



Golden 24 hours principle

----all the responses should be done within 24 hours!

- **Step.1 订单 Order**
- **Step.2 开模分析 DFMEA**
- **Step.3 模具设计要求 Tooling BOM Form**
- **Step.4 模具 2D 图纸 Tooling 2D Drawing**
- **Step.5 开工通知单 Cutting Tooling Notice**
- **Step.6 生产进度表 Weekly Report**
- **Step.7 模具3D Tooling 3D drawing**
- **Step.8 检测报告 Dimension Report of T1 sample**
- **Step.9 箱麦 Packing Information**
- **Step.10 走模光碟 CD**
- **Step.11 顶出机构测试 3000 cycles testing for tooling ejecting system**
- **Step.12 模具测试手册 Plastic Mould Operation Manual**



Step.1 订单 *Order*

1. 确认订单 *Confirm Order*
2. 出示发票 *Issuer PI*
3. 产品图纸&要求 下达工程 *Provide Engineers with part drawings and special requirements*



Step.2 开模分析 *DFMEA*

DFMEA(Design Failure Mode & Effect Analysis) should be prepared before the 2D tooling design ,which should include P/L, Gate location, Ejector pins and the basic structure of tooling as well as the comments for any parts design defects. This is a good way to save much time and cost for tooling design and fabrication.

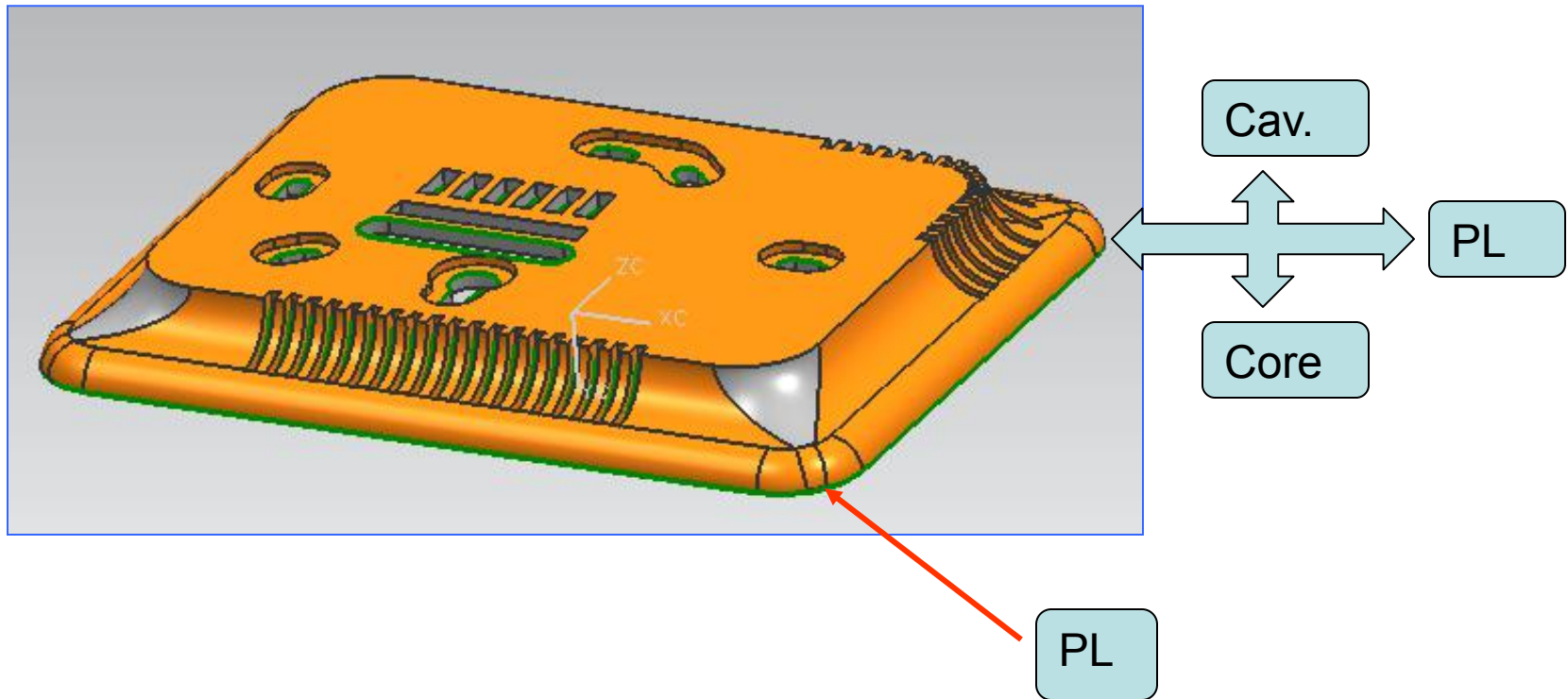


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Client:		Gate type:	Tunnel gate
Model:		NO. of gate(Each part)	
Part name:	960-011010-1_R1+960-011010-2_R1	Hot runner:	
Part No:		Tool type:	
General thickness	1.004	Slider qty(Each part):	2PCS
Plastic material:	ABS	Lifter qty(Each part)	12 PCS
Part weight:		Tool Number:	
Cavities:	1+1	DFM by:	Robbie Gao

