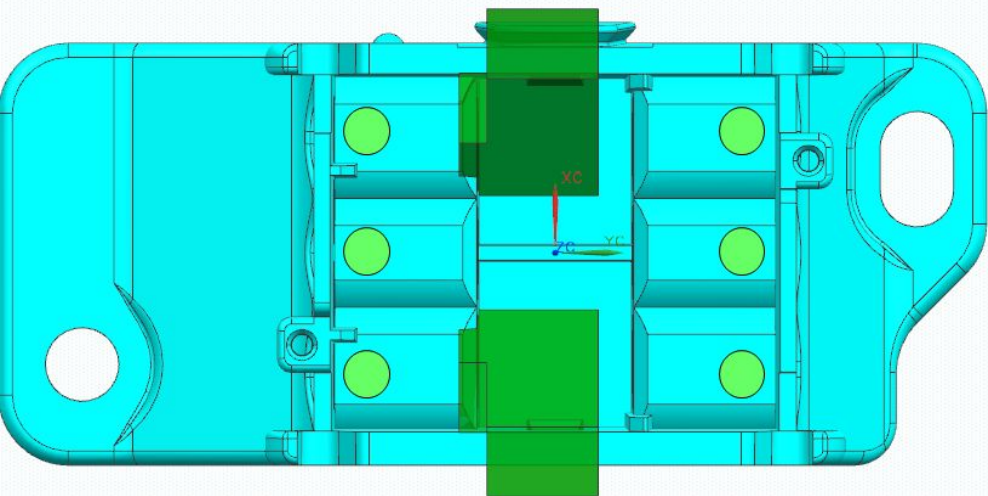


如图示因产品空间有限,斜顶侧面到扣位侧面钢料只有0.5mm
建议扣位侧面(红色面)减胶0.3mm(2侧同改)
The part space is limited, we suggest to red face reduce 0.3mm.(Both change 2 sides)

