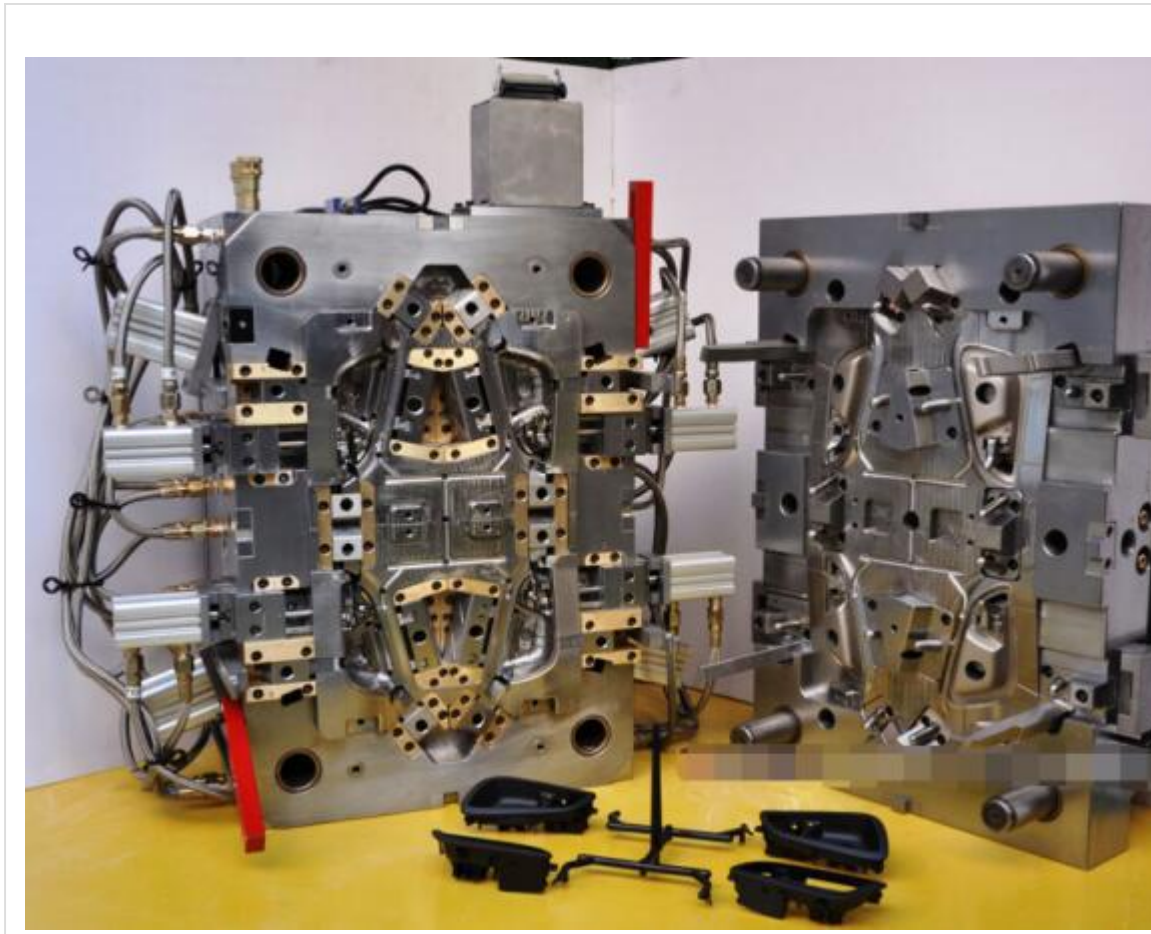