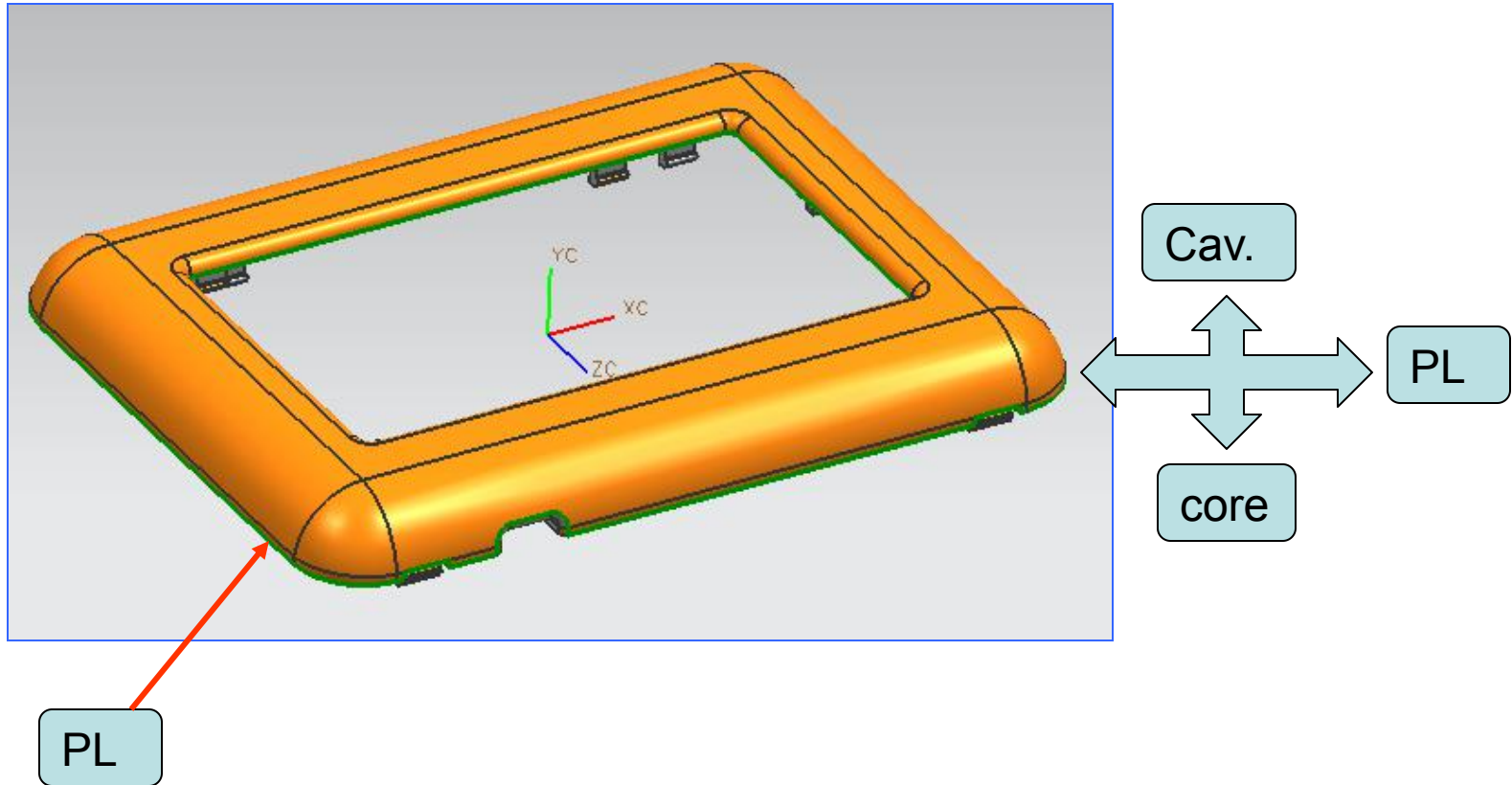


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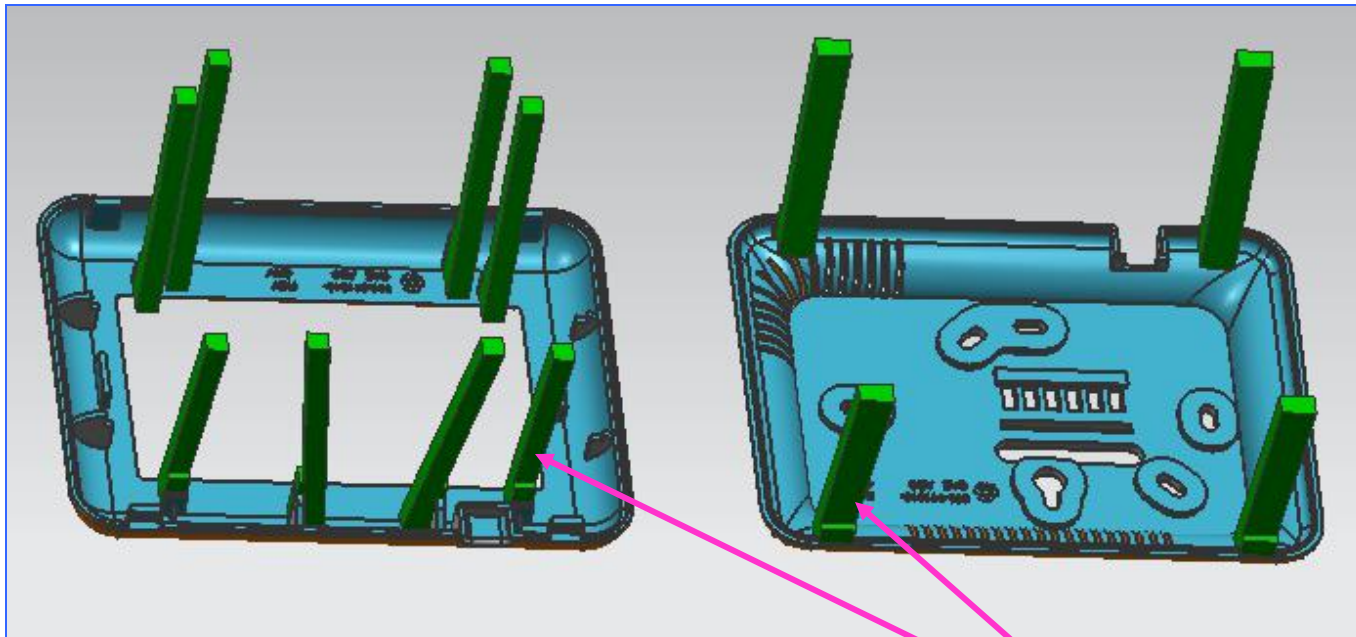


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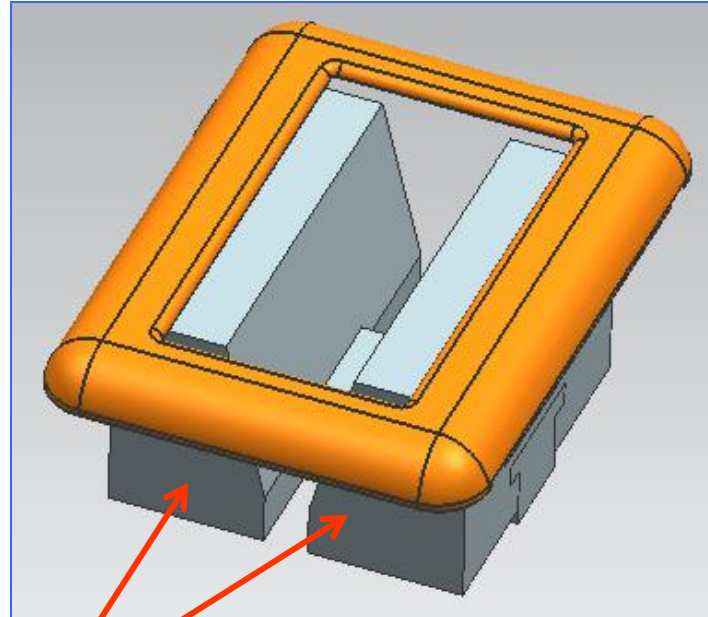


Option-1 for clips: To use 12 pcs lifers for 12 clips. By this way , then it is not good for the tooling life. We prefer to use option-2. How do you think?