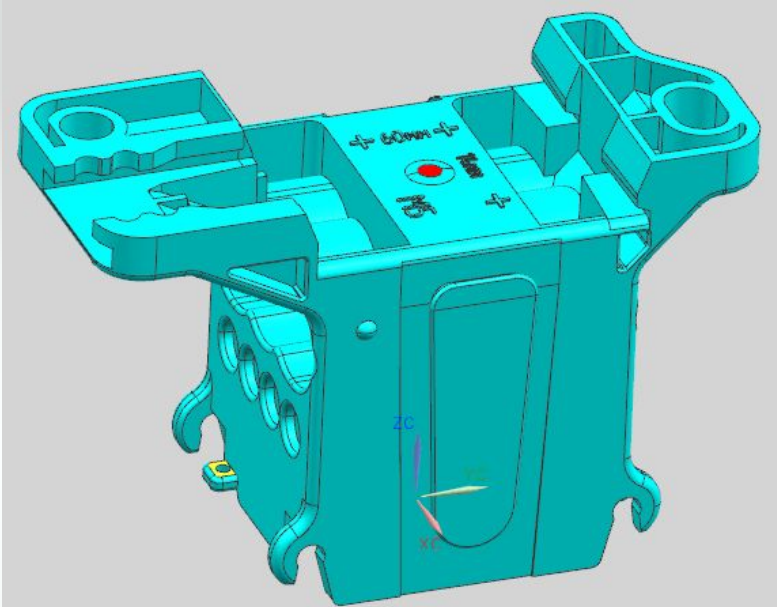


 Ejector Pin $\varnothing 3.5$



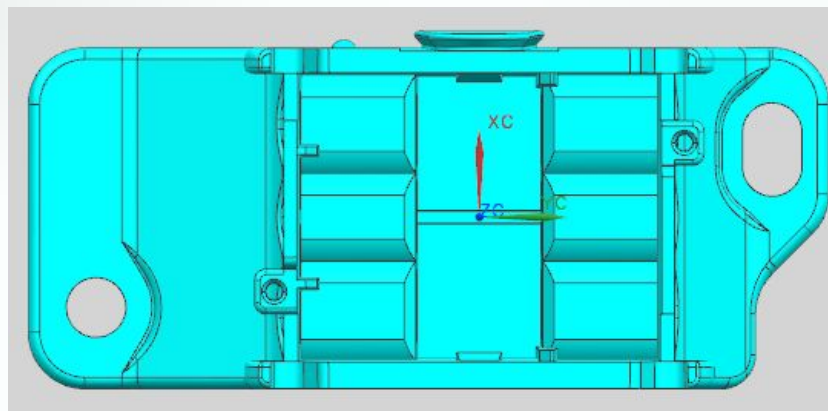


顶针和斜顶都在产品后模深腔内,将无法完全自动脱落产品.
请确认.谢谢
Ejectors and sliders are in the deep of core, product can not automatically from mold,please confirm.



资料显示外观面为晒纹VDI21。请提供哪些面为外观面。谢谢
 Technical Assignment for Design wrote surface texture VDI21,
 please remark which positions are visible surfaces.

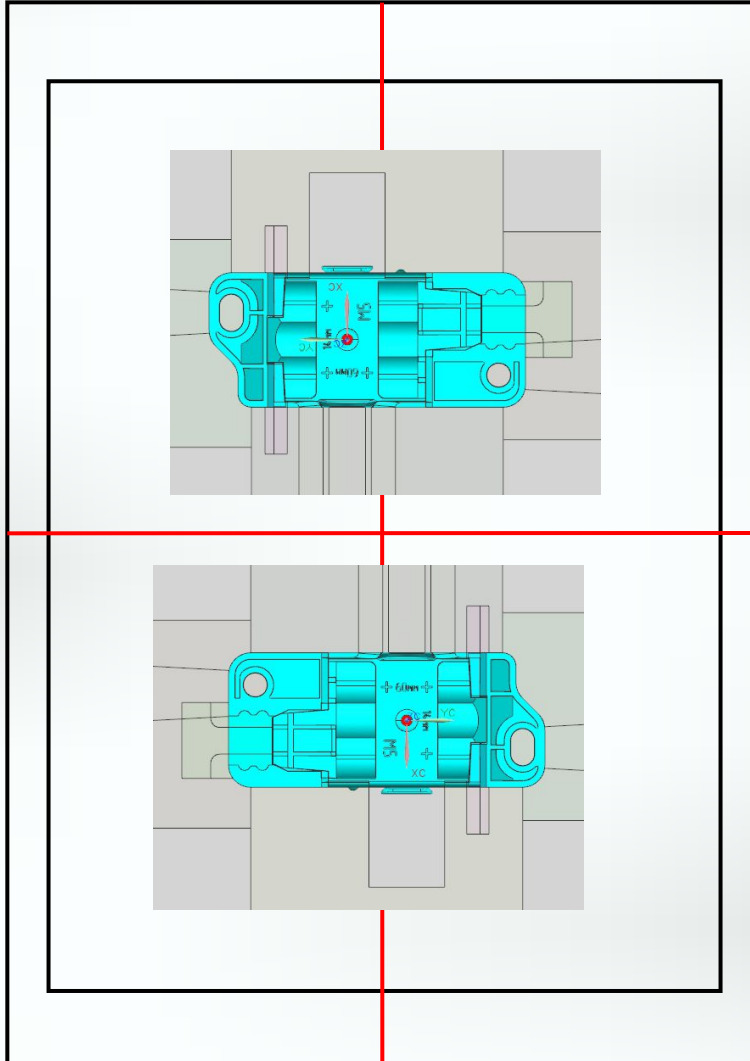
Видимые поверхности (матрицы) / Visible (cavity) surfaces Ref-VDI21
 VDI3400; SPI-SPE 前模表面处理
 Остальные поверхности (пуансона) / The rest (core) surfaces Ra0,4 后模



是否需做产品号, 胶料号, 日期章等刻字, 如需请指示位置和内容。谢谢
 If there are add mold cavity number and the raw material, text, please help remark the positions.

Mold Layout—option

Tool top



Customer 's approval /comments