

ABIS MOLD TECHNOLOGY (HK) CO., LTD



Welcome to visit ABIS



- Founded in 1996 ,located in Shenzhen China, Over **23 years experience** in mold industry.
- Certification with **TS/16949, ISO9001/ ISO14001...**
- We have about **100 employees** with professional designer team & engineers team to offer service and solutions from design to finish product.
- One molding room Press machine range from **80T to 1600T.**
- 300+ molds** capacity each year, and 95% exported (mainly to Europe and North America).
- We are focused on plastic injection mold, but also provide **stamping/ punching, blowing molds, die casting molds, as well as the secondary process.**



Equipment list

Name of machine	BRAND	QTY	PLACE OF ORIGIN
CNC	DMG	1	Germany
CNC	YCM-FP66A	2	Taiwan
EDM AQ35L	SODICK	3	Japan
EDM	CHARMILLES-350	2	Swiss
EDM	TAIWAN NUMERIC CONTROL	6	Taiwan
Digital display milling machine	YINGSHUN	8	Taiwan
Digital display grinding machine	SUHRE	8	Taiwan
Injection molding machine	JIANDE	8	China
Injection molding machine	HAITIAN	11	China
Injection molding machine	FANUC	1	Japan
computer	HAIER SAUSUNG	15	China
JD12-300 digital display projection apparatus	PROJECTOR	1	China
3 Dimension Coordinate	DABAO	1	Taiwan
Wire cutting machine	QIGNYUAN	4	Shanghai
Wire EDM AQ327L	SODICK	2	Japan









Working Process with QC control



Customer RFQ	→	2D or 3D drawings, or the samples, even ideas.
Quotation	→	Issue quotation within 2 days (Preliminary DFM if necessary.)
PO	→	Got the PO with release the final drawing.
DFM	→	DFM report within 2 days, Proactive comments like draft analysis, parting line, Undercut, Slider/Lifter structure, Cooling, Venting, Gateing, Ejection, Cavity/lifter sticking, short shot possibility, Thin steel conditions, so on.
3D Mold design	→	3D mold design with all components details.
2D Mold design with Mould design control	→	Submit 2D mold design assembly drawing with BoM within 3 days, After customer write approved. The designer and project manager, director will together to review the mold design to confirm all details are the best solution.
Order steel with incoming quality control	→	According 2D drawing BOM to purchas steels. 3-5 days for cavity/ Core steel and components, 2 weeks for mold base and Hot runner, after them arrived, QC team will check all the dimension and hardness from outsource.



Mould Design Control



Incoming quality control



▼		
Mold building with in process quality control	→	Rough machining, Heat Treatment, final CNC, Wire Cut, EDM, Polish, Mold Fitting, Assembly, Will update project schedule every friday with machining photos. After each machining step, QC will check the features and dimensions.
▼		
T 1 with Final quality control	→	Normally about 4 weeks from 3D mold design approved to T1, also welcome on-site mold trial. Once we get the samples we will check molding defect, dimension problem, function /assembly issue.
▼		
T1 reports	→	Provide 10 shots parts for free with mold test video, mold trial report, sample dimensions and sampling parameter.
▼		
T2 or T2+	→	Fix customer's T1 comments and mold trial report, then have mold test.
▼		
Mold Approval with Mould Pre-Shipment Final Inspection	→	Make sure samples approved, and mold movement smoothly. We will check it one by one according to the mold checklist.
▼		
mold package with shipping	→	Wooden case with three-ply fumigation, electrode, spare parts, steel certification report, heat treatment report, and CD.
▼		
After-sales services	→	Make sure mold runs smoothly at your side.



In process quality control



Final quality control

Mold Checklist

Moldbase			
Yes	No	N/A	
			1. Moldbase material: S50C
			2. Hardness:
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	3. Is locating ring in right size?
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	4. Are nozzle radius and orifice diameter
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	3. Are the pry-bar slots shown?
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	4. Does the tool have guided ejection?
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	5. Are support pillars shown and adequate?
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	6. Are the K.O. holes in the proper location?
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	7. Are the water line holes recessed?
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	8. Does the mold need insulator sheets?
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	9. If there are hydraulic cylinders are they

Mould Pre-Shipment Final Inspection



Dimension Inspection Report

Customer	SMP	Mold Trial#	T1	Unit	Metric	Picture 
Project #	Phase 2	Trial date	2014.12.29	Inspection date	2015.01.08	
Part Name	BS76_SCALP without TS_RH	Mold number	ABIS2014128	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), Micrometer (MM), Projector (PJ), Pingauge (PG), Radius gauge (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	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: _____

