



DFM REPORT OF

Y060-001

Product information

General Information

Material: PP + 20% talcum

Part Name: UPPER_PULT

Shrinkage: 1.010

Machine: 40 days

Surface Treatment : VDI 24/SPI B3

Tool Life Guaranty :200000

Basic Mold Information

Mold Number: **Z060**

Core Inserts: 1.2738

No of Cavity: 1

Type of Gate: One drop hot nozzle

Surface Treatment: VDI 24/SPI B3

Mold Size: 900*600*630 MM

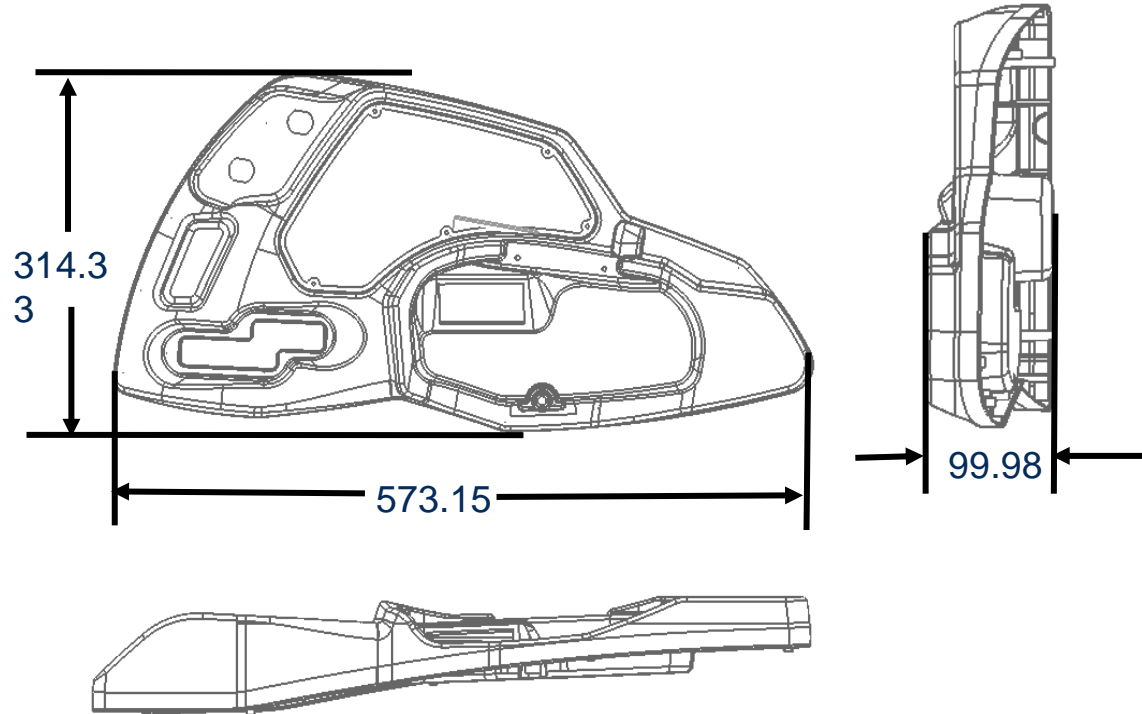
Mold Weight: 2400KG

Injection Machine Detail

Locating Ring Dia: \varnothing 199.8 mm

Nozzle Radius: R20

KO Diameter: M30

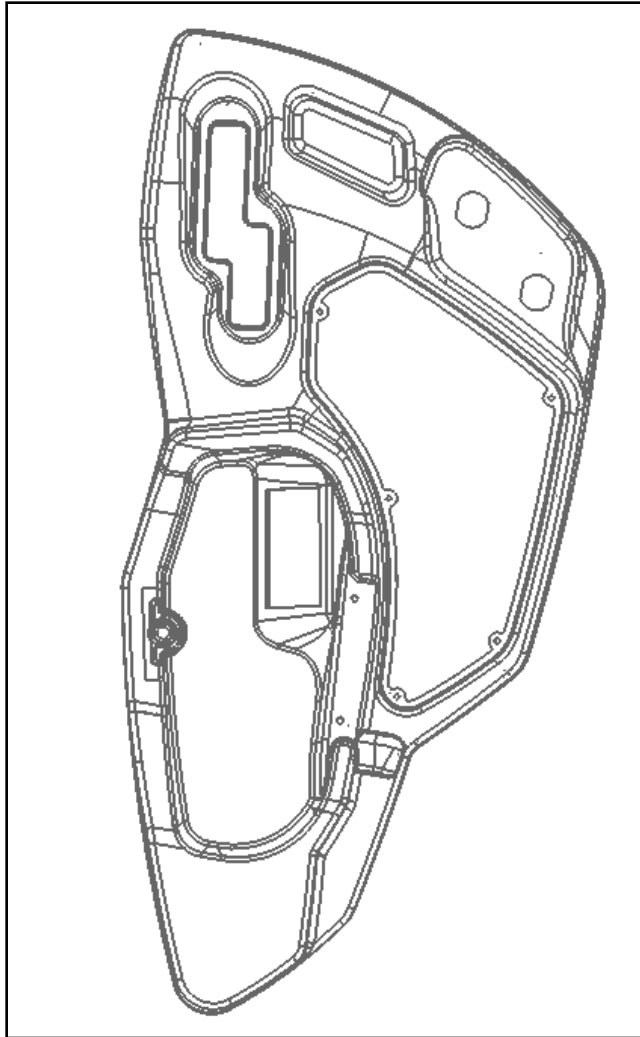


Mold size is 900x600MM,
Produce in a BM 650T machine

Part Layout

Need to show part layout to avoid customer misunderstanding our proposal

Tool top

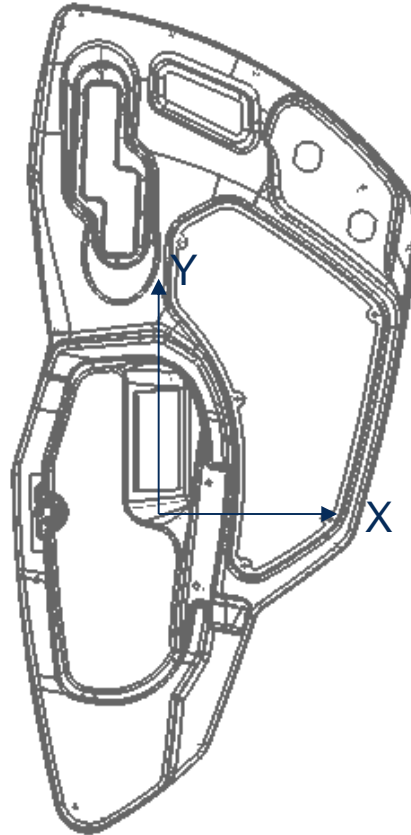


Notes: this is very rough layout, but it is a Useful guidance for our tool designer.