Lifter-12pcs



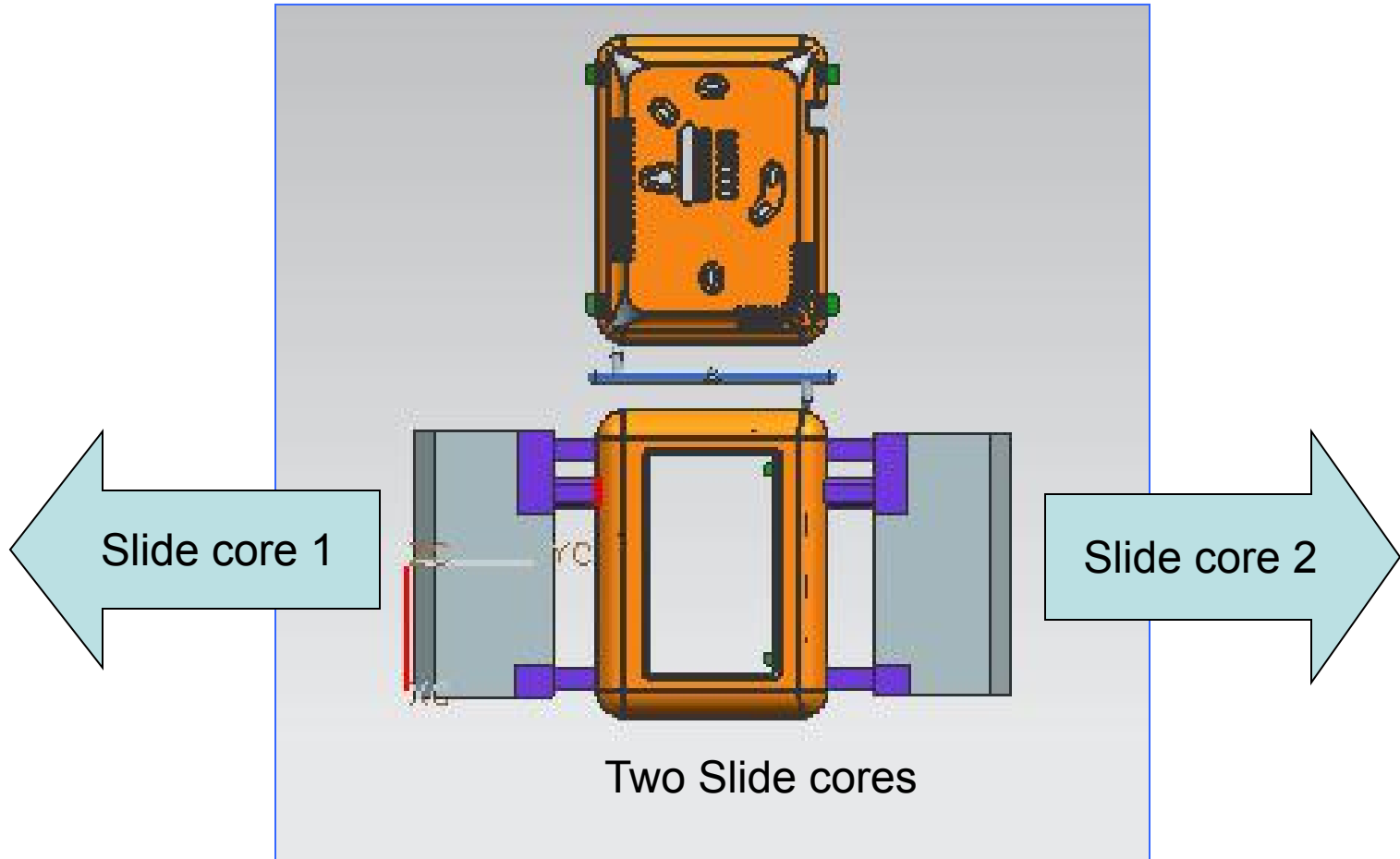
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Option 2: To design two slides core instead of the lifters. How do you think?

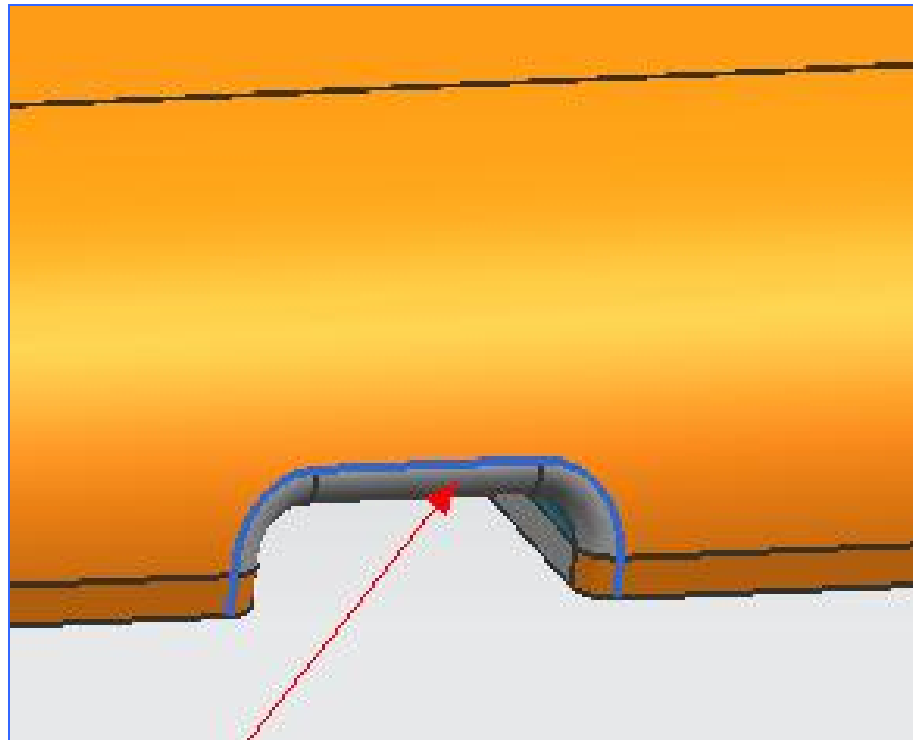


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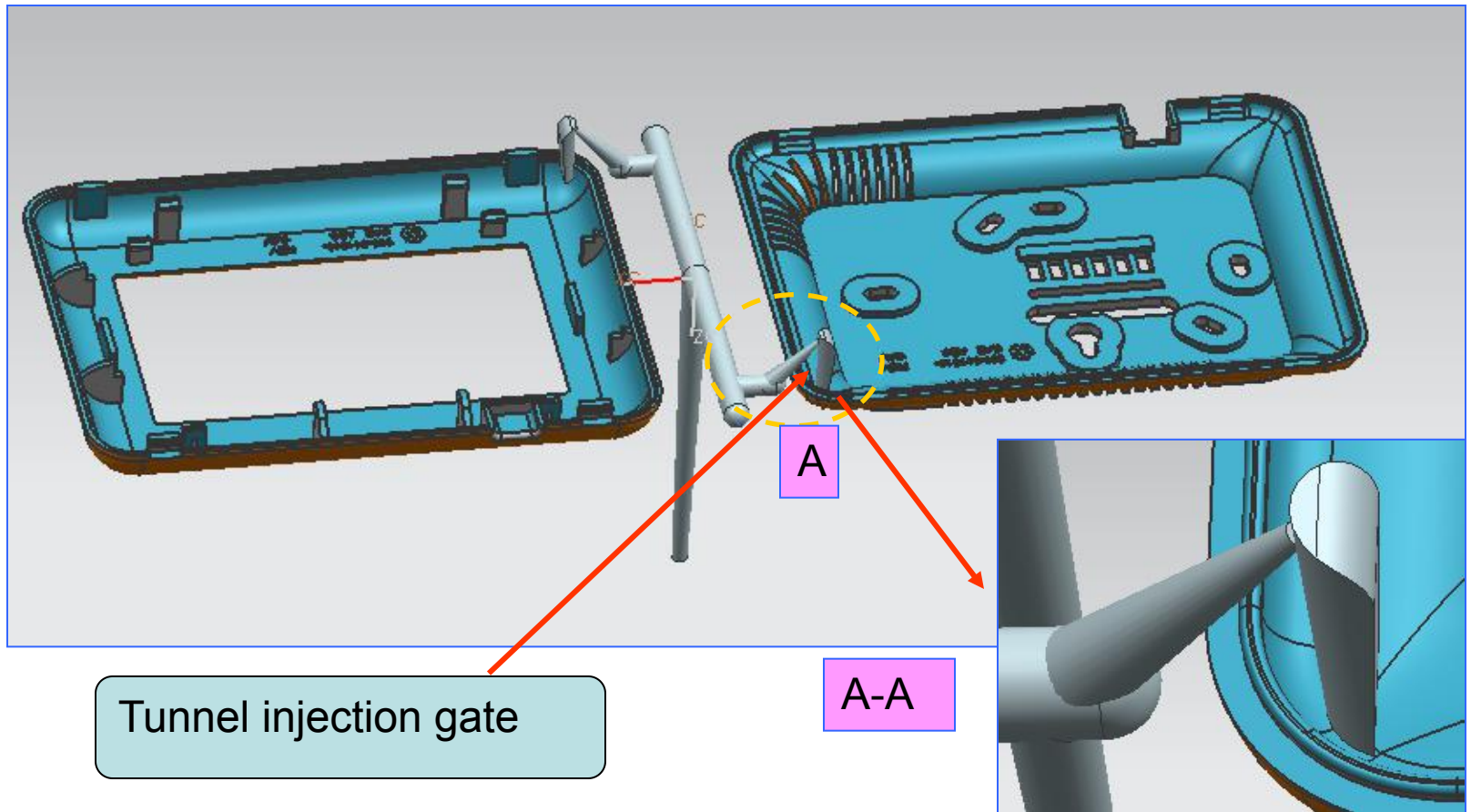
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P/L for slide core, please confirm it.

