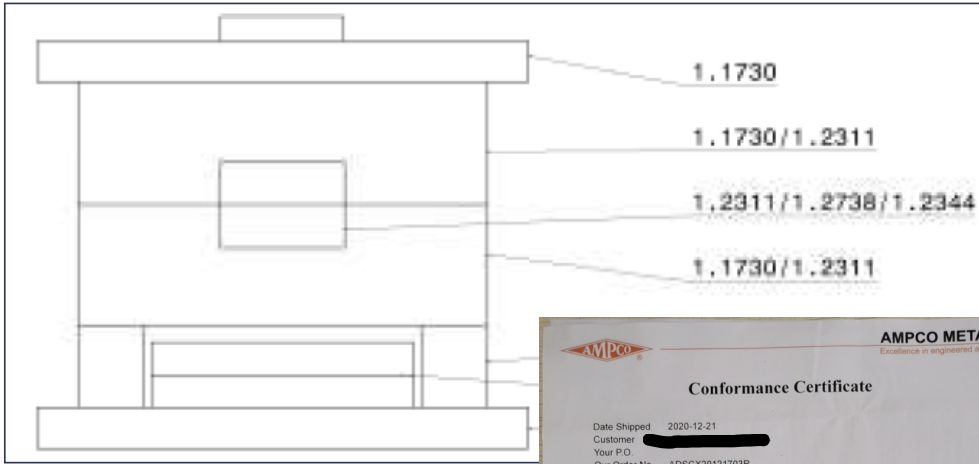


Buy off Report Example

Steel certificates and hardness test

Standard



Design

AMPCO METAL
Excellence in engineered alloys

Conformance Certificate

Date Shipped: 2020-12-21
Customer: [REDACTED]
Your P.O.: [REDACTED]
Our Order No.: ADSCX20121703R
Specification: AMPCOLOY® 83 Forged

No.	Customer Material No.	Size/mm	Qty/pc	Weight/kg	Heat No.
1	BK20151	97 x 98 x 123	1	9.66	A97834-2-2
2	BK20151	54 x 73 x 92	1	3.00	A96927-1-2
3	BK20151	51 x 68 x 100	1	2.86	A88164-3
4	BK20151	63 x 125 x 140	1	9.50	A97151-1-1
5	BK20151	86 x 90 x 144	1	9.21	A95104-1-1
6	BK20151	40 x 46 x 90	1	1.37	A97831-1-2

NOMINAL CHEMISTRY

Beryllium	Cobalt-Nickel	Other	Copper
1.9	0.5	Max. 0.5	balance

NOMINAL PROPERTIES

Tensile Strength	Elongation	Brinell Hardness	Thermal Conductivity
1140 MPa	5 %	350 HB	106 W/m K

Remark: All chemistry and properties data above is nominal value

Ampeco Metal(Foshan)Co., Ltd.
Warehouse 9-1, No.9 Xinyue Road, Jingqiao Industrial City
Wusha, Dailing Town, Shunde Foshan, Guangdong Province
Tel: +86(0)75722326071
Fax: +86(0)75722326570
P.C. 528333

***** THE CERTIFICATE IS END *****
***** NO DATA BELOW THIS LINE *****

info@ampcometal.com www.ampcometal.com

Mold

Prüfbescheinigung / Type of document
INSPECTION CERTIFICATE ACC. TO DIN EN 10204-01/05/3.1

Schmidewerke Grödtz GmbH Resener Straße 1 01606 Grödtz

Besteller / Customer: GUANGDONG HUAXINGLONG MOULD & DIE MATERIAL TECHNOLOGY CO., LTD. Nr. / No.: S/2267
Seite/Page: 1 von/of: 1

Bestell-Nr. / P.O. No.: 1.2344 Gegenstand / Object: STEEL BLOCK, precision forged
Kommissions-Nr. / Commission No.: S200453003 / 7 Abmessung / Dimension [mm]: 1000 x 355 x 3525 / Single weight: 10050 kg

Werkstoff / Material: 1.2344 ID-Nr./ID-No.: Anforderungen / Demands: DIN EN ISO 4957/11.18

Lieferzustand / Condition of delivery: EFS-annealed

Erschmelzungsart / Steelmaking process: EAF Chemische Analyse / Chemical analysis (% / H₂ : O₂ ppm)

Stück Quantity	Chargenr. Heat no.	Probe Sample	C	Si	Mn	P	S	Cr	Ni	Mo	V	Cu	Al	H2
1	GP105787	Heat	.41	.07	.39	.019	.001	5.14	.34	1.33	.065	.18	.019	.7

Prüfergebnisse / Test results
Härte Soll / Hardness required [HFW] min - max 230 Härte Ist am Teil / Hardness measured on part [HB] 198; 204

part-marking: 64711
Ultrasonic tested according to SNT-TC-1B, Part II, Level 2, by factory material mix up tested - satisfactory

Anmer: ultrasonic test report

Die gezeigten Anforderungen sind erfüllt. Beschädigung und Ausmessungen, s.B.
The a.m. mentioned requirements, should and dimensional inspection: satisfactory

日期: 2020-12-09
客户名称: 深圳市百金辉精密模具塑胶制品有限公司
订单编号: SJ20-020720
采购单号: [REDACTED]

下单尺寸	数量	模具编号
167.5X384X702	2	BK20151
169X327X702	2	BK20151

扫码验证

Herstellerzeichen, Manufacturer's brand

se

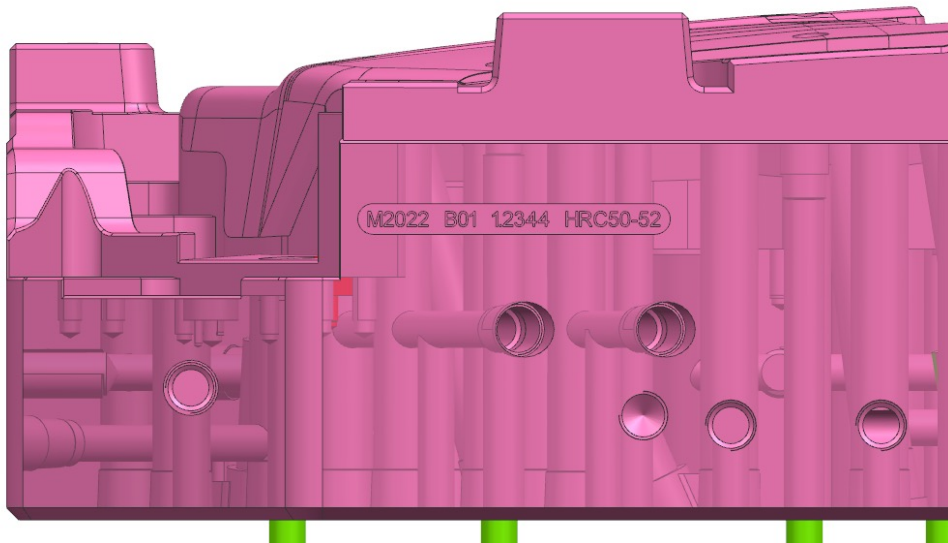
Stempel des Sachverständigen Inspector's stamp

Datum / Date: 29.08.2020
Abnahmebeauftragter Hersteller Manufacturer's authorized representative

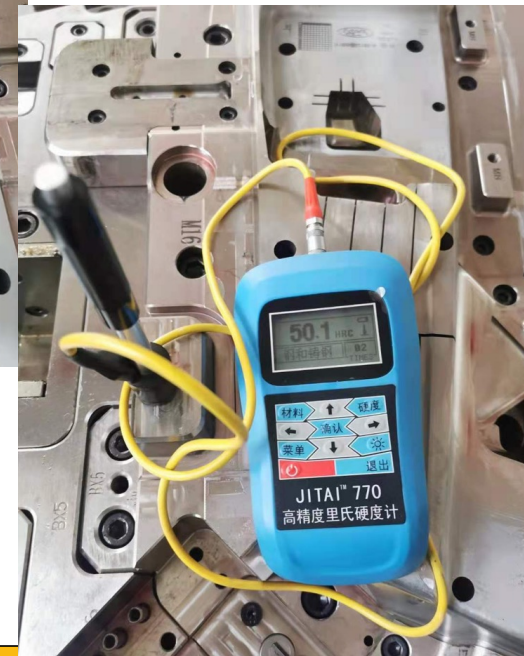
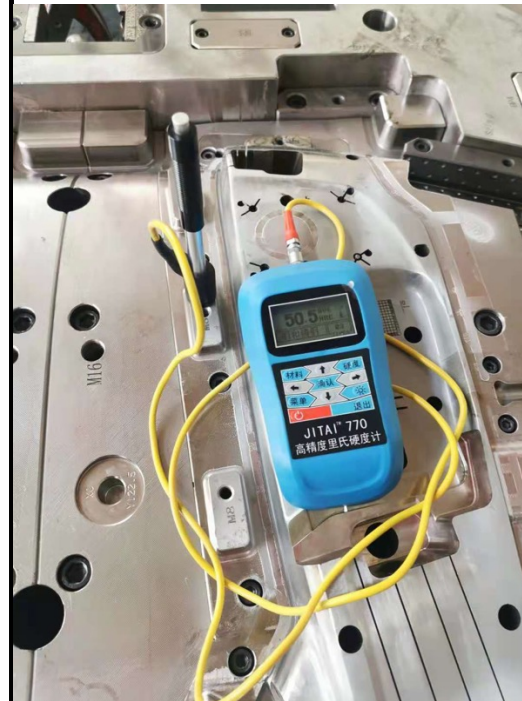
Steel certificates

Steel certificates and hardness test

Standard



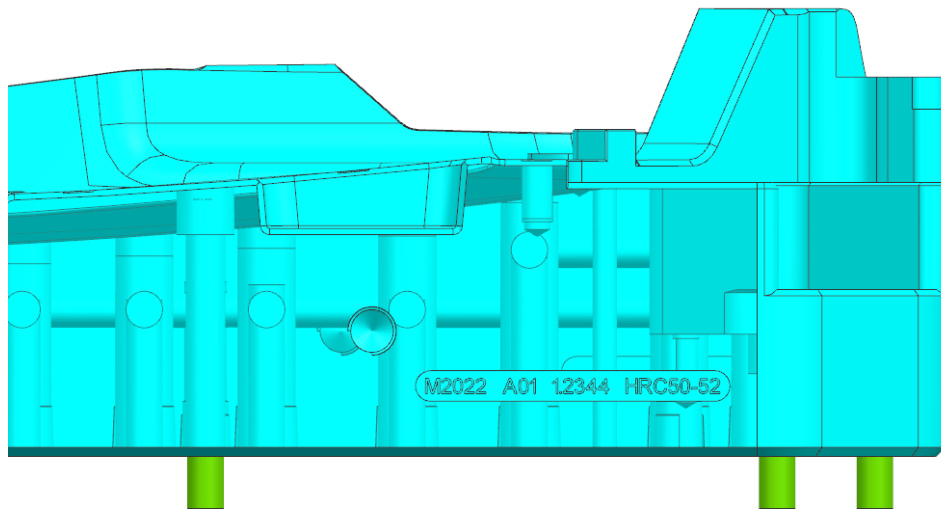
Mold



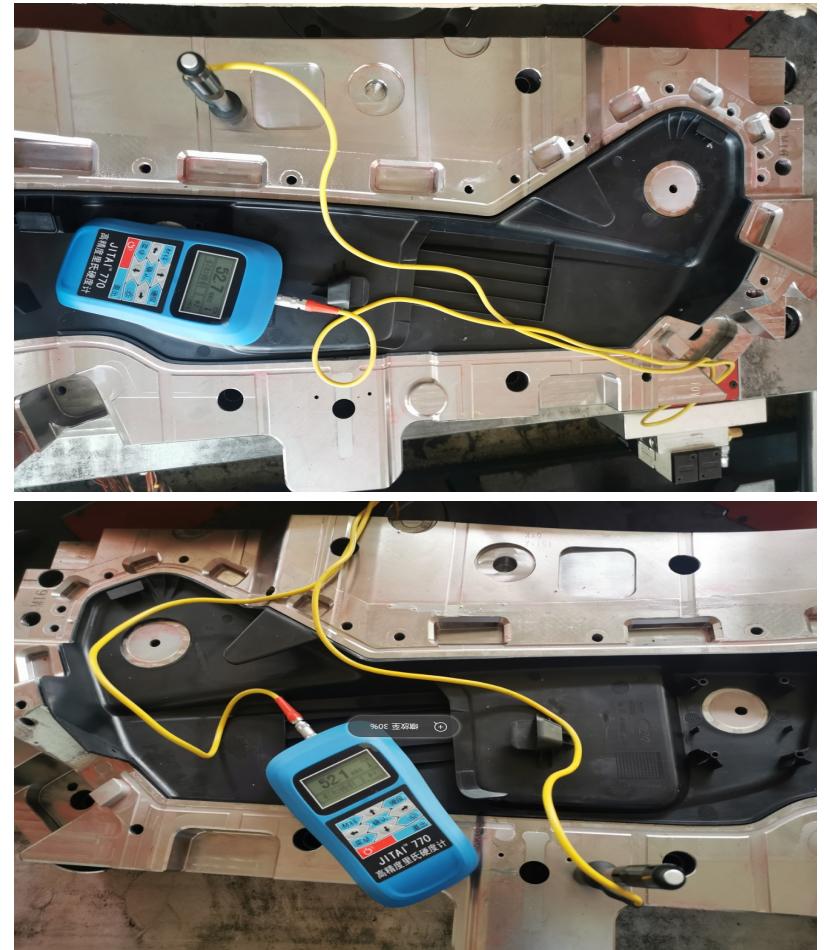
Core hardness

Steel certificates and hardness test

Standard



Mold

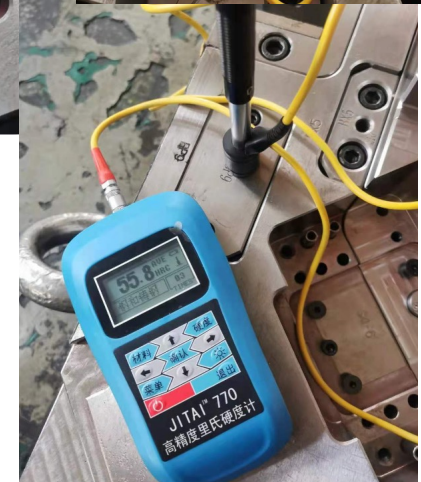
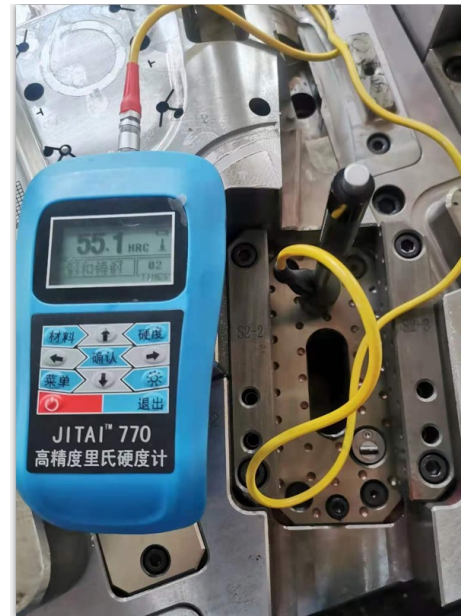


