

Our commitment to servicing our customers with quality product at competitive price and on-time delivery is backed by our continued investment in our equipment. Our employees and in our systems . ABIS is a full service molding that a 12 000 square foot facility housing our molding department in-housing mold making , quality control. Warehousing secondary operations and offices , If we find a client's product concept would be too costly to manufacture . We will assist the customer in designing parts that not only can be manufacture but one that can be made cost-effectively from prototype to production. With our extensive experience we are confident .We have the solution to your next injection molding application.





Product Description

Part Name	PET water bottle and oil bottle blow mould
Description	Household Appliance
Country of Original	ShenZhen, China (Mainland)
Brand Name	ABIS
Lead Time	30-45 Days

Payment Terms

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

General Information

Item#	Item	Description
1	Product Name	OEM customized plastic injection blow mold manufacture
2	Mold base	LKM,HASCO,DME
3	Runner system	cold runner/hot runner
4	Mold cavity	

		single or Multiple cavity
5	Mould material	45#/50#/P20/718/2738/NAK80/S136
6	Product Material	ABS,PP,PC ,PA6,PA66, TPU,POM ,PBT,PVC,HIPS,PM A,TPE,PC/ABS,TPV,TPO,TPR,EVA,HDPE.
7	Mould steel	45#,P20,2738,2344,2316,718,S136,H13 et
8	Design software	UG,PROE,CAD,SOLIDWORK
9	Shaping Mode	Blowing Mould
10	Mold life	500-1000 thousand times
11	Lead time	30-45Days
12	Transportation	By sea, by air or by land as you request
13	Package	According to clients requirement
14	Surface treatment	polishing,texture or as per Customized request

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
JD 12-300digital display projection apparatus	PROJECTOR	1	China

Dimension Report and Sampling Parameter

 ABIS Tooling & Molding		TEL: +86-755-89984896 EXT:821 • FAX: +86-755-28960682 • Building B, Ying-Ke-Li Industrial Area, Long-Gang District, Shenzhen City, Guang-Dong Province, China P.C: 518116											
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	B976_SCALP without TS_RH		Mold number	ABIS 2014128		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), Pin gauge (PG), Rad (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	Remark
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			

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
模腔数量 N° Cavity		塑胶原料 Raw Material		颜色 Color
产品总重量 Gross Wt(g)		机台型号 Press Type		试模数量(啤数) Shot Qty
试模日期 Test Date		上机时间 Beginning Time		完成时间 Finish Time
				试模次数 Test times
				项目负责人 Project Manager
				设计工程师 Design Engineer
				审核 Review ed /日期 Date

***试模前的准备:** 试模单、产品图纸、物料表、卡尺、模温计、注温机、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	喷嘴温度 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 Slide Temp. Setup		
		二段 2nd Stage			射胶速率一段 Injection Speed 1		
		三段 3rd Stage			射胶速率二段 Injection Speed 2		
	储料压力 Charge Pressure				原料干燥 Raw Material	射胶速率三段 Injection Speed 3	
背压 Back Pressure			射胶速率四段 Injection Speed 4				
			保压速率一 1st Holding Speed				
位置 Position(mm)	射胶位置 1st Inj. End Position			速度或速率 Percent of Speed(mm/s) or Flow Rate(g/s)	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	
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	☐ 结合线 Weld L
☐ 粘后模 Sticking in Core	☐ 顶出不顺 Uneven Eject	☐ 顶台 Ejector Marks	☐ 喷射痕 Jetting	☐ 黑点 Dark Spot
☐ 水印 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:

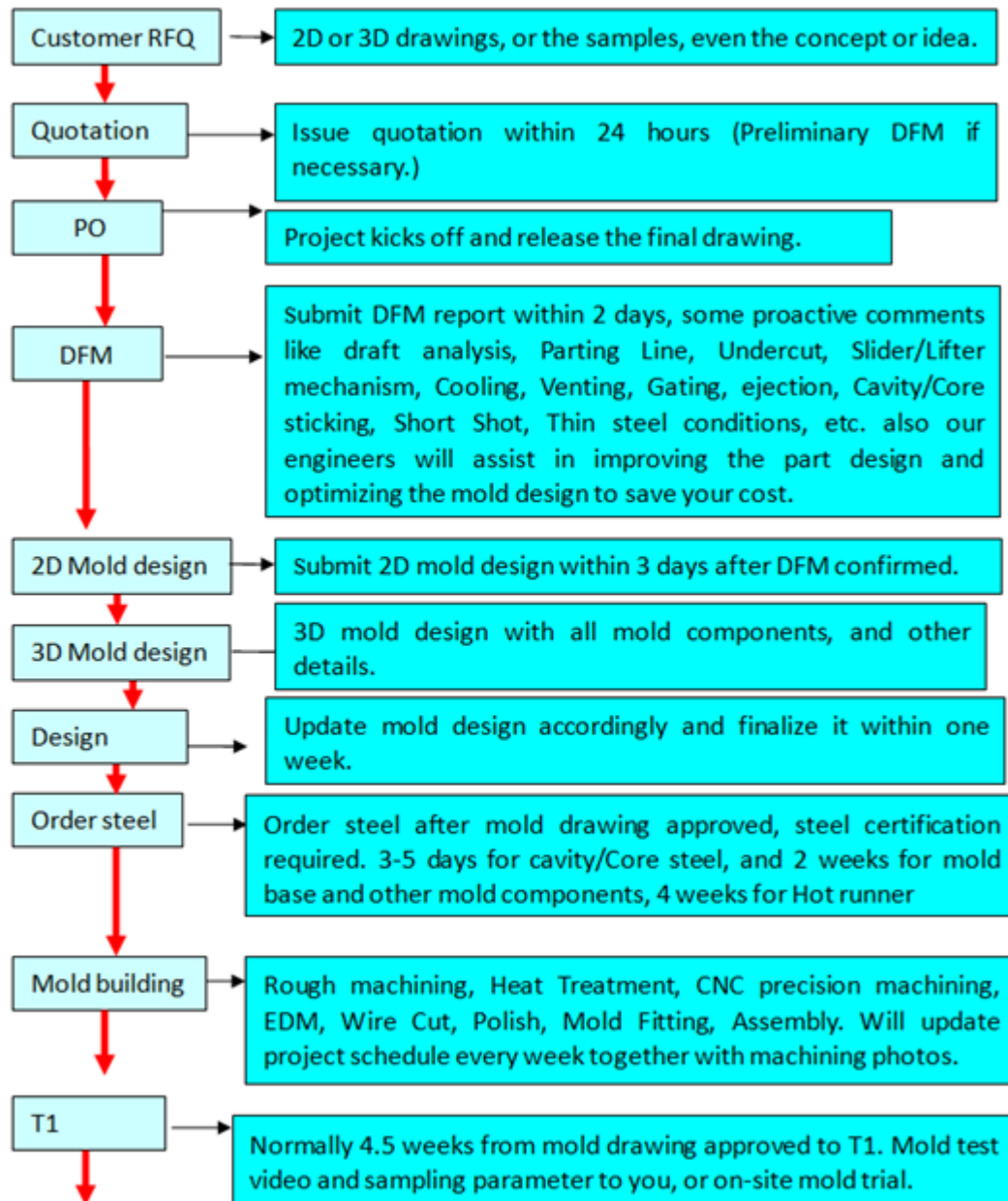
开合模动作检查	模具漏水检查	流动平衡检查, 填充30%、60%、90%
模具顶出动作检查	快速填充检查模具排气	填充99%检查毛边、缩水与变形

> 试模问题点描述及建议/Comments:

问题: 产品毛边/破折纹
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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Working process:



Company

Information

ABIS was founded in Shenzhen China, adjacent to Hong Kong, in 1996, has its own factory of 12,000 square meters. With the advanced facilities from Germany, Swiss and Japan, and a highly experienced design and engineering team, ABIS builds multi-cavity molds to exacting tolerances, providing the critical structural foundation for leading manufacturing companies to produce high precision mold.

	ABIS	Mold	which	engaged	in
1.	Cold&Hot	Runner/	Single&Multi-	Cavity-Injection	moulding
2.			Single&Multi-		Shot
3.		Die		Cast-Aluminum&Zinc	
4.			Inserting		Mold
5.					Overmolding
6.			Prototype		Tooling
7.			Mass		Production

ABIS applies advanced software for mold design-Auto CAD, UG, Solid works and ProE etc. So far, ABIS has received the "ISO 9001", "ROHS" green, SGS certificate.

The brochure for ABIS (Shenzhen) features a prominent logo of a white horse on the left. The main body is divided into several sections:

- 公司简介 (Company Introduction):** Contains text in both Chinese and English describing the company's history, facilities, and services.
- 公司架构 (Organizational Chart):** A hierarchical diagram showing the company's structure, including departments like Sales, Production, and R&D.
- 客户分布 (Client Distribution):** A world map with red dots indicating global office locations and client bases across various continents.
- 荣誉证书 (Certificates of Honor):** A section on the right displaying various awards and certifications received by the company.

Certification



认证证书

此证书授予

深圳市艾比斯精密五金塑胶有限公司

认证通过：深圳市龙岗区龙岗街道龙东社区沙湾路普特利工业园D栋 2楼

符合 ISO/TS 16949:2009 质量管理体系标准

认证范围：

塑胶制品（把手）的生产（不包括 7.3 产品设计）

注册号	首次注册日期	本次发证日期
17001010001504001	2017 年 1 月 3 日	2017 年 1 月 3 日
获证负责人	证书有效期至	ATP No.
17001010001504001	2019 年 1 月 3 日	031000

发证人

认证批准

URS 认证有限公司（中国）深圳分公司（URS (China) Co., Ltd.）
地址：（中国）地址：Room 425, 308, Block 5, Tanya International Building
of Houshuo Center, 100 in Houshuo City, Zhejiang Province of China P.R., 31171-8670999