Mold size is 900x600MM,

Produce in a BM 650T machine

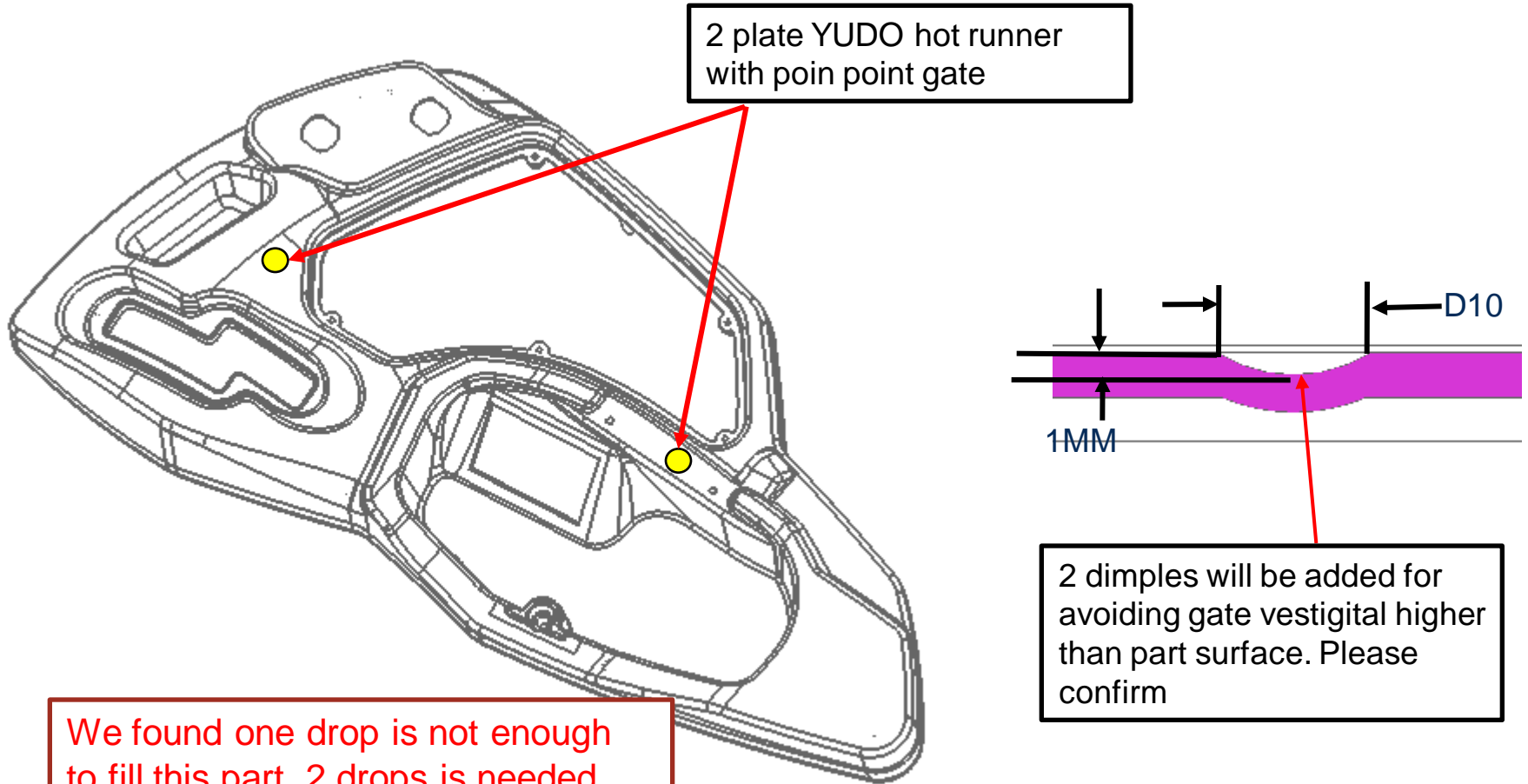
Shrinkage



Notes: above shrinkage is estimated according to our understanding, pls correct it if there is any risk of getting right dimension

Shrinkage with orientation	X	1.01	Customer comment. (please give your approval and comments)			
	Y	1.01	OK or NG	remark	Approval by:	date
	Z	1.01				

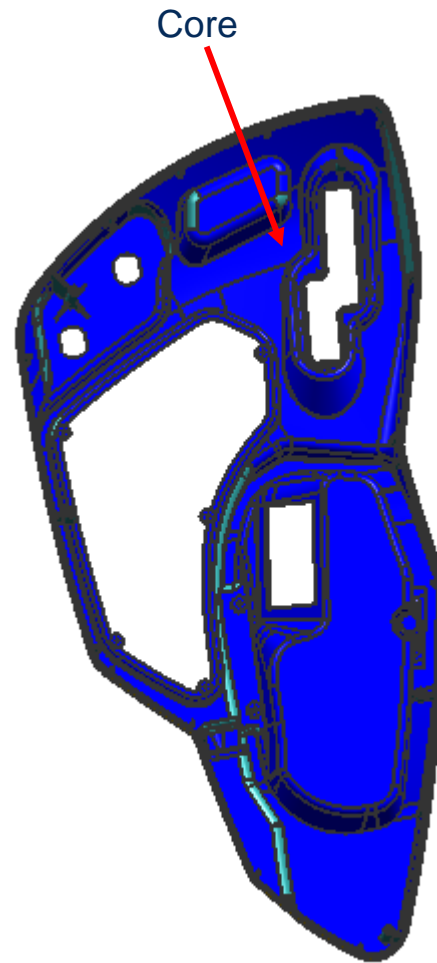
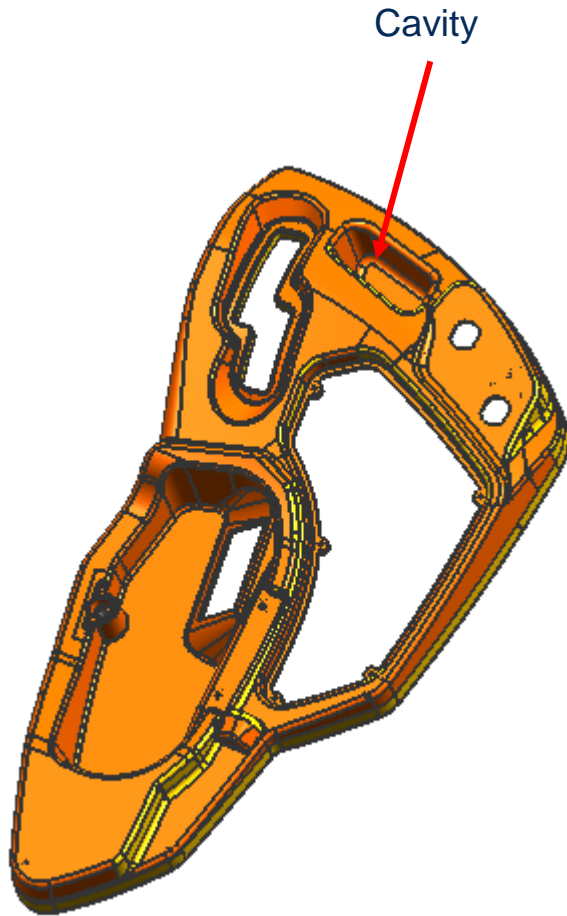
Gate layout



We found one drop is not enough to fill this part, 2 drops is needed, please confirm. If you want one drop, could you please provide hot runner drawing for our reference? Thank you.

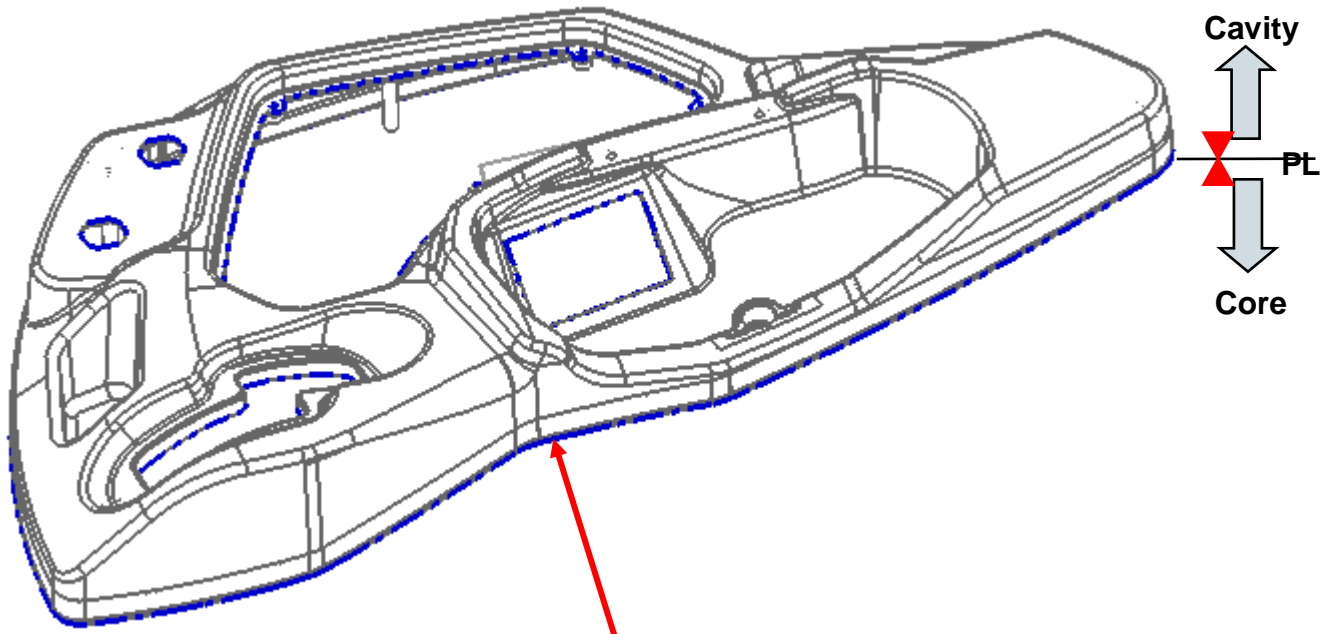
Customer comment. (please give your approval and comments)			
OK or NG	remark	Approval by:	date