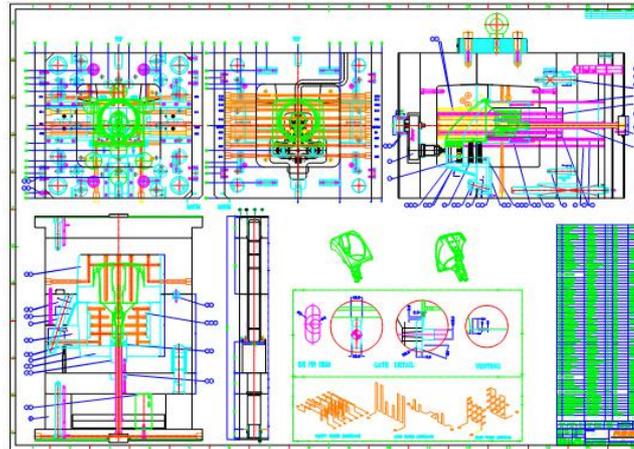
Result:

Pass

Fail

Special Acceptance





Engineering:

- Pro/ENGINEER(3D Modeling)
- Solid works(3D Modeling)
- AutoCAD(2D Modeling)
- Mold flow Mold Advisor
- Master CAM (CNC Programming)
- CNC Machining Centers
- CNC EDM's (Electro-Discharge Machining)
- Wire-Cut Machines

Mold standards

- Mold Steel: ASSAB, DAIDO, FINKL, AUBERT & DUVAL, GS, LKM;
- Mold Base: DME, HASCO, FUTABA, LKM;
- Hot Runner: MOLD MASTER, Master TIP, HUSKY, HASCO, DME, YUDO, INCOE, THERMOPLAY;
- Standard Parts: DME, HASCO, NEAREST ANSI STANDARD, NEAREST DIN STANDARD, LKM;
- Texture: Mold-tech, Yick Sang,
- Polish: SPI standard



Small Precision Plastic Mold



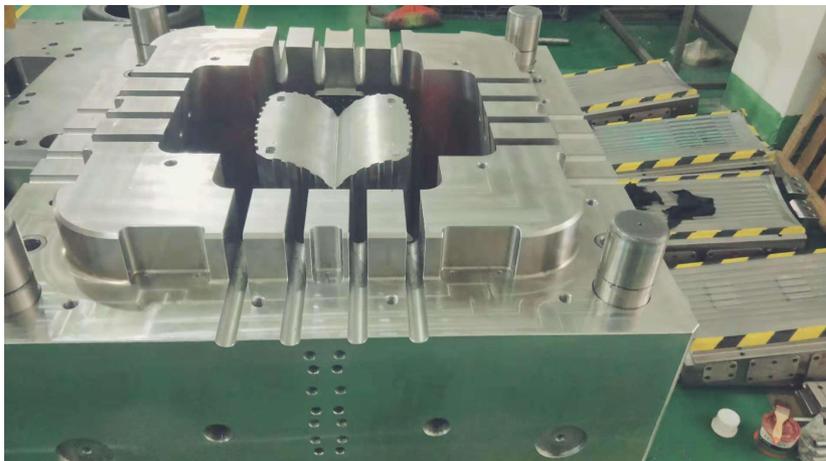
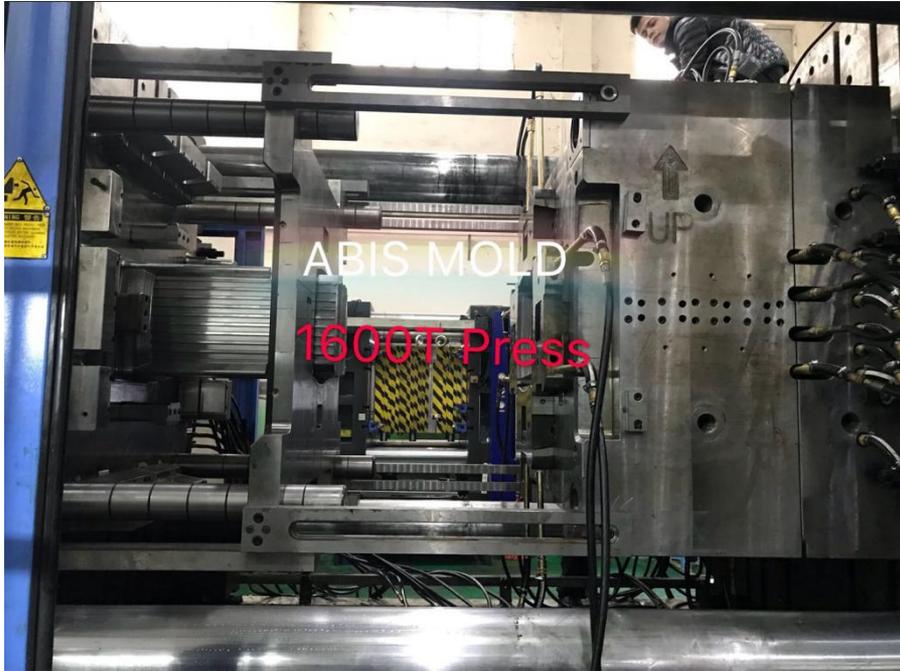
Medium & Big Plastic Mold