Cavity hardness

Steel certificates and hardness test

Standard

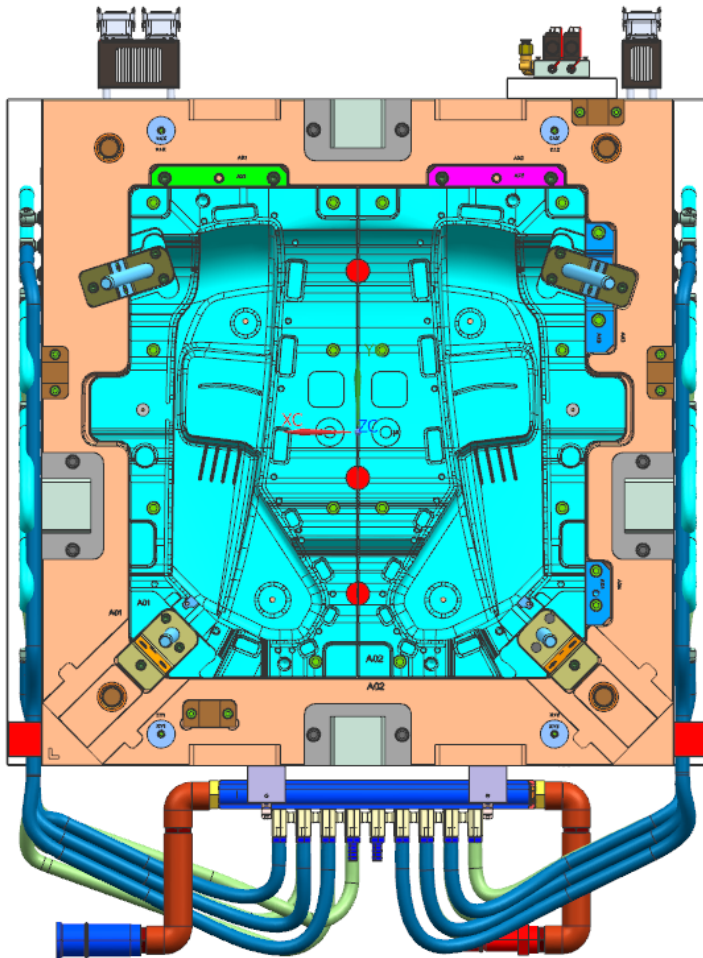
Mold



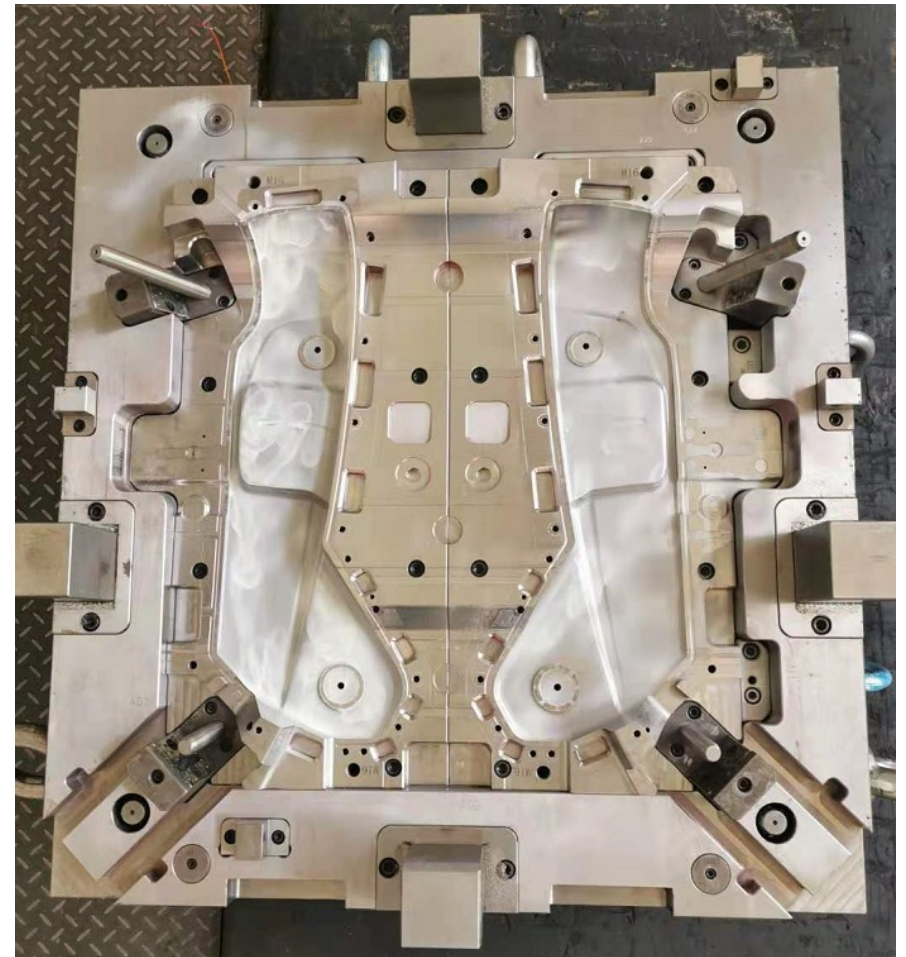
Pad plate hardness

Pictures of the mold

Design



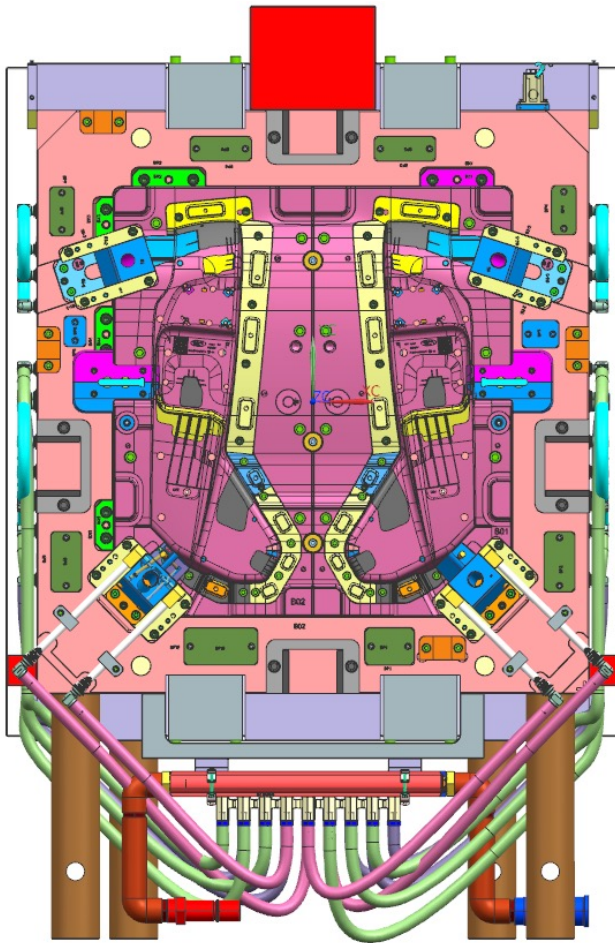
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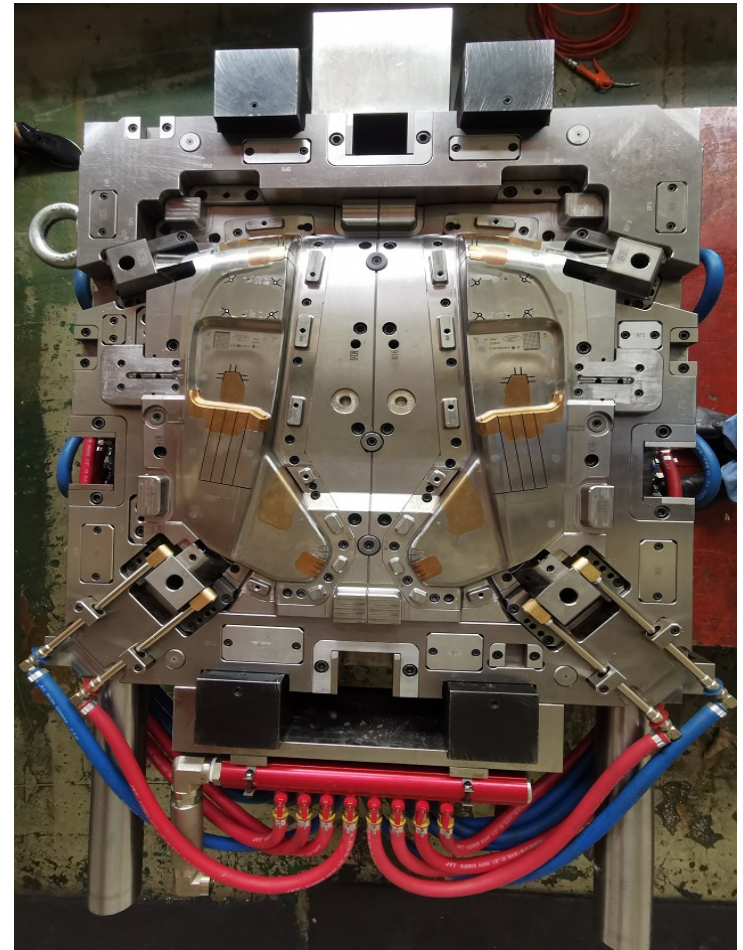
Cavity side