Cavity and core Impression



Parting line

— P/ LINE



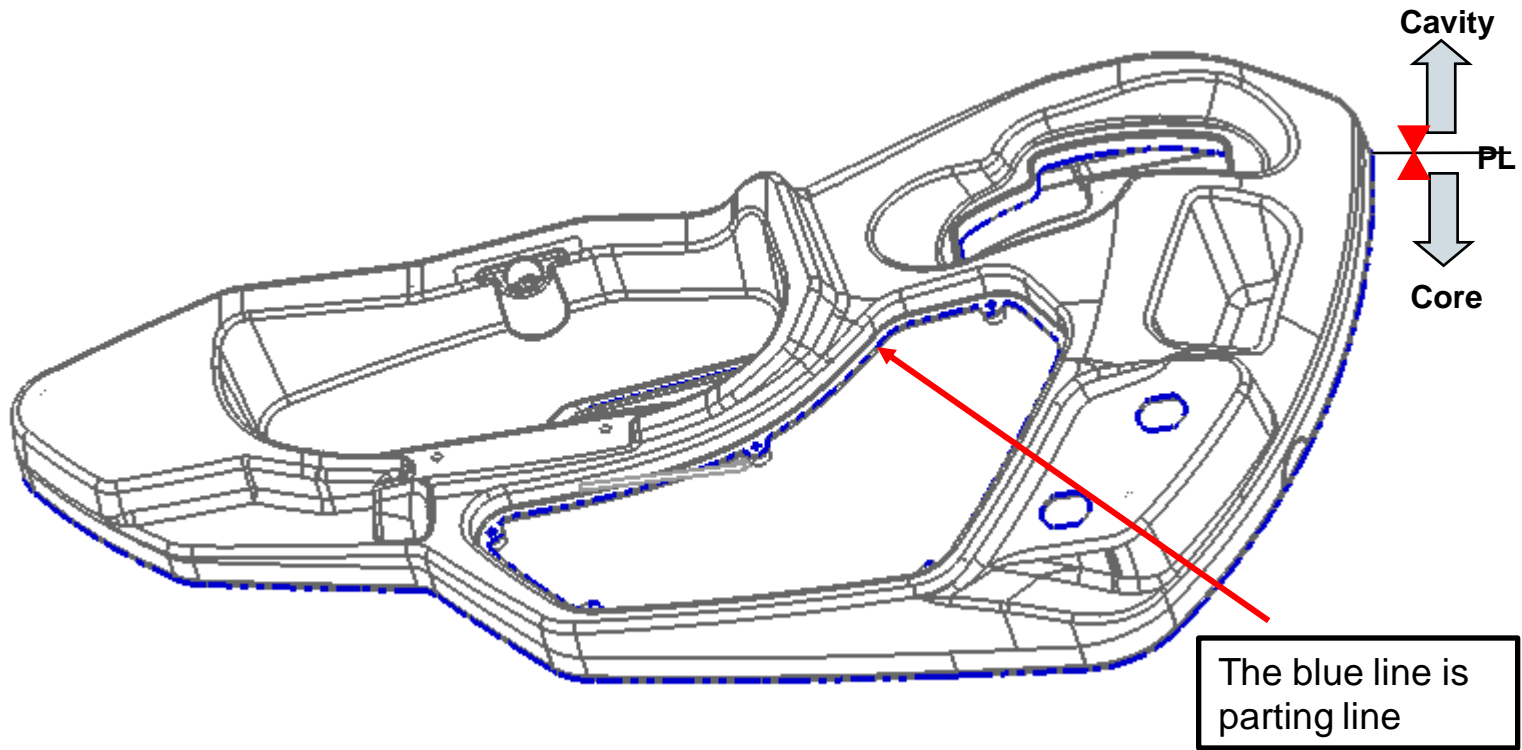
The blue line is parting line

Notes: please advice any concern on propose parting line.

Customer comment. (please give your approval and comments)			
OK or NG	remark	Approval by:	date

Parting line

— P/ LINE



Customer comment. (please give your approval and comments)

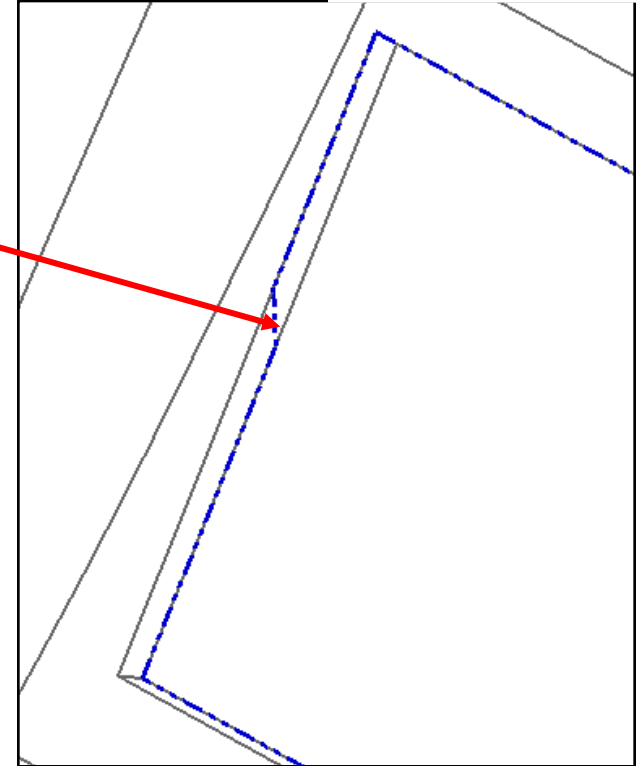
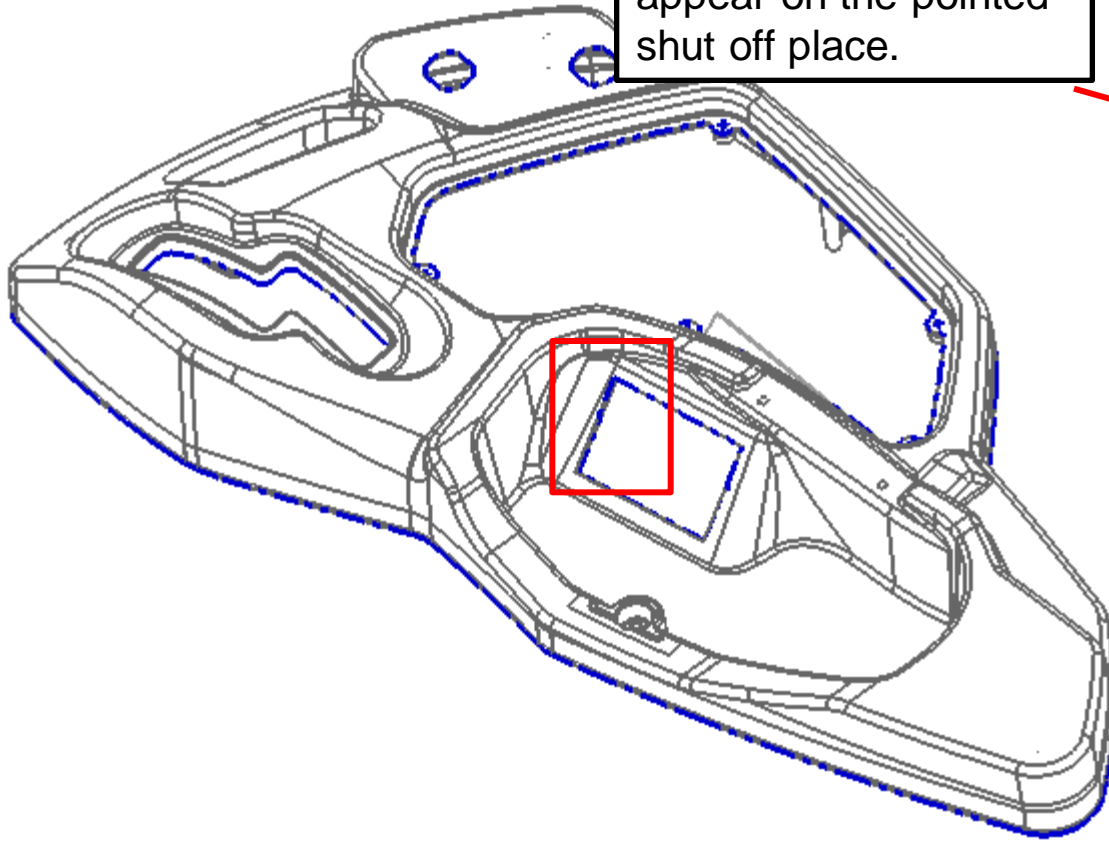
OK or NG	remark	Approval by:	date

Notes: please advice any concern on propose parting line.

Parting line

— P/ LINE

0.3mm mismatch will appear on the pointed shut off place.



Customer comment. (please give your approval and comments)

OK or NG

remark

Approval by:

date

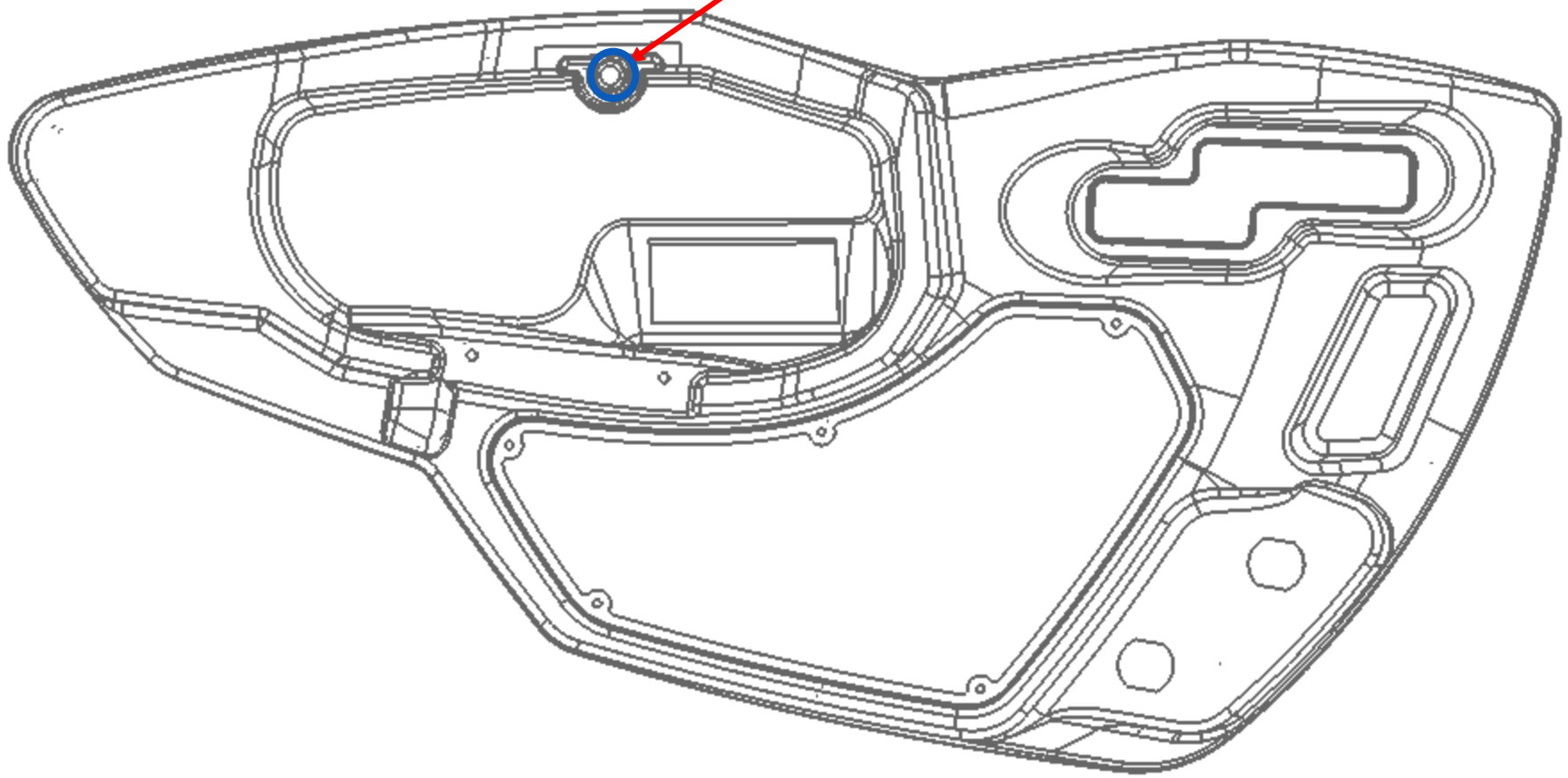
Notes: please advice any concern on propose parting line.

Customer comment. (please give your approval and comments)			
OK or NG	remark	Approval by:	date

Insert lines of core side

— P/ LINE

Insert parting line on cavity



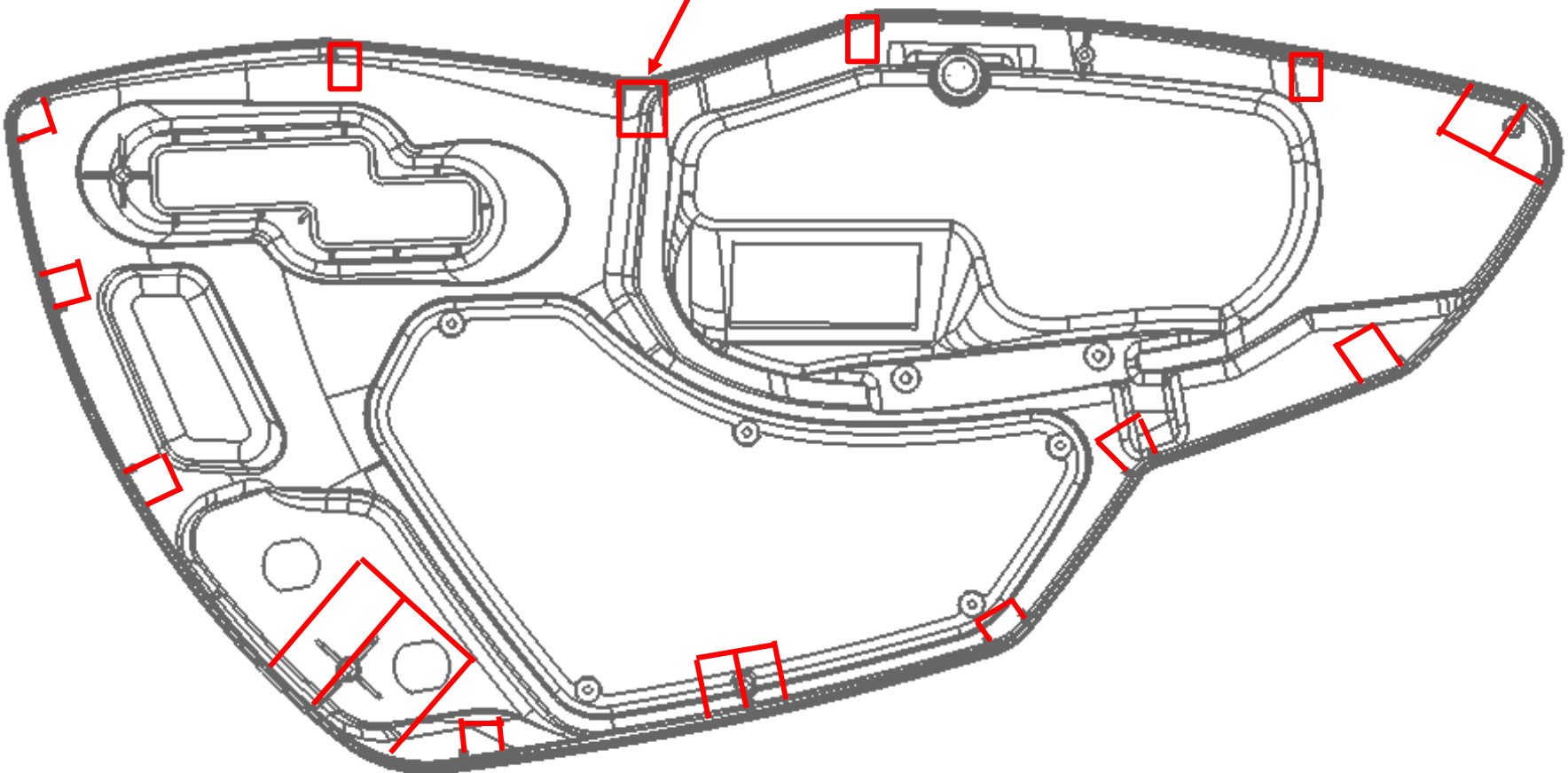
Customer comment. (please give your approval and comments)			
OK or NG	remark	Approval by:	date

Notes: please advice any concern on propose parting line.

Insert lines of core side

— P/ LINE

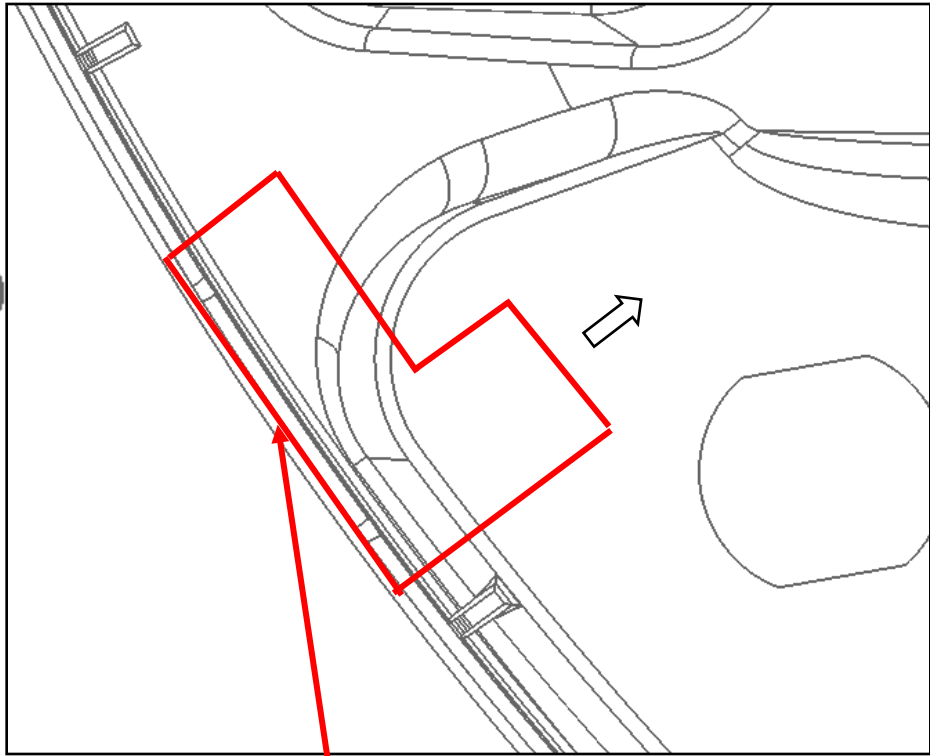
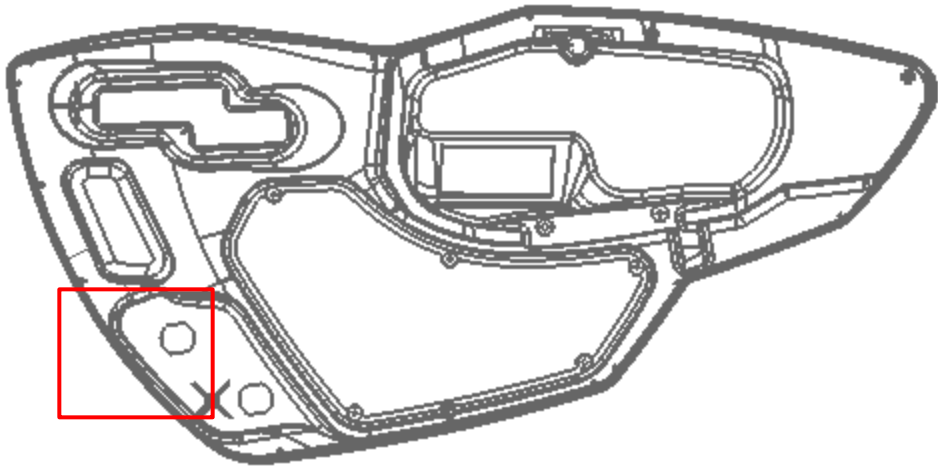
Insert parting line on core