Molded parts

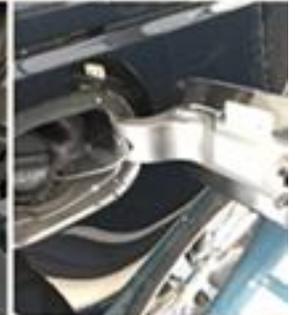
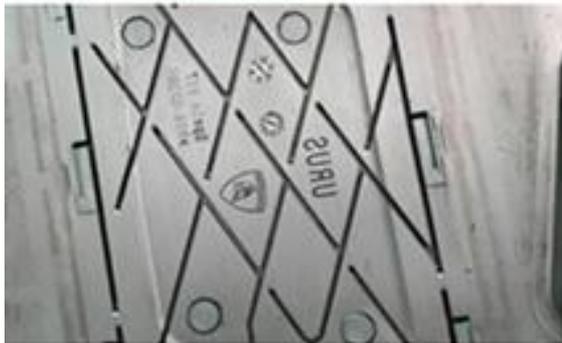


Big Plastic Mold



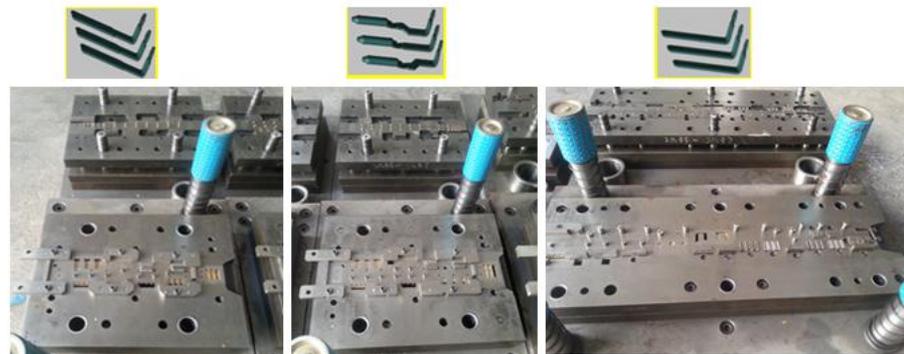
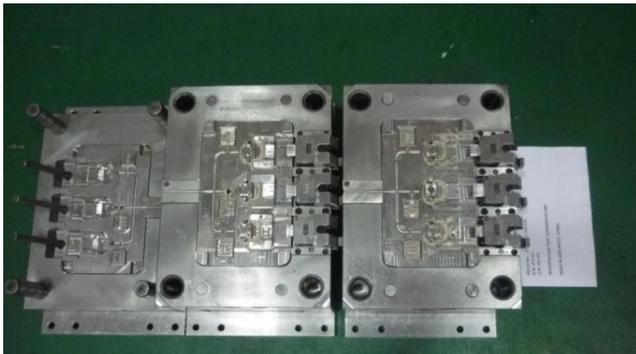