Pictures of the mold

Design



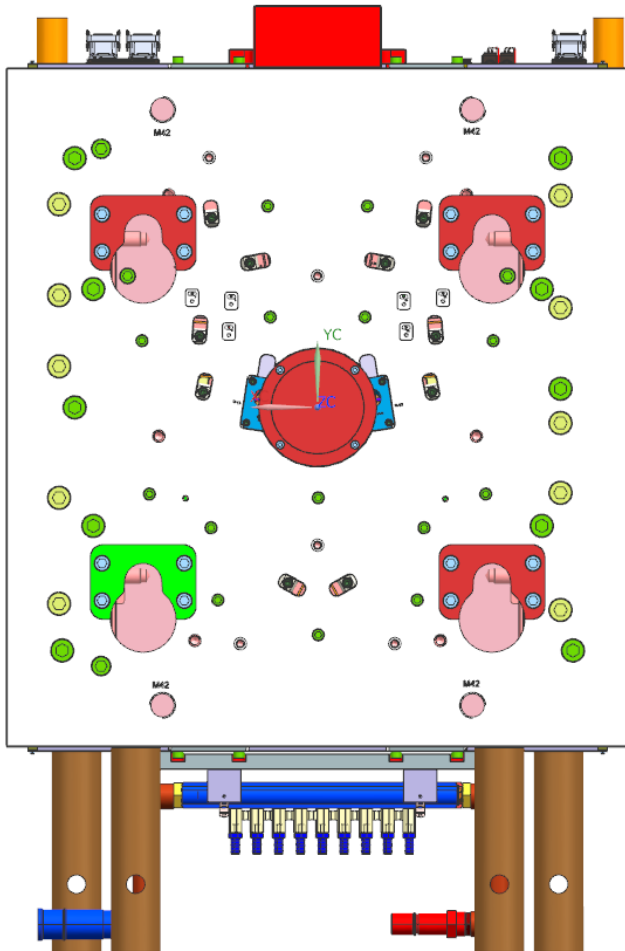
Mold



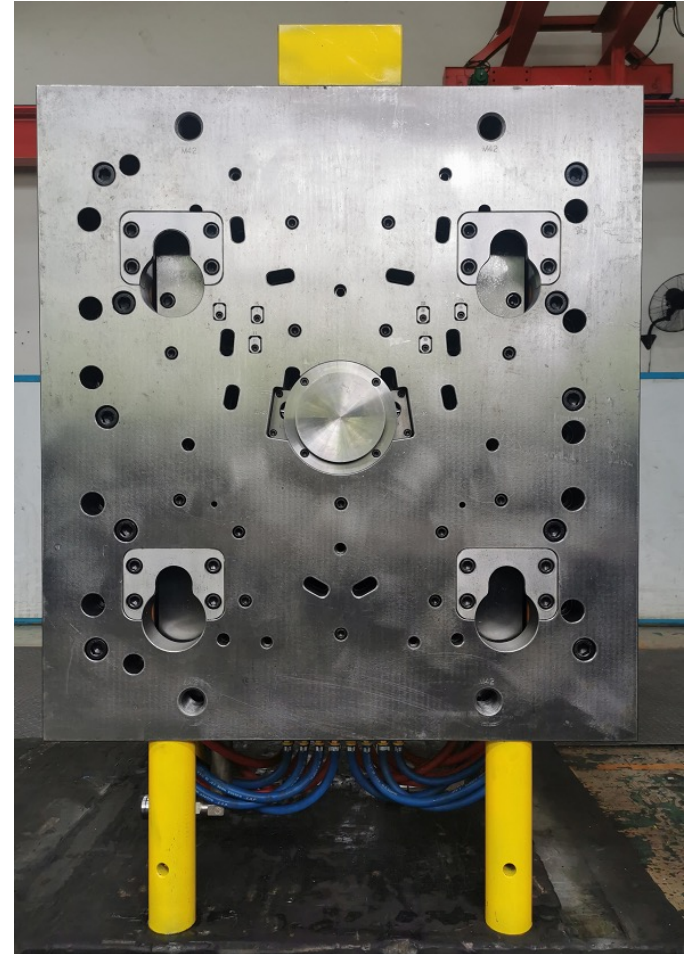
Core side

Pictures of the mold

Design



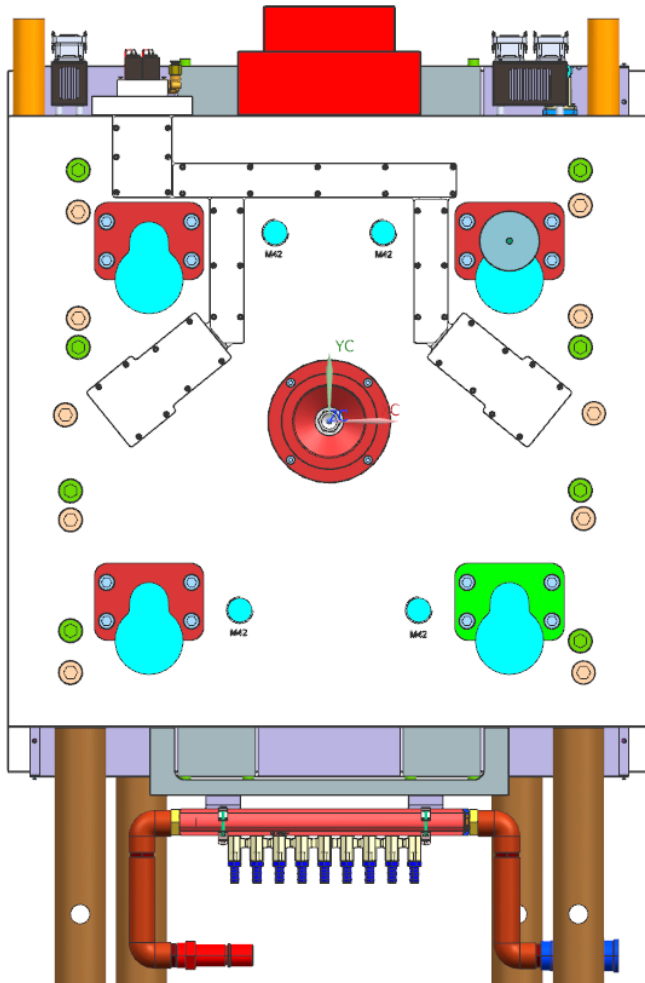
Mold



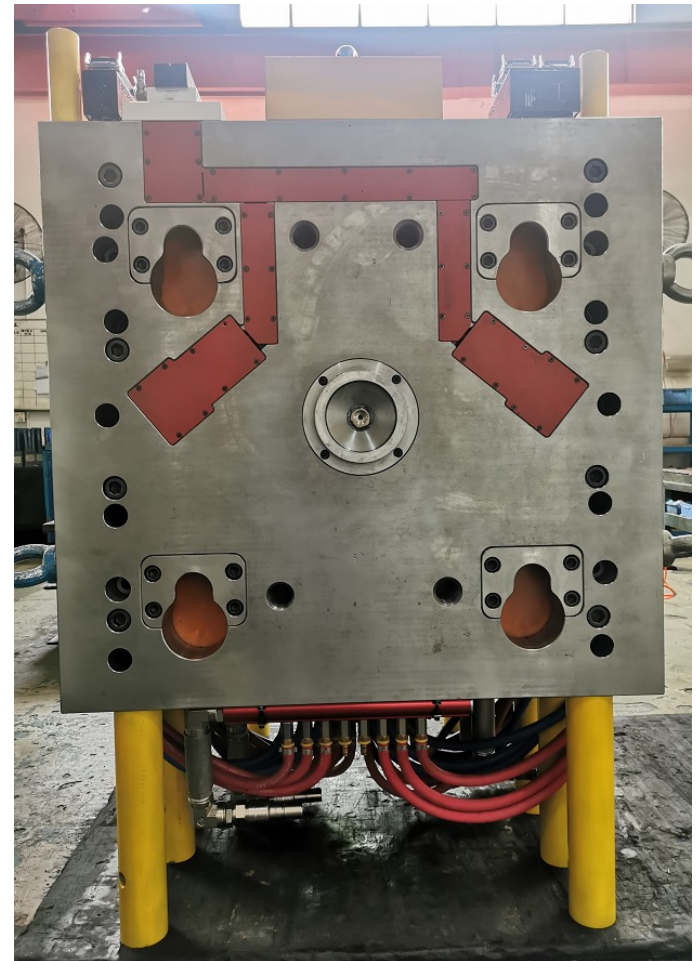
Clamp plate in core side

Pictures of the mold

Design



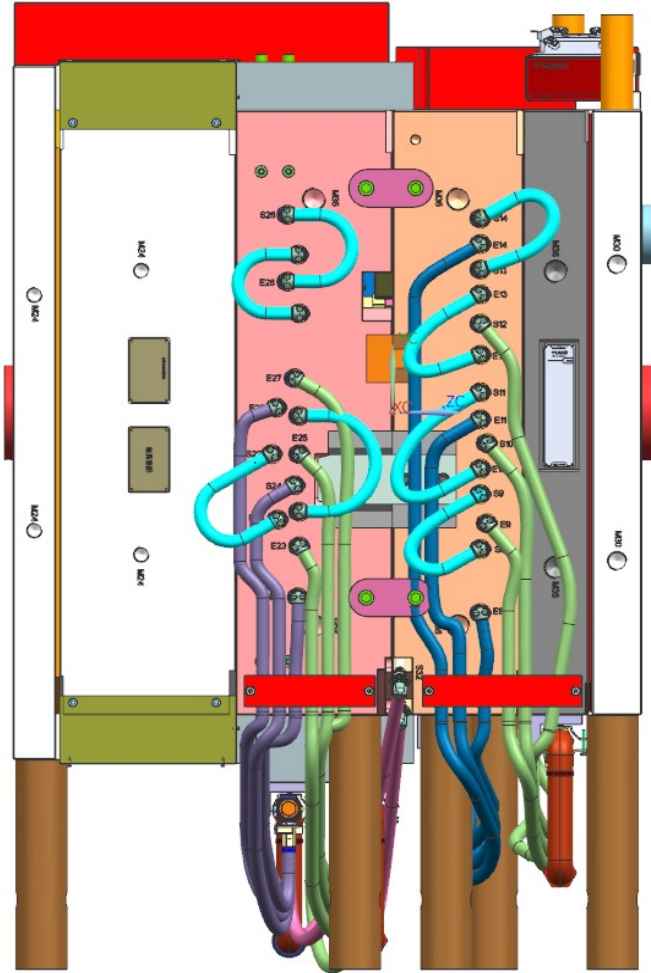
Mold



Clamp plate in cavity side

Pictures of the mold

Design



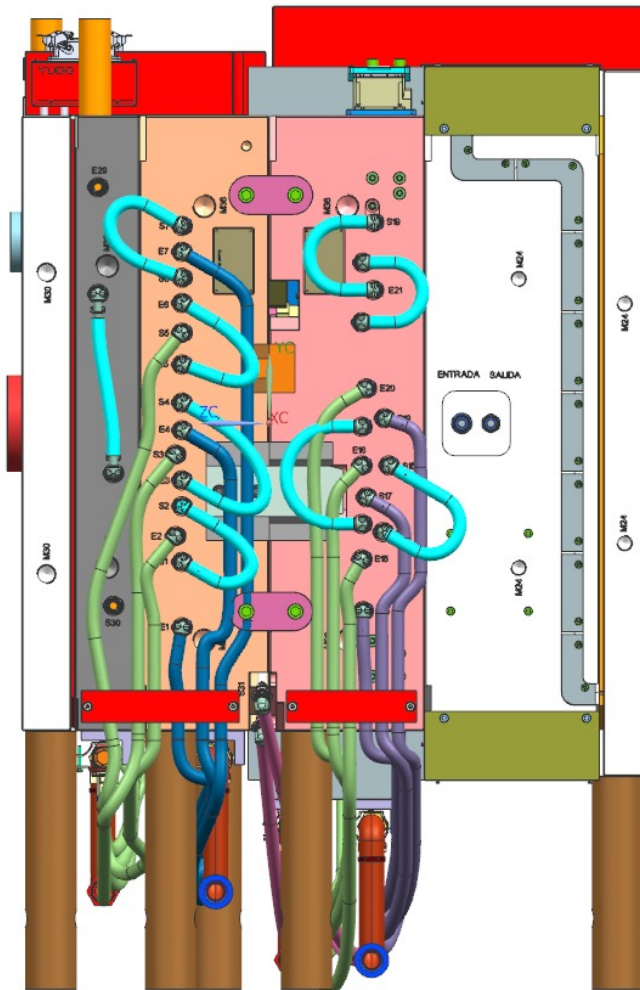
Mold



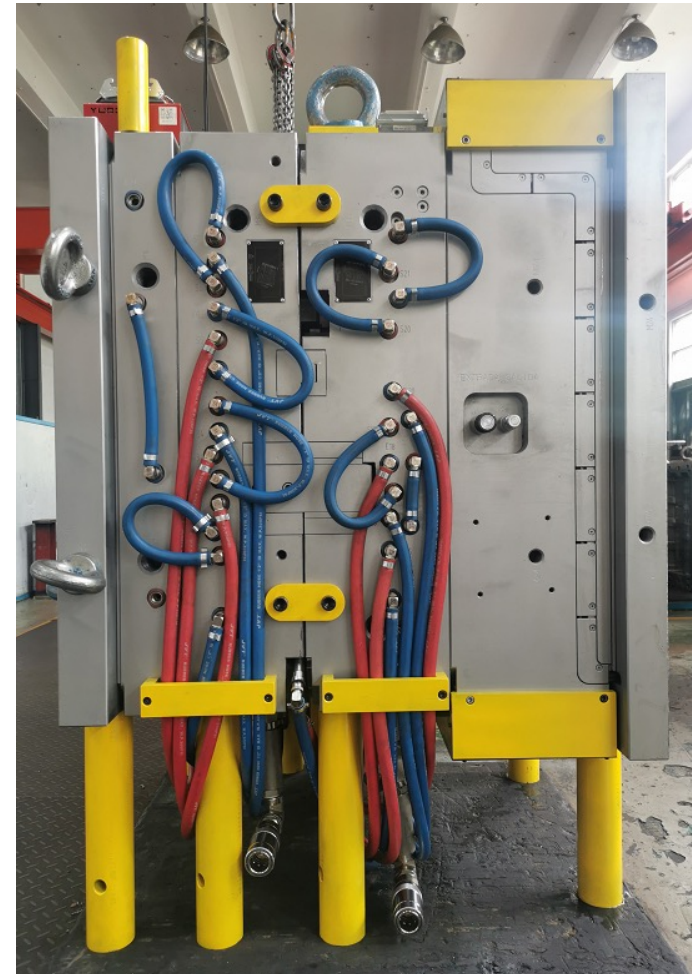
Operator side

Pictures of the mold

Design



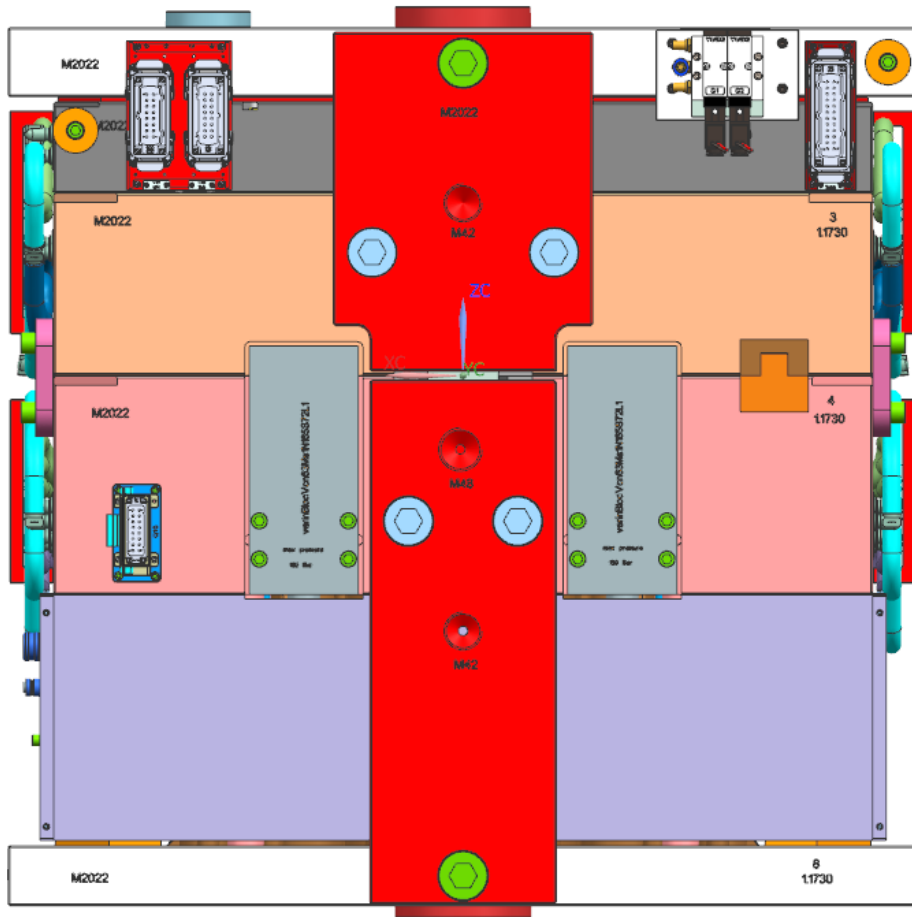
Mold



Opposite side

Pictures of the mold

Design



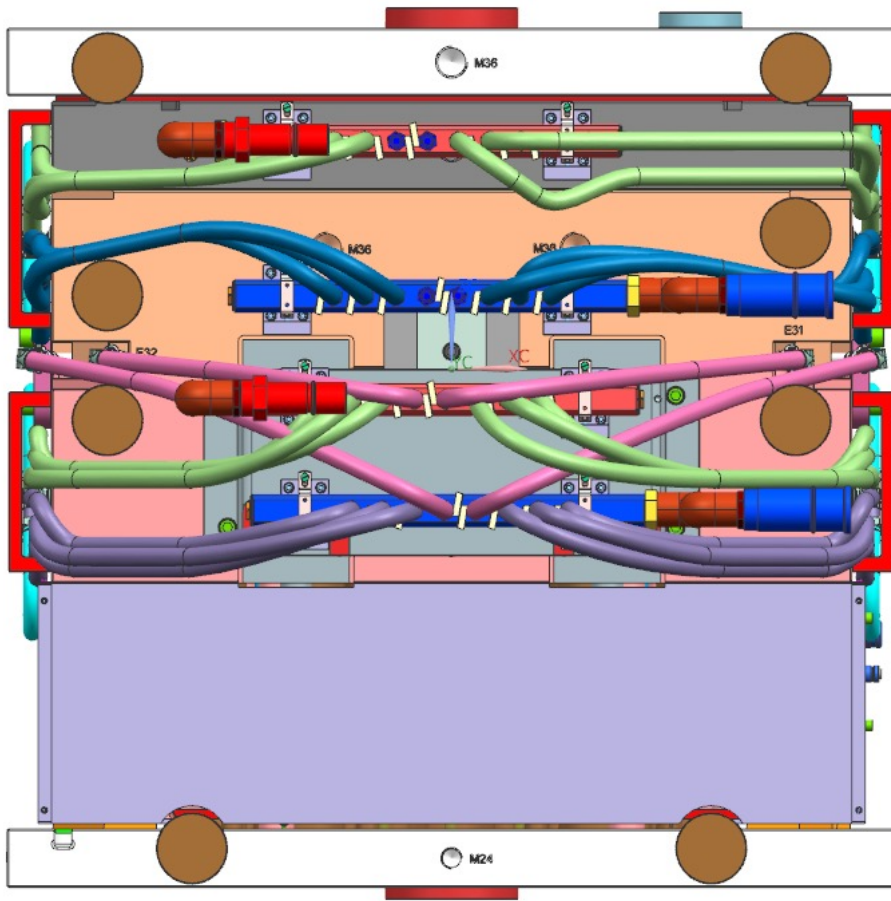
Mold



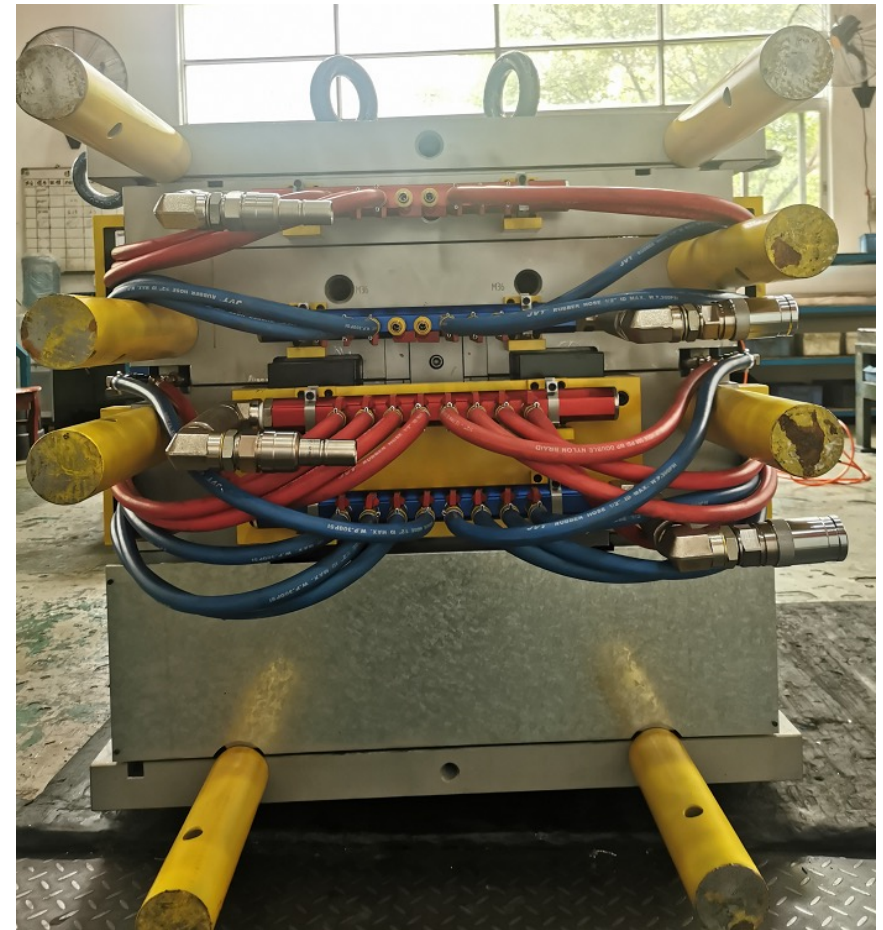
Top side

Pictures of the mold

Design



Mold



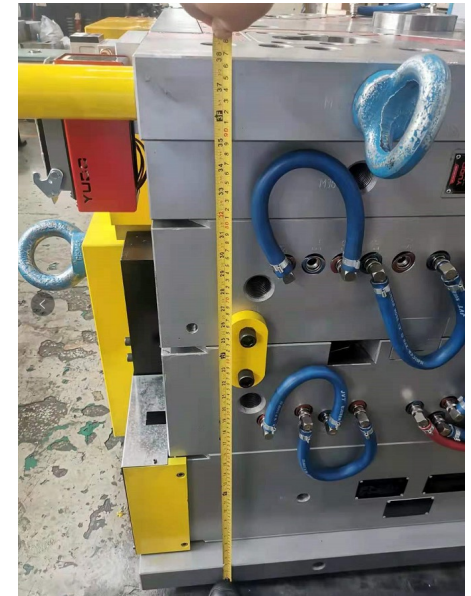
Bottom side

Structure

Standard

Caption (mm)										
A = width					F = thickness of plate to cover ejectors					
B = thickness clamping plates					G = distance between ejector plates and clamping plate (stops type mushrooms)					
C = incision for clamping mold to machine					d1 = guide columns diameter					
D = clamping incision depth					T1 = Screws for structure					
E = thickness of plate to carry up ejectors					T2 = Screws for ejector plates					
* = special dimensions according to injection machine										
Group	A	B	C	D	E	F	d1	T1	T2	G
1	166	26	30	20	20	26	16	M10	M8	5
	246/296	26	30	20	20	26	24	M12	M10	5
	346/396	26	30	20	20	26	30	M12	M10	5
	396	36	40	20	26	36	36	M16	M10	5
	446	36	40	20	26	36	40	M20	M12	5
	496	36	40	20	26	36	40	M20	M12	5
2 y 3	596	60	50	30	36	46	40	M20	M12	5
	696	60	50	30	36	46	40	M20	M12	5
	796	60	50	30	36	46	40	M20	M12	5
	896	60	50	30	36	46	40	M20	M16	5
	>896*	66/76*	50	40	46	56/76*	50/60	M24	M20	5

Mold



Design

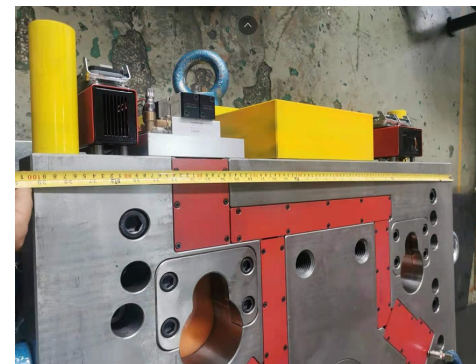
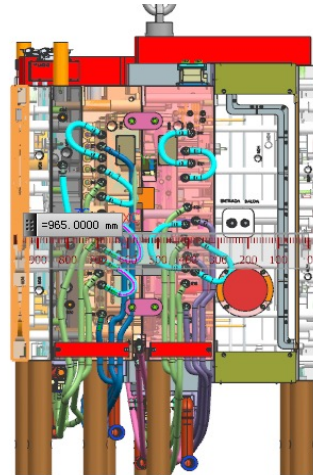
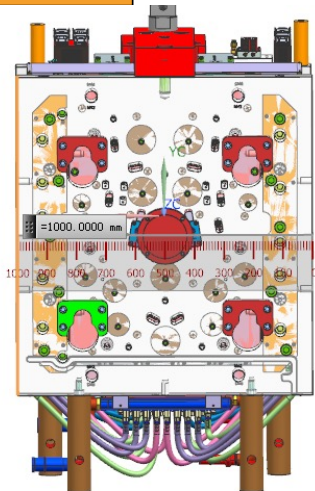


Plate thickness

Standards

Standard

Caption (mm)										
A = width					F = thickness of plate to cover ejectors					
B = thickness clamping plates					G = distance between ejector plates and clamping plate (stops type mushrooms)					
C = incision for clamping mold to machine					d1 = guide columns diameter					
D = clamping incision depth					T1 = Screws for structure					
E = thickness of plate to carry up ejectors					T2 = Screws for ejector plates					
