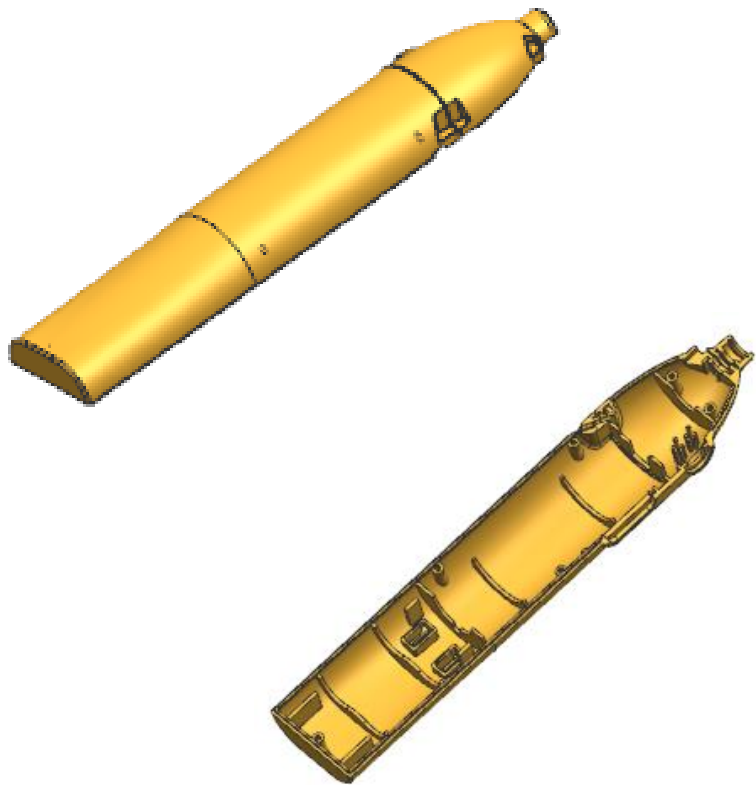
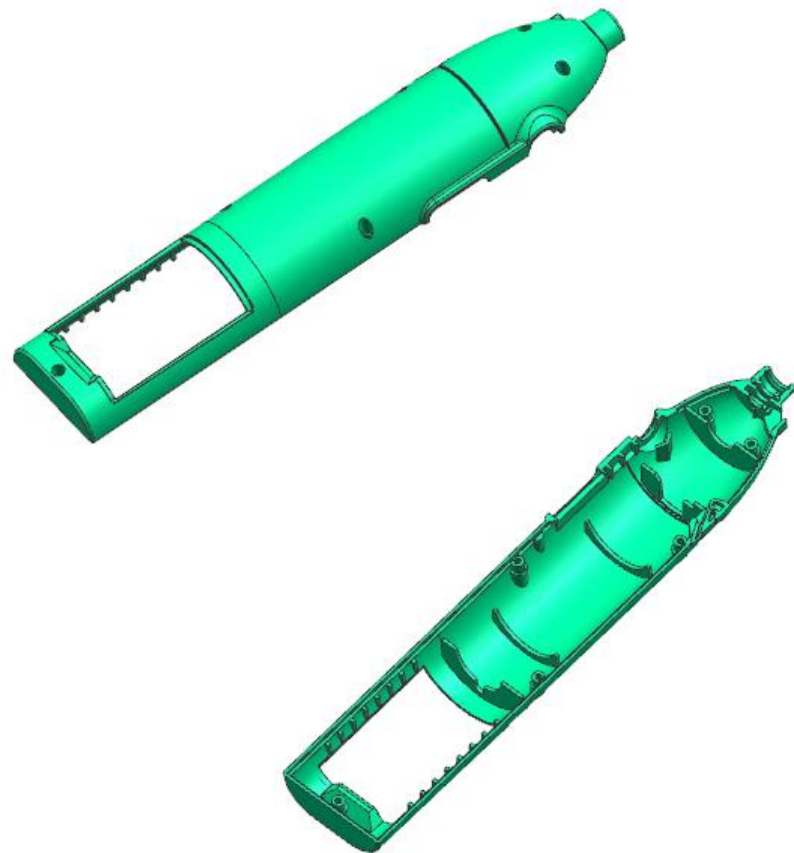