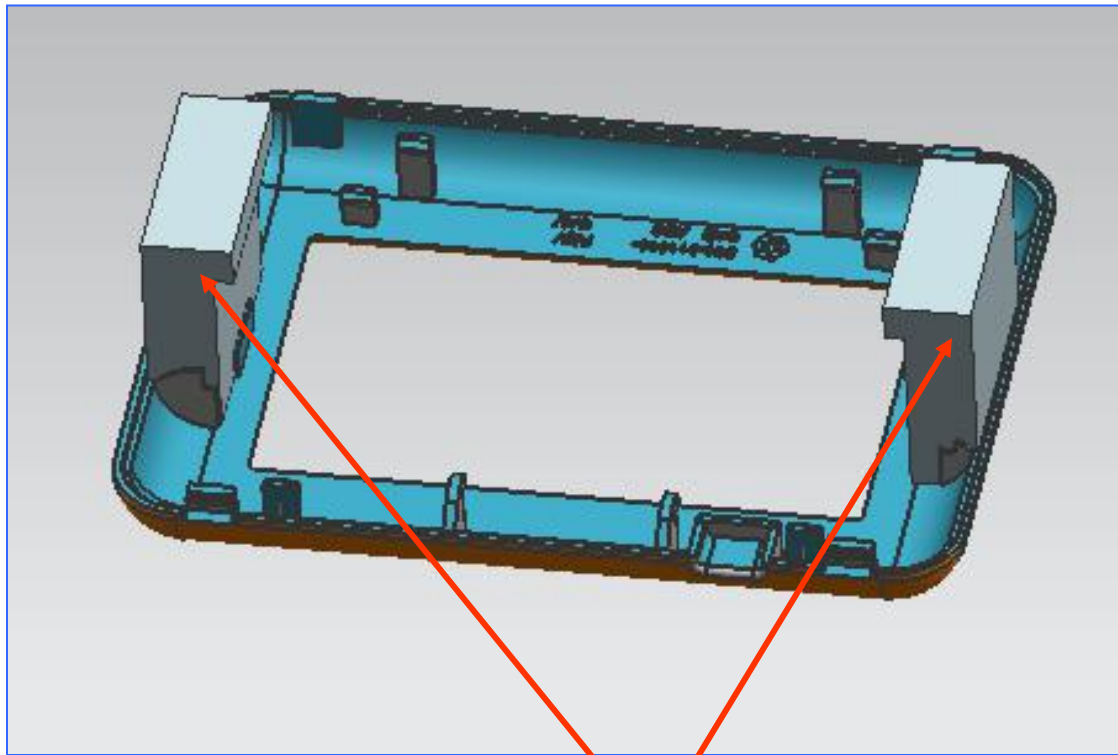


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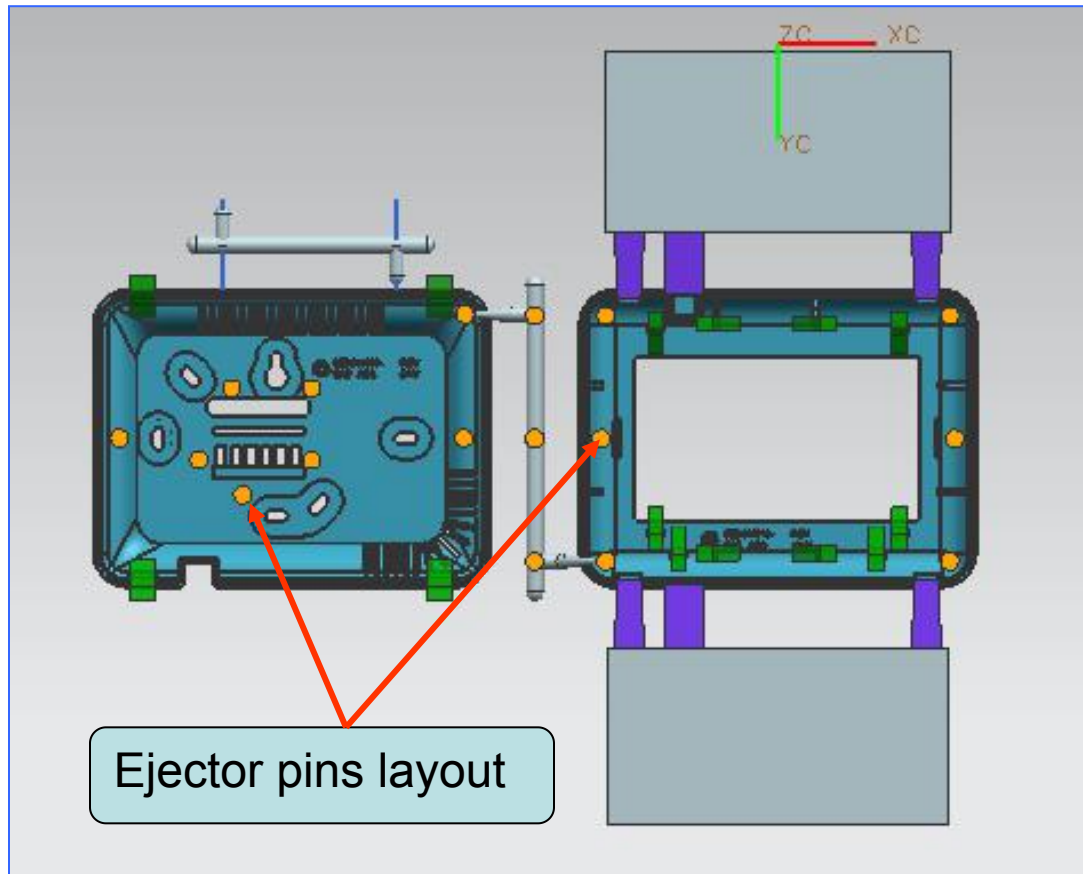
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Core inserts