* = special dimensions according to injection machine										
Group	A	B	C	D	E	F	d1	T1	T2	G
1	166	26	30	20	20	26	16	M10	M8	5
	246/296	26	30	20	20	26	24	M12	M10	5
	346/396	26	30	20	20	26	30	M12	M10	5
	396	36	40	20	26	36	36	M16	M10	5
	446	36	40	20	26	36	40	M20	M12	5
2 y 3	496	36	40	20	26	36	40	M20	M12	5
	596	60	50	30	36	46	40	M20	M12	5
	696	60	50	30	36	46	40	M20	M12	5
	796	60	50	30	36	46	40	M20	M12	5
	896	60	50	30	36	46	40	M20	M16	5
	>896*	66/76*	50	40	46	56/76*	50/60	M24	M20	5

Mold

Design

NO

Clamp slot injection side

Standards

Standard

Caption (mm)										
A = width					F = thickness of plate to cover ejectors					
B = thickness clamping plates					G = distance between ejector plates and clamping plate (stops type mushrooms)					
C = incision for clamping mold to machine					d1 = guide columns diameter					
D = clamping incision depth					T1 = Screws for structure					
E = thickness of plate to carry up ejectors					T2 = Screws for ejector plates					
* = special dimensions according to injection machine										
Group	A	B	C	D	E	F	d1	T1	T2	G
1	166	26	30	20	20	26	16	M10	M8	5
	246/296	26	30	20	20	26	24	M12	M10	5
	346/396	26	30	20	20	26	30	M12	M10	5
	396	36	40	20	26	36	36	M16	M10	5
	446	36	40	20	26	36	40	M20	M12	5
2 y 3	496	36	40	20	26	36	40	M20	M12	5
	596	60	50	30	36	46	40	M20	M12	5
	696	60	50	30	36	46	40	M20	M12	5
	796	60	50	30	36	46	40	M20	M12	5
	896	60	50	30	36	46	40	M20	M16	5
	>896*	66/76*	50	40	46	56/76*	50/60	M24	M20	5

Mold

Design

NO

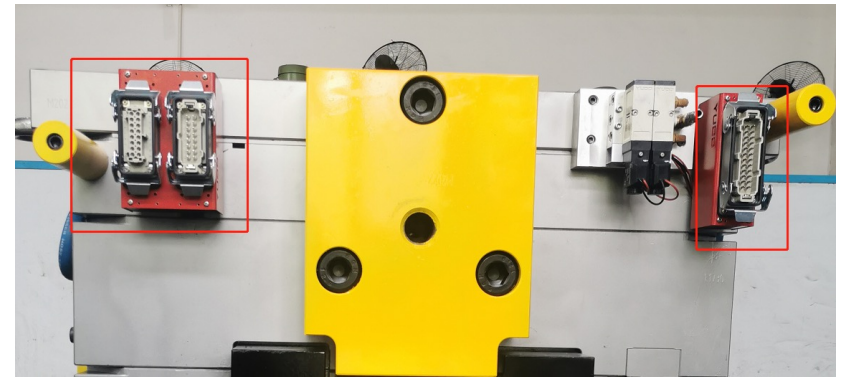
Clamp slot ejection side

Hot runner

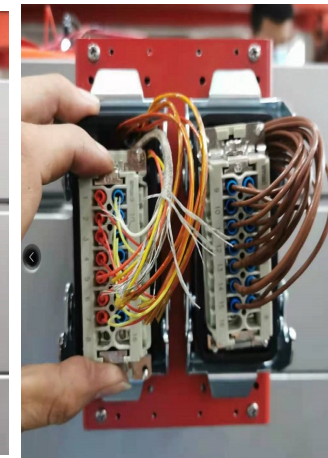
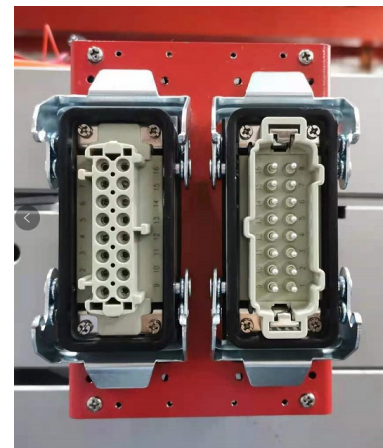
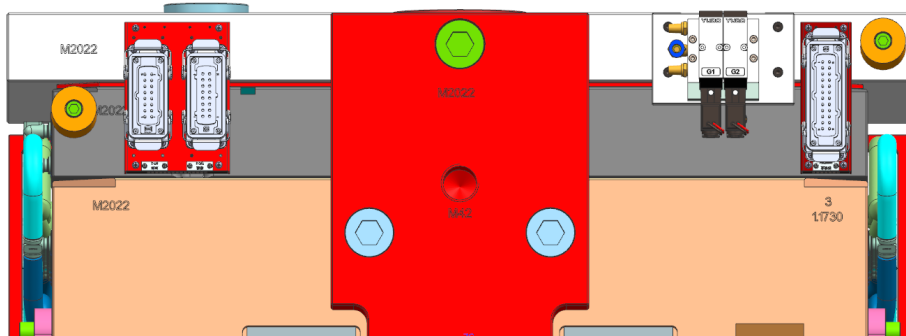
Standard

HARTING CONNECTOR 16 PINS - THERMOCOUPLES		HARTING CONNECTOR 16 PINS - RESISTANCES HOTRUNNER	
MOLD 16 PIN SOCKET Ref. 09 33 016 2701	MACHINE Hose PLUG Thermocouples	MOLD 16 PINS PLUG Ref. 09 33 016 2601	MACHINE Hotrunner Hose Socket
 termopar=1 termopar=2 termopar=3 termopar=4 termopar=5 termopar=6 termopar=7 termopar=8		 Resistencia=1 Resistencia=2 Resistencia=3 Resistencia=4 Resistencia=5 Resistencia=6 Resistencia=7 Resistencia=8	
		 Cover / Hot Runner Ref. 09 30 016 1270	

Mold



Design



Hot runner connections

Hot runner

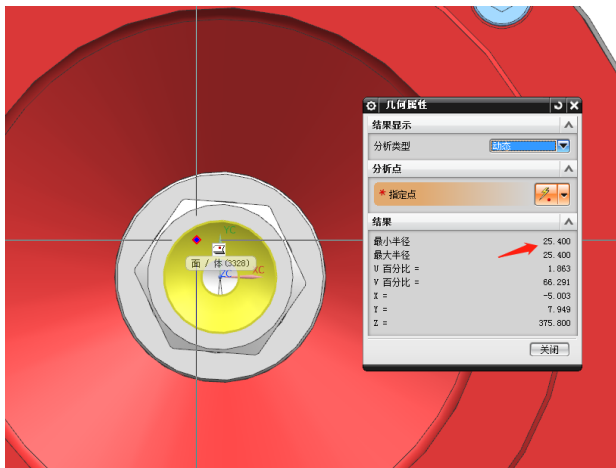
Standard

Machines	Sitting radius	Ø Mold Sprue	Ø Machine Sprue
110TM - 170TM	R25.4	Ø 6	Ø 5
250TM - 650TM		Ø 8	Ø 7
680TM -1800TM		Ø 10	Ø 9