Certificate of Registration

This certificate has been awarded to

Shenzhen ABIS Precision Hardware Plastic Co. Ltd

Ficert, Building C, She Bei U Ying Keli Industrial Park LongDong
Community, Longgang street, Longgang District, Shenzhen city,
Guangdong Province, China

in recognition of the organization's Quality Management System which complies with

ISO/TS 16949:2009

The scope of activities covered by this certificate is defined below:

Manufacture of Plastic Parts (Handles) (Excludes Product Design under
Clause 7.3)

Certificate Number	Date of Issue of Certification Cycle	
17001010001504001	02 January 2017	
Issue No.	Expiry Date	ATP No.
1	14 September 2019	031000

Issued by:

On behalf of the Soleperson Manager





BEIJING HANGXIE CERTIFICATION CENTER CO.
QUALITY MANAGEMENT SYST
CERTIFICATION
ABIS MOLD TECHNOLOGY(HK)CO.,L

Organization Code: 55388449-1

No.102, Building B, Ying Keli Industry Area, Longgang District, Shenzhen, China. PC 518

is in conformity with

GB/T19001-2008 (ISO9001:2008)

This certificate is covering the following product scope

Plastic Mold Development and Manufacturing; Plastic Products P
(Not Include the Products With Administrative Licensing
Registration No. 03415Q20263ROM
The Duration of Validity :Feb . 10, 2015—Feb . 09, 2018



CNAS
MANAGEMENT SYSTEM
CNAS CBM-Q



IA
MEMBER OF MULTIPLE
COGNITION AREA

General Manager: 

After this certificate is issued, there should be at least 2 surveillance audits within the 3 year period of valid validity of the certificate can be checked on : <www.bhcc.com.cn> The certificate information is available official website of the National Certification and Accreditation Administrator : <www.cnca.gov> It is also available by scanning the two dimensional code at the bottom right corner.

Address : NO.7 Jingshun Road,Chaoyang District,Beijing,China.



Certificate

Certificate No.: 114175

This is to certify that the Occupational Health and Safety Management
SHENZHEN ABIS PRECISION HARDW
PLASTIC CO., LTD.
Unified Social Credit Code: 91440300553884491N
Registered/Production/Office Address: Yingkel Industrial District B Building No. 102, Shabe
Longdong Community, Longgang Street, Longgang I
Guangdong Province, China
Sales Address: Yingkel Industrial District C Building 1/F, Shabeii Village, Longdong Comm
Street, Longgang District, Shenzhen, Guangdong Province, China
Has been audited to conform to the following Occupational Health
Management System standard
GB/T 28001-2011 idt OHSAS 18001:20
This Occupational Health and Safety Management System is valid
Development and production of plastic mould; sales
plastic parts and related Occupational health and saf
management activities of involved sites

Initial issued date: May. 16, 2017
Date of issue: May. 15, 2017
Date of expiry: May. 15, 2020

Issued by:  **Beijing East Allreach Certification Cen**



EACC
OHSAS

The certificate will remain valid only if the certified organization keeps its certificate with it, register, internet and is subject to be audited. Please note the surveillance audit conforming mark on the engaged products 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 Fintec, No. 123 building, No. 17 Jingshun Road, Beijing Science & Technology Industrial Base, Beijing 100101



CNAS
中国
管理
认证
中心
CNCA

The 1st Surveillance Conforming Mark

The 2nd Surveillance Conforming Mark

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 problem.

The molded parts are then inspected again by experienced QA department for the full dimensions, especially the critical dimensions set by customer. If a quality result was recorded at the same time, the result will be to our QC Supervisor directly. If any unqualified dimensions (if exist) are caused by uncontrolled factors or our mistakes and we will take the related actions to improve it.

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



Our ABIS Family



- Why choose us?:
1. More than 20-years experience.
 2. ISO9001:2008 certificated.
 3. Competitive price with high quality.
 4. More than 50 machines support to run the business.
 5. Custom R&D program coordination.
 6. Expert technicians.
 8. Diligent and loyal workforce.
 9. Up-to-date software.
 10. International standards, SAY, HASCO, DME, MISUMI, etc
 11. Well-rounded after service.

Lynn Xiao

ABIS Mold Technology Co.,Ltd.

Add:B Building, YingkeLi Area, Longdong Community, Longgang District, ShenZhen, CHN.

Tel:0086-75589984896 ext 808

Mobile(Whatsapp):+8613924454678

Web:www(dot)abismold(dot)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!

FAQ

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

Q:Can we test the plastic injection mold?

A:after the mold is ok ,we can help you to test the mold for free.

Q:Can you process the die-casting parts of injection mold?

A: We can help to process die-casting parts for small run or mass production.

Q:What about the plastic products samples are wrong?

A: if you are not satisfied with the plastic sample, we can send the sample to you again for free.