Automotive Parts & Molds
www.abismould.com





Inserting mold





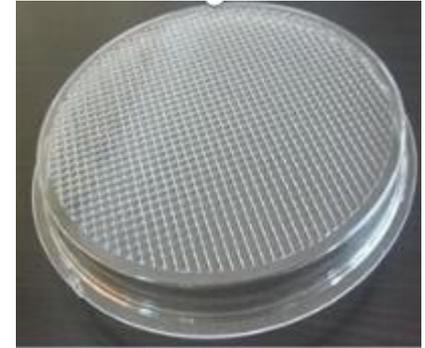
MOULD NAME: SEMAFORO_LENTE

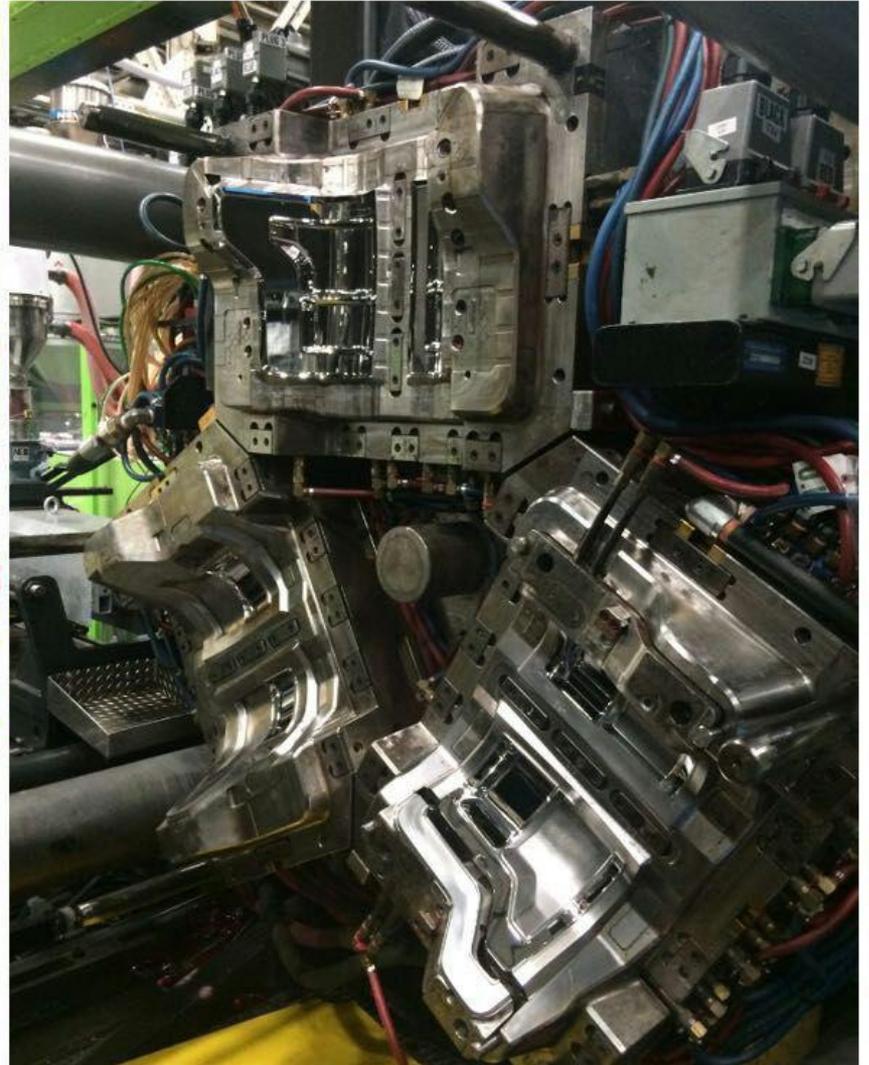
SIZE: 590X540X590 MM

N.W: 483 KG

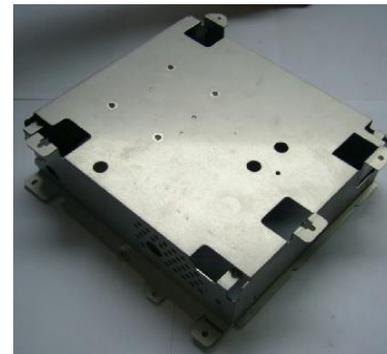
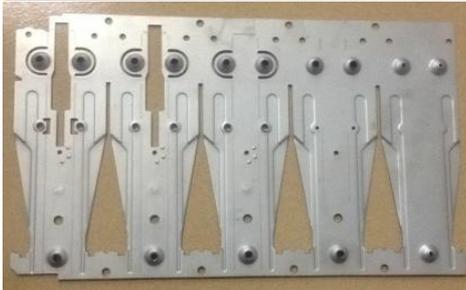
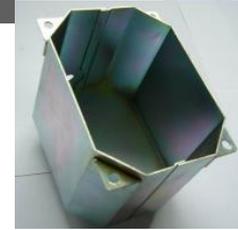
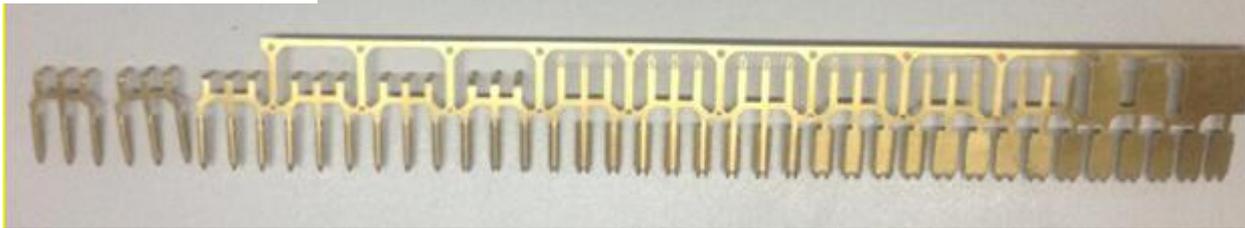
G.W: 505 KG