Mold



Design



Injector screw radius

Standards

Standard

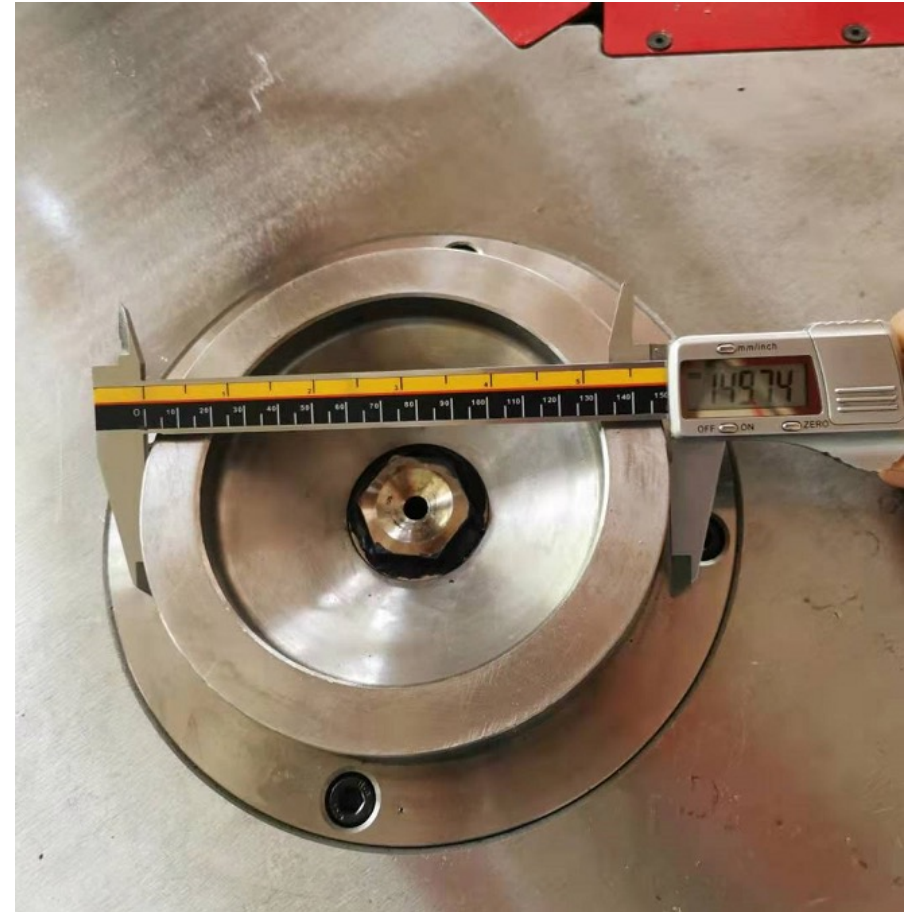
Spain

Machine	Cavity centering ring (mm)	Core centering ring (mm)
110Tn - 170Tn	Ø 99.8	NO
250Tn - 1800Tn	Ø 149.8	Ø 149.8

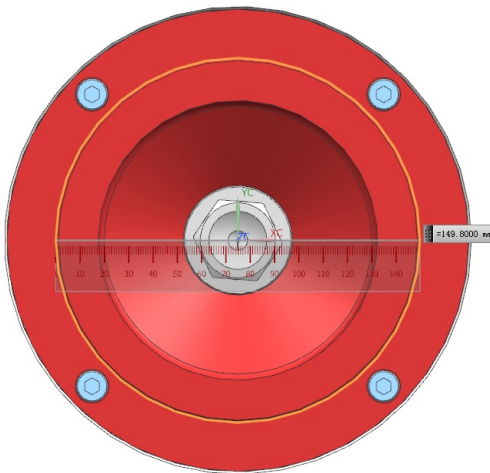
Romania

Machine	Cavity centering ring (mm)	Core centering ring (mm)
40Tn - 320Tn	Ø 99.8	Ø 79.8
550Tn - 1300Tn	Ø 149.8	Ø 149.8

Mold



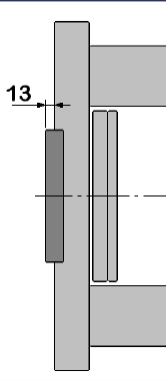
Design



Location ring injection side

Standards

Standard



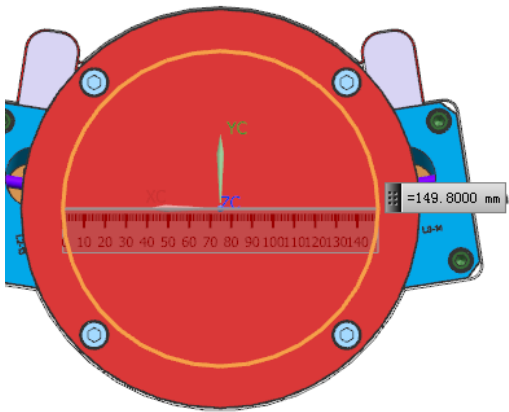
Spain

Machine	Cavity centering ring (mm)	Core centering ring (mm)
110Tn - 170Tn	Ø 99.8	NO
250Tn - 1800Tn	Ø 149.8	Ø 149.8

Romania

Machine	Cavity centering ring (mm)	Core centering ring (mm)
40Tn - 320Tn	Ø 99.8	Ø 79.8
550Tn - 1300Tn	Ø 149.8	Ø 149.8

Design



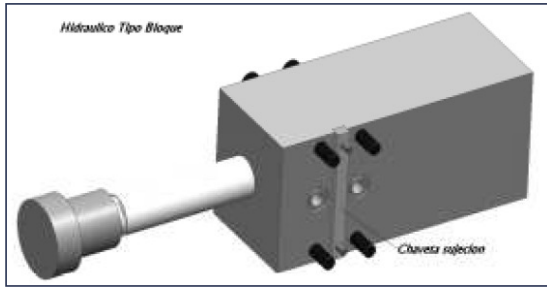
Mold



Location ring ejection side

Standards

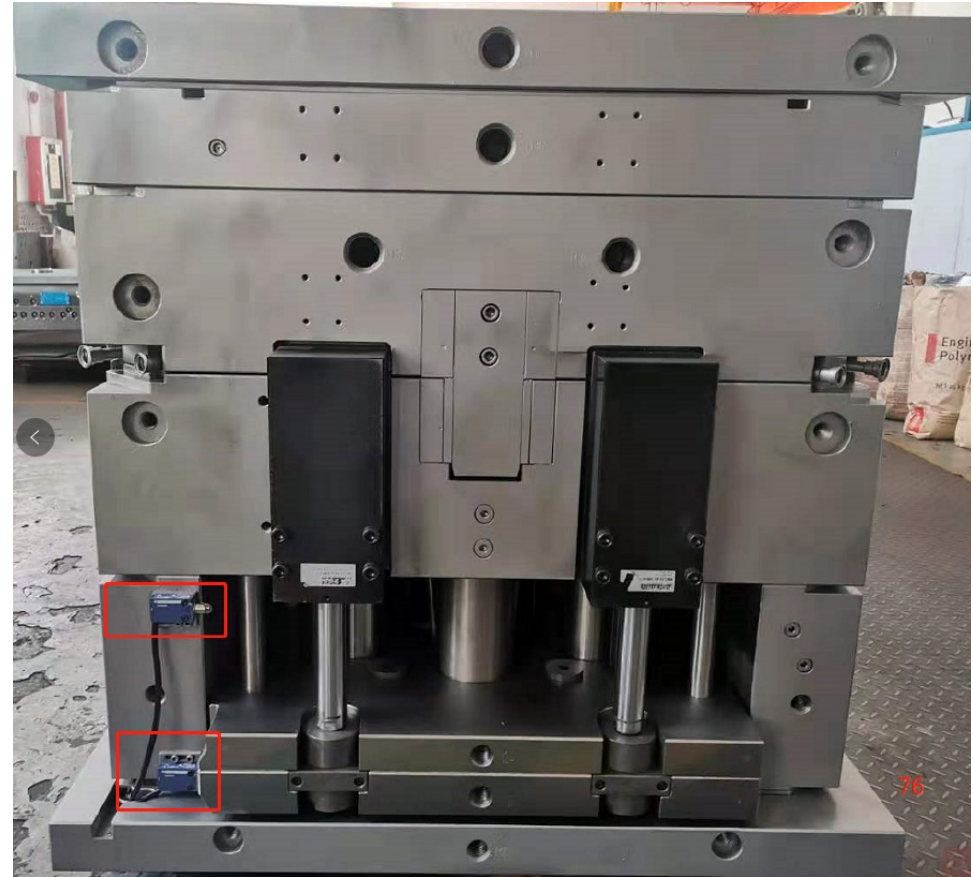
Standard



Machines	Ø Piston (mm)
110 TM -250 TM	Ø32
320 TM -700 TM	Ø50-Ø63
700 TM -1800 TM	Ø63-Ø80

Design

Mold



Hydraulics

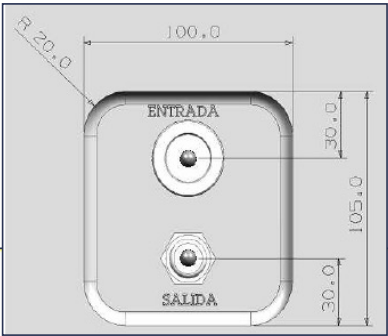
Standards

Standard

* Available with Nitrile seal (NBR) : cancel "JV" code in the part-number

MPX 10

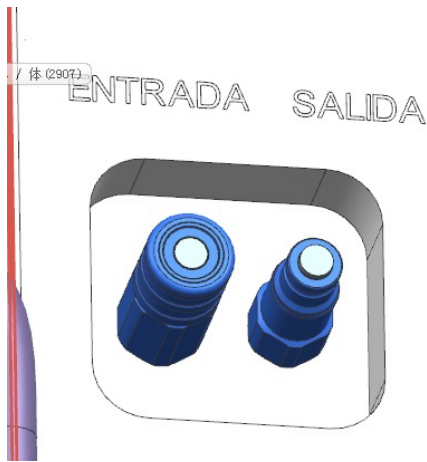
Threads	Dimensions (mm)						Part numbers	
	Socket			Plug		Plug and socket connected	Socket	Plug
F	A	B	C/flats	D	E/flats	G		
G 3/8	65	32	30	60	27	109	MPX 10.1102 / JV *	MPX 10.7102 / JV *



Mold



Design

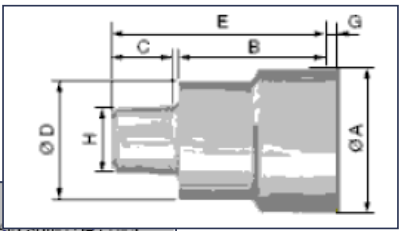


Hydraulic connections

Standards

Standard

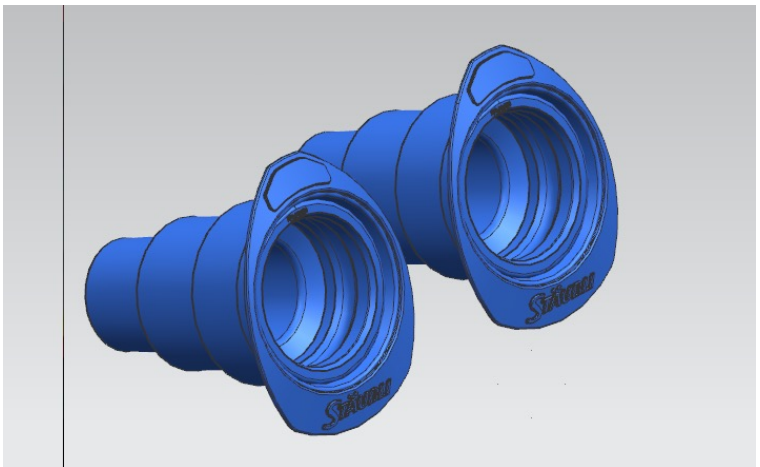
Modelo	Rosca H	Dimensiones (mm)							Sin anillo de color
		OA	B	C	OD	E	G	Llave Hexagonal	
RPL 06	R 1/8	17	18.5	7.5	14	28.5	1.5	6	RPL 06.1150
	NPT 1/8	17	18.5	7	14	28.5	1.5	6	RPL 06.1250
	R 1/4	17	15.5	11	14	28.5	1.5	6	RPL 06.1151
	NPT 1/4	17	-	11	-	29.5	1.5	6	RPL 06.1251
RPL 08	R 1/8	21	22	8	17.5	32	1.5	6	RPL 08.1150
	NPT 1/8	21	22	7	17.5	32	1.5	1/4"	RPL 08.1250
	R 1/4 (G)	21	21	10	17.5	33	1.5	8	RPL 08.1151
	NPT 1/4	21	21	11	17.5	33	1.5	5/16"	RPL 08.1251



Mold



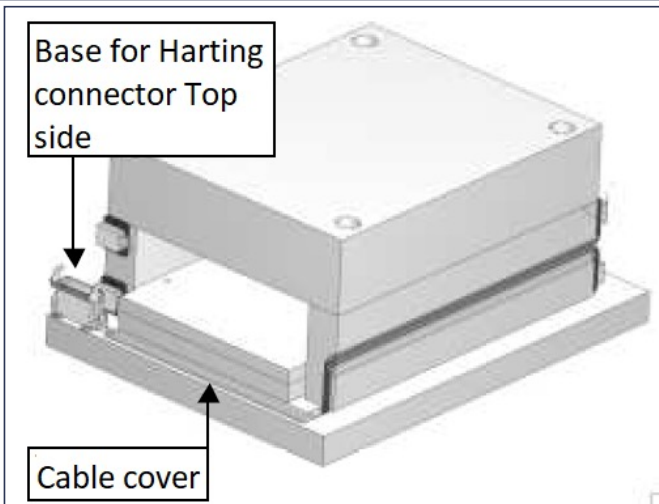
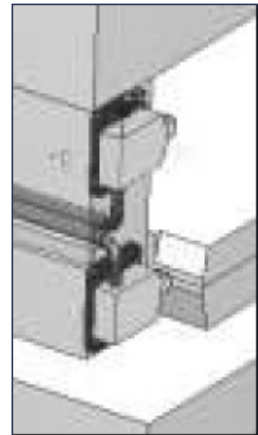
Design



