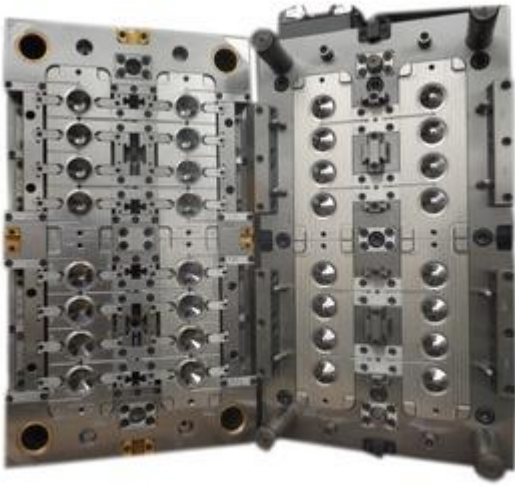


Our commitment to servicing our customers with quality product at competitive price and on-time delivery is backed by our continued investment in our equipment. Our employees and in our systems . ABIS is a full service molding that a 12 000 square foot facility housing our molding department in-housing mold making , quality control. Warehousing secondary operations and offices , If we find a client's product concept would be too costly to manufacture . We will assist the customer in designing parts that not only can be manufacture but one that can be made cost-effectively from prototype to production. With our extensive experience we are confident . We have the solution to your next injection molding application.





## Product Description

Part Name	Two color plastic injection mold
Description	Household Appliance
Country of Original	ShenZhen, China (Mainland)
Brand Name	ABIS
Lead Time	25-35Days

### Payment Terms

1. T/T: 40% Deposit,30% upon T1 Sample,30% Balance before shipment
2. L/C: irrevocable 100% L/C at sight.

## General Information

Item#	Item	Description
1	Product Name	Two color plastic injection mold
2	M o l d   b a s e	LKM;HASCO;DME
3	Mold Material	Stainless steel
4	Product material	ABS, PC
5	Cavity	Multi Cavity
6	Finish	Anodized,Polish,Silk-screen,Painting,etc
7	Runner type	Hot/cold runner
8	Design software	UG,PROE,CAD,SOLIDWORK
9	Color	White
10	Mold life	250000-300000shots


11	Mould material	P20.718HH
12	Transportation	By sea, by air or by land as you request
13	Package	According to clients requirement
14	Shaping Mode	Plastic Injection Mould

## Processing Equipment

NAME OF MACHINE	BRAND	Q'TY	PLACE OF ORIGIN
CNC	DMG	1	Germany
CNC	YCM-FP66A	2	Taiwan
EDM AQ35L	SODICK	3	Japan
Wire EDM AQ327L	SODICK	2	Japan
EDM	CHARMILLES-35P	2	Swiss
EDM	TAIWAN NUMERIC CONTROL	6	Taiwan
Wire cutting machine	QIGNYUAN	4	Shanghai
digital display milling machine	YINGSHUN	8	Taiwan
digital display grinding machine	SUHRE	8	Taiwan
Injection molding machine	HAITIAN	11	China
3 Dimension Coordinate	DABAO	1	Taiwan
JD 12-300digital display projection apparatus	PROJECTOR	1	China

## Dimension Report and Sampling Parameter

### Dimension Inspection Report

Customer	SMR	Mold Trial#	T1	Unit	Metric	Picture	
Project #	Phase 2	Trial date	2014.12.29	Inspection date	2015.01.08		
Part Name	B876_0CALIP without TG_RH	Mold number	ABIS 2014128	Inspector	Mr. Li		
Part / Draw #	60063006D #2	Material	ABS MP0160R	Manager	/		

Inspection Tools: Block gauge (BG), Caliper (CP), Coordinate Measuring Machine (CMM), Height gauge (HG), Mikrometer (MM), Projector (PJ), Pingauge (PG), Rad (RG), Thickness gauge (TG)

