

1、 Part name :180809 Spule V2 #2

2、 Part No:

3、 Plastic material: **ABS**

4、 Part weight: **2.4g**

5、 Shrink value : **1.006?**

6、 Cavity : **1*2**

7、 Steel : **1.2343**

8、 Type of gate : **Tip feeding**

9、 Type of runner: **YUDO Hot runner**

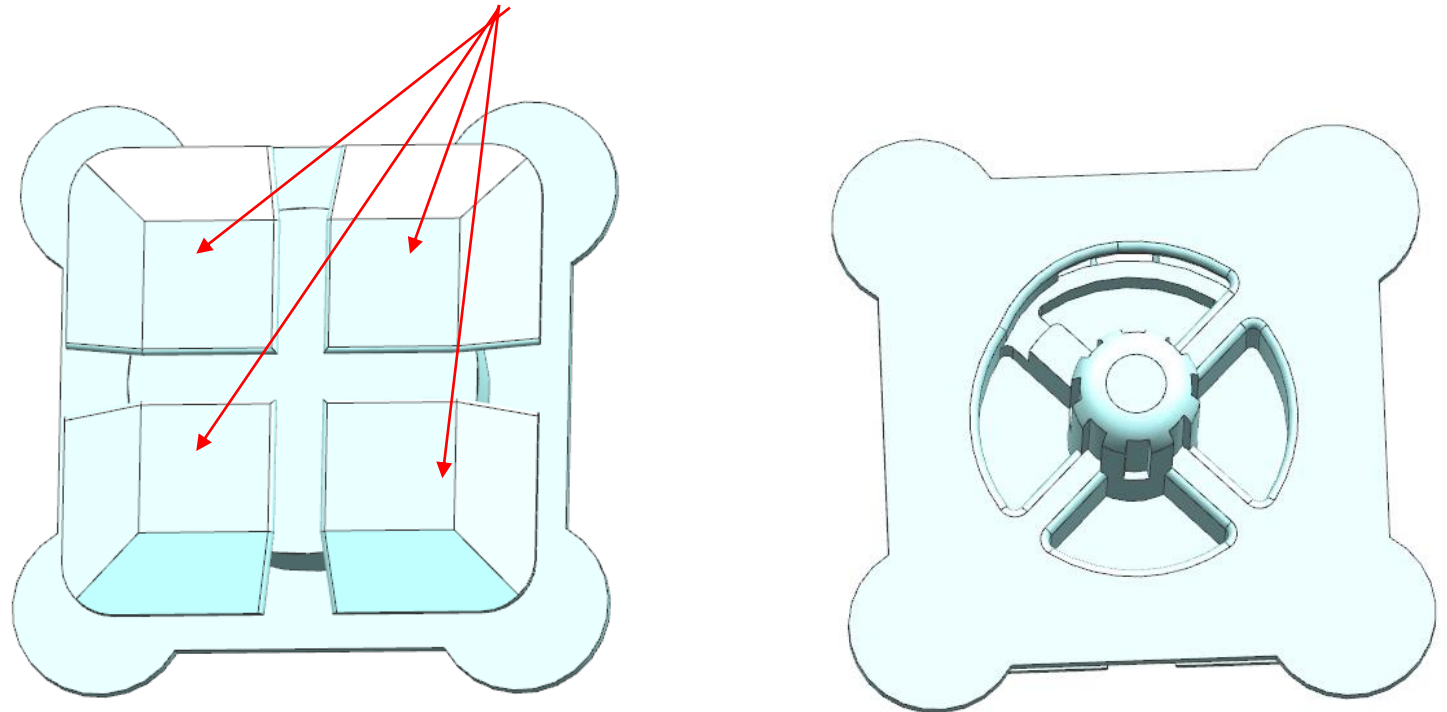
10、 Product Size : **34X15X34mm**

11、 General thickness : **1.05mm**

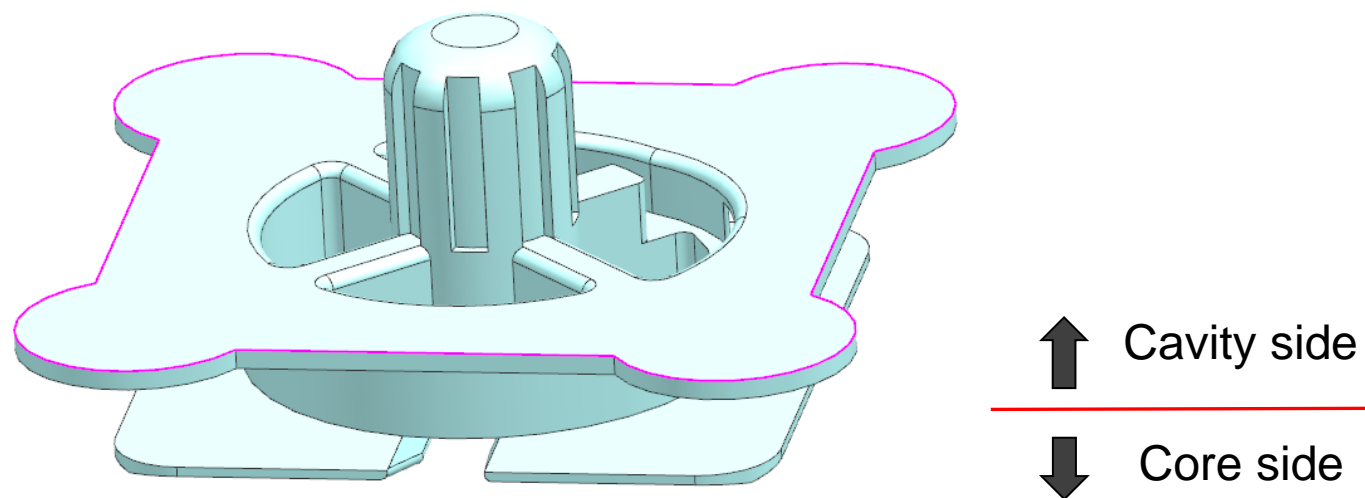
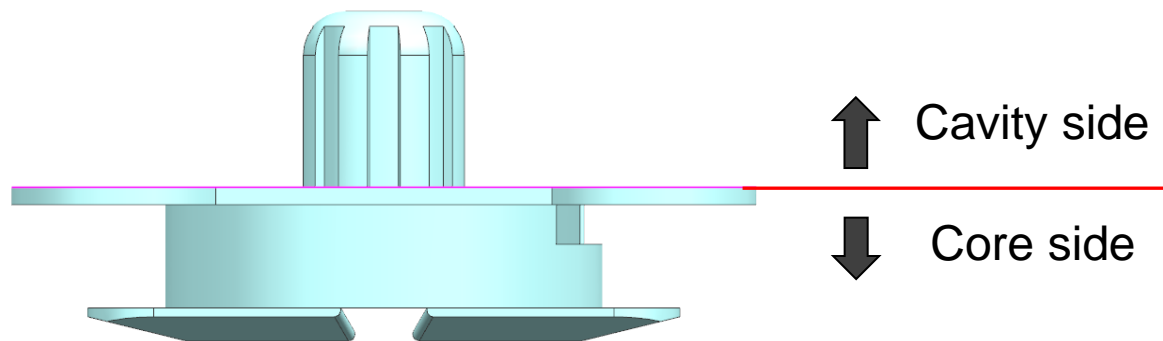
12、 Surface require : **VDI#**