Customer comment. (please give your approval and comments)			
OK or NG	remark	Approval by:	date

Notes: please advice any concern on propose parting line.

Core Lifter & Slider



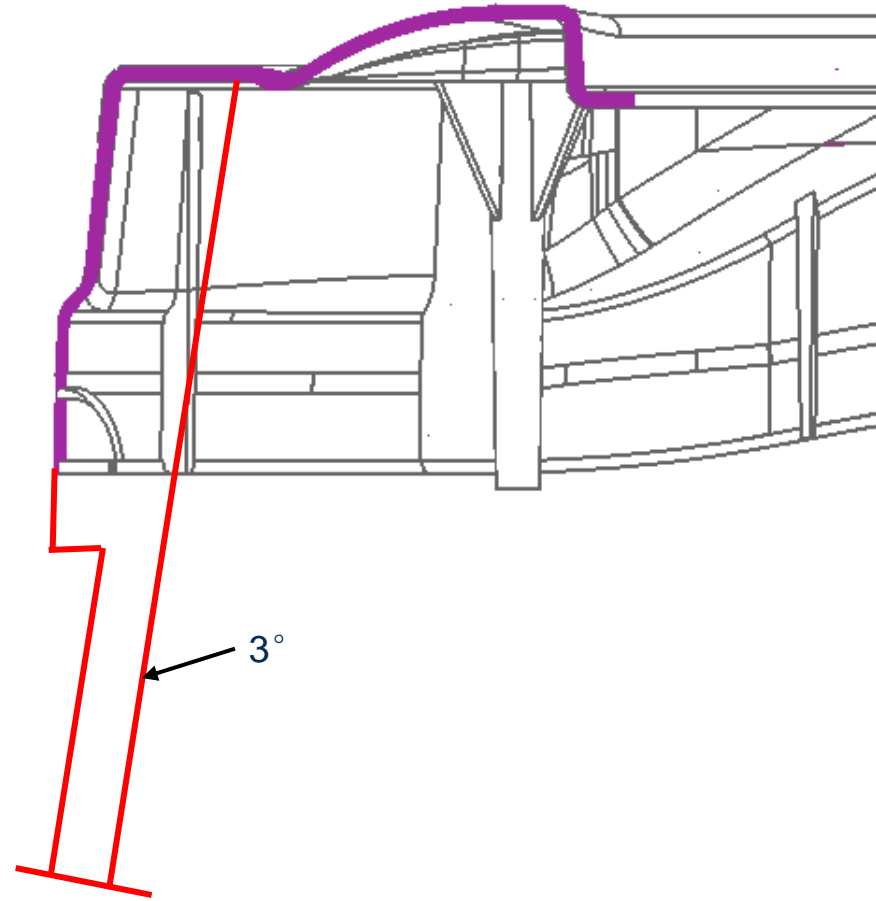
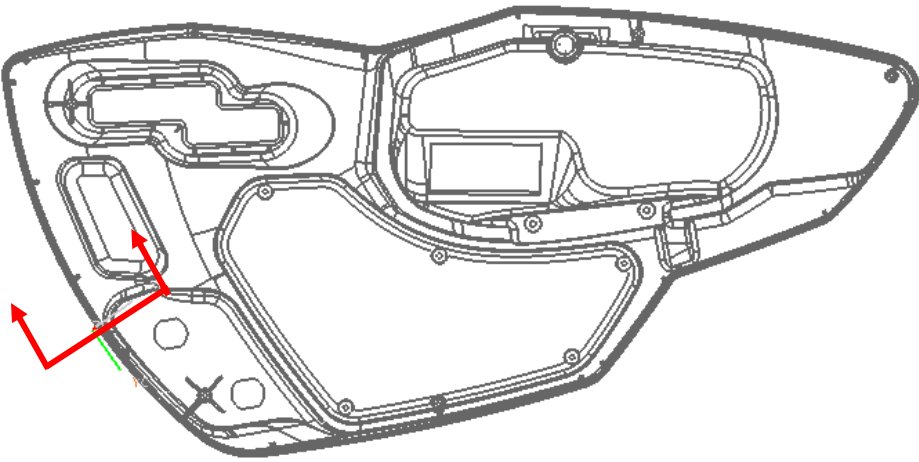
Slide parting line on core

- =Lifter
- =Slider

Notes: please advise any concern on witness line form by lifter.

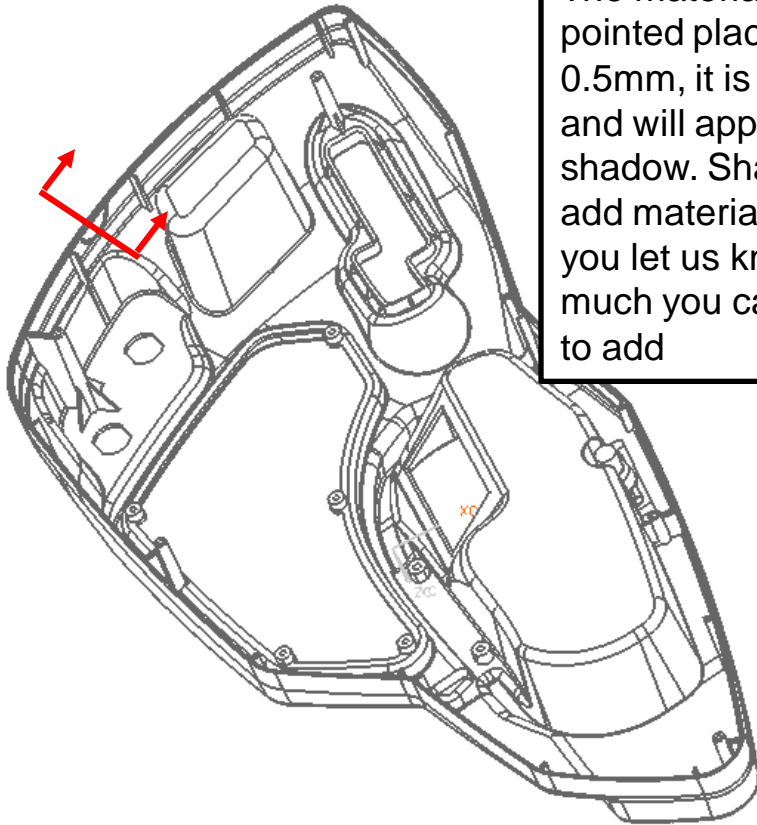
Customer comment. (please give your approval and comments)			
OK or NG	remark	Approval by:	date

Lifter draft angle

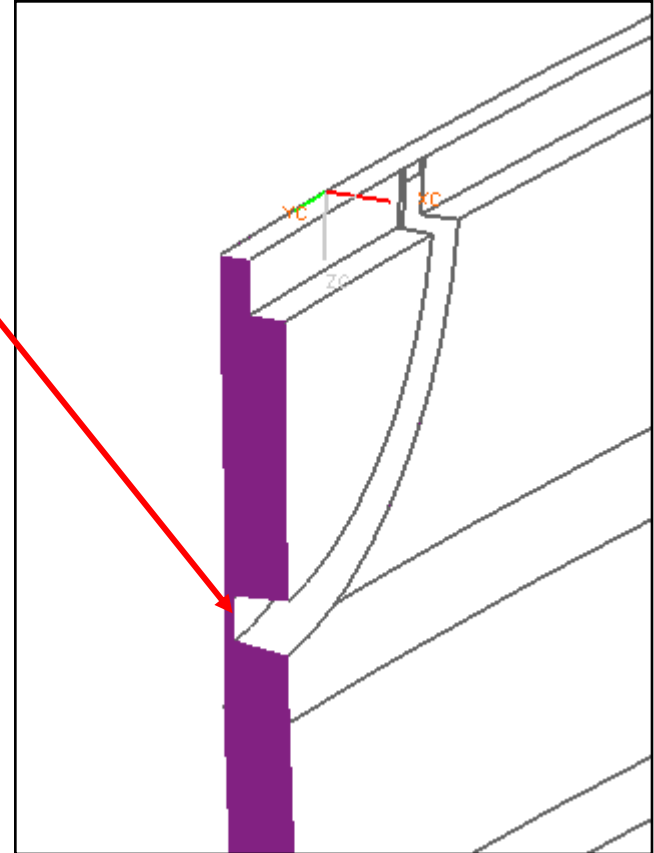


Please make lifter side draft.	
Color	Propose Draft angle

Customer comment. (please give your approval and comments)			
OK or NG	remark	Approval by:	date

