

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	Custom Plastic Injection mold s witched socket/power socket S hell Manufacturing
Description	Household Appliance
Country of Original	ShenZhen, China (Mainland)
Brand Name	ABIS
Lead Time	30-60Days

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	Custom Plastic Injection mold switched socket/power socket Shell Manufacturing
2	Mold base	LKM;HASCO;DME
3	Mold material	P20/718/738/NAK80/S136
4	Mold cavity	Multi
5	Runner	Hot/Cold
6	Plastic material	ABS/PP/PS/PE/PVC/PA6/PA66
7	Shaping Mode	Plastic Injection Mould
8	Design software	UG,PROE,CAD,SOLIDWORK
9	Product Material	Steel
10	Mold life	250000-300000shots
11	Lead time	30-60Days
12	Transportation	By sea, by air or by land as you request
13	Package	According to clients requirement
14	Surface treatment	Polishing


Processing Equipment

NAME OF MACHINE	BRAND	Q'TY	PLACE OF ORIGIN
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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

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	B876_0CALIP without TG_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), Mikrometer (MM), Projector (PJ), Pingauge (PG), Rad (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	Remark
1-1	1.20	+	0.20	CP	1.19	1.23	1.22	1.24	1.22	1.23	1.20	1.21	OK
		-	0.20										
1-2	1.20	+	0.20	CP	1.21	1.22	1.20	1.20	1.21	1.23	1.22	1.20	OK
		-	0.20										
2-7	1.50	+	0.20	CP	1.51	1.52	1.52	1.53	1.51	1.50	1.49	1.52	OK
		-	0.20										
2-8	1.50	+	0.20	CP	1.52	1.52	1.52	1.52	1.51	1.53	1.49	1.51	OK
		-	0.20										
2-9	1.50	+	0.20	CP	1.51	1.52	1.52	1.52	1.51	1.50	1.49	1.50	OK
		-	0.20										
3-1	1.70	+	0.20	PJ	1.72	1.69	1.70	1.69	1.70	1.71	1.73	1.70	OK
		-	0.20										
3-2	1.70	+	0.20	PJ	1.71	1.72	1.69	1.70	1.71	1.72	1.71	1.72	OK
		-	0.20										
3-3	1.70	+	0.20	PJ	1.71	1.72	1.71	1.70	1.69	1.70	1.69	1.71	OK
		-	0.20										
3-4	1.70	+	0.20	PJ	1.69	1.70	1.70	1.71	1.72	1.71	1.73	1.71	OK
		-	0.20										
3-5	1.70	+	0.20	PJ	1.71	1.71	1.72	1.73	1.71	1.71	1.72	1.73	OK
		-	0.20										
3-6	1.70	+	0.20	PJ	1.71	1.72	1.73	1.71	1.72	1.71	1.71	1.72	#REF!
		-	0.20										

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:	<input checked="" type="checkbox"/> Pass	<input type="checkbox"/> Fail	<input type="checkbox"/> Special Acceptance
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ABIS MOLD INJECTION PARAMETER REPORT

> 类型 Shot Type: <input checked="" type="checkbox"/> 单色 One shot mold <input type="checkbox"/> 双色第一次 1st shot of 2-shot <input type="checkbox"/> 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	试模次数 Test times
模腔数量 N Cavity	塑胶原料 Raw Material	颜色 Color	项目负责人 Project Manager
产品总重量 Gross Wt(g)	机台型号 Press Type	试模数量(啤数) Shot Qty	设计工程师 Design Engineer
试模日期 Test Date	上机时间 Beginning Time	完成时间 Finish Time	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、烘压机、退料箱、电子天平、照相机、打磨机(用于铜或漆口直径)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	射嘴温度 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	速度或速率 Percent of Speed(mm/s) or Flow Rate(g/s)	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		
送料压力 Charge Pressure			射胶速率三段 Injection Speed 3		
背压 Back Pressure			射胶速率四段 Injection Speed 4		
位置 Position(mm)	射胶位置 1st Inj. End Position		原料干燥 Raw Material	保压速率 1st Holding Speed	
	射胶位置 2nd Inj. End Position			保压速率 2nd Holding Speed	
	射胶位置 3rd Inj. End Position			保压转换 Turn Hold(time/pos.)	
	射胶终止位置 Inj. End Position			熔胶速率 Charge Speed	
	熔胶终止位置 Melt End Position			干燥温度 Drying Temp(°C)	
	射退位置 Suck Back End Position			干燥时间 Drying Time(H)	
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	凉水 Cool Water	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:

<input type="checkbox"/> 粘前模 Sticking in Cav	<input type="checkbox"/> 抛光不良 Poor Polishing	<input type="checkbox"/> 披锋 Flash	<input type="checkbox"/> 裂痕 Stress Crack	<input type="checkbox"/> 结合线 Weld L
<input type="checkbox"/> 粘后模 Sticking in Core	<input type="checkbox"/> 顶出不顺 Uneven Eject	<input type="checkbox"/> 顶台 Ejector Marks	<input type="checkbox"/> 喷射痕 Jetting	<input type="checkbox"/> 黑点 Dark Spot
<input type="checkbox"/> 水印 Water Wave Marks	<input type="checkbox"/> 拖花 Scratch Marks	<input type="checkbox"/> 变形 Deformation	<input type="checkbox"/> 缺胶 Short Filling	<input type="checkbox"/> 烧焦 Burn Mark
<input type="checkbox"/> 冷料流痕 Cold Slug Marks	<input type="checkbox"/> 困气 Gas Trap Effect	<input type="checkbox"/> 缩水 Sink Marks	<input type="checkbox"/> 胶纹 Gap	<input type="checkbox"/> 气泡 Air Bubble

> 试模过程检查/Tryout Process Check:

开合模动作检查	模具透水检查	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

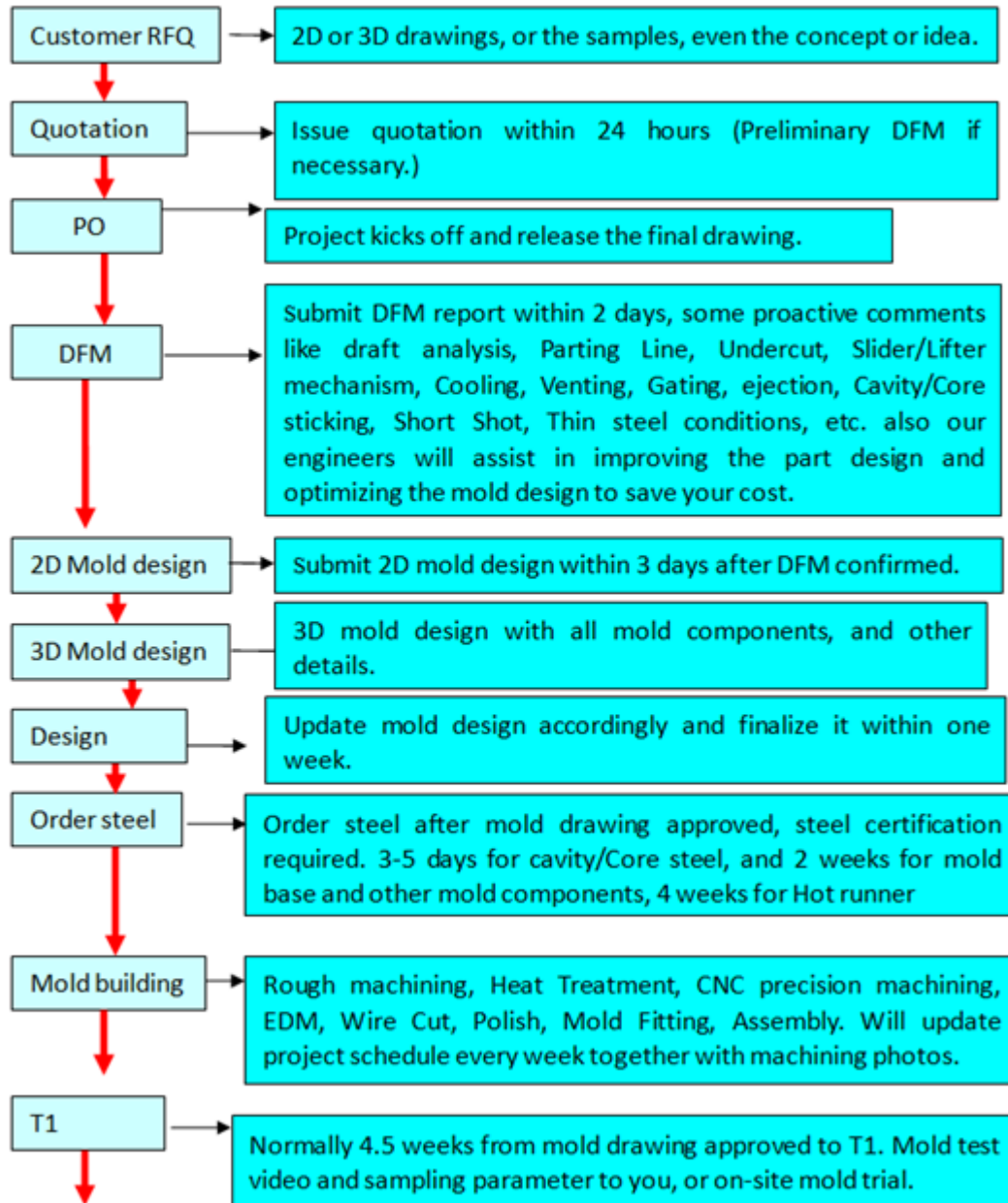
> 试模问题点描述及建议/Comments:

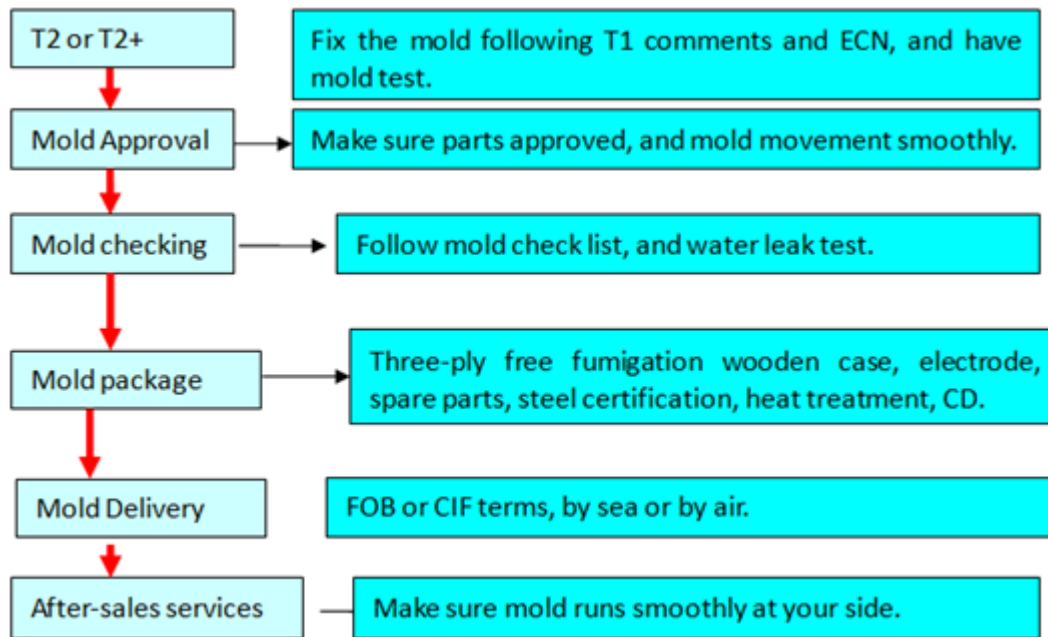
问题: 产品毛边/破斩纹

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.