Client:	/	Gate type:	Sub gate
Model:	TP1029.1-M1	NO. of gate (Each part)	1
Part name:	ORBscr-120923-0004-01 ORBscr-120819-0005-00	Hot runner:	/
Part No:	/	Tool type:	2 type plate (LKM)
General thickness	ORBscr-120923-0004-01=1.56 ORBscr-120819-0005-00=1.44		/
Plastic material:	ABS	Lifter qty (Each part)	/
Part weight:	ORBscr-120923-0004-01=30.6g ORBscr-120819-0005-00=23.3g	Shrinkage:	0.6%
Cavities:	1+1	DFM by:	/

**Plastomold.**



ORBscr-120923-0004-01



ORBscr-120819-0005-00

**Plastomold.**

↑ TOP

ORBscr-120923-0004-01



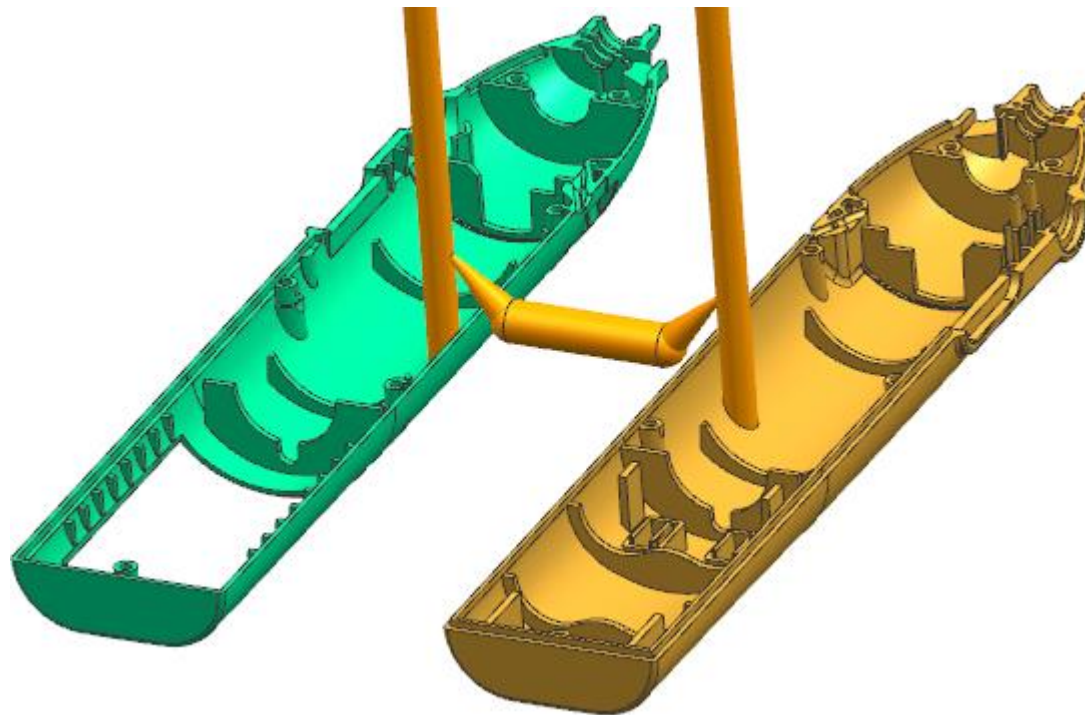
ORBscr-120819-0005-00

Plastomold.