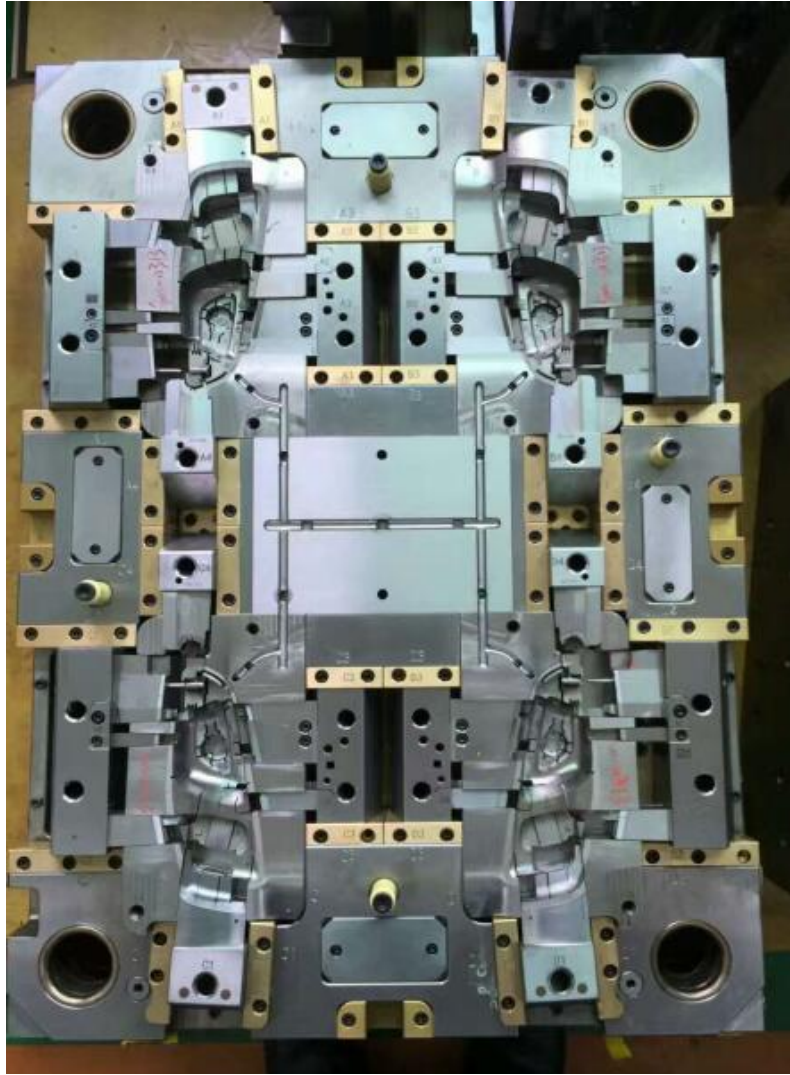