13、 Type of Mold : **Production Mould**

What is surface requirement for this side? VDI texture or ?

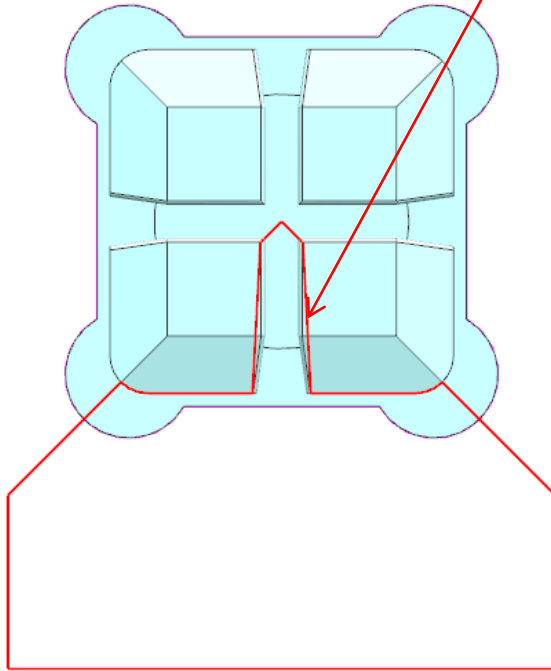


Parting Line

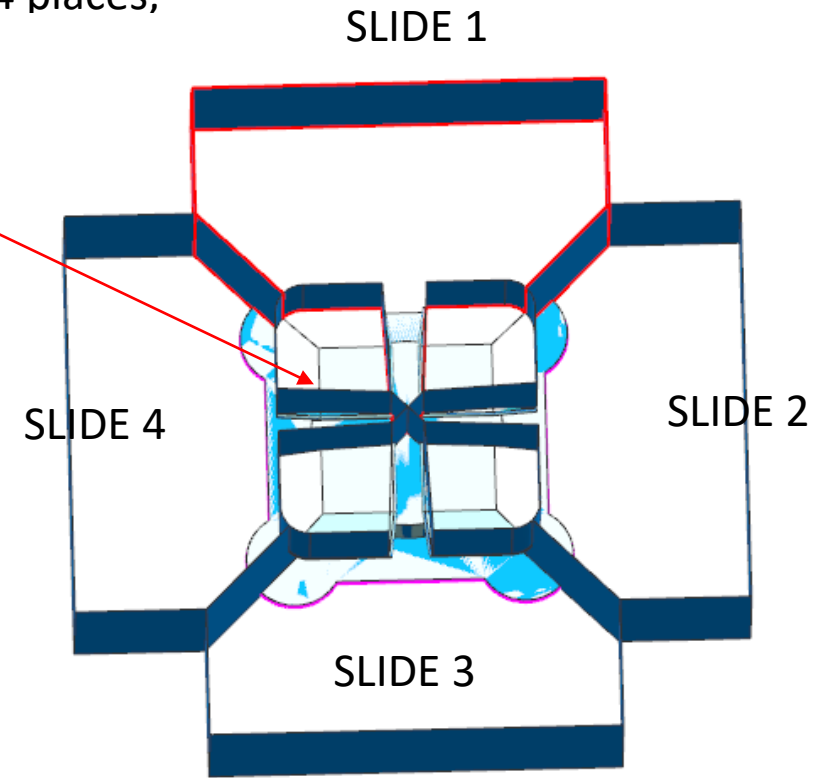


Parting Line

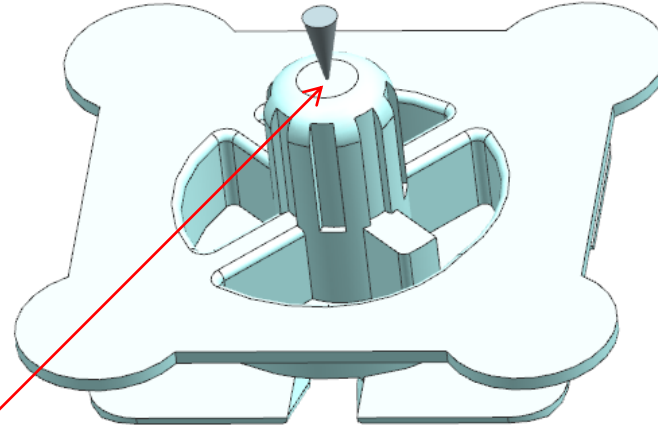
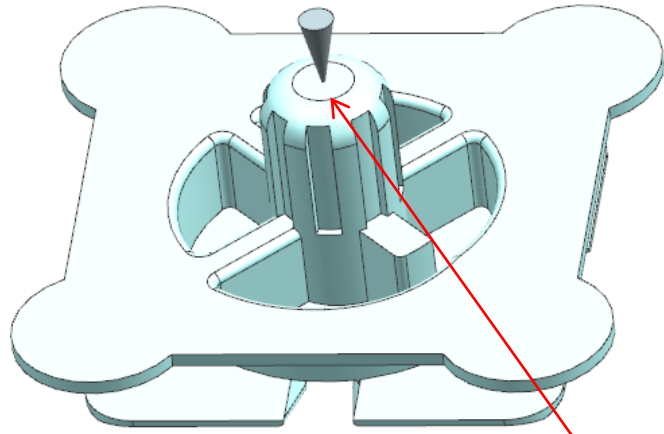
Slider parting line will be like this, total 4 places,
please check and confirm?