gate

ORBscr-120819-0005-00

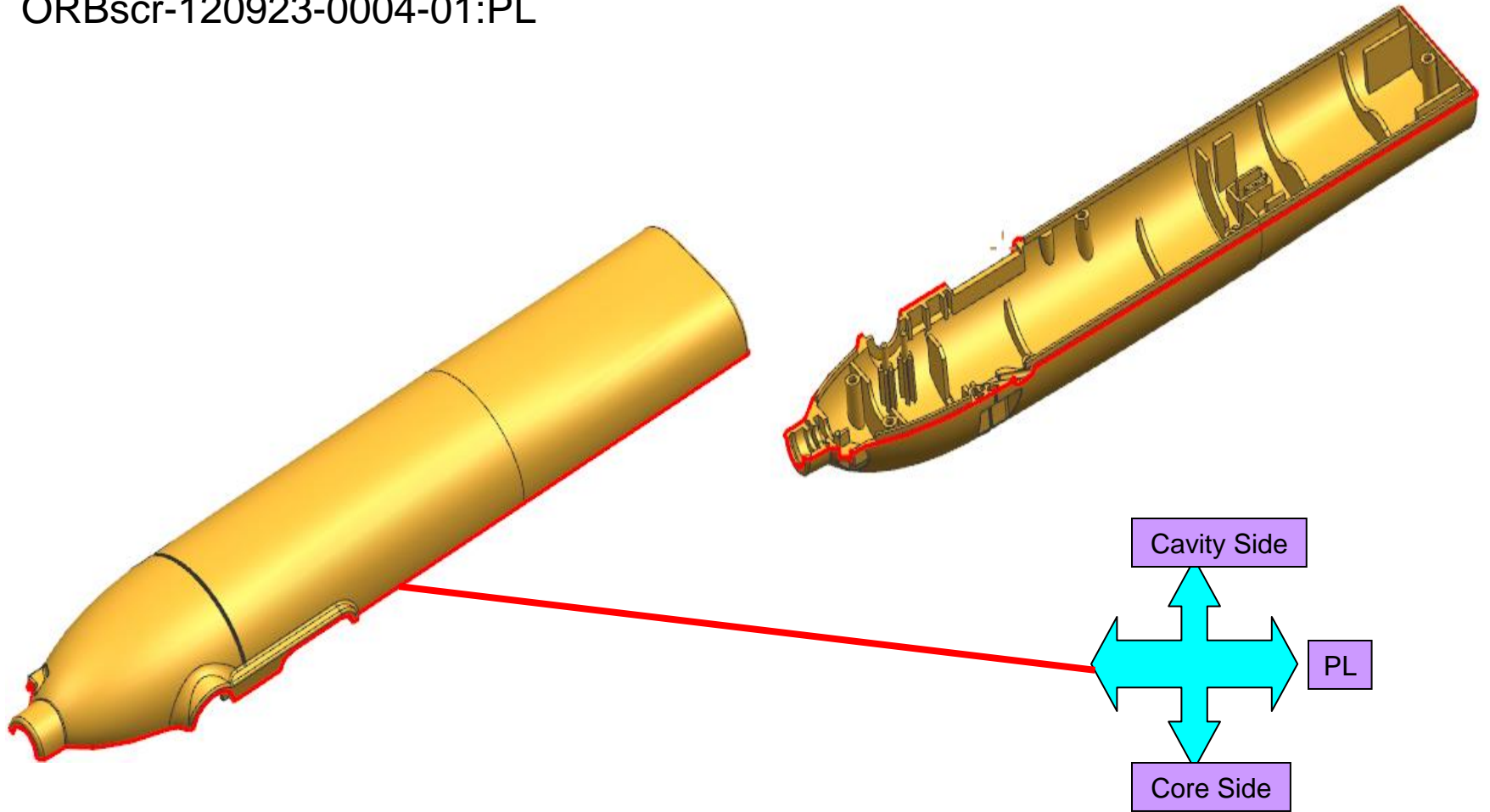
ORBscr-120923-0004-01