Power Car Door Lock Actuator for Great Wall
Florid Spare Part





ABIS Mold was found in 1996 in Shezhen, adjacent to HK, China. and we moved to Long gang District in 2010. With the advanced facilities from Germany, Switzerland and Japan, and a highly experienced design and engineering team. Our molding press machine ranges from 40T to 650T, 300+ molds capacity each year, and 70 % are exported to Europe and North America.

In addition to our plastic mold and molding specialties, we also can

provide you the services such as die casting, stamping /punching, blowing mold, as well as the secondary process.

Product Description

Part Name	Power Car Door Lock Actuator for Great Wall Florid Spare Part
Description	Plastic Injection Mould /Plastic Auto Mould
Country of Original	China (ShenZhen)
Current Export Markets	North America
Lead Time	30 Days

Key Specification

1. Plastic Injection Over Mould
2. Cold Runner Mould
3. Plastic Injection Connector Mould

4. 1*4 Cavity , Ultramid A3K PA66 Material

5. H13 Steel

6. Two - Plate Mould

7. DME Standard Accessories

8. Cycle Time 45s

9. Press 350 Tons

General Information

Item#	Item	Description
1	Mold standard	DME or HASCO
2	Mold Base	LKM,DME, HASCO, FUTABA
3	Cavity/Core Steel	H13,S-7,S136,SS420,NAK80,P20
4	Hot Runner:	MOULD MASTER, MASTER TIP, HUSKY, HASCO, DME, YUDO, INCOE, THERMOPLAY, SYNVENTIVE .
5	Hydraulic Cylinder	PARKER, TAIYO, STAUBLI, JUFAN
6	Mold Components	DME, Progressive, PCS, Punch, Royal, etc
7	Steel Treatment	Heat Treatment, Nitriding, Chrome Plating
8	Surface Finish:	SPI standard, VDI EDM, Texture, etc
9	Texture:	Mold-tech, Yick Sang, Ni Hong ,Tanazawa etc
10	Plastic Material	PP, PC, ABS, PE, HDPE, PET, POM, PMMA, PA(GF), PBT(GF), PVC, PPS, PEI, PEEK, LCP, PSU
11	Design Software:	CAD,UG, Pro E, Solidworks
12	Value-added Service:	Dust-free Spraying, Silk-screen Printing, Ultrasonic Welding, Thermal Bonding, Assembling, Prototype
13	Export Country:	Europe, USA, Canada, Mexico, Brazil, Australia ,Middle-east , India etc

14	Our Capability:	Auto, Aerospace, Household, Electrical, Industrial, Medial, Toys Office, Cosmetic, Outdoor, OA Equipment etc
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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
digital display projection apparatus		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_SCALP without TS_RH	Mold number	ABIS 2014128	Inspector	Mr. Li		
Part / Draw #	60063006D #2	Material	ABS MPD160R	Manager	/		

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

Dimension spec				Shot 1		Shot 2		Shot 3		Shot 4		Judgment	
Dim #	Dimension	Tolerance	Inspection Tools	1	2	1	2	1	2	1	2	OK / NG	Remarks
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:	☒ Pass	☐ Fail	☐ Special Acceptance
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ABIS MOLD INJECTION PARAMETER REPORT

> 类型 Shot Type: ☒ 单色 One shot mold ☐ 双色第一次 1st shot of 2-shot ☐ 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(模数) 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 Reviewed /日期 Date	

*试模前的准备: 试模单、产品图纸、物料表、卡尺、模温计、油温机、温控箱、电子天平、照相机、打磨机(用于调整浇口直径)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 Side Temp. Setup		
		二段 2nd Stage			射胶速率一段 Injection Speed1		
		三段 3rd Stage			射胶速率二段 Injection Speed2		
储料压力 Charge Pressure			原料干燥 Raw Material	射胶速率三段 Injection Speed3			
背压 Back Pressure				射胶速率四段 Injection Speed4			
				保压速率一 1st Holding Speed			
位置 Position(mm)	射胶位置 1st Inj. End Position			保压速率二 2nd Holding Speed			
	射胶位置 2nd Inj. End Position			保压转换 Turn Hold(time/pos.)			
	射胶位置 3rd Inj. End Position			熔胶速率 Charge Speed			
	射胶终止位置 Inj. End Position			干燥温度 Drying Temp(°C)			
	熔胶终止位置 Melt End Position			干燥时间 Drying Time(H)			
	射退位置 Suck Back End Position						
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	
	顶出行程 Ejection Stroke					凉水 Cool Water	
	顶出次数 Count of Ejection				后模表面 Core Surface	机水 Normal Water	
	抽胶机构 Side Action(组Unit)					热油 Hot Oil	
			凉水 Cool Water				
顶出 Ejection (%)	托模进 Forward	压力 Pressure			行位表面 Slide Surface	机水 Normal Water	
		速度 Speed				热油 Hot Oil	
	托模退 Backward	压力 Pressure				凉水 Cool Water	
		速度 Speed					

> 产品外观问题/Product Appearance Faults:

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

> 试模过程检查/Tryout Process Check:

开合模动作检查	模具进水检查	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

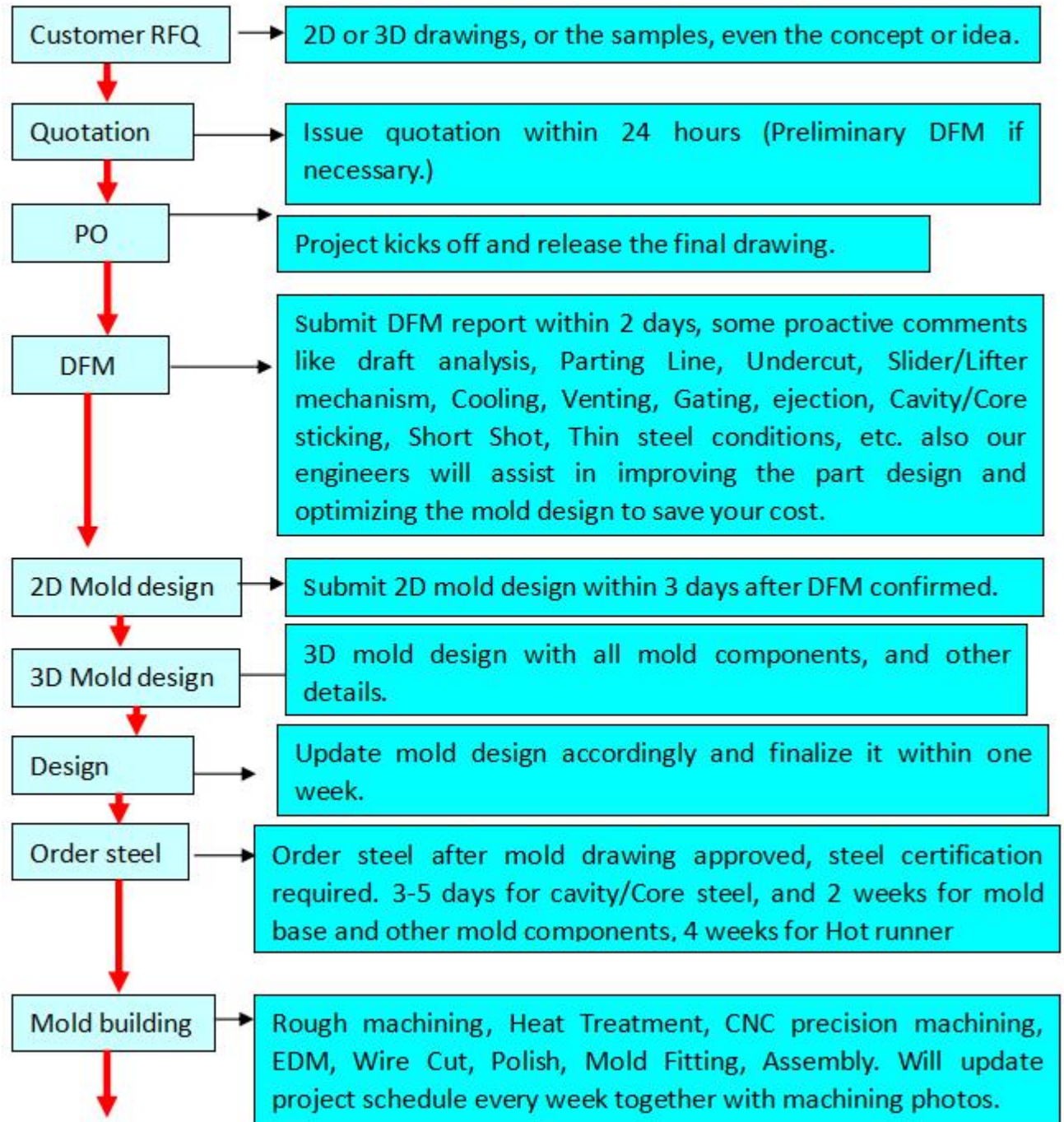
> 试模问题点描述及建议/Comments:

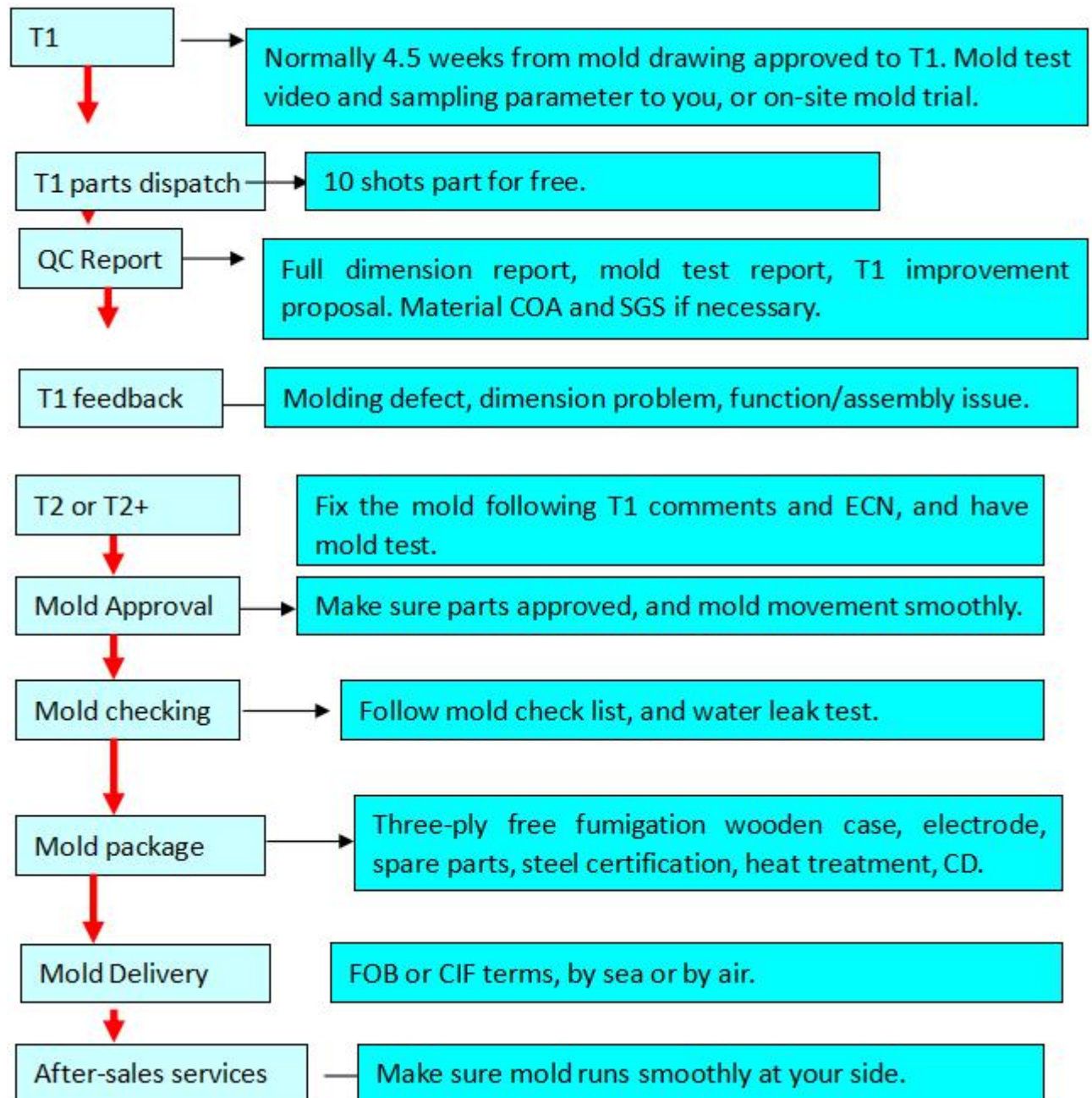
问题: 产品毛边/玻纤纹
对策: 飞模/流道加大/进胶口加大/冷料井加大

记录 Record	日期 Date	审核 Review ed	日期 Date
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Project Procedure