MADE IN ABISMOLD, CHINA





Metal Stamping





Die Casting Projects





**Wooden case with
three-ply free fumigation,
electrode, spare parts,
steel certification report,
heat treatment report,
and CD.**



河源龙记金属制品有限公司
HEYUAN LUNG KEE METAL PRODUCTS CO., LTD.

(A member of Lung Kee Group 龙记集团附属公司)

客户名称 Name of Customer : ABIS MOLD TECHNOLOGY (HK) CO., LTD LM213K741
证书号码 REF.NO : 0A70-98-41201
日期 DATE : 15/08/2014
模号 REF.NO : ABIS2014092

材质证明书
CERTIFICATION OF MATERIAL

兹证明以下所有材料已经我司之品管部检查及认可, 详查如下:
THIS IS TO CERTIFY THAT THE FOLLOWING MATERIAL(S) HAVE BEEN CHECKED AND APPROVED
BY OUR QUALITY CONTROL DEPARTMENT AND THE SPECIFICATIONS ARE STATED AS BELOW:

序号 No.	产品类型 Product Type	材料名称 Steel Grade	硬度 HARDNESS	比较标准 Comparable Standard	尺寸 Dimensions (mm)	产品编号 Product LKM_ID
1	锣磨	H13	Annealed to HB 225 (max)	AISI H11	210.5*160.5*45.5	DERKZA01
2	锣磨	H13	Annealed to HB 225 (max)	AISI H11	210.5*160.5*48	DERKZA02

材料名称 Steel Grade	合金成分 (只供参考用, %) Chemical Contents (For Reference Only, %)					
	C	Cr	Mn	Mo	Si	V
H13 (cavity)	0.392	≤5.1	0.39	1.25	0.98	1.0
H13 (core)	0.38	≤4.9	0.36	1.1	0.95	0.96

本公司已荣获 ISO9001 品质证书
Accredited With ISO9001 Quality
Management System Certificate.



QC DEPARTMENT
FC-15-8-14

地址: 中国广东省河源市高埔工业区
Address: Gaopu Industrial Zone, Heyuan, Guangdong Province, China
Tel: (86) 0762-3210 502 Fax: (86) 0762-3210 501 Web: http://www.lkm.com.cn



热处理质量报告
Heat Treatment Quality Report

报告编号 Report No.	PD4419016239870041				日期 Date	2014-9-23				
客户名称 Customer Name	ABIS MOLD TECHNOLOGY (HK) CO., LTD				工作单号 Job Order No.	V450-831330				
材料 Material	来料状态 Delivery Condition		数量 Quantity	重量 Total Weight	技术要求 Technical Requirements				硬度 Required Hardness	变形尺寸 Allowed Distortion
	退火 Annealed	预硬 (注明硬度) Hardened			淬火/回火 Hardening	退火 Annealing	氮化 Nitriding	其他 Other		
H13			2PCS	14.8KG	✓				HRC48-52°	
预热温度及时间 Preheating	淬硬温度及时间 Hardening		第一次回火 1st Tempering	第二次回火 2nd Tempering	第三次回火 3rd Tempering		其他工艺 Other H. T. Processes			
650°C/850°C	1030°C		570°C	560°C						
热处理检查结果 Result of the heat treatment	材料 Material	规格 Dimension	数量 Qty	重量 Total Weight	硬度 Hardness	变形 Distortion	备注 Remarks			
	H13	190.5X150.5X35.5	1	6.7kg	48~52HRC					
	H13	190.5X150.5X41	1	8.1kg	48~52HRC					

检验/QC: 周时

审核/CHIEF: 周时



FC-14-9-23





Frankfurt Euromold show(Germany) & Orlando NPE show(USA) & South Africa Plastic Show







Our final aim: ABIS Building!



THANKS!



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