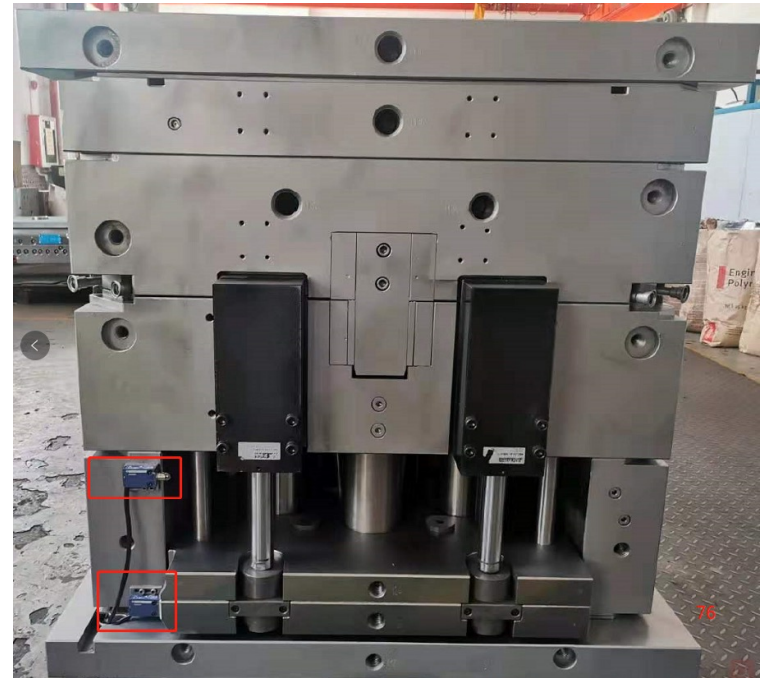
Cooling connector plug

Standards

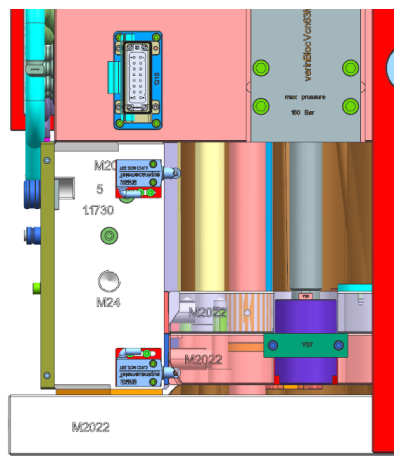
Standard



Mold



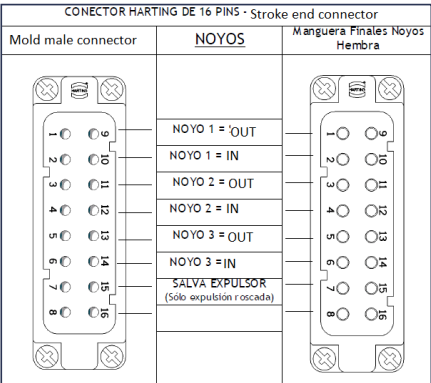
Design



Location of limit switch with connector plug

Standards

Standard



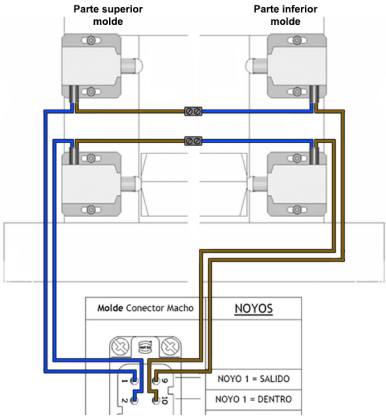
Mold



Conector HARTING	Interruptor TELEMECANIQUE
Macho-09 20 016 2612	XCMD-A1023
Hembra-09 20 016 2812	
Base- 09 20 016 0252	

Design

Conexiones electricas para micros de seguridad



Connections of limit switch with connector plug

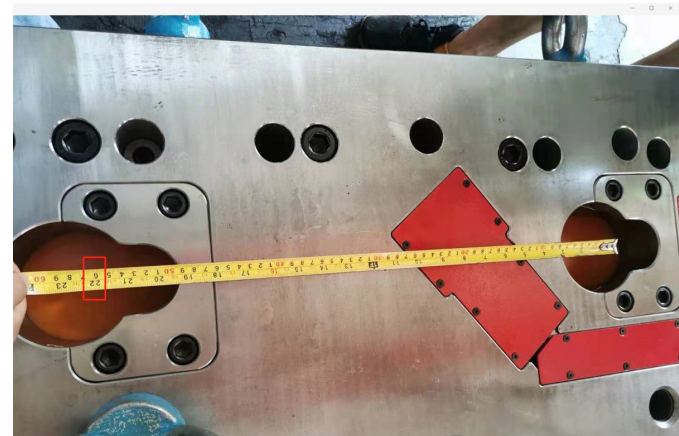
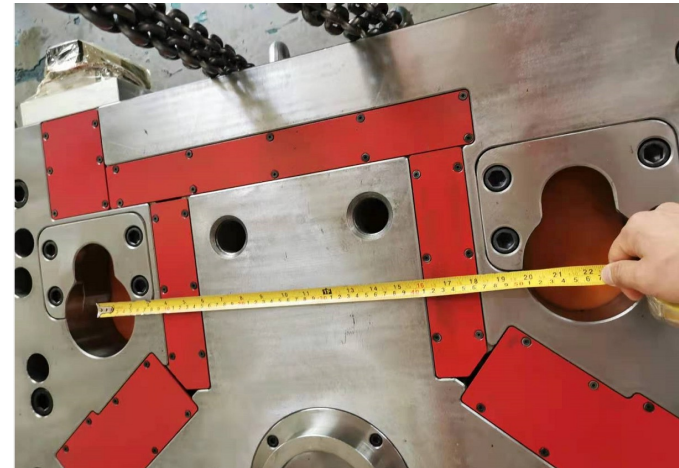
Standards

Standard

- Quick Clamp **280 x 560** : for injection machines from 250 to 320 TM
- Quick Clamp **560 x 560** : for injection machines from 450 to 850 TM
- Double Quick Clamp **560 x 560 - 840 x 840** : for injection machines from 1000 Tn. This distribution only is required if the mold could be mounted over 800 TM injection machines because the dimension allows the assembly
- Quick Clamp **840 x 840** : for injection machines from 1000 to 1800 TM

Design

Mold

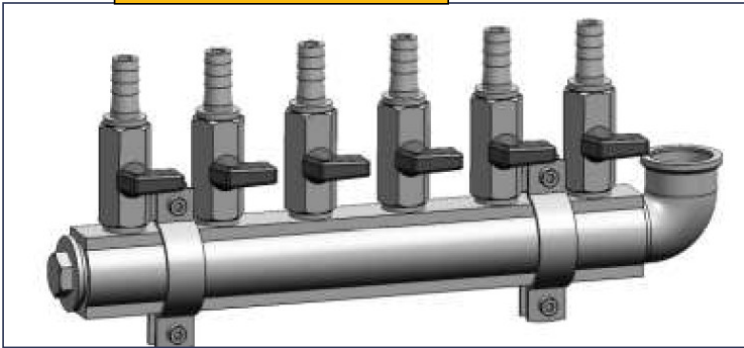


Quick clamping plates

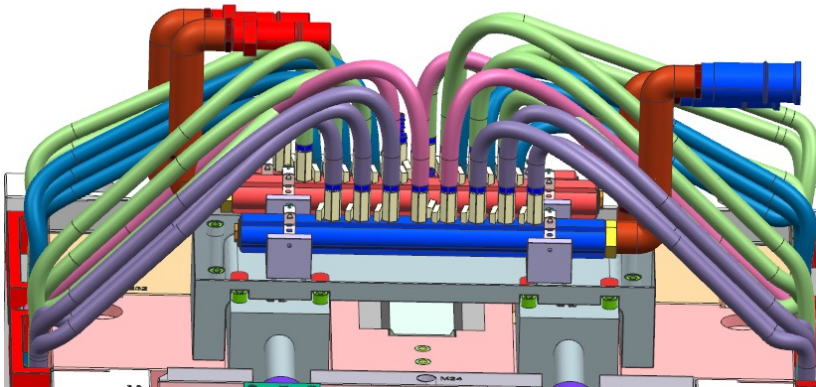
Standards

Standard

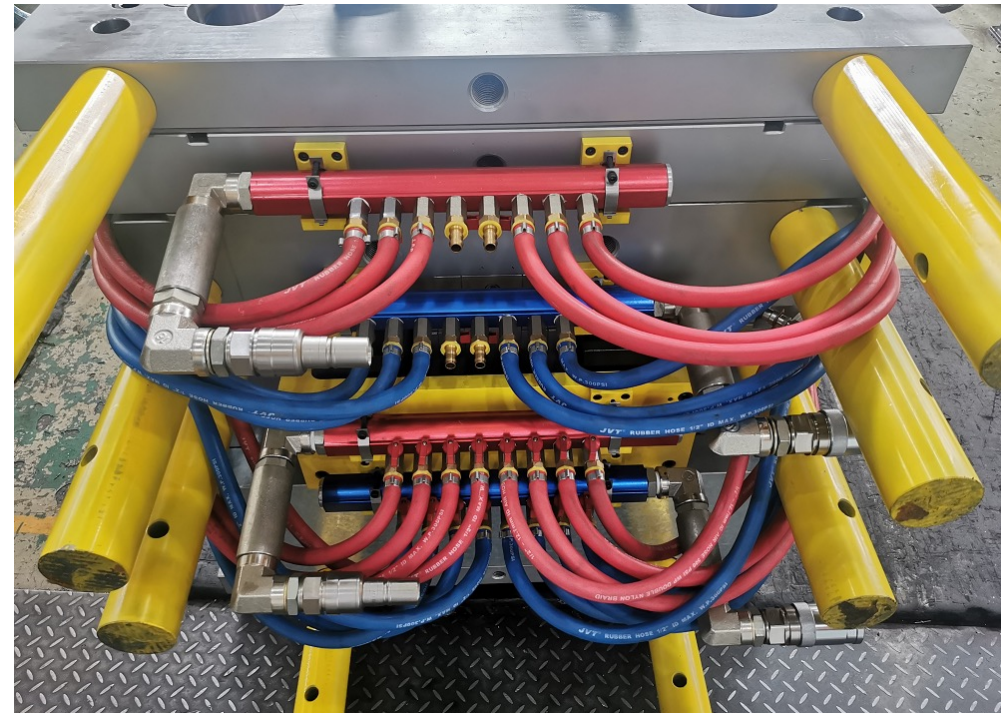
BLUE = ENTRY
RED = EXIT



Design



Mold

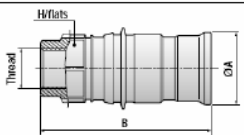
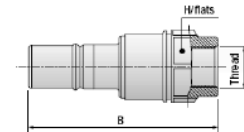


Water manifolds

Standards

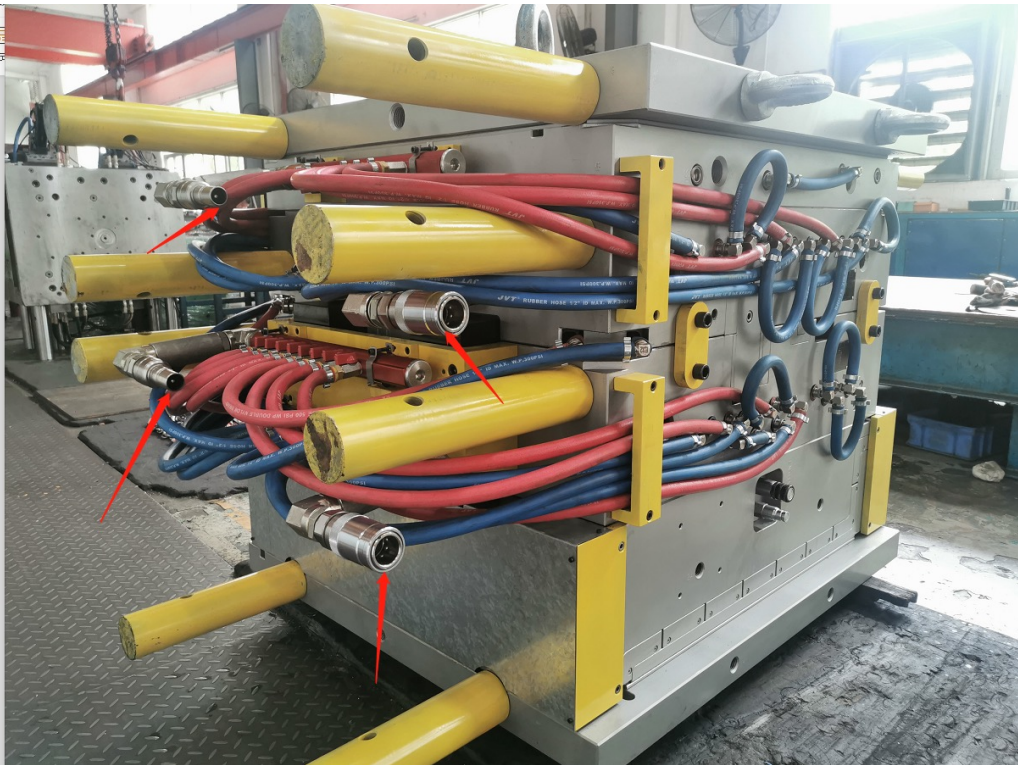
Standard

FEMALE = ENTRY
MALE = EXIT

DESIGNATIONS	MODELS	DIMENSIONS (mm)					PART-NUMBERS
		F	ØA	B	H/flats	D	
	RMI 20	G 3/4	53	119.5	42		RMI 20.1104/EA/JV
	RMI 20	G 3/4	126.5		42		RMI 20.7104/EA/JV

Design

Mold



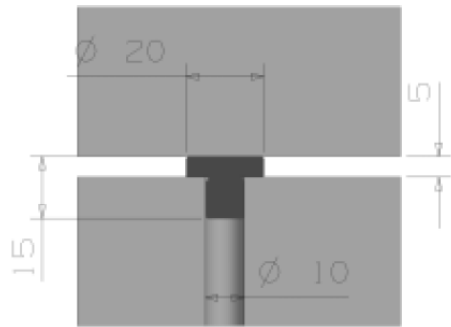
Staubli original components

Standards

Standard

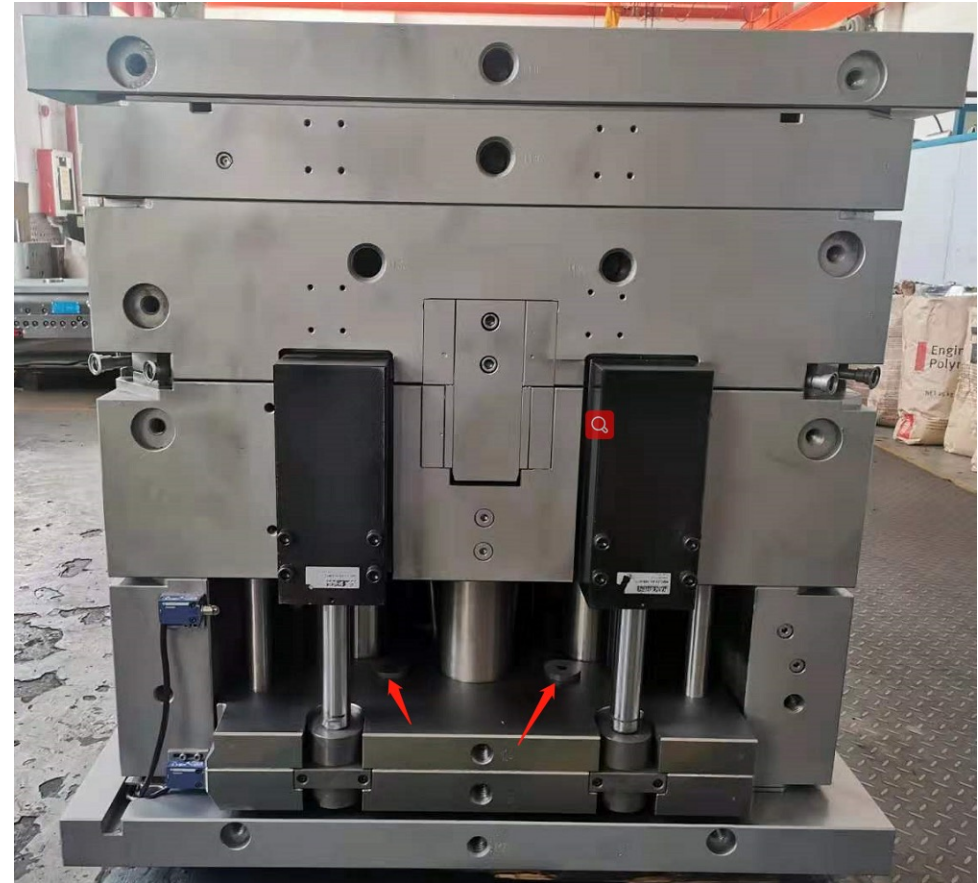
7.3 EJECTION STOPPERS (EJECTION MUSHROOMS)