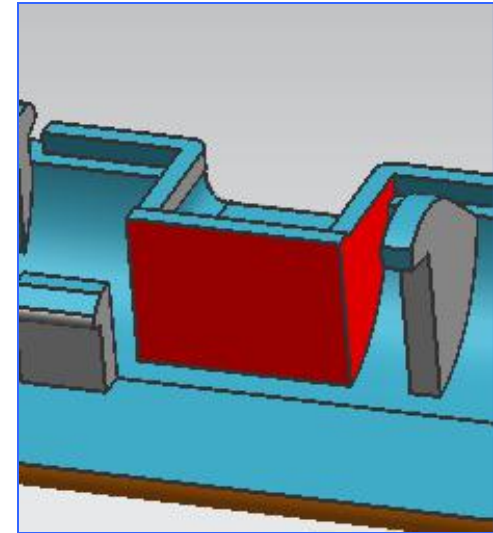
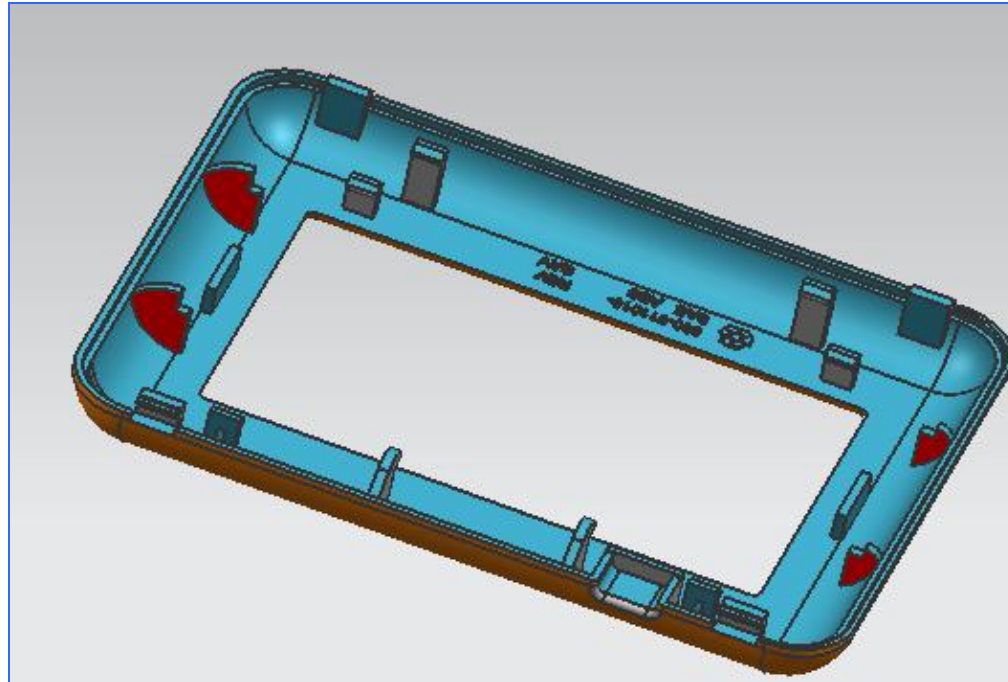


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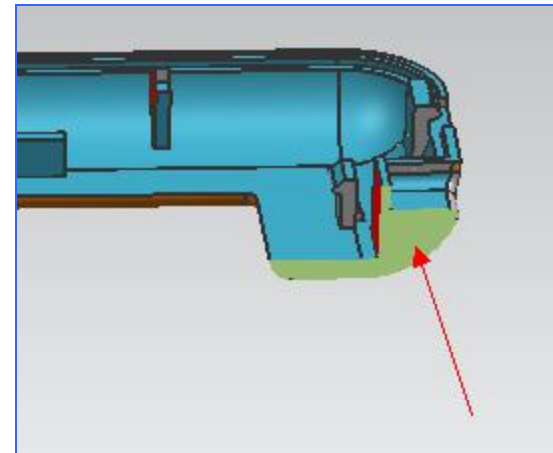
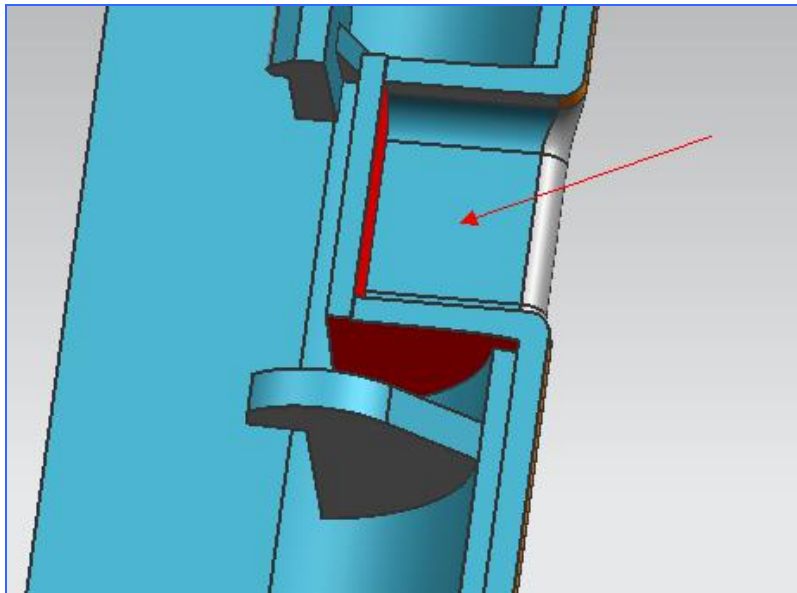
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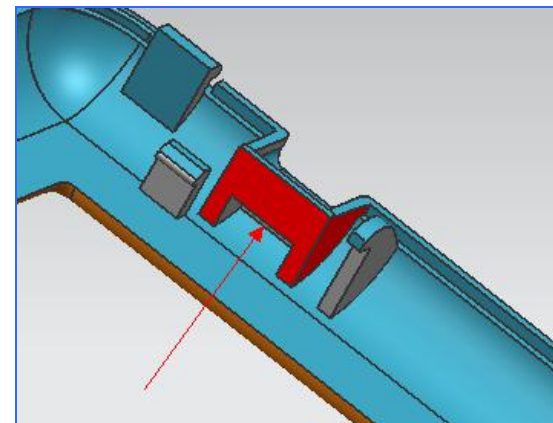
One degree draft angle at least is necessary for the red area. We changed the 3d for your approval.



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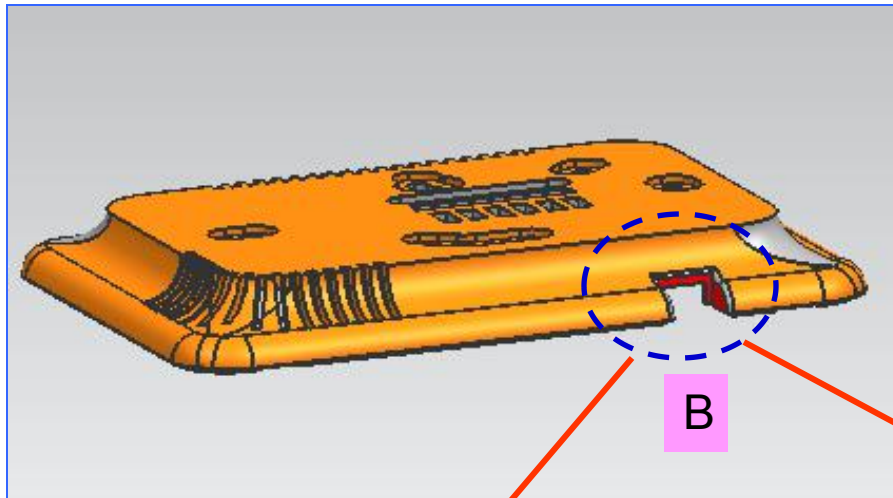


The thick section should cause sink mark. We have changed the 3d for your approval.