Gate position and gate style: sub gate

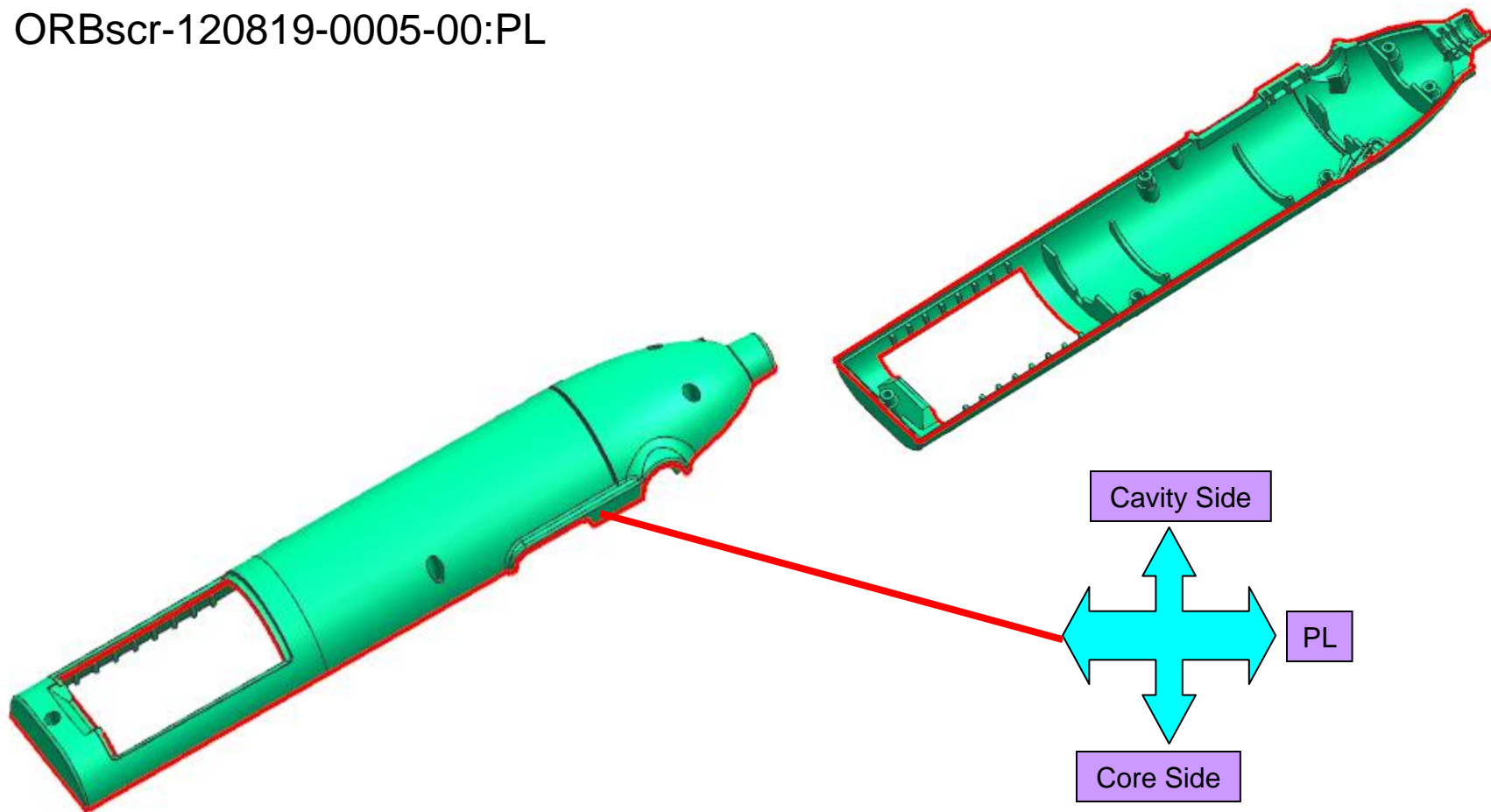