公司简介
 本公司于1992年，在深圳市宝安区成立，经过多年发展，已成为国内领先的精密五金制造企业。我们专注于为客户提供高品质的精密五金零件，广泛应用于汽车、电子、机械等行业。我们的产品和服务遍布全球，赢得了广泛的认可和好评。

公司结构
 总经理
 副总经理
 生产部
 品质部
 销售部
 研发部
 采购部
 财务部
 人力资源部

客户分布
 全球客户分布图，覆盖北美、欧洲、亚洲、非洲、澳洲等地区。

参展情况
 2014年 深圳国际五金模具展
 2014年 深圳国际五金模具展
 2014年 深圳国际五金模具展

合作伙伴
 SKF, YUPO, etc.

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
 认证地址：深圳市宝安区龙岗街道东乐社区沙湾路特制工业园C栋 5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）

证书号： 1718020001584501	有效日期： 2017年11月3日	有效期至： 2019年11月3日
颁发机构： URS CERTIFICATION	注册日期： 2016年02月14日	工厂号： 018002

发证人：[Signature] 认证经理

URS 认证机构地址：深圳市宝安区沙井街道沙井社区沙井大道100号沙井国际中心B座1101室
 电话：+86 755 8122 1888, 8122 1889, 8122 1890, 8122 1891, 8122 1892, 8122 1893, 8122 1894, 8122 1895, 8122 1896, 8122 1897, 8122 1898, 8122 1899
 地址：+86 755 8122 1888, 8122 1889, 8122 1890, 8122 1891, 8122 1892, 8122 1893, 8122 1894, 8122 1895, 8122 1896, 8122 1897, 8122 1898, 8122 1899
 地址：+86 755 8122 1888, 8122 1889, 8122 1890, 8122 1891, 8122 1892, 8122 1893, 8122 1894, 8122 1895, 8122 1896, 8122 1897, 8122 1898, 8122 1899

Certificate of Registration
 This certificate has been awarded to
Shenzhen ABIS Precision Hardware Plastic Co. Ltd
 Floor 5, Building C, She Bei Li Ying Ke 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: 1718020001584501	Date of Issue of Certification Cycle: 02 January 2017	Issue No: 1	Expiry Date: 14 September 2019	IATF No: 0310005
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Issued by: [Signature] On behalf of the Certification Manager



**BEIJING HANGXIE CERTIFICATION CENTER CO.
QUALITY MANAGEMENT SYST
CERTIFICATION**

ABIS MOLD TECHNOLOGY(HK)CO.,L'

(Organization Code: 55388449-)

No.102, Building B, Ying Keli Industry Area, Longgang District, Shenzhen, China. P.C.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. 03415Q20263R0M

The Duration of Validity Feb . 10, 2015—Feb . 09, 2018




MANAGEMENT SYSTEM
CNAS 0384-Q

General Manager: 

BEIJING HAN
CERTIFICATION CE

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 < a href="http://www.bhcc.com.cn" > www.bhcc.com.cn) The certificate information is avail official website of the National Certification and Accreditation Administrator < a href="http://www.cnca.gov.cn" > www.cnca.gov.cn . 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, Shaozhi Village, Longgang Commu
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




The certificate will remain valid only if the certified organization keeps certificate audit at regular intervals and is subject to the conditions. Please note the surveillance audit conforming mark on the designated position of the certificate. The information of this certificate is available at EAGC website < a href="http://www.eagc.com.cn" > www.eagc.com.cn and CNCA website < a href="http://www.cnca.gov.cn" > www.cnca.gov.cn .

EAGC address: Floor, No. 121 building, No. 17 Jingfangwan Street, Jiqiao Science & Technology Industrial Park, Longgang District of

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

The molded parts are then inspected again by experienced QA department for the full dimension, especially the critical dimensions set by customer. If quality result was recorded at the same time. Result will be to our QC Supervisor directly. If 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 parts 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](tel:0086-75589984896) ext 808

Mobile([Whatsapp](#)):+8613924454678

Web:[www\(dot\)abismold\(dot\)com](http://www.abismold.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.