Dimension spec				Shot 1		Shot 2		Shot 3		Shot 4		Judgment	
Dim #	Dimension	Tolerance	Inspection Tool	1	2	1	2	1	2	1	2	OK/NG	Remark
1-1	1.20	+ 0.20 - 0.20	CP	1.19	1.23	1.22	1.24	1.22	1.23	1.20	1.21	OK	
1-2	1.20	+ 0.20 - 0.20	CP	1.21	1.22	1.20	1.20	1.21	1.23	1.22	1.20	OK	
2-7	1.50	+ 0.20 - 0.20	CP	1.51	1.52	1.52	1.53	1.51	1.50	1.49	1.52	OK	
2-8	1.50	+ 0.20 - 0.20	CP	1.52	1.52	1.52	1.52	1.51	1.53	1.49	1.51	OK	
2-9	1.50	+ 0.20 - 0.20	CP	1.51	1.52	1.52	1.52	1.51	1.50	1.49	1.50	OK	
3-1	1.70	+ 0.20 - 0.20	PJ	1.72	1.69	1.70	1.69	1.70	1.71	1.73	1.70	OK	
3-2	1.70	+ 0.20 - 0.20	PJ	1.71	1.72	1.69	1.70	1.71	1.72	1.71	1.72	OK	
3-3	1.70	+ 0.20 - 0.20	PJ	1.71	1.72	1.71	1.70	1.69	1.70	1.69	1.71	OK	
3-4	1.70	+ 0.20 - 0.20	PJ	1.69	1.70	1.70	1.71	1.72	1.71	1.73	1.71	OK	
3-5	1.70	+ 0.20 - 0.20	PJ	1.71	1.71	1.72	1.73	1.71	1.71	1.72	1.73	OK	
3-6	1.70	+ 0.20	PJ	1.71	1.72	1.73	1.71	1.72	1.71	1.71	1.72	#REF!	

Prepared	Mr. Lillian	Checked	Mr. Li	Approved	Mr. Zhang
Date	2015.01.10	Date	2015.01.08	Date	2015.01.08

To be completed by customer:

Signature: _____		
Result:	<input checked="" type="checkbox"/> Pass	<input type="checkbox"/> Fail
		<input type="checkbox"/> Special Acceptance

## ABIS MOLD INJECTION PARAMETER REPORT

> 类型 Shot Type: <input checked="" type="checkbox"/> 单色 One shot mold <input type="checkbox"/> 双色第一次 1st shot of 2-shot <input type="checkbox"/> 双色第二次 2nd shot of 2-shot			
模具编号 Tool No.	产品名称 Part Name	模具规格(mm) Tool L*W*H	试模次数 Test times
模腔数量 N Cavity	塑胶原料 Raw Material	颜色 Color	项目负责人 Project Manager
产品总重量 Gross Wt(g)	机台型号 Press Type	试模数量(啤数) Shot Qty	设计工程师 Design Engineer
试模日期 Test Date	上机时间 Beginning Time	完成时间 Finish Time	审核 Review ed /日期 Date

\*试模前的准备: 试模单、产品图纸、物料表、卡尺、模温计、烘压机、退料箱、电子天平、照相机、打磨机(用于铜或漆口直径)等工具  
备注 Comments:

### > 成型参数表 Molding Parameter Sheet:

时间 Time(s)	周期时间 Cycle Time		温度设定 Temp(°C) Setup	射嘴温度 Nozzle Temp °C		
	填充时间 Filling Time			一段温度 Zone 1 Temp °C		
	保压时间 Holding Time			二段温度 Zone 2 Temp °C		
	冷却时间 Cooling Time			三段温度 Zone 3 Temp °C		
压力 Pressure (Bar)  (1Mpa=10Bar =145Psi)	射胶压力 Injection Pressure	一段 1st Stage	速度或速率 Percent of Speed(mm/s) or Flow Rate(g/s)	四段温度 Zone 4 Temp °C		
		二段 2nd Stage		热流道温度 Hot Runner Temp °C		
		三段 3rd Stage		前模设定温度 Cavity Temp. Setup		
		四段 4th Stage		后模设定温度 Core Temp. Setup		
保压压力 Holding Pressure	一段 1st Stage	行位设定温度 Slide Temp. Setup	射胶速率一段 Injection Speed 1			
	二段 2nd Stage	射胶速率二段 Injection Speed 2	射胶速率二段 Injection Speed 2			
	三段 3rd Stage	射胶速率三段 Injection Speed 3	射胶速率三段 Injection Speed 3			
送料压力 Charge Pressure	背压 Back Pressure	射胶速率四段 Injection Speed 4	射胶速率四段 Injection Speed 4			
位置 Position(mm)	射胶位置 1st Inj. End Position		原料干燥 Raw Material	保压速率 1st Holding Speed		
	射胶位置 2nd Inj. End Position			保压速率 2nd Holding Speed		
	射胶位置 3rd Inj. End Position			保压转换 Turn Hold(time/pos.)		
	射胶终止位置 Inj. End Position			熔胶速率 Charge Speed		
	熔胶终止位置 Melt End Position			干燥温度 Drying Temp(°C)		
	射退位置 Suck Back End Position			干燥时间 Drying Time(H)		
模具 Tool	锁模压力 Clamp Pressure		实际模温 Actual Temperature (°C)	前模表面 Cavity Surface	机水 Normal Water	
	开模压力 Opening Pressure			热油 Hot Oil	冻水 Cool Water	
	顶出行程 Ejection Stroke			后模表面 Core Surface	机水 Normal Water	热油 Hot Oil
	顶出次数 Count of Ejection			冻水 Cool Water	机水 Normal Water	热油 Hot Oil
	抽胶机构 Side Action(组Unit)			行位表面 Slide Surface	机水 Normal Water	热油 Hot Oil
顶出 Ejection (%)	托模进 Forward	压力 Pressure	冻水 Cool Water			
		速度 Speed				
	托模退 Backward	压力 Pressure				
		速度 Speed				