**Plastomold.**

ORBscr-120923-0004-01:PL



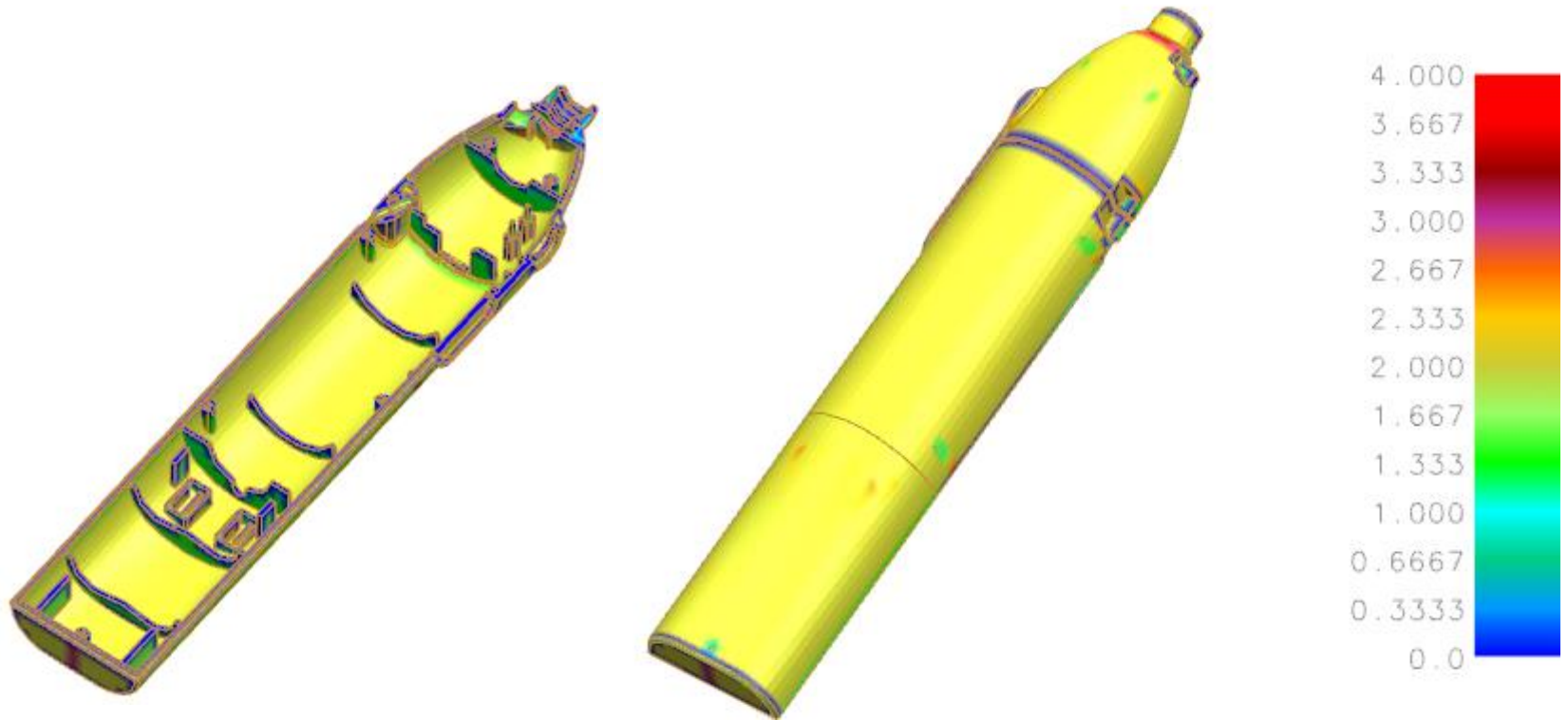
Plastomold.