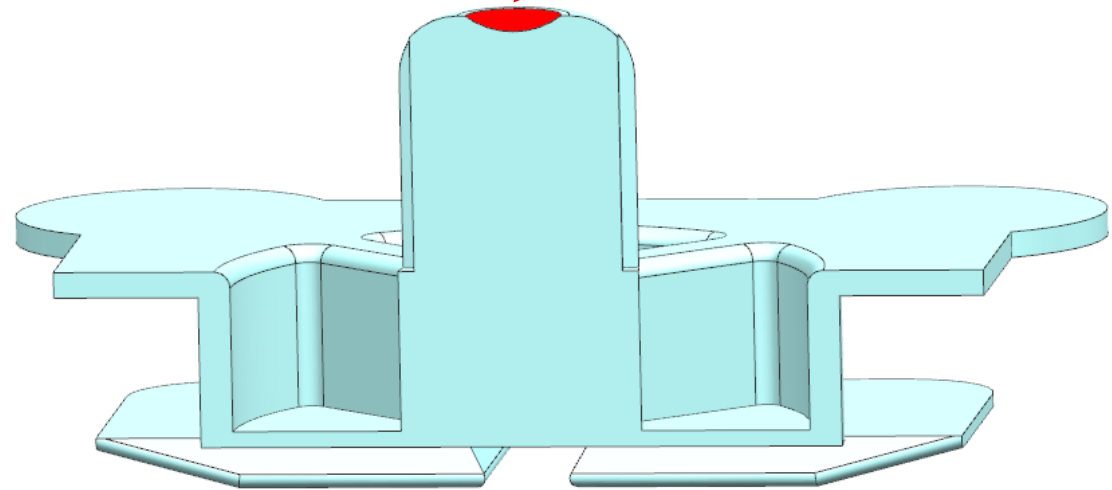
Slider parting line



行位分型如图，共4个

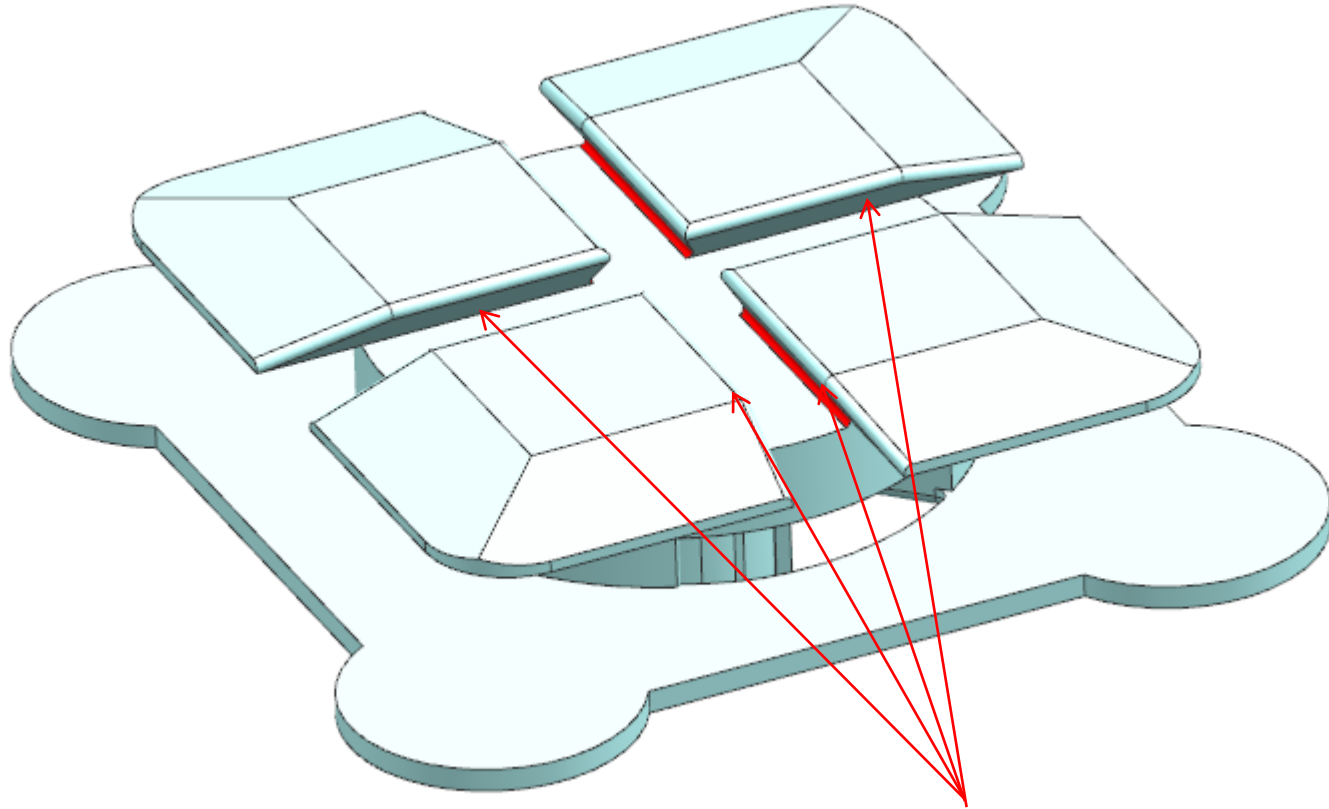


To avoid the gate vestigial here, we suggest to reduce some plastic and make dimple here, size will be 3 x 0.5mm(deep), please confirm?