### > 产品外观问题/Product Appearance Faults:

<input type="checkbox"/> 粘前模 Sticking in Cav	<input type="checkbox"/> 抛光不良 Poor Polishing	<input type="checkbox"/> 披锋 Flash	<input type="checkbox"/> 裂痕 Stress Crack	<input type="checkbox"/> 结合线 Weld L
<input type="checkbox"/> 粘后模 Sticking in Core	<input type="checkbox"/> 顶出不顺 Uneven Eject	<input type="checkbox"/> 顶台 Ejector Marks	<input type="checkbox"/> 喷射痕 Jetting	<input type="checkbox"/> 黑点 Dark Spot
<input type="checkbox"/> 水印 Water Wave Marks	<input type="checkbox"/> 拖花 Scratch Marks	<input type="checkbox"/> 变形 Deformation	<input type="checkbox"/> 缺胶 Short Filling	<input type="checkbox"/> 烧焦 Burn Mark
<input type="checkbox"/> 冷料流痕 Cold Slug Marks	<input type="checkbox"/> 困气 Gas Trap Effect	<input type="checkbox"/> 缩水 Sink Marks	<input type="checkbox"/> 胶纹 Gap	<input type="checkbox"/> 气泡 Air Bubble

### > 试模过程检查/Tryout Process Check:

开合模动作检查	模具透水检查	流动平衡检查, 填充30%、60%、90%
模具顶出动作检查	快速填充检查/模具排气	填充99%检查毛边、缩水与变形

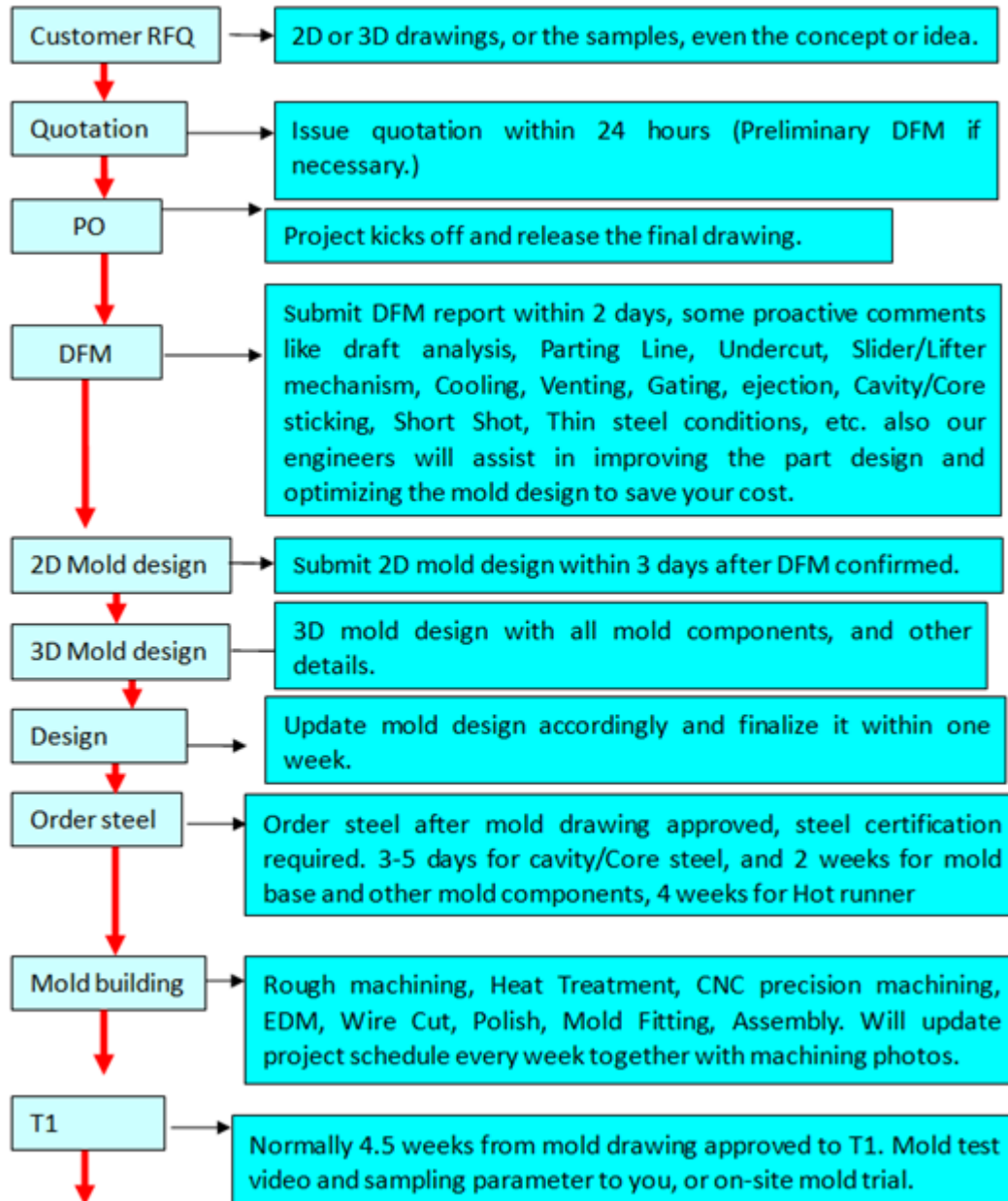
### > 试模问题点描述及建议/Comments:

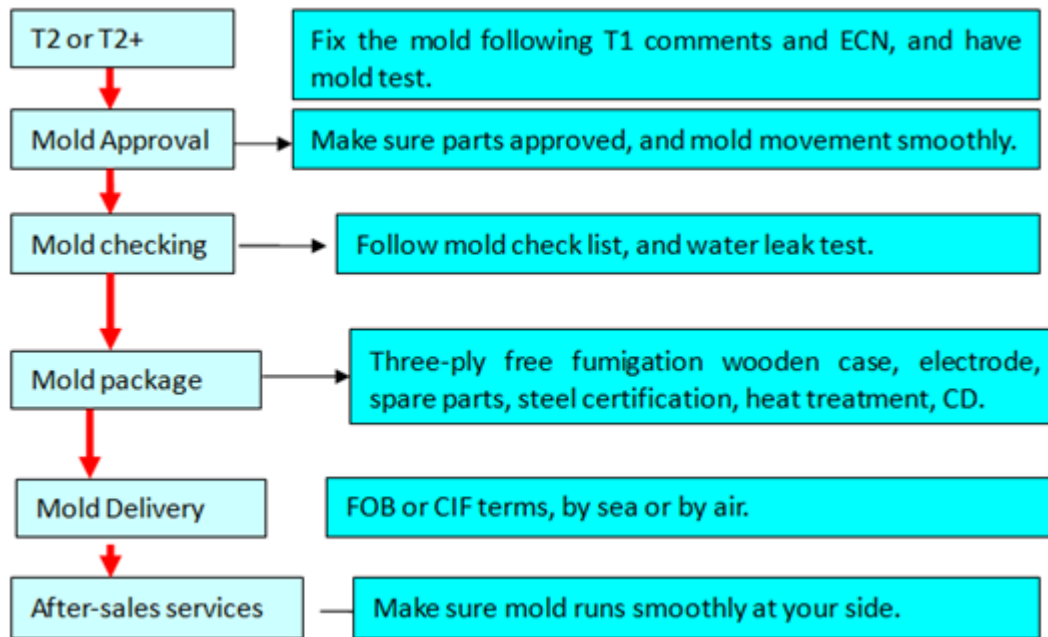
问题: 产品毛边/破斩纹

对策: 飞模/流道加大/进胶口加大/冷料井加大

记录 Record	日期 Date	审核 Review ed	日期 Date
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## Working process:





## Company

## Information

ABIS was founded in Shenzhen China, adjacent to Hong Kong, in 1996, has its own factory of 12,000 square meters. With the advanced facilities from Germany, Swiss and Japan, and a highly experienced design and engineering team, ABIS builds multi-cavity molds to exacting tolerances, providing the critical structural foundation for leading manufacturing companies to produce high precision mold.