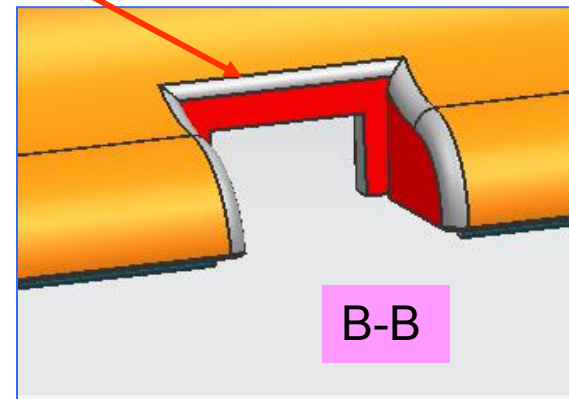
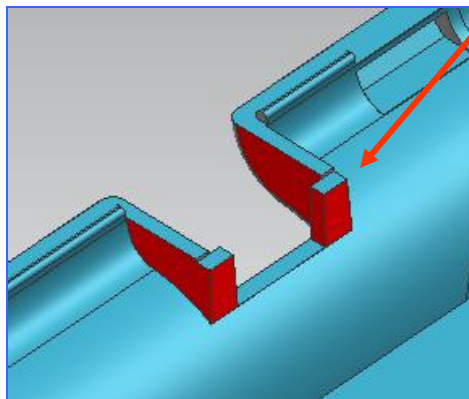




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We have changed the red area by adding 2 degree draft angle. Please confirm it.





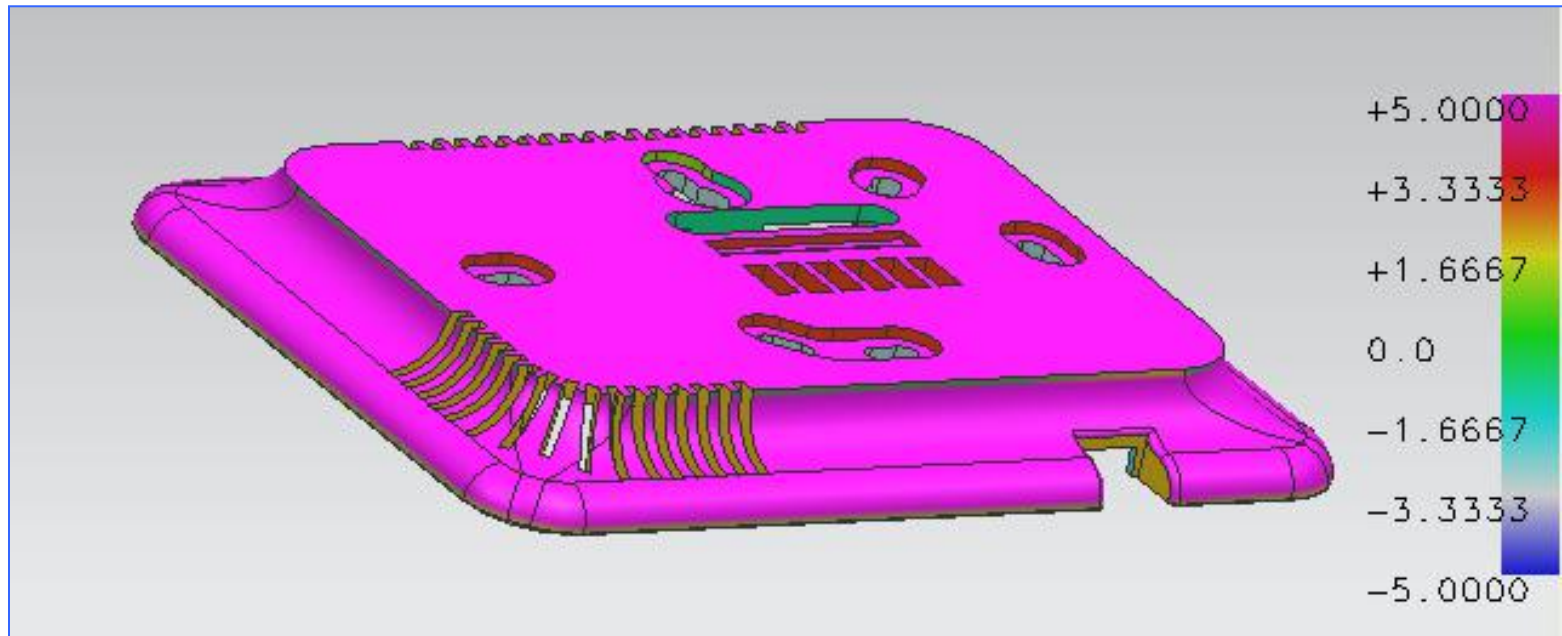
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The thickness is only 0.389mm which should cause short shot. We don't dare to change it by ourselves in order not to impact the fitting function. Please correct this at your side!