ORBscr-120819-0005-00:PL



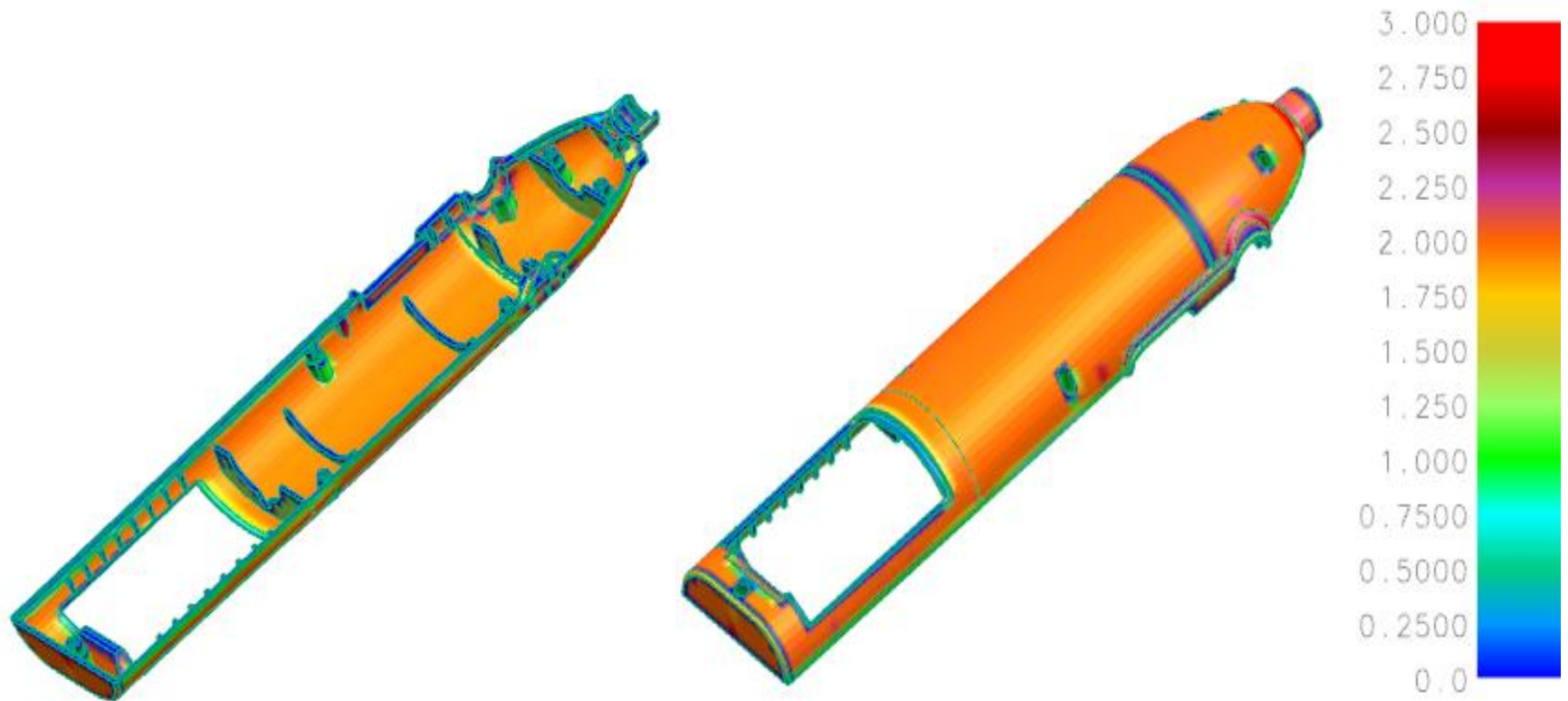
Plastomold.

ORBscr-120923-0004-01 thickness analysis :



Plastomold.

ORBscr-120819-0005-00 thickness analysis :