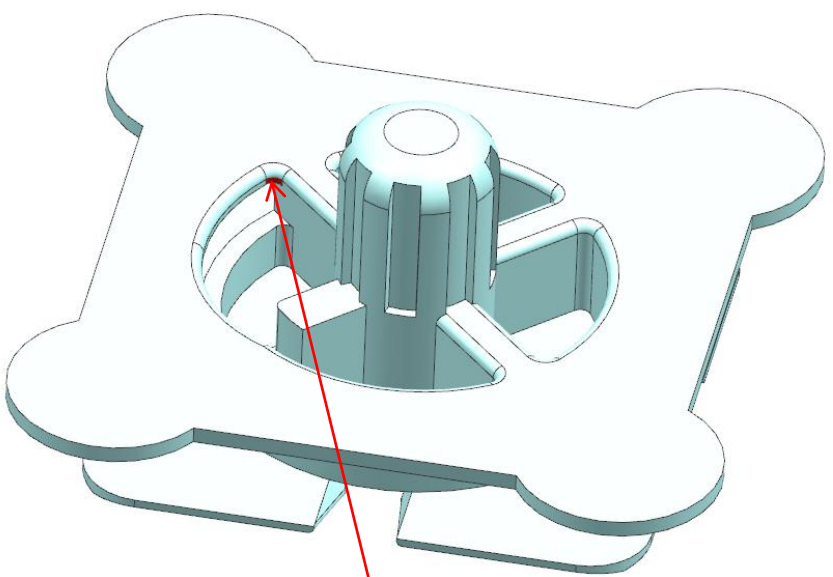
YUDO hot runner two drops, one drop to one part,
This is gate point

Structure analysis

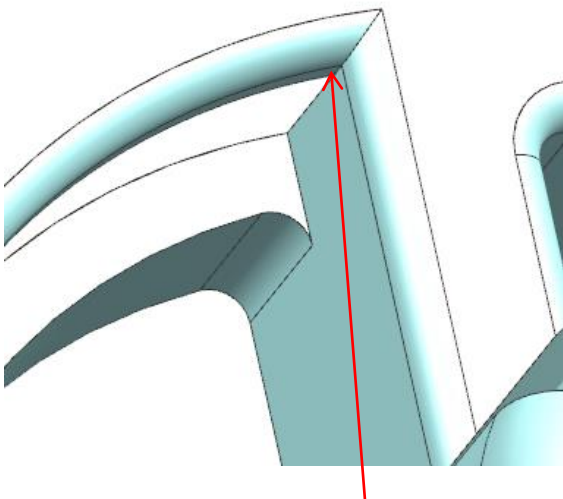


Some of area that has radius and some area does not have any radius, please check the part design and confirm ?