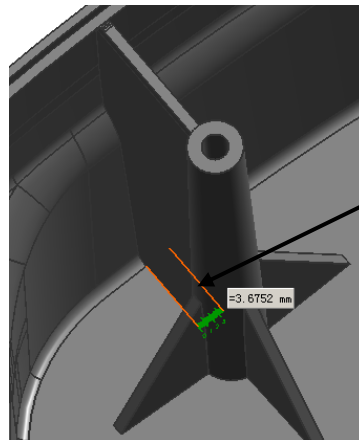
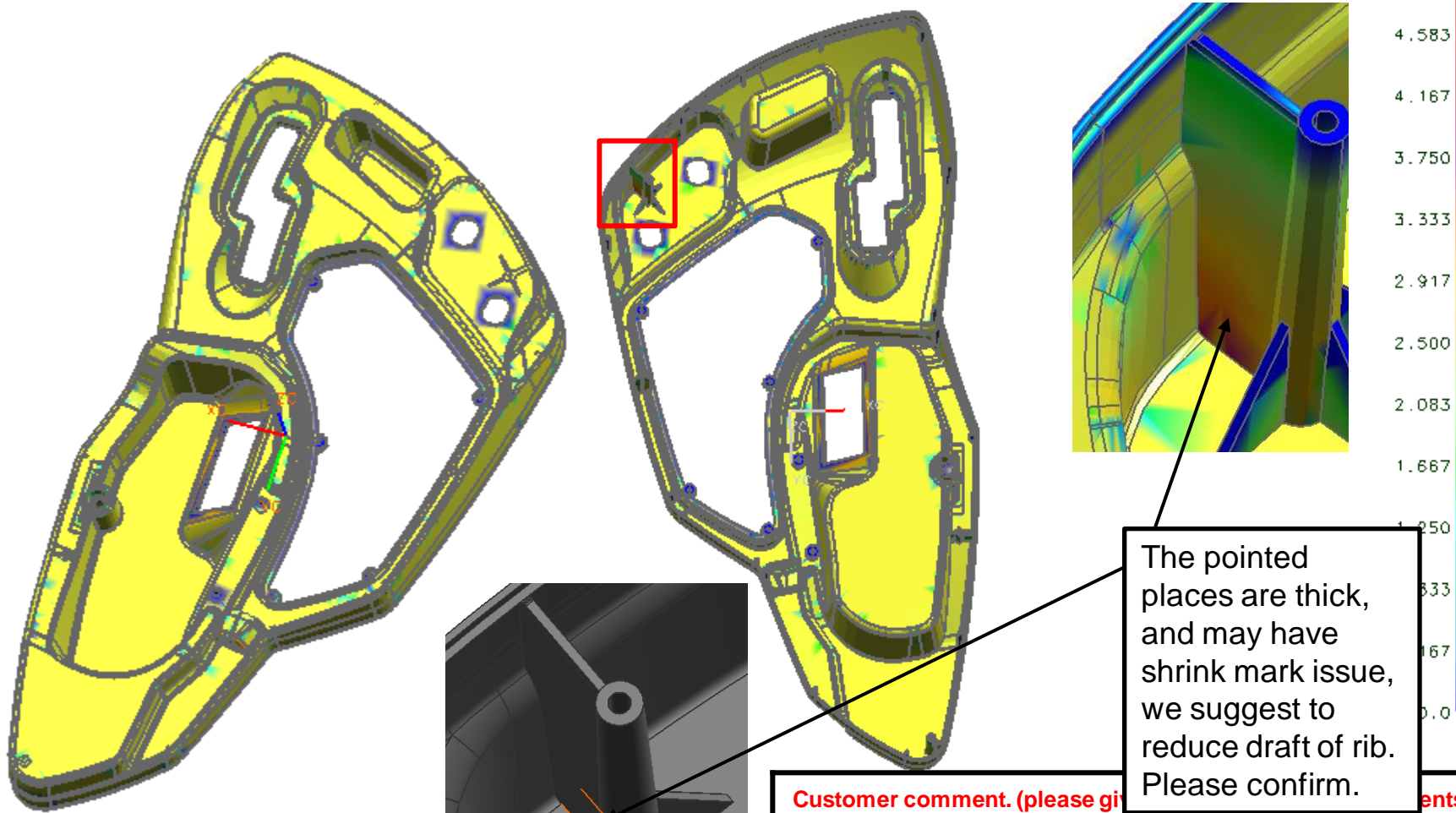


The material on the pointed places is only 0.5mm, it is too thin and will appear shadow. Shall we add material? Can you let us know how much you can accept to add



Please make lifter side draft.		Customer comment. (please give your approval and comments)			
Color	Propose Draft angle	OK or NG	remark	Approval by:	date

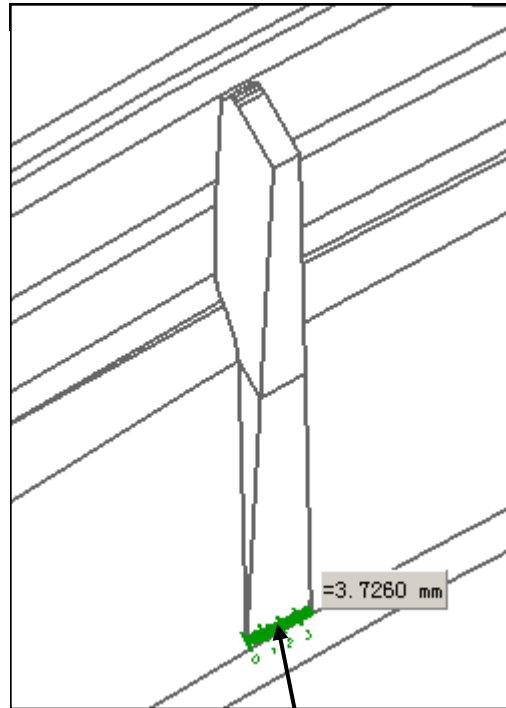
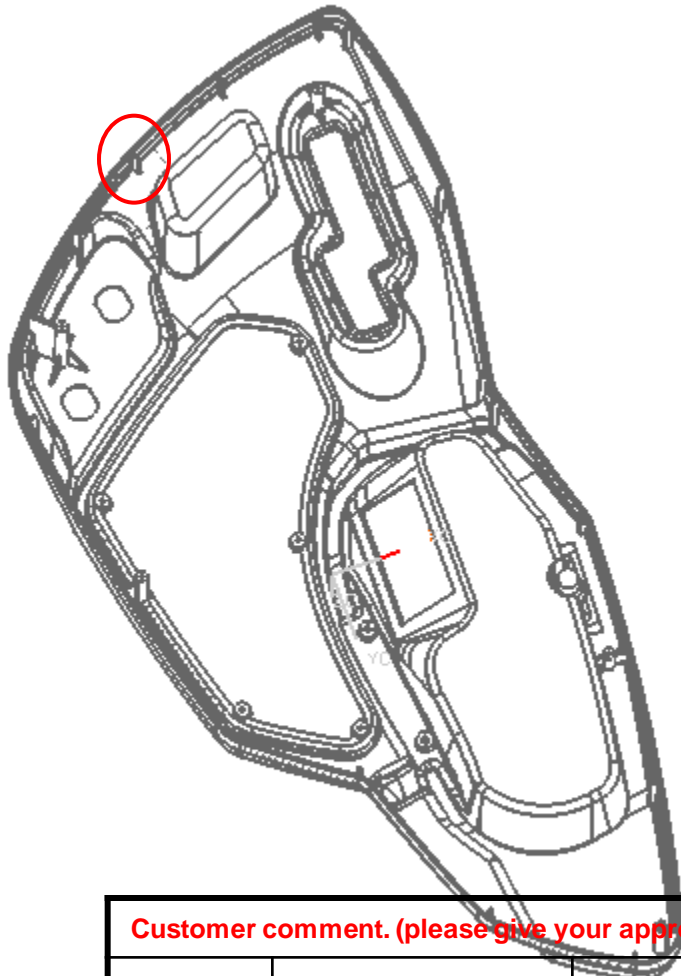
Thickness Analysis (shrinkage/strength/sink mark)



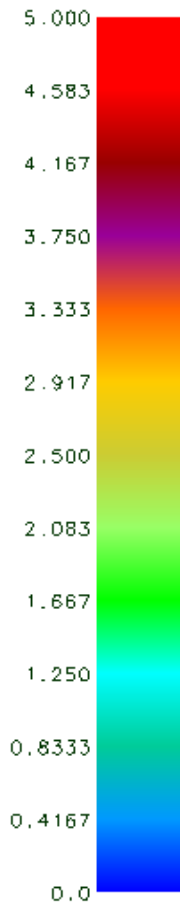
The pointed places are thick, and may have shrink mark issue, we suggest to reduce draft of rib. Please confirm.