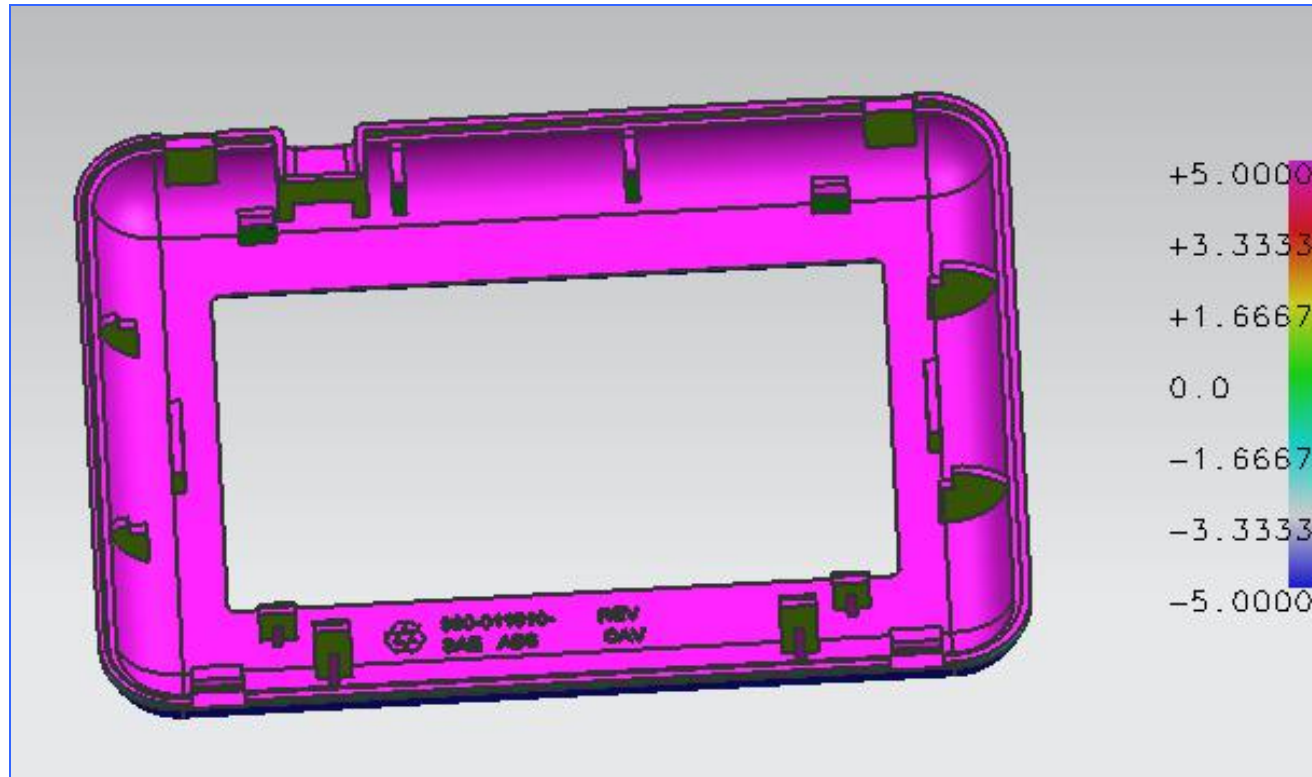


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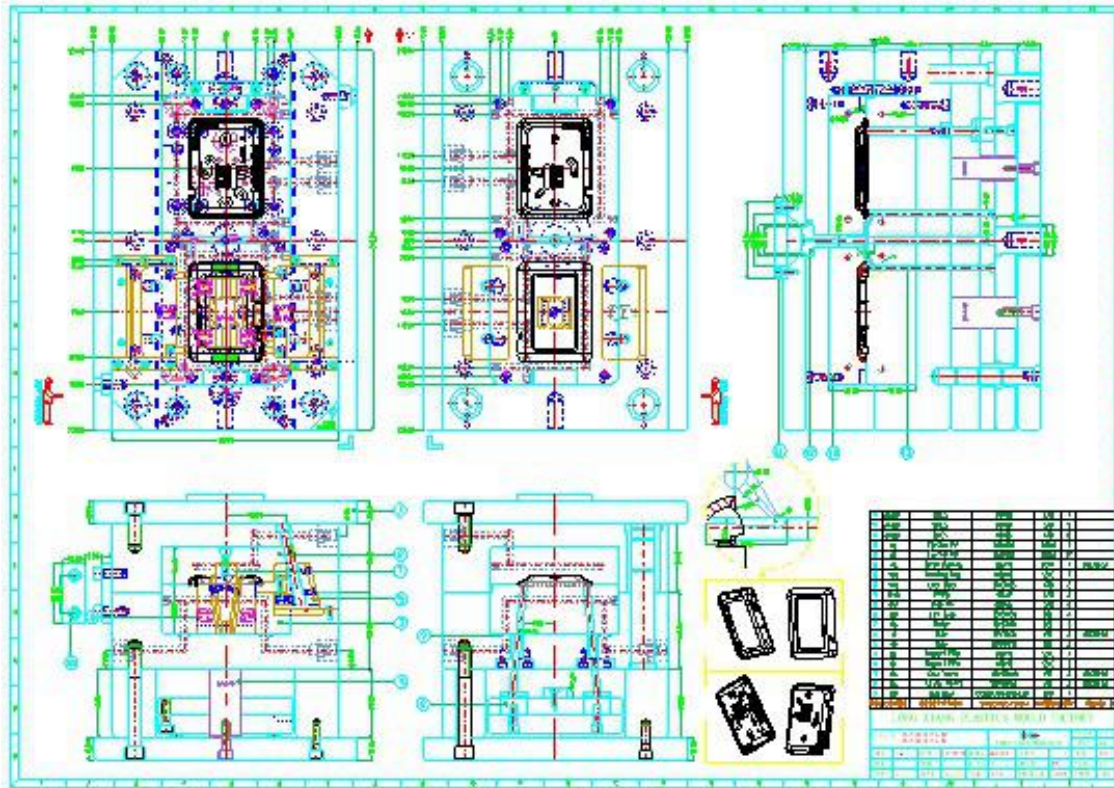
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Step. 4 模具2D 图纸 *Tooling 2D drawing*





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Step.5 开工通知单 *Cutting Tooling Notice*

Cutting Tooling Steel Notice													
模具开工通知单													
Rev. (版本): 1													
P.O. (客户订单号)	Tooling No. (模号)	Resin (塑料)	Color (颜色)	Shrinkage Rate (缩水率)	Tooling core (内模钢材)	Surface of Cav. (前模表面)	Surface of Core (后模表面)	Full Name of 2D Drawing (2D图纸全名)	Full Name of 3D Drawing (3D图纸全名)	Date for 2D Consenting (2D产品图生效日期)	Date for 3D Consenting (3D产品图生效日期)	Date for GA consenting (模具图生效日期)	Inner T1 Date (日期)
CPI-57056	LXG-024	ABS(LG AF312)	white 白色	1.004	H13	喷纹#T11020	#T11020 (slanted sidewalls) SPHS (the rest)	960-011010-X-R_dram.pdf	960-011010-1_R1.STEP 960-011010-1_R1.IGS 960-011010-2_R2.STEP 960-011010-2_R2.IGS	2011.9.8	2011.09.8	2011.9.9	2011.10.20
Remark:													
1. The information above is for tooling fabrication, please carefully check it in order to avoid any mistakes. 以上内容将用于模具制造, 动工前请仔细核对。													
2. The inner T1 date marked is only available for Longxiang's inner system, the T1 date for customers will be extended five days based on our inner T1 date.													
3. We will treat your approval for all of information above in case we don't get your comments within 3 days. 如果3日内未得到您的回复, 我们将视为您对上述信息完全确认。													
									Prepared by (编写):			Candy Pang	
									proofreading (核对):				
									Issued date (动工日期):			2011.09.10	



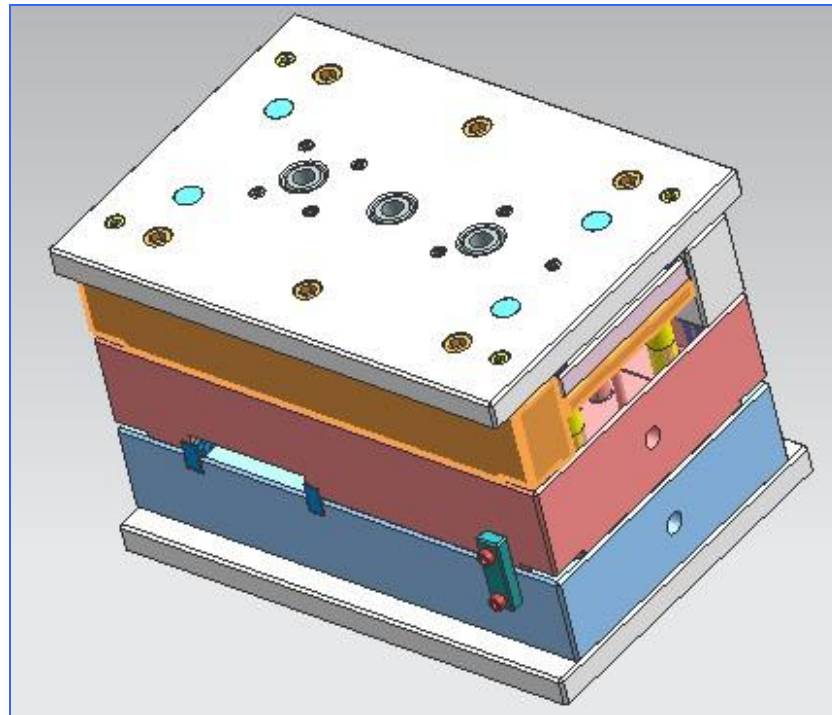
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Step.6 生产进度表 *Weekly Report*

LONG XIANG PLASTICS MOULD FACTORY		MOLD PROJECT SCHEDULE AND REPORT							Process within Schedule	Finished before Schedule	Scheduled Finish Date	Finished after Schedule (Delay)	N/A: non-applicable
Project Name: LYG029		Weeks							Process within Schedule	Finished before Schedule	Scheduled Finish Date	Finished after Schedule (Delay)	N/A: non-applicable
P.O. Date: 1-Sept-11		Weeks							Process within Schedule	Finished before Schedule	Scheduled Finish Date	Finished after Schedule (Delay)	N/A: non-applicable
T.I. Date: 16-Oct-11		Weeks							Process within Schedule	Finished before Schedule	Scheduled Finish Date	Finished after Schedule (Delay)	N/A: non-applicable
Report Date: 18-Sept-11		Weeks							Process within Schedule	Finished before Schedule	Scheduled Finish Date	Finished after Schedule (Delay)	N/A: non-applicable
This is a weekly basis report which will be approved by Top-level each week for your best practice and reference.													
Process	Status	Weeks							Remarks				
		Week 1	Week 2	Week 3	Week 4	Week 5	Week 6	Week 7					
Drawing Approval	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule					
Detailed Mold and 3D Accurate Drawing	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule					
Purchase of Steel	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule					
Purchase of Mold Base	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule					
ERC Programing													
Cavity	Rough Machining	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule					
	Encrude	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule					
	Heat Treatment	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule					
	Pre-casting Machining cavity	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule					
	UIMWC machining	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule					
	Wire-cuting	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule					
Core	Rough Machining	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule					
	Encrude	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule					
	Heat Treatment	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule					
	Pre-casting Machining core	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule					
	UIMWC machining	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule					
	Wire-cuting	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule					
Mold Base Machining	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule						
Ejector System	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule						
Injection System	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule						
Cooling System	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule						
Polishing	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule						
Tring and Mold Assembly	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule						
T1 Trial	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule						
Final Article Test (before Tooling)	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule						
Production Start (Date of requesting client)	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule	On Schedule						