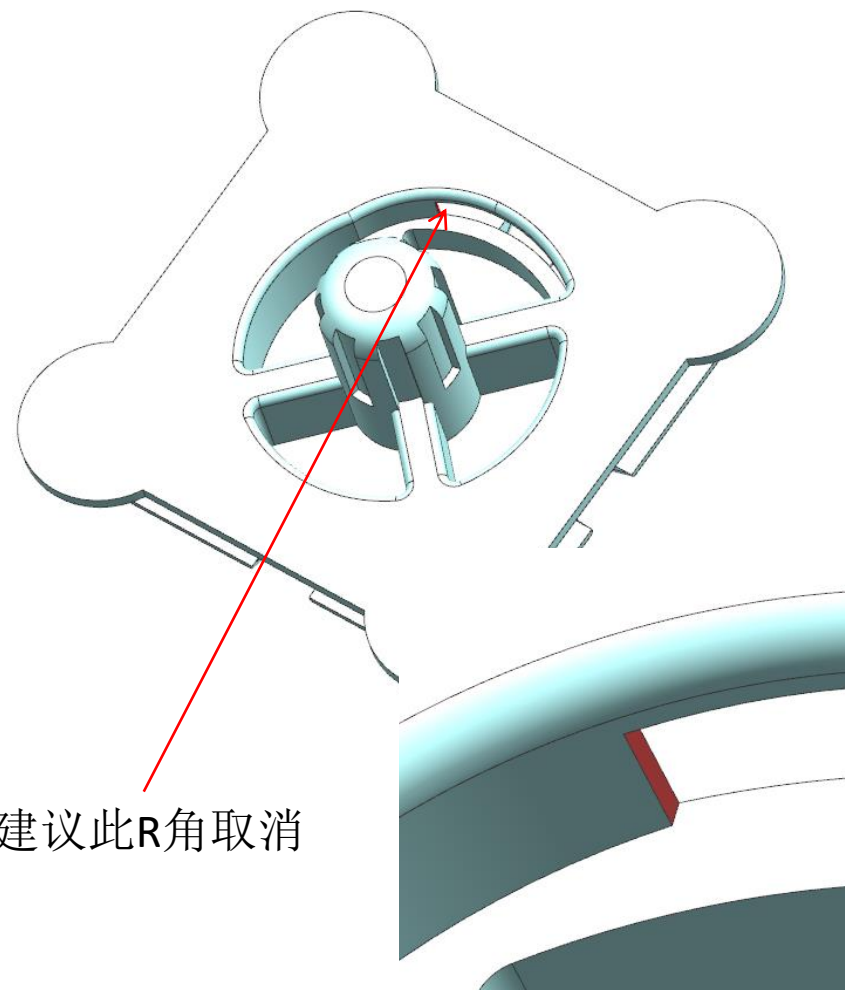
Structure analysis



Suggest to check that area to



After change

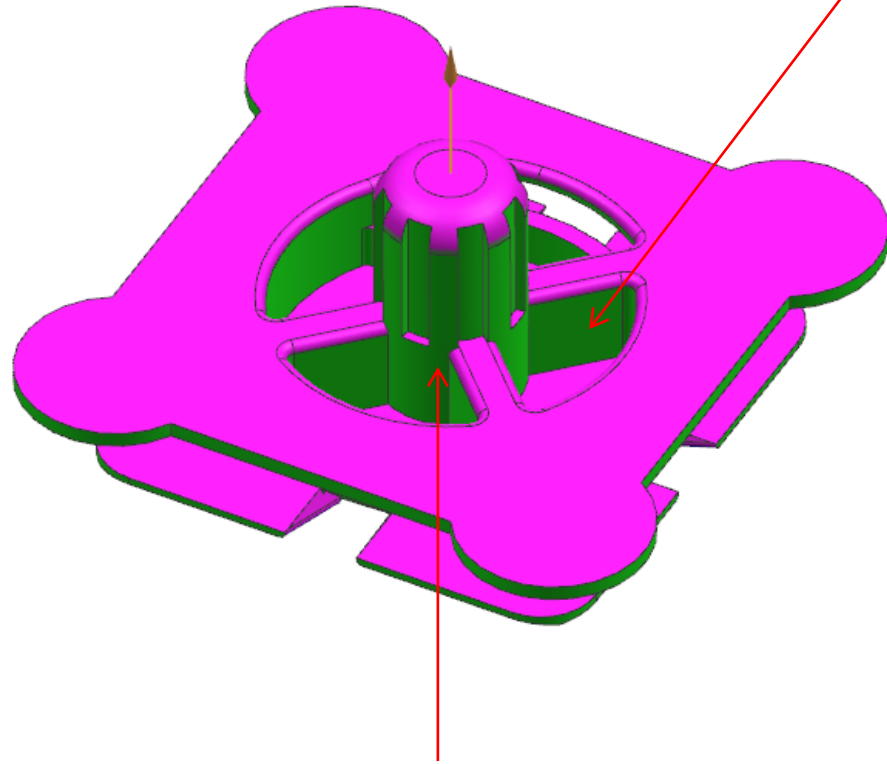


建议此R角取消

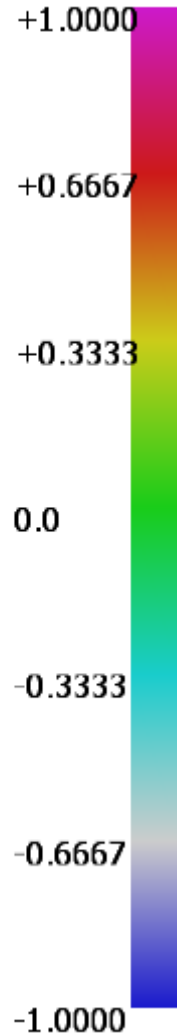
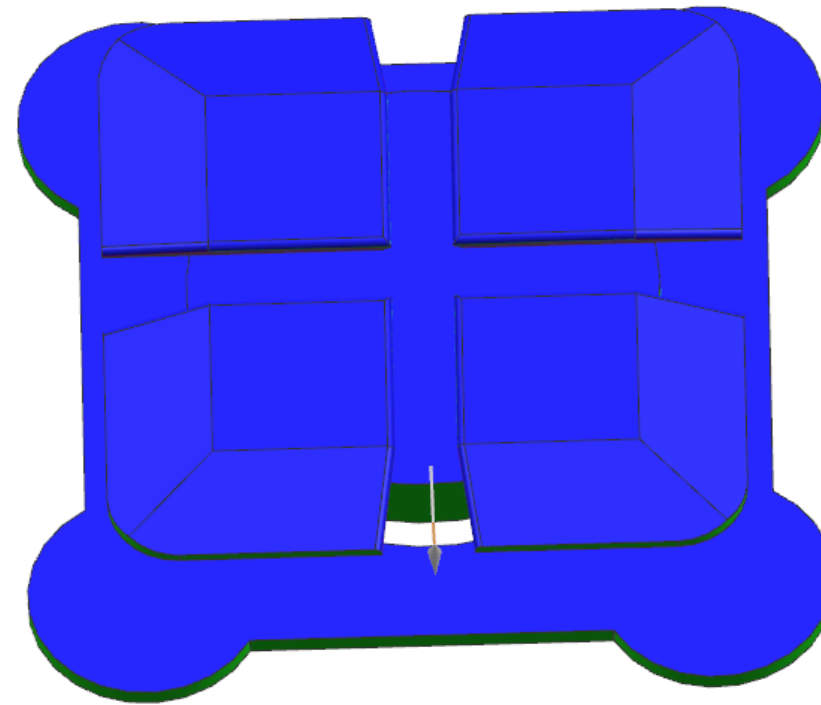
更改后

Draft angle analyze

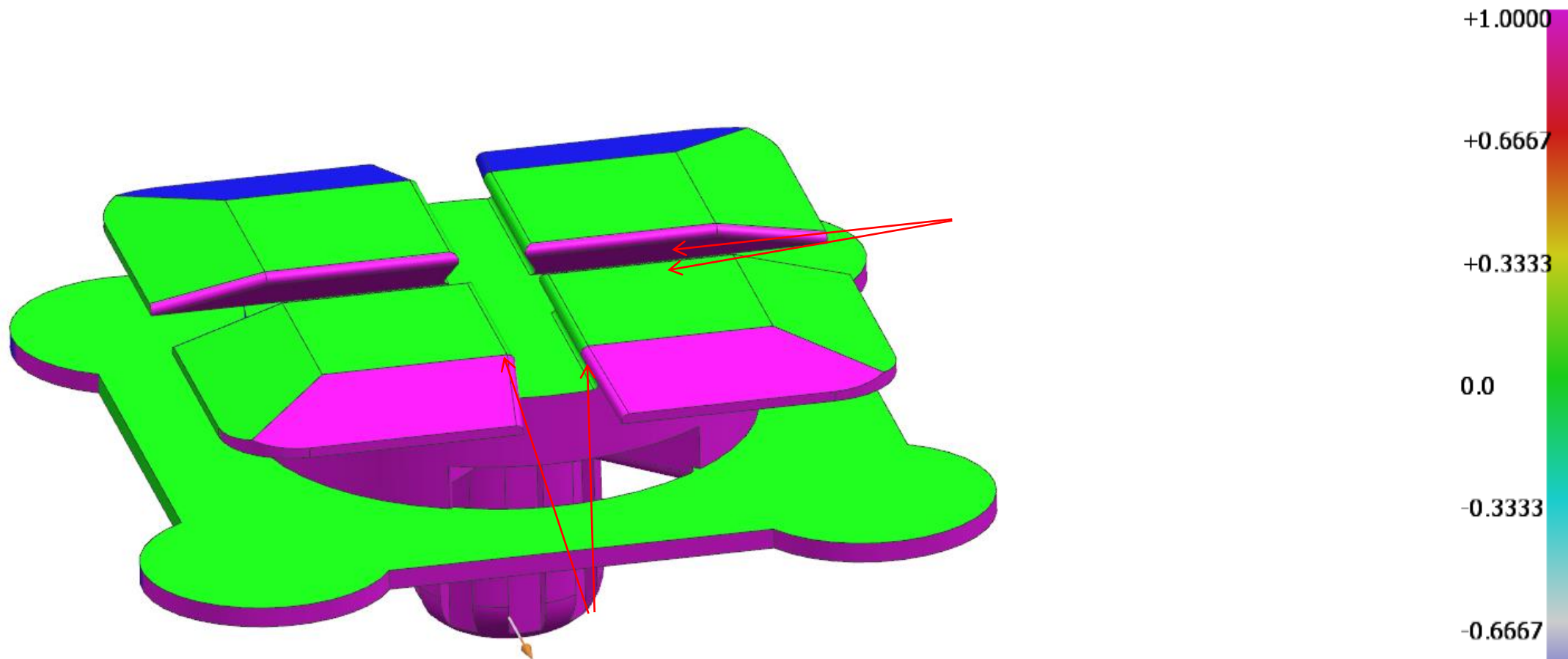
The green area does not have any draft angle,
we suggest to add 1.5 draft angle, to all of similar ribs