Customer comment. (please give your comments)			
OK or NG	remark	Approval by:	date

Thickness Analysis (shrinkage/strength/sink mark)

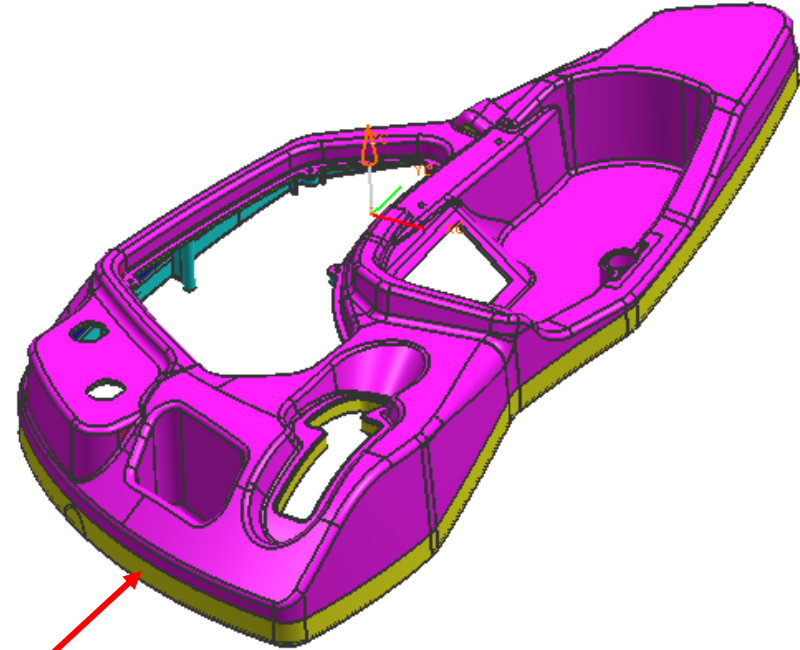
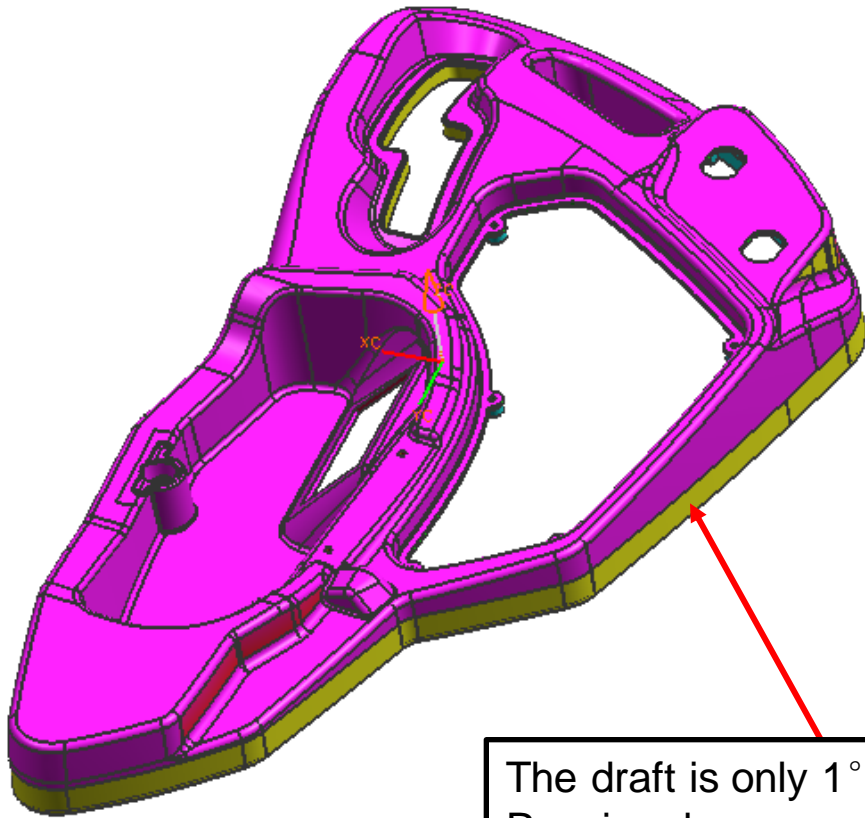


The material on the pointed places is too thick and will have shrink mark. we suggest to make the max thickness 1.8mm, min thickness 1.2mm. Please confirm



Customer comment. (please give your approval and comments)			
OK or NG	remark	Approval by:	date

Draft angle information cavity



The draft is only 1° , as texture is making in Russia, please confirm with texture supplier if the draft is acceptable.

Product is checked in UG as per the direction of tooling release. This will help to evaluate draft angle and propose draft requirements.

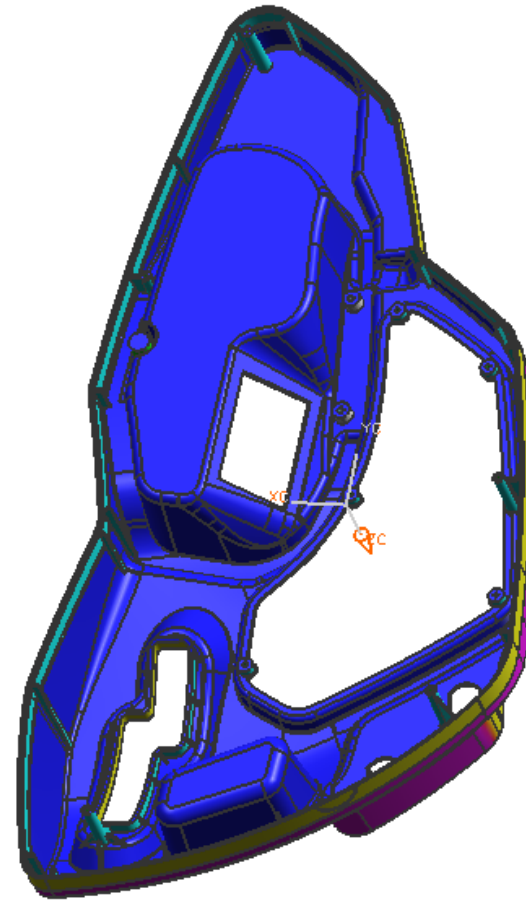
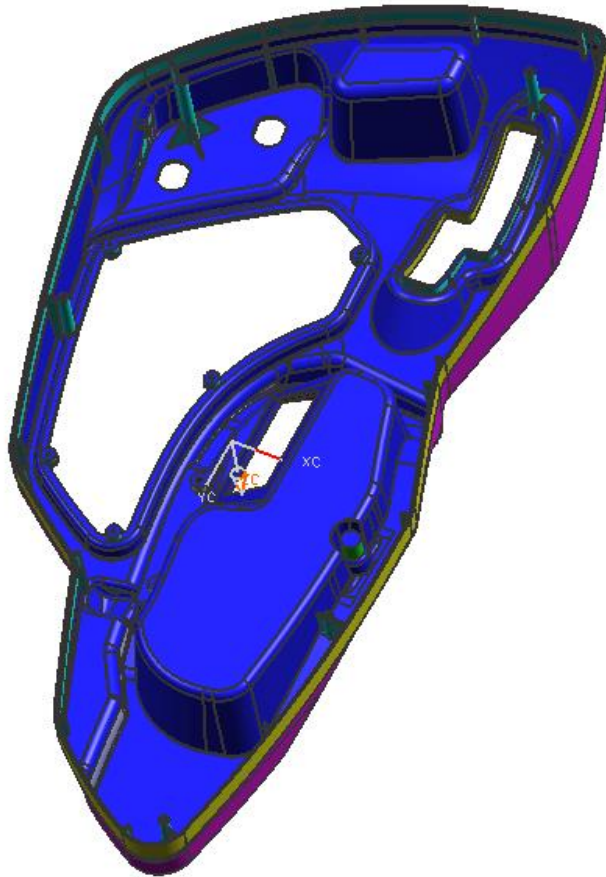
P\L is decided on the basis of draft direction , if need, propose to reverse the draft angle or increase it for release the product easy.