ABIS --Project Procedure





Payment Terms

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

Workshop



 BEIJING HANGXIE CERTIFICATION CENTER CO., LTD. QUALITY MANAGEMENT SYSTEM CERTIFICATION ABIS MOLD TECHNOLOGY(HK)CO., LTD. Organization Code: 55388449-1 No.102, Building B, Ying Keli Industry Area, Longgang District, Shenzhen, China. P.C. 518102 <i>is in conformity with</i> GB/T19001-2008 (ISO9001:2008) <i>This certificate is covering the following product scope</i> Plastic Mold Development and Manufacturing; Plastic Products (Not Include the Products With Administrative License) Registration No. 03415Q20263R0M The Duration of Validity: Feb. 10, 2015—Feb. 09, 2020  MANAGEMENT SYSTEM CNAS CBM-Q  MEMBER OF INTERNATIONAL ACCREDITATION FEDERATION General Manager:  BEIJING HANGXIE CERTIFICATION CENTER CO., LTD. After this certificate is issued, there should be at least 2 surveillance audits within the 3-year period of validity of the certificate can be checked on: www.bhcc.com.cn The certificate information is available on the official website of the National Certification and Accreditation Administrator: www.cnca.gov.cn. It is also available by scanning the two-dimensional code at the bottom right corner. Address: NO.7 Jingshun Road, Chaoyang District, Beijing, China.	 <i>Certificate</i> Certificate No.: 1141 This is to certify that the Occupational Health and Safety Management System of SHENZHEN ABIS PRECISION HARDWARE PLASTIC CO., LTD. Unified Social Credit Code: 91440300553884491N Registered/Production/Office Address: Yingke Industrial District B Building No.102, Shuanglang Community, Longgang Street, Longgang District, Shenzhen, Guangdong Province, China Sales Address: Yingke Industrial District C Building 1/F, Shaoji Village, Longgang District, Shenzhen, Guangdong Province, China Has been audited to conform to the following Occupational Health and Safety Management System standard GB/T 28001-2011 idt OHSAS 18001:2007 This Occupational Health and Safety Management System is valid for the development and production of plastic mould; sale of plastic parts and related Occupational health and safety management activities of involved sites Initial issued date: May, 15, 2017 Date of issue: May, 15, 2017 Date of expiry: May, 15, 2020 Issued by: <i>Wu Fongmei</i> Beijing East Allreach Certification Center Co., Ltd.   The certificate will remain valid only if the certified organization agrees to undergo audit at regular intervals and is notified to be audited. Please note for surveillance audit monitoring mark on the designated position of the certificate. The information of this certificate is available at EACC website (www.eacc.com.cn) and CNCA website (www.cnca.gov.cn). EACC address: at Floor, No. 121 building, No. 17 Jingshun Road, Chaoyang District, Beijing, China The 1st Surveillance Confirming Mark The 2nd Surveillance Confirming Mark
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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 dimensions, especially the critical dimensions set by customer. If quality result was recorded at the same time. Result will be to our QC Supervisor directly. If unqualified dimensions (if exist) are caused by uncontrolled factors or our mistakes and the related actions to improve it.

We will trustily report the T1 result to customer. We will send T1 samples to customers for checking. Sometimes T1 samples need improvement. If T1 samples are required by customer at first, we will take actions to improve the mold to make sure the final product 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 & Delivery

Packaging Details: Free-Fumigation Three-Plywood case

Delivery Detail: 25-35 days by sea, 3-7 days by air



Our ABIS Family





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Skype: daisymold@outlook.com

www.abismold.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!

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FAQ

Q: Can you do post production?

A:Some customers in addition to plastic injection require post processing, assembly of their products and packaging.

Q:

Is it possible to know how are my products going on without visiting your company?

A:We will offer a detailed production schedule and send weekly reports with digital pictures and videos which show the machining progress.

Q: If you make poor quality goods, will you refund our fund?

A: As a matter of fact, we won't take a chance to do poor quality products. Meanwhile, we manufacture goods quality products until your satisfaction.

Q: What is the software you will use to check the drawing? And what is format of drawing you can check?

A: Our designers and engineers all use VISI and UG to check 2D and 3D drawings.

We can check the drawing with PDF .AI, DWG ,STP or IGS formats.

Q: How can you confirm the plastic injection mold you produce is the one we need?

A: we can provide professional mold analysis reports before mold making.

Q: What can we do if we don't have the mold drawing ?

A: you will only provide the actual sample to us then we can help you to make the design injection mold drawings for your confirmation.