This boss does not have any draft angle on the green surface,
we suggest to add 1 degree draft angle by reducing plastics, please confirm?

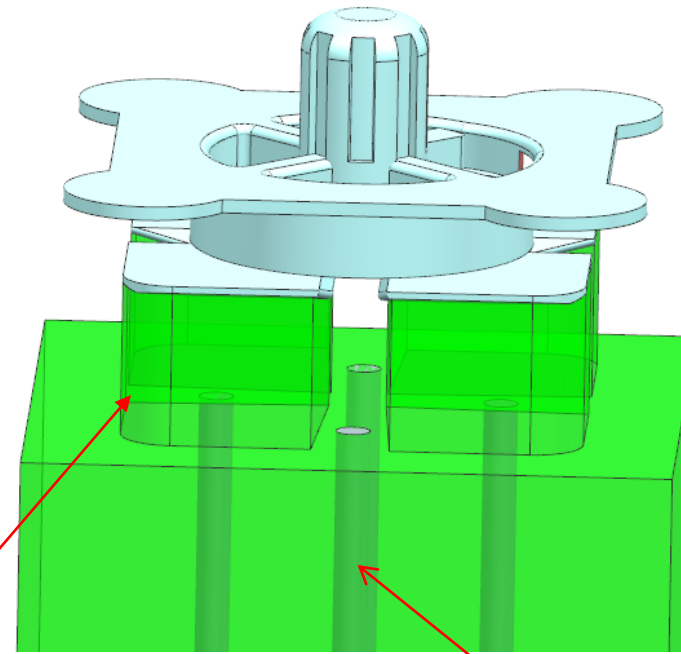
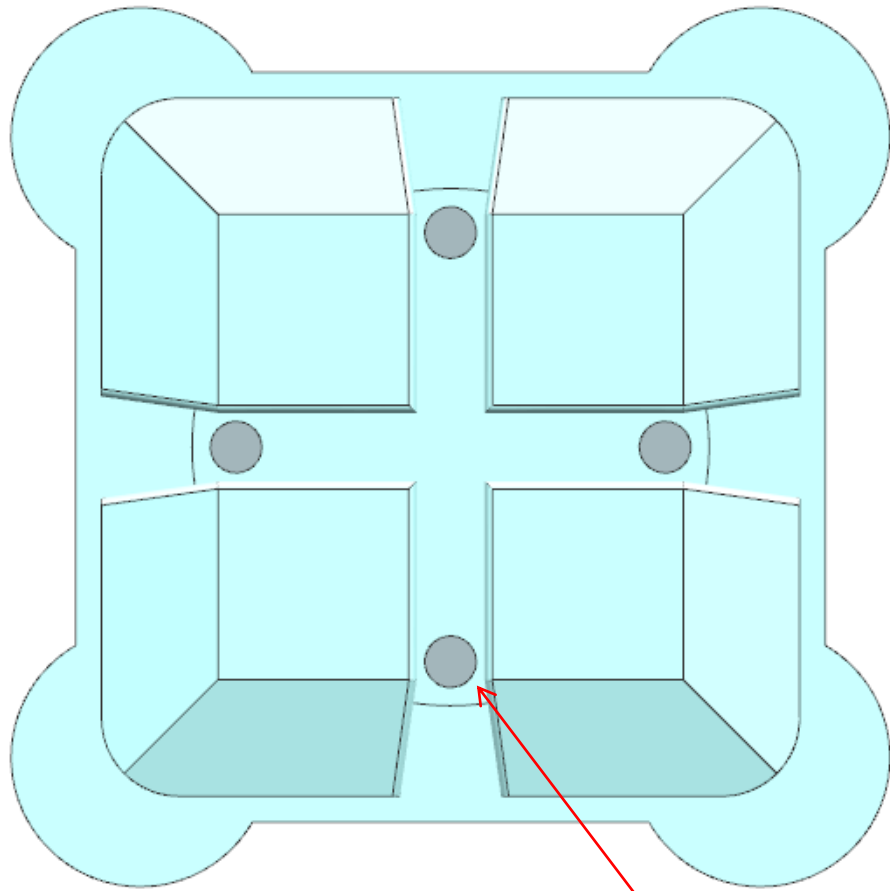