The ejection stoppers will be the same for all the molds. See below picture:



Design

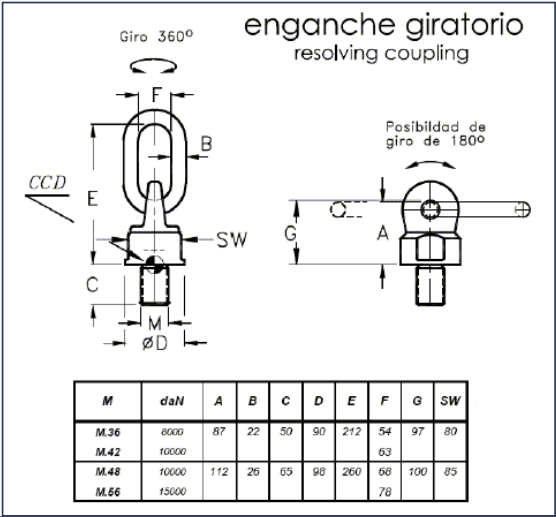
Mold



Ejection stoppers

Standards

Standard



Mold

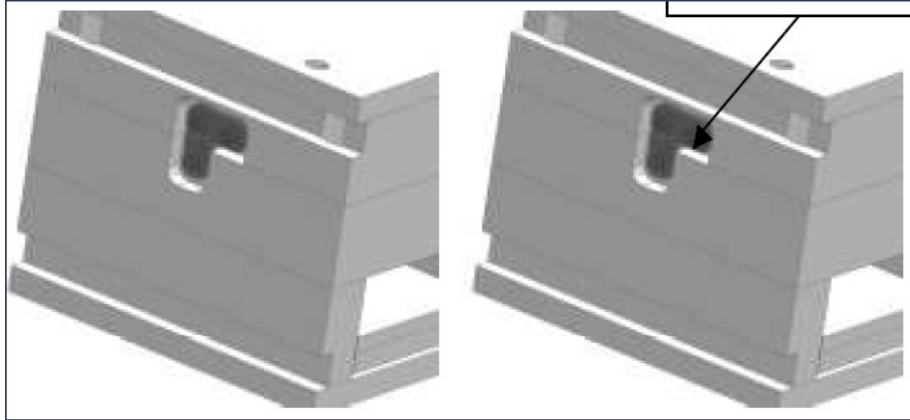


Design

Eyebolts

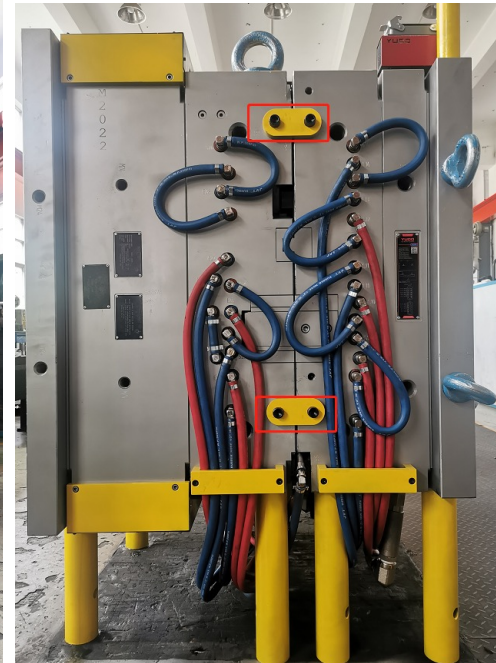
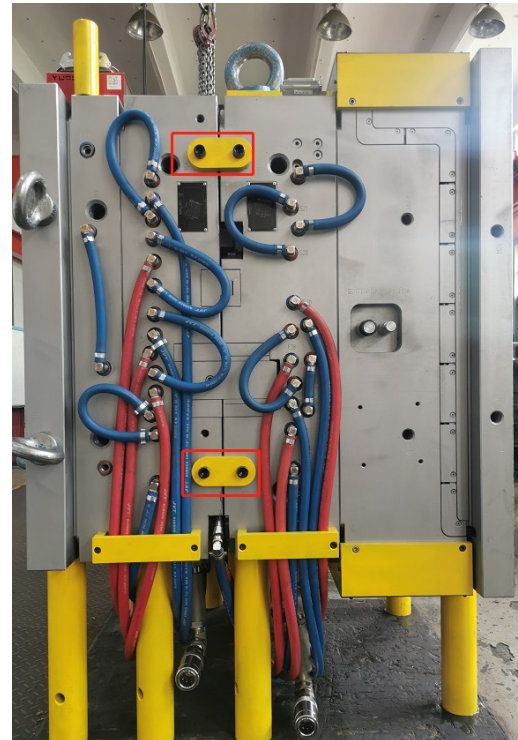
Standards

Standard



Design

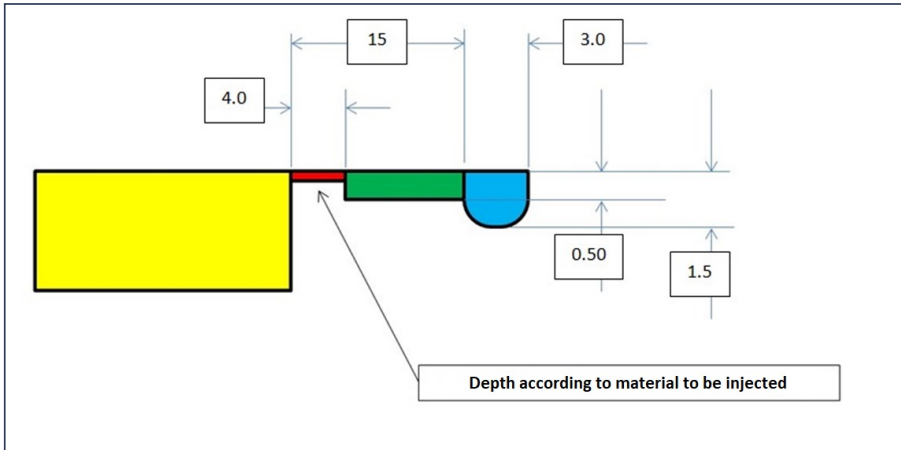
Mold



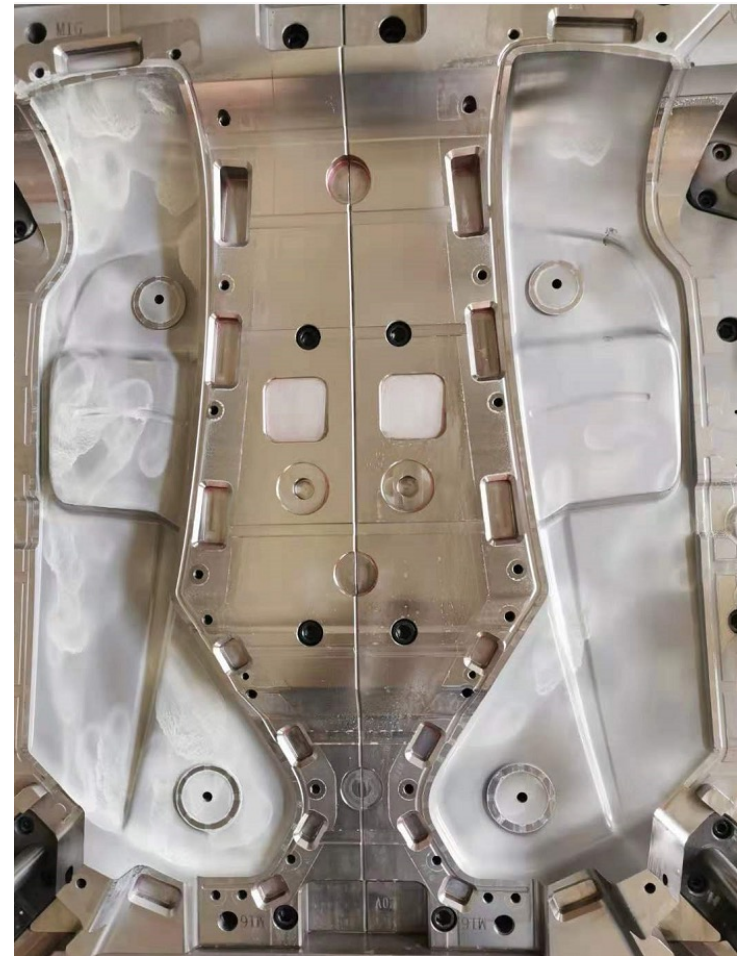
Safe locks

Standards

Standard



Mold

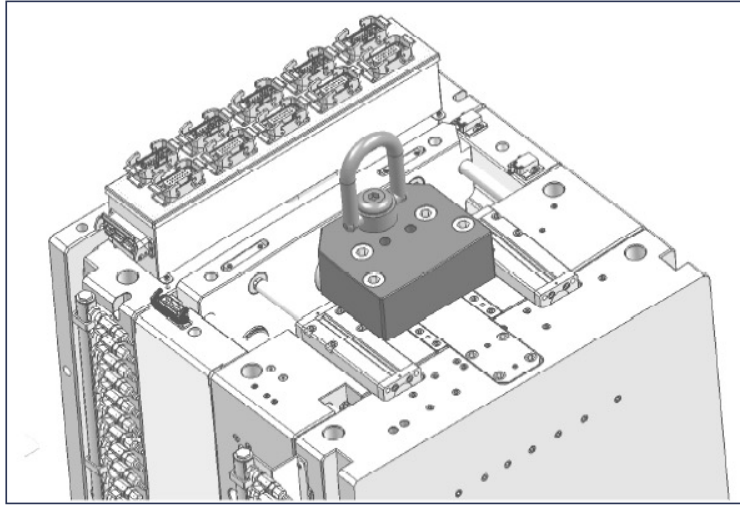


Design

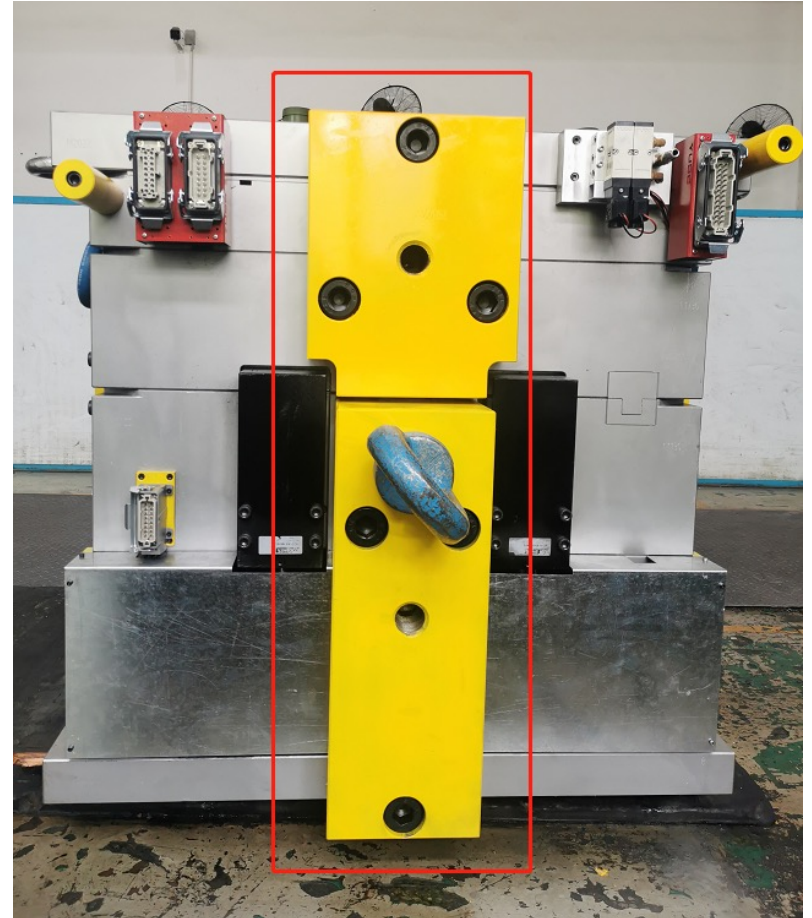
Gas venting 排气

Standards

Standard



Mold



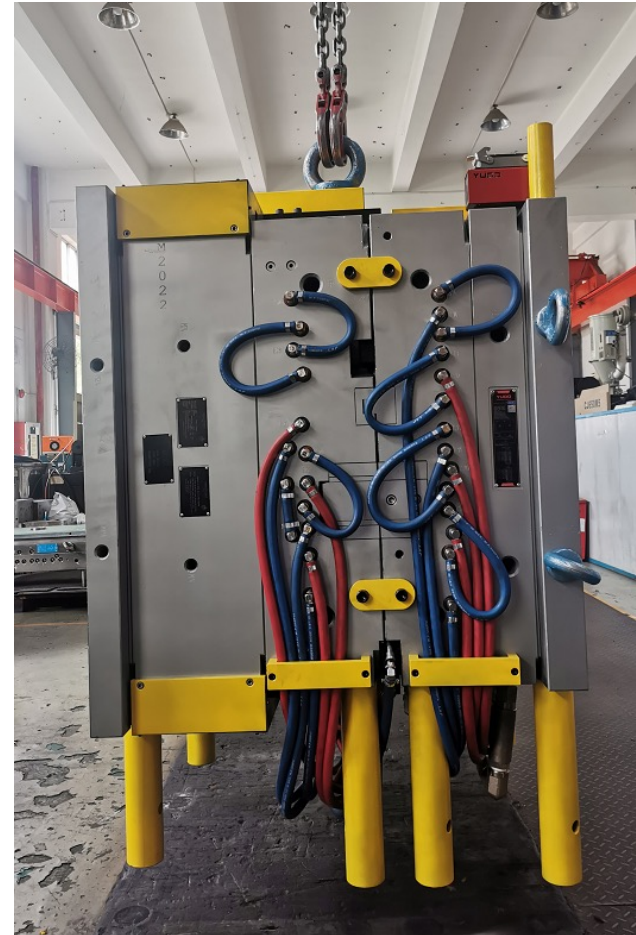
Design

Lift bar

Standards

Design

Mold



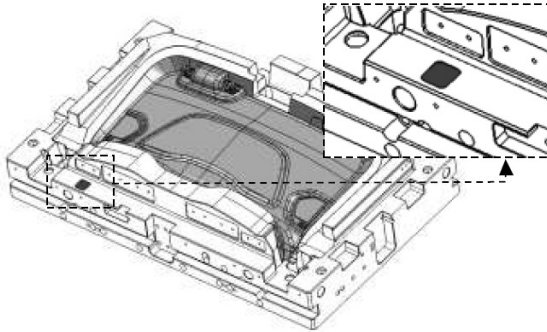
Balanced lifting

Texture

Standard

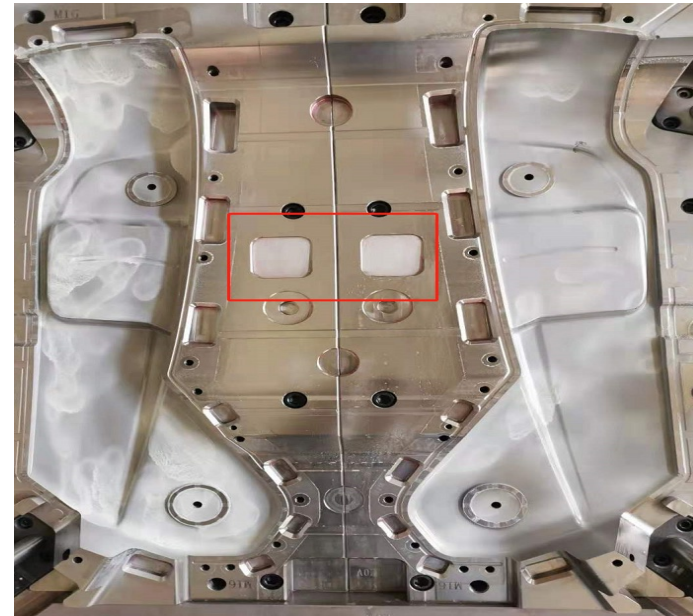
2.6.2 SAMPLE FOR TEXTURE

The cavities will be being acid etched or textured must have a 50x50mm area in the closing area and must be marked. This area must be polished as the rest of cavity to be etched and to be test of texture during lifecycle of mold.