Cavity side



Core side

Draft Analysis information-Core side



Cavity side

+3.0000

+2.0000

+1.0000

0.0

-1.0000

-2.0000

-3.0000

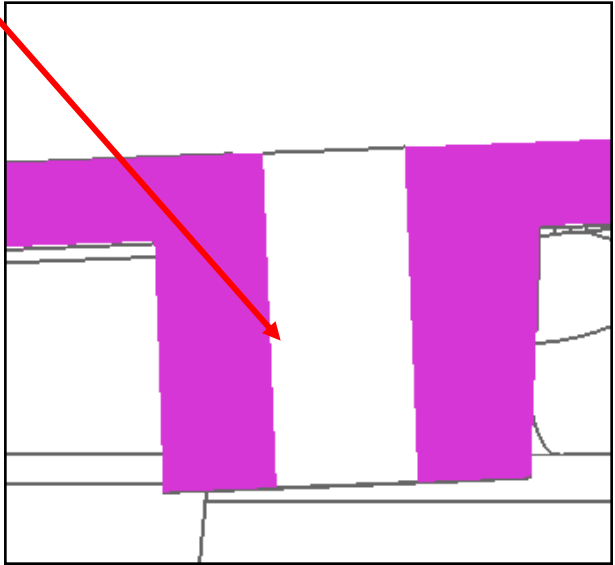
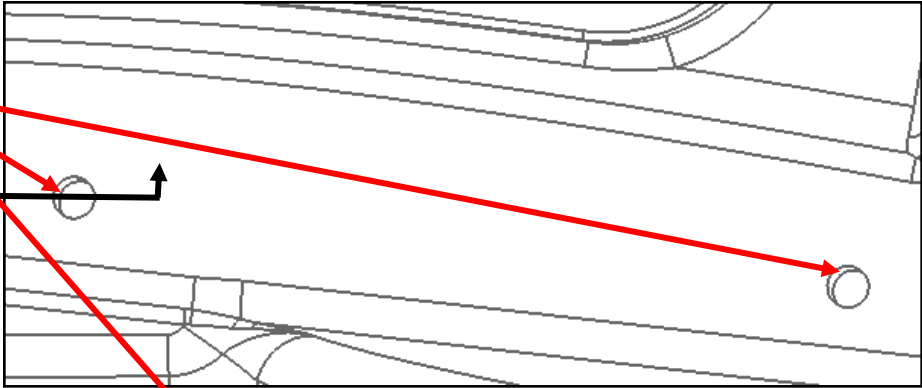
Core side

Product is checked in UG as per the direction of tooling release. This will help to evaluate draft angle and propose draft requirements.

P\L is decided on the basis of draft direction, if need, propose to reverse the draft angle or increase it for release the product easy.

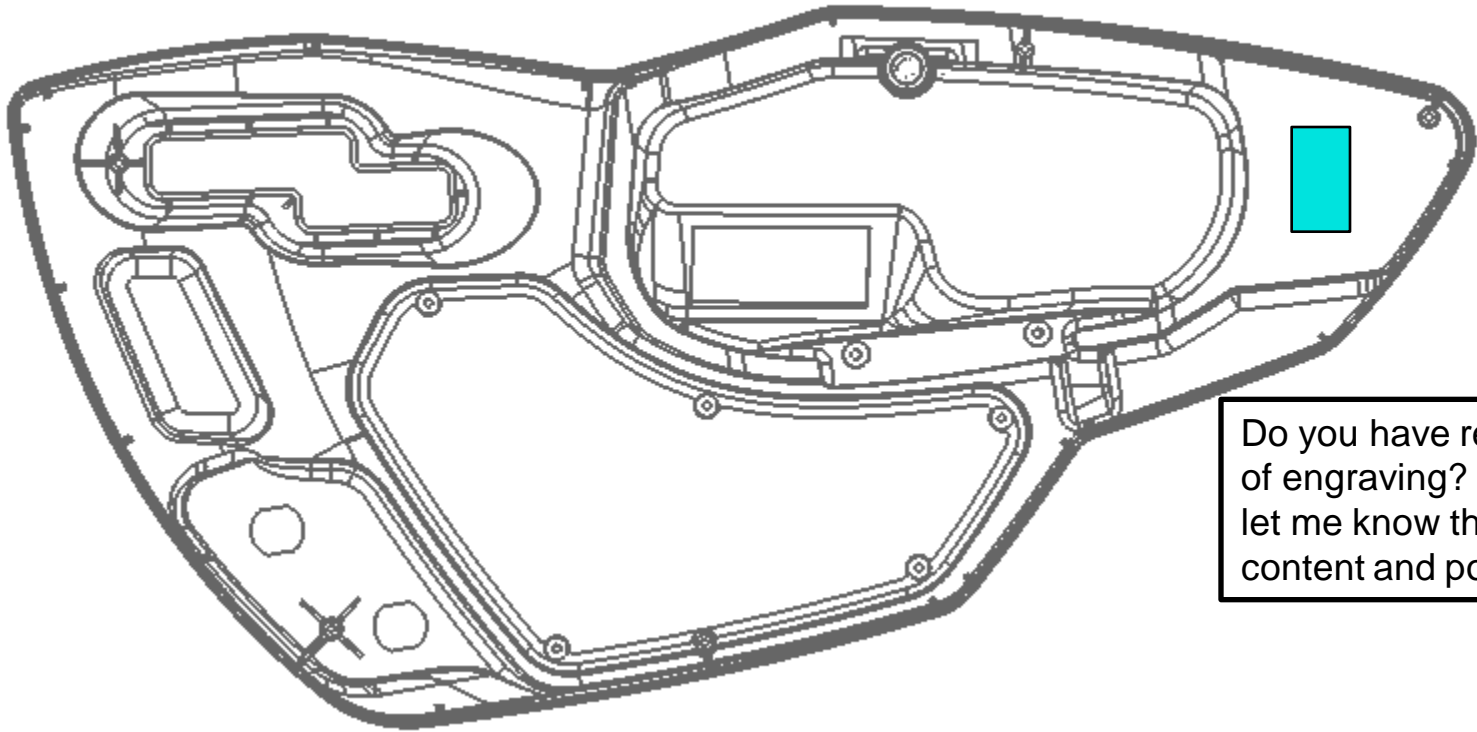
Issue

The hole is undercut, we suggest to make it straight. Please confirm



Customer comment. (please give your approval and comments)			
OK or NG	remark	Approval by:	date

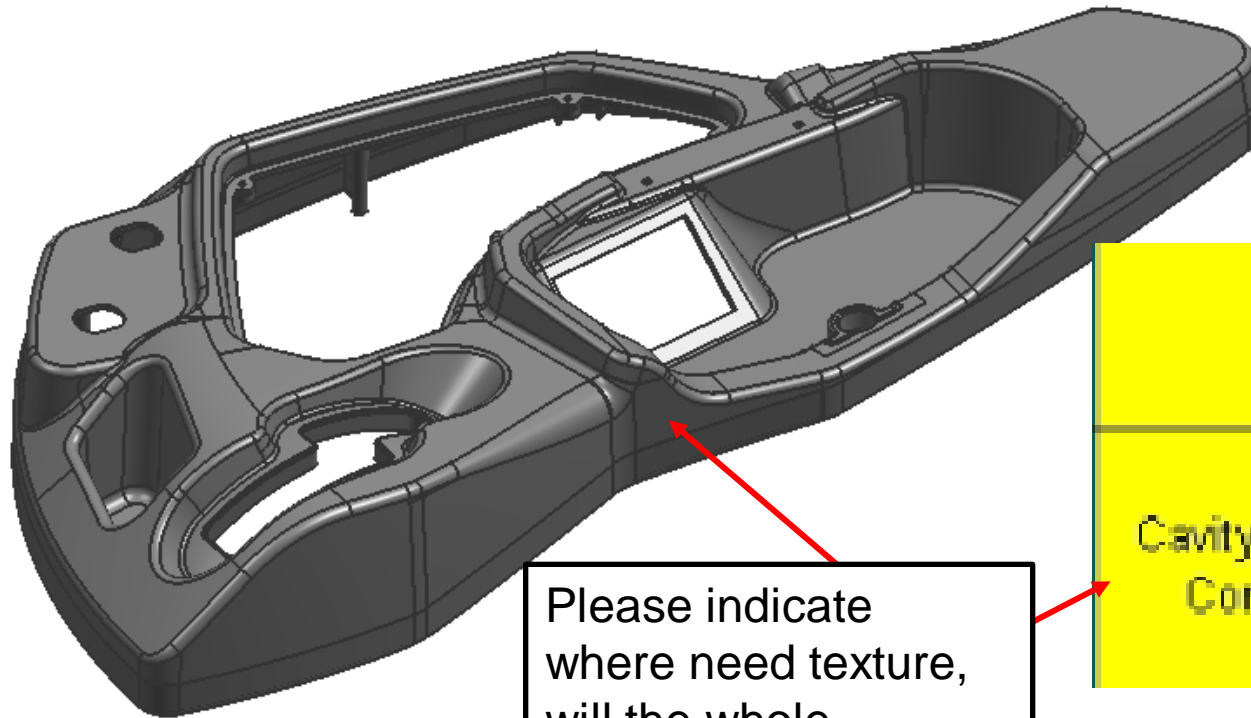
Engraving



Do you have request of engraving? Please let me know the content and position .

Customer comment. (please give your approval and comments)			
OK or NG	Remark	Approval by:	date

Cosmetic requirement



Please indicate where need texture, will the whole appearance surface need making texture?

Finish

Cavity finish= VDI 24
Core finish= B-3

comment. (please give your approval and comments)

We need cosmetic specification to make this Detailed surface finishing. Please highlight it.

OK or NG	remark	Approval by:	date