Draft angle analyze



行位出模方向没有出模角，建议做
减胶拔模0.5度，请确认！共8处。

Ejector advise



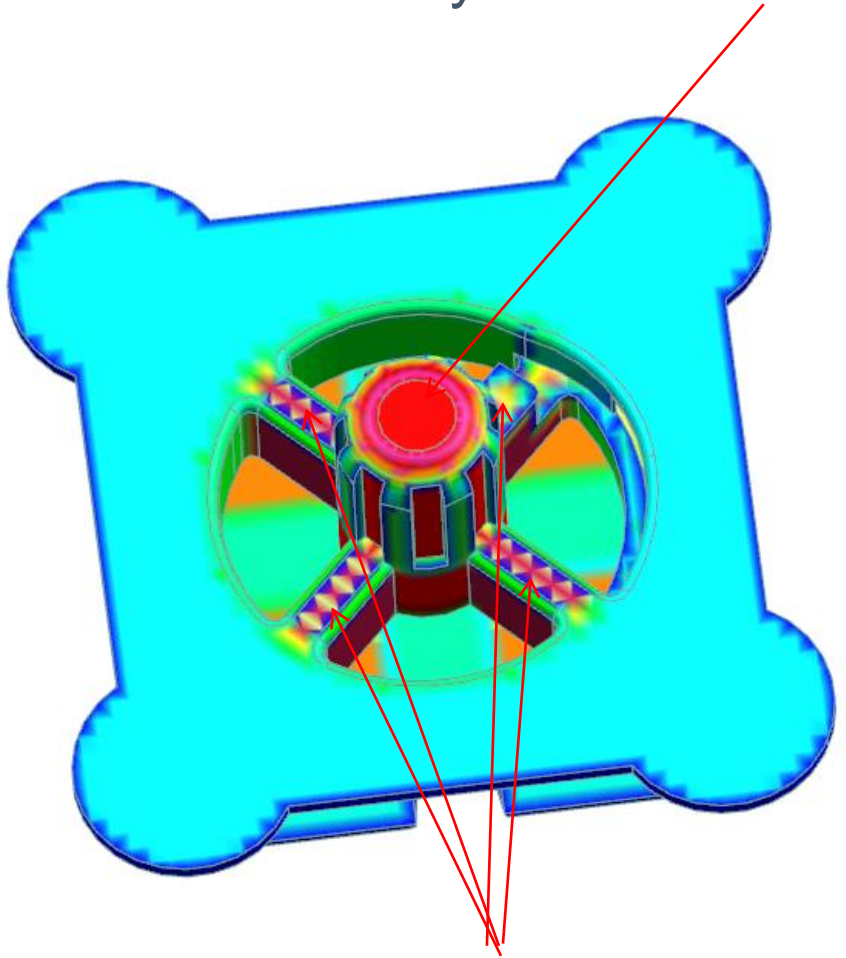
Ejector pins will be under the sliders, we will make earlier return systems to avoid ejection issue

Ejector pins diameter 2MM, this could avoid the ejector marks on the 4 plan surface,

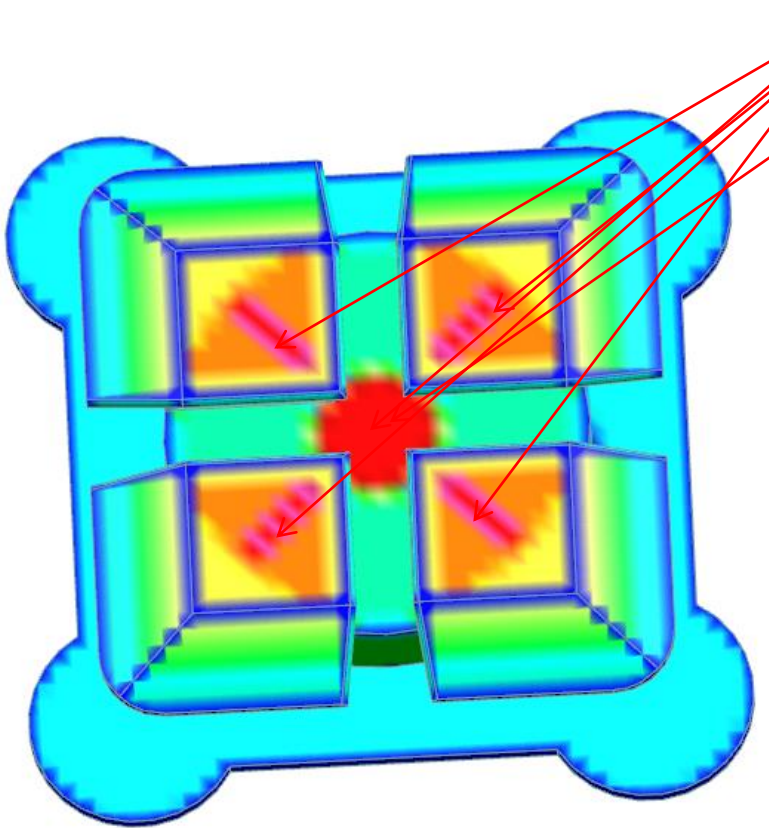
total 4 pcs, please check if this is ok?

Thickness analyze

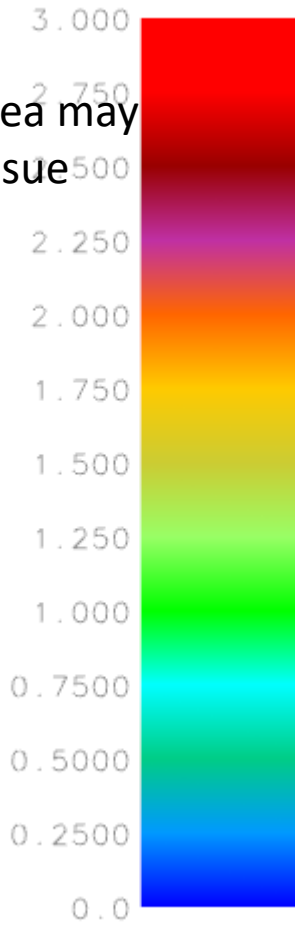
This boss will have sink mark due to unbalance wall thickness