Step.7 模具3D 3D drawing





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Step.8 检测报告 Dimension Report of T1

隆翔工业有限公司 Long Xiang Industrial Limited															
Mould No:	969-011010-1 3L-082			Material:	AHS			Date:	14-Oct-11						
Drawn By:	Long Xiang			Date:	INT			Cavity:	1+2						
Part Name:	LXC024			Drawing No:				Shrinkage:	1.004			Page			
Drawing															
Dimension Inspection				Actual Data											
Dim No	Point	Spec	Tolerance	Sample 1		Sample 2		Sample 3		Sample 4		Sample 5		Inspec	Status
				1	2	1	2	1	2	1	2	1	2		
969-011010-1															
1		5.200	0.005	±0.005	5.199	±0.005	5.201	±0.005	5.200	±0.005					OK
2		5.750	0.005	±0.005	5.751	0.001	5.752	0.002	5.751	0.001					OK
3		2.165	0.005	±0.005	2.166	0.001	2.165	0	2.161	±0.005					OK
4		5.980	0.005	±0.005	5.999	±0.005	5.997	±0.005	5.997	±0.005					OK
5		4.150	0.005	±0.005	4.150	0	4.150	0	4.151	0.001					OK
6		4.600	0.005	±0.005	4.603	0.003	4.602	0.002	4.601	0.001					OK
7		2.650	0.005	±0.005	2.653	0.003	2.653	0.003	2.652	0.002					OK
8		0.543	0.005	±0.005	0.549	0.004	0.548	0.003	0.547	0.002					OK
9		3.070	0.005	±0.005	3.073	0.003	3.072	0.002	3.071	0.001					OK
10		0.450	0.005	±0.005	0.452	0.002	0.452	0.002	0.451	0.001					OK
969-011010-2															
1		5.990	0.005	±0.005	5.997	±0.005	5.998	0	5.997	±0.005					OK
2		5.198	0.005	±0.005	5.196	±0.005	5.196	±0.005	5.197	±0.005					OK
3		0.520	0.005	±0.005	0.521	0.001	0.522	0.002	0.521	0.001					OK
4		0.160	0.005	±0.005	0.160	±0.005	0.160	±0.005	0.160	±0.005					OK
5		0.128	0.005	±0.005	0.129	0.001	0.129	0.001	0.128	0					OK
6		0.197	0.005	±0.005	0.198	0.001	0.198	0.001	0.198	0.001					OK
7		0.100	0.005	±0.005	0.099	±0.005	0.099	±0.005	0.099	±0.005					OK
8		0.520	0.005	±0.005	0.520	0	0.520	0	0.520	0					OK
9		0.320	0.005	±0.005	0.322	0.002	0.321	0.001	0.322	0.002					OK




Note: (1) The measuring points refer to the attached drawing.
 IF-Block Gauge D-Depth Verifier V-Verrier R-Radius Gauge
 AG-Angle Gauge CMM-Coordinate Measure Machine TMM-Thickness Measure Machine

Inspected by:	Es bin	Checked by:	Joe Irang	Approved by:	Es ger
Date:	14-Oct-11	Date:	14-Oct-11	Date:	14-Oct-11



Step.9 箱麦 *Packing Information*



Part name: 960-011010-1_R1+
960-011010-2_R1

Cavity number: 1+1

Mold size: 350*500*351

Mold weight: 370KG

Longxiang tooling: LXG-024

<i>Packing informations</i>							
PO NO.	part name	mould weight(KG)	Box weight(KG)	Total weight(KG)	Max mould size(mm)	Box inner size(mm)	Box outer size(mm)
PO 57058	LXG024	370kg	30KG	400KG	350 X 500 X 351	380X 380 X 530	420X 420 X 640



Step.10 走模光碟 CD

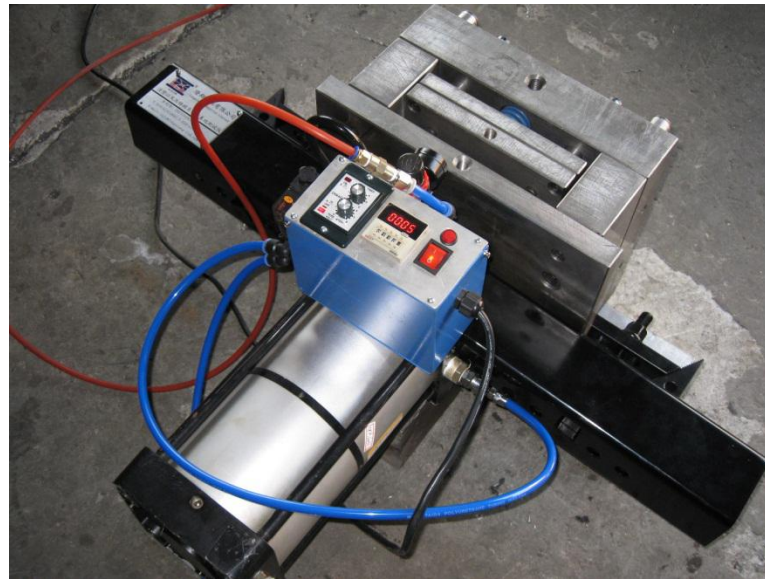
- *Contents:*

1. Tooling 2D
2. Tooling 3D
3. 检查报告 *Dimension Report*
4. 照片 *Photograph*
5. 录像 *Video*



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Step.11 顶出机构测试 3000 cycles testing for tooling ejecting system



It is easy to have problems for tooling ejecting system during mass production . So we developed our patent fixture to test it for 3000 cycles before shipment. Patent No.: 201020282768.X



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Step.12 模具操作手册

Plastic Mould Operation Manual

Services after sales:

As an experienced player in the line, we strive for customer satisfactions. So we ensure you that we will follow up every product we sell.

We provide necessary technology and technical supports for all our products. We have decades of technicians available to assist in the assembly or the relevant support services whenever and wherever you need.

We make compatible parts available whenever and wherever you want. We do as we say, for we have established mature logistic and inventory system to supply what you need.

We are obliged to provide necessary maintenance, for which we have enough technicians in service.

And last but not least, our responsive and helpful customer service force is available by below means.

Plastic Mould Operation Manual
塑料注塑模具操作说明书

Contact Person: Rocky Lee
E-mail: rockylee@longxiang-ltd.com
Mobile: 13178879403

Longxiang Industrial Limited
www.longxiang-ltd.com



LONGXIANG INDUSTRIAL LIMITED

The Introduction of Longxiang's Owner:

Mr. Rocky Lee

Born in 1975

Senior Engineer

MBA from South China University of Technology

Have been in manufacturing field for about 18 years



YOUR REAL PARTNERS IN CHINA!