- |    |          |         |               |                    |             |   |
|----|----------|---------|---------------|--------------------|-------------|---|
|    | ABIS     | Mold    | which         | engaged            | in          | : |
| 1. | Cold&Hot | Runner/ | Single&Multi- | Cavity-Injection   | moulding    |   |
| 2. |          |         | Single&Multi- |                    | Shot        |   |
| 3. |          | Die     |               | Cast-Aluminum&Zinc |             |   |
| 4. |          |         | Inserting     |                    | Mold        |   |
| 5. |          |         |               |                    | Overmolding |   |
| 6. |          |         | Prototype     |                    | Tooling     |   |
| 7  |          |         | Mass          |                    | Production  |   |

ABIS applies advanced software for mold design-Auto CAD, UG, Solid works and ProE etc. So far, ABIS has received the "ISO 9001", "ROHS" green, SGS certificate.







# Tooling Shop



## QC Control

### Mold Making QC main steps

Mould Design Control : Design review checklist before submitting to the customer. We will not start the steel purchasing work until get your written approval on our mold drawing.

Incoming quality control: all steel material and outsourcing standard components will be checked to ensure that they are in accordance with the BOM(QTY and material/components name specified).

In process quality control: all the machining and assembling process is under control, we have QC team to check and supervise the tolerance and processed surface to satisfy the requirements. (Mould Steel Hardness Inspection, Mould Electrodes Inspection, Mould Core and Cavity Steel Dimension Inspection , Mould Pre-Assembly Inspection )

Final quality control: within 3 days the completion of the plastic mold, we will have a thorough check for the main size of the molded plastic sample and mold to ensure that the critical or full dimension (if required) are within tolerance.

Mould Pre-Shipment Final Inspection : Free-fumigation three-plywood case packing; make sure the mold is conformity to the approved mold drawing. The spare components and easily broken components and the electrode (if required) are packaged, as well as the mold drawing and some certificated.

### Plastic Molding QC main steps

Vernier caliper measurement is performed by trained operators when the first product is produced on our machine, we check the contour dimension and assembly status (if exist) to identify if any

The molded parts are then inspected again by experienced QA department for the full dimension, especially the critical dimensions set by customer. If a quality result was recorded at the same time. Result will be to our QC Supervisor directly. If any unqualified dimensions (if exist) are caused by uncontrolled factors or our mistakes and we will take the related actions to improve it.

We will trustily report the T1 result to customer and send T1 samples to customers for checking. Sometimes T1 samples need improvement. If more samples are required by customer at first, we will take actions to improve the mold to make sure the parts have 0 defects. No shrinkage, warpage, flash, streak, air bubble, step line, ejector mark, and dimension within tolerance.

Package inspection: make sure QTY/color and weight are correct.

## Packaging & Shipping



**Our ABIS Family**



- Why choose us?:
1. More than 20-years experience.
  2. ISO9001:2008 certificated.
  3. Competitive price with high quality.
  4. More than 50 machines support to run the business.
  5. Custom R&D program coordination.
  6. Expert technicians.
  8. Diligent and loyal workforce.
  9. Up-to-date software.
  10. International standards, SAY, HASCO, DME, MISUMI, etc
  11. Well-rounded after service.

Lynn [Xiao](#)

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Mobile([Whatsapp](#)):+8613924454678

Web:[www\(dot\)abismold\(dot\)com](#)



We will give our best service, quality, price and delivery time !  
If you have any question just call me or send E-mail to me please!

## FAQ

1. Are you factory?

Yes, we are direct factory, professional on plastic mould, plastic and hardware parts.

2. I have no drawing, how I should do to start the new project ?

You can supply a sample, we will help to finish the 3D drawing design.

3. What is your shipment way?

Sea shipment , air shipment, express shipment for small quantity.

4. Before shipment, how to make sure the products quality?

If you don't come to our factory and also don't have the third party for inspection, we will be as your inspection worker, we just require your trust. We will supply you a vedio for production process detail include process report, products size, structure and surface detail, packing detail and so on, so you will feel you are in our factory.

5. How is your after-sale service?

We have a very good reputation for our after-sale service, we bear all problem responsibility if they are ours, timely reply and satisfied solving is our strength. Your problems are ours too. So you never need worry the after-sale service.