Those ribs are too thicker, may have some sink marks issue



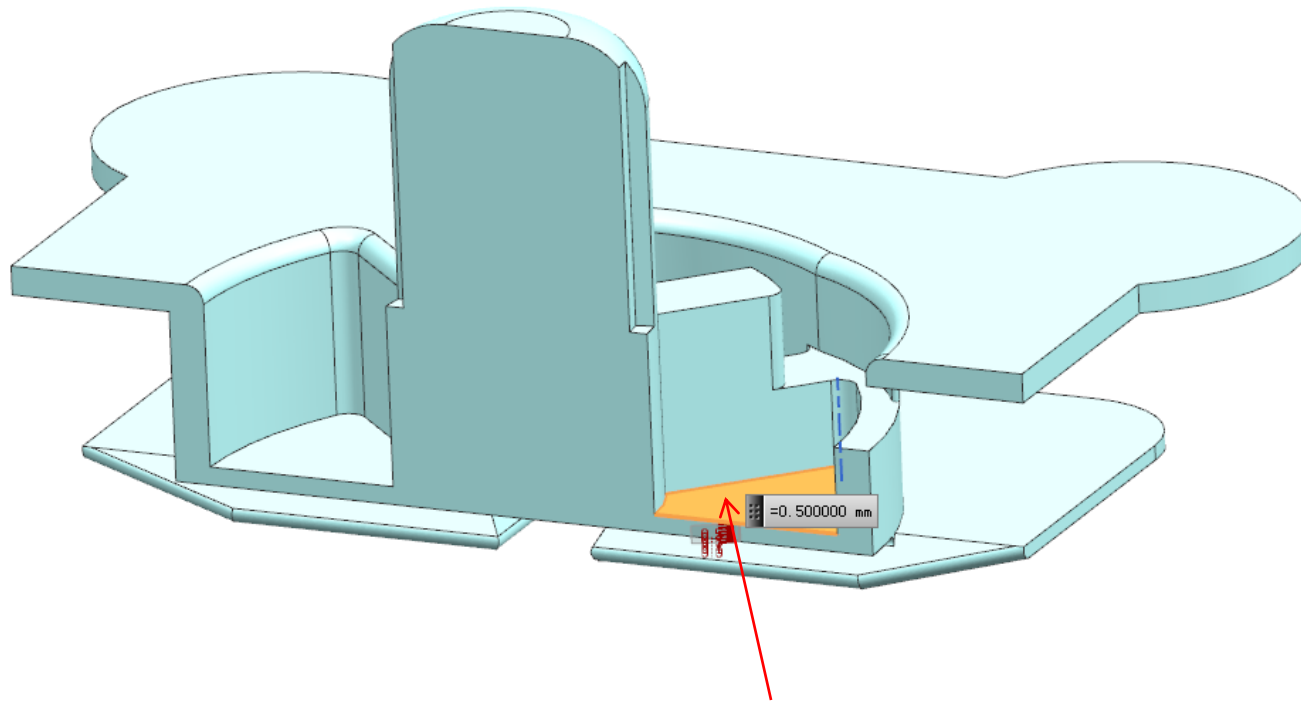
All of those red area may have sink marks issue



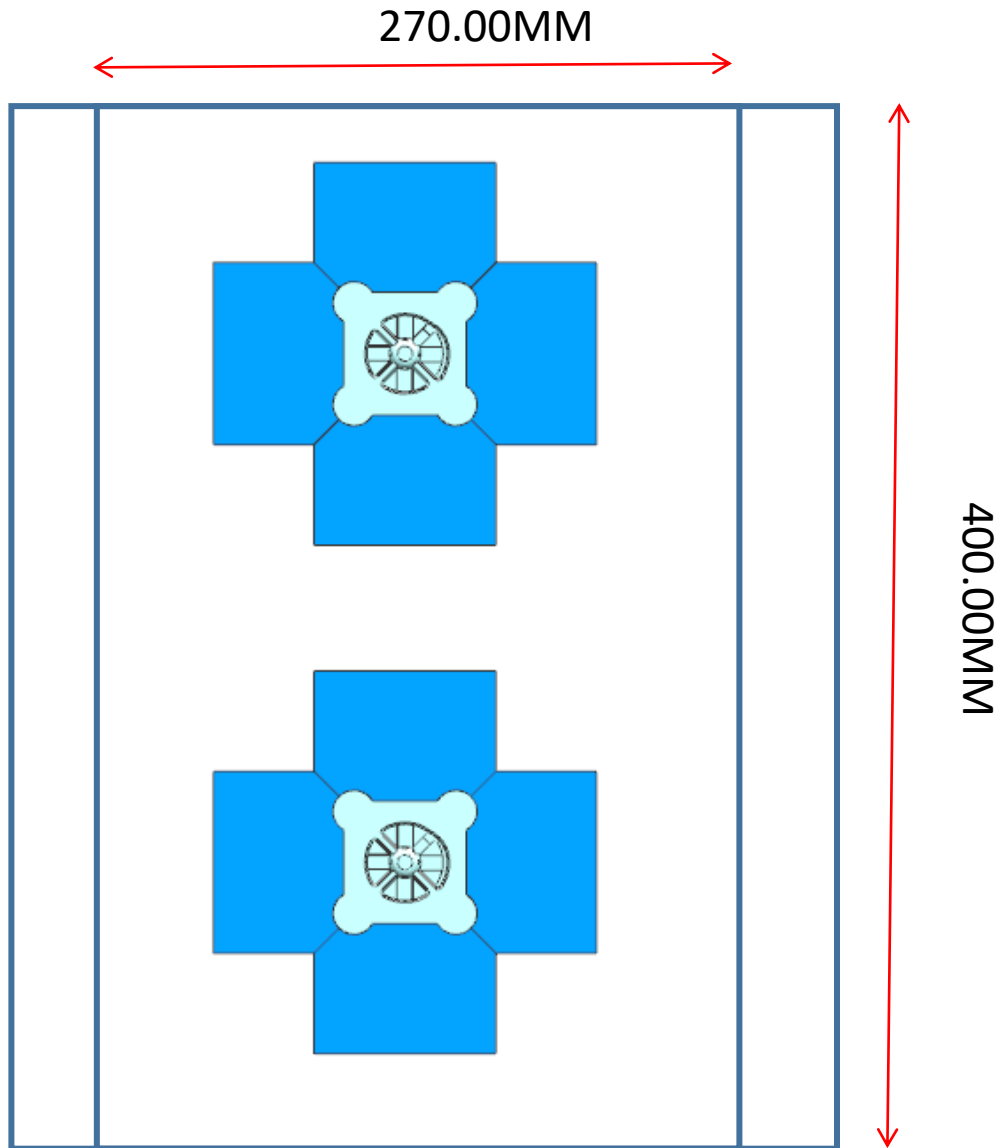
Wall thickest area is 7.4, average wall thickness is 1mm

总体结果
平均厚度: 1.05
最大厚度: 7.40

Thickness analyze



This area today is 0.5mm only, we suggest to add to 1mm, please check and confirm?



The End, thanks for your time