**Plastomold.**

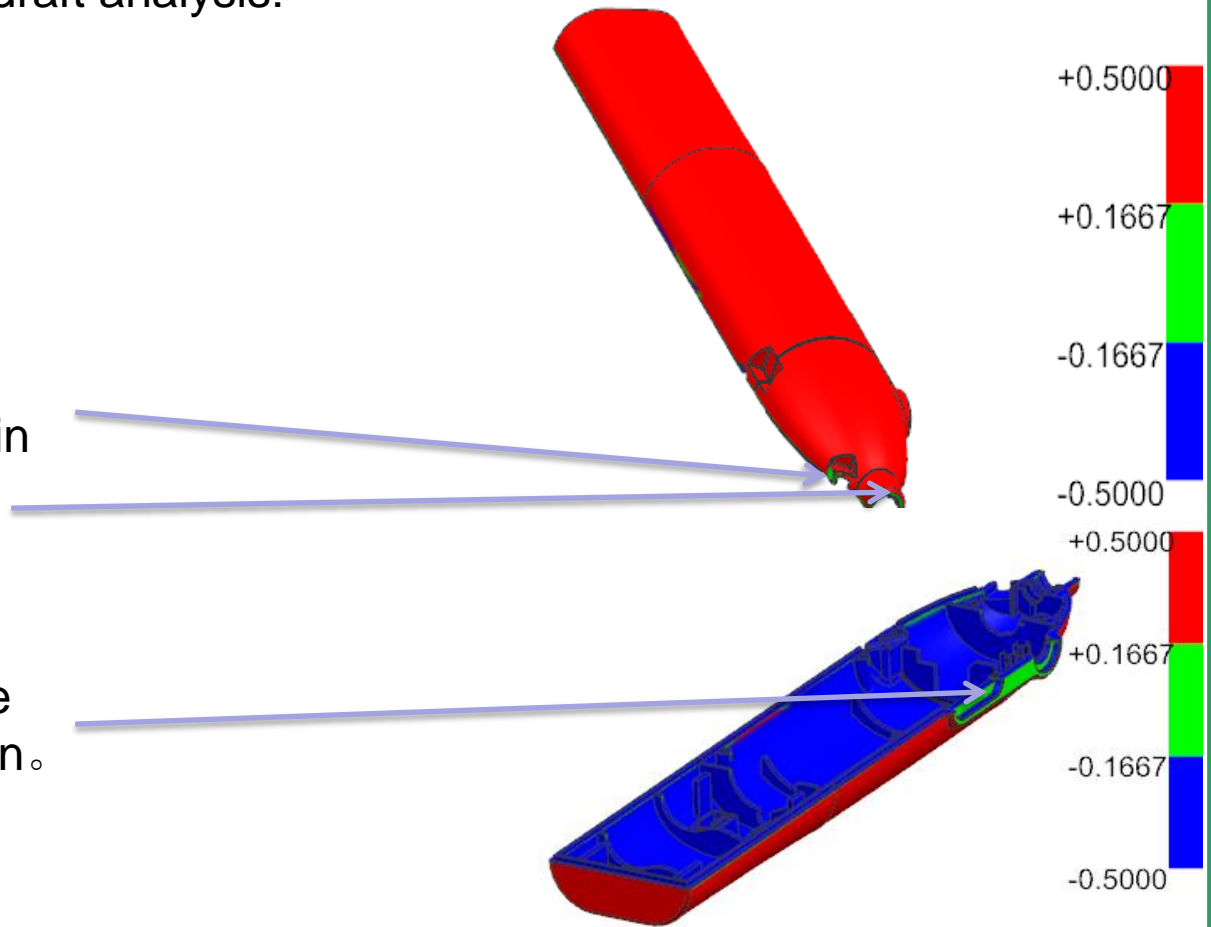


ORBscr-120923-0004-01 draft analysis:

As pic, the red surface is cavity side the blue is core side, the green don't have draft.

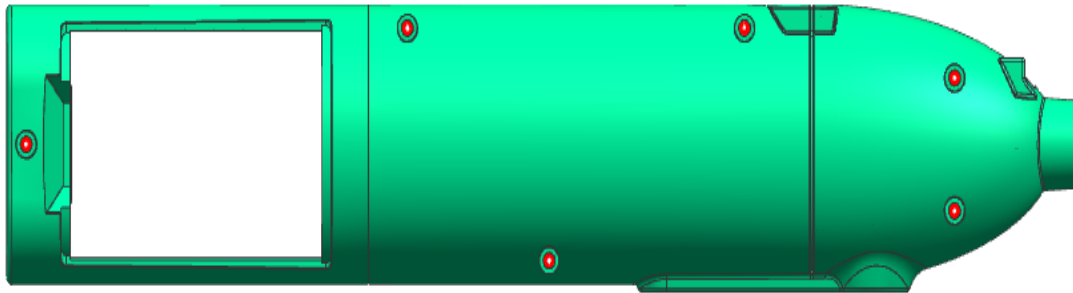
So please add 2 degree in the green area to cavity direction.

Please add 2 degree in the green area to core direction.

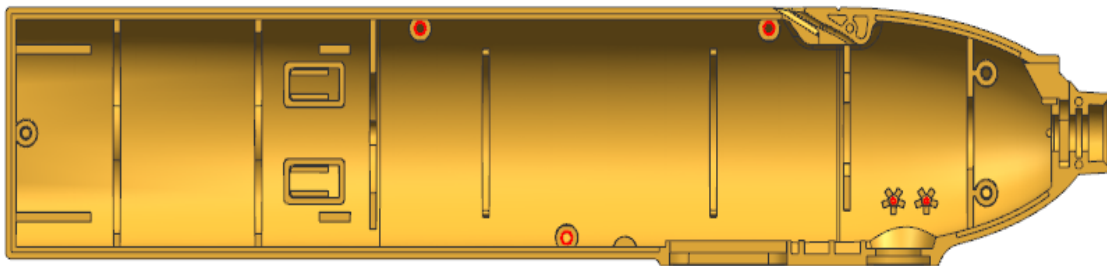


Plastomold.

ORBscr-120819-0005-00



The red line will do insert pin in cavity, so it is good for venting and process.

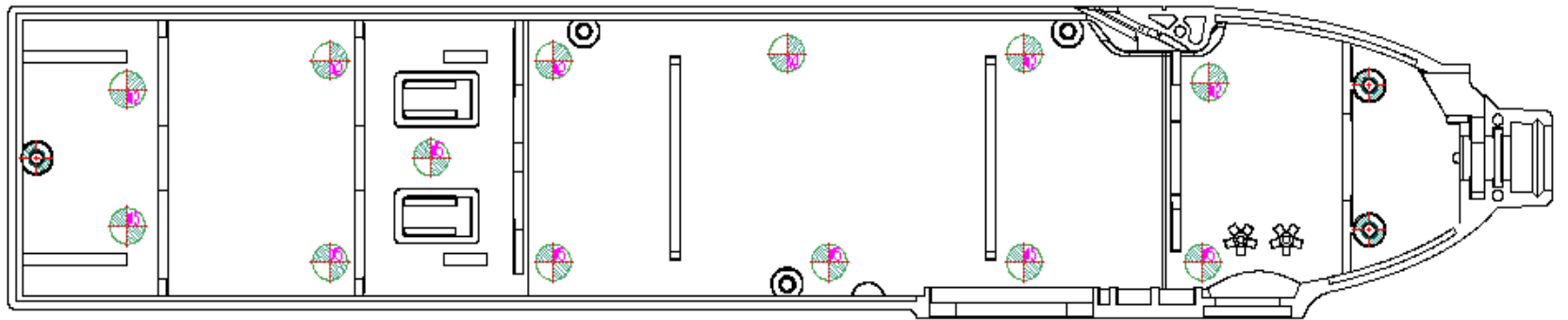
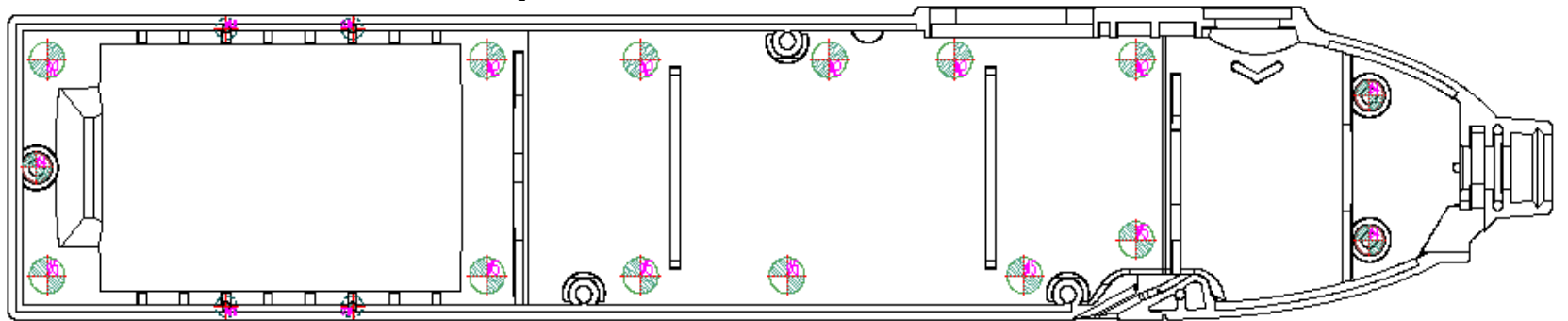


The red line will do insert pin in core, so it is good for venting and process

ORBscr-120923-0004-01

Plastomold.

ORBscr-120819-0005-00 ejection



ORBscr-120923-0004-01 ejector