Design

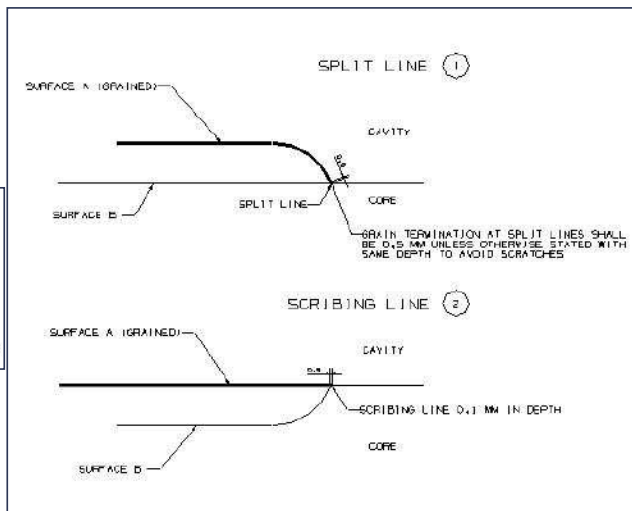
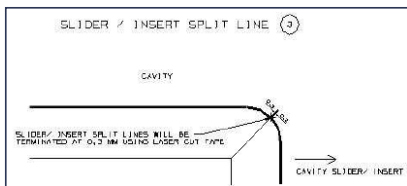
Mold



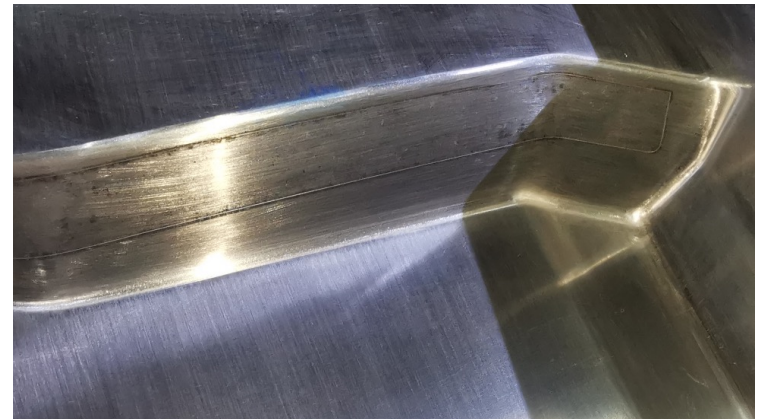
Texture sample

Texture

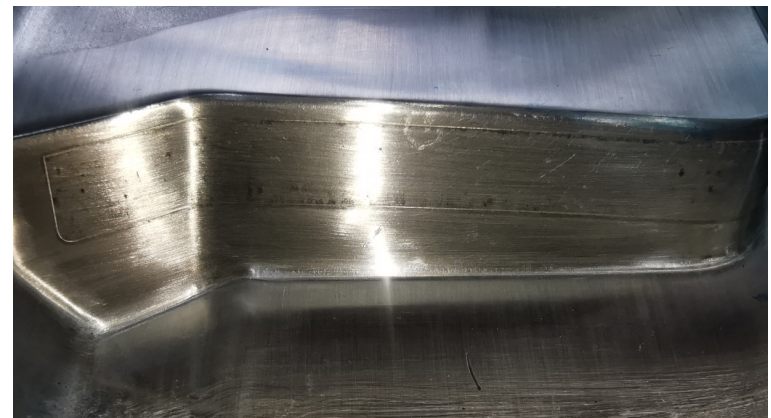
Standard



Mold



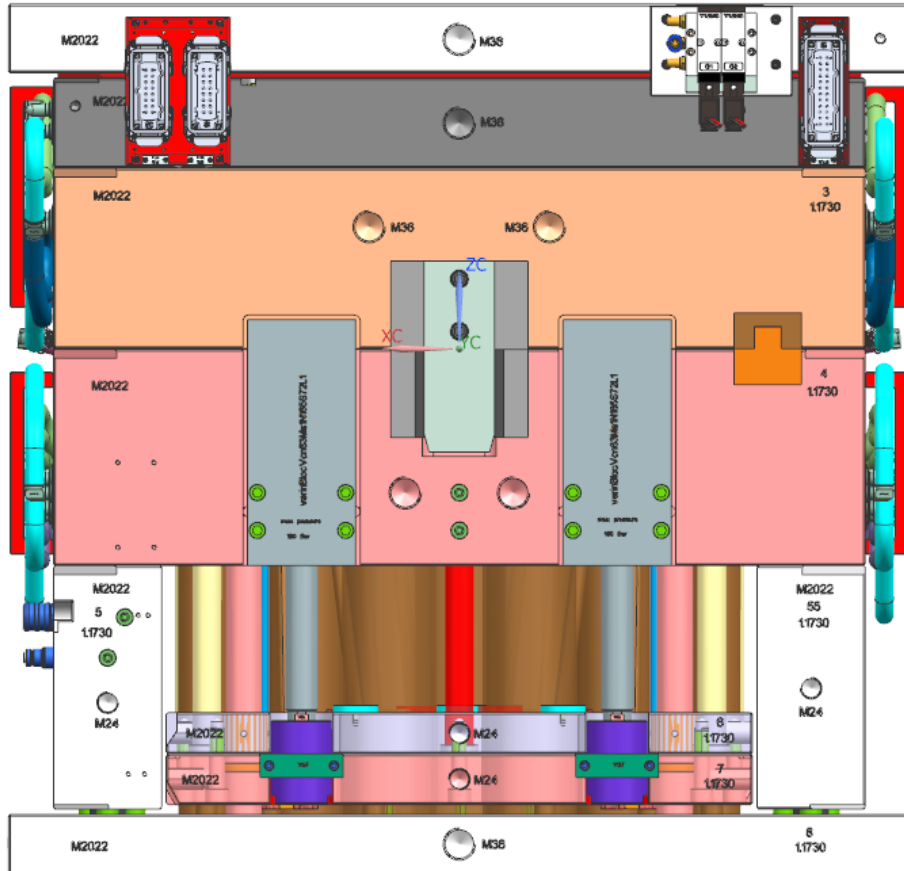
Design



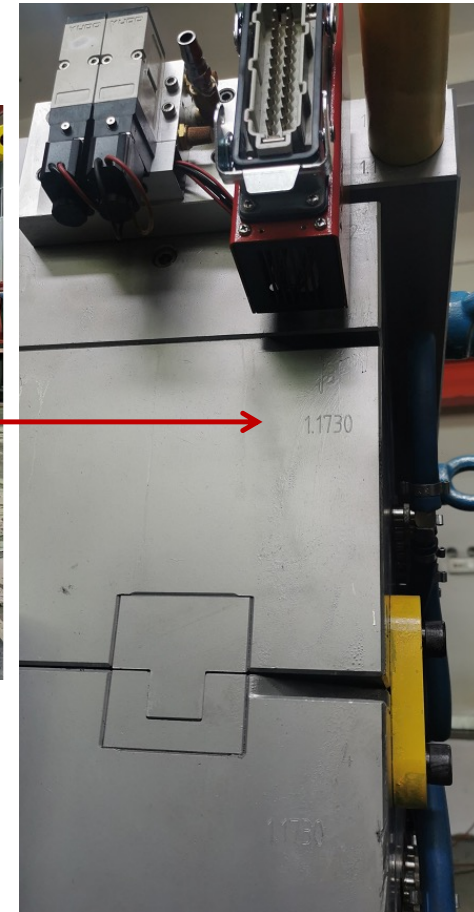
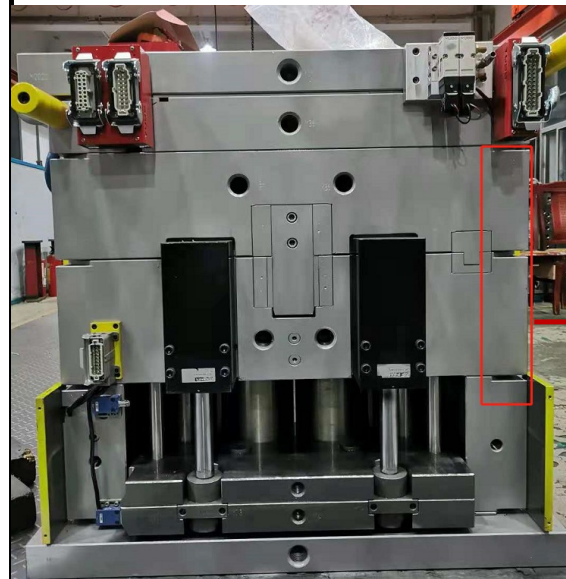
Scribing lines

Engravings

Design



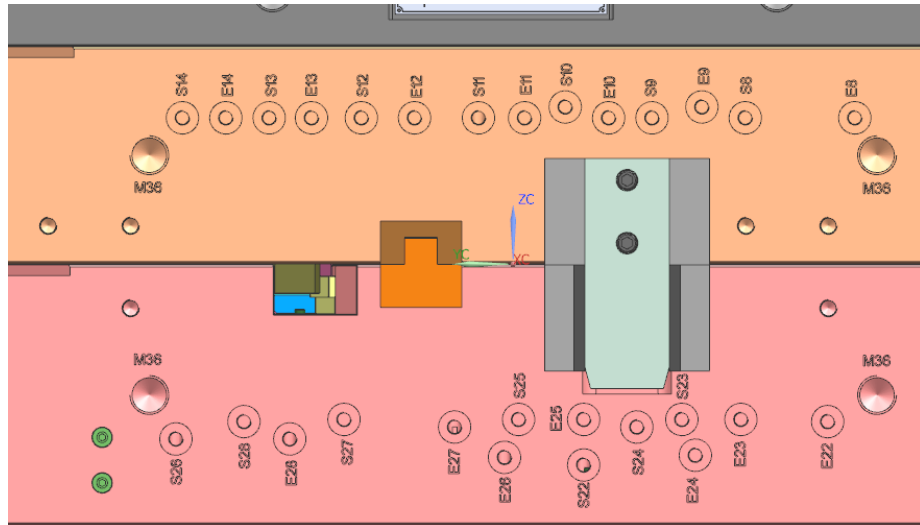
Mold



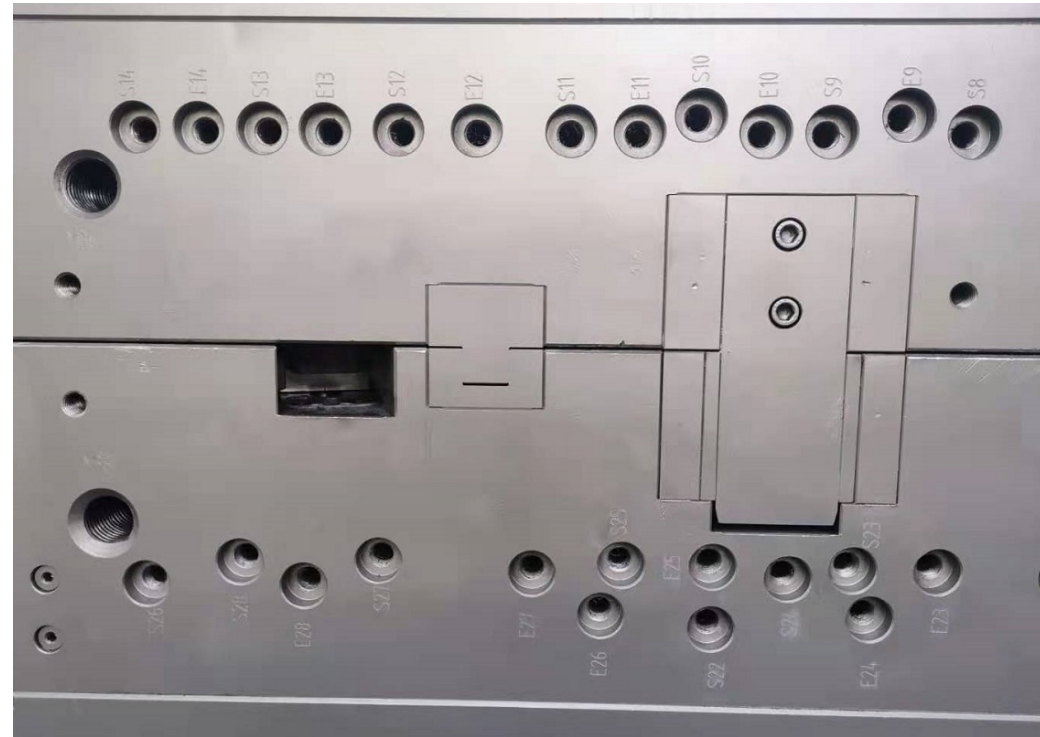
Mold base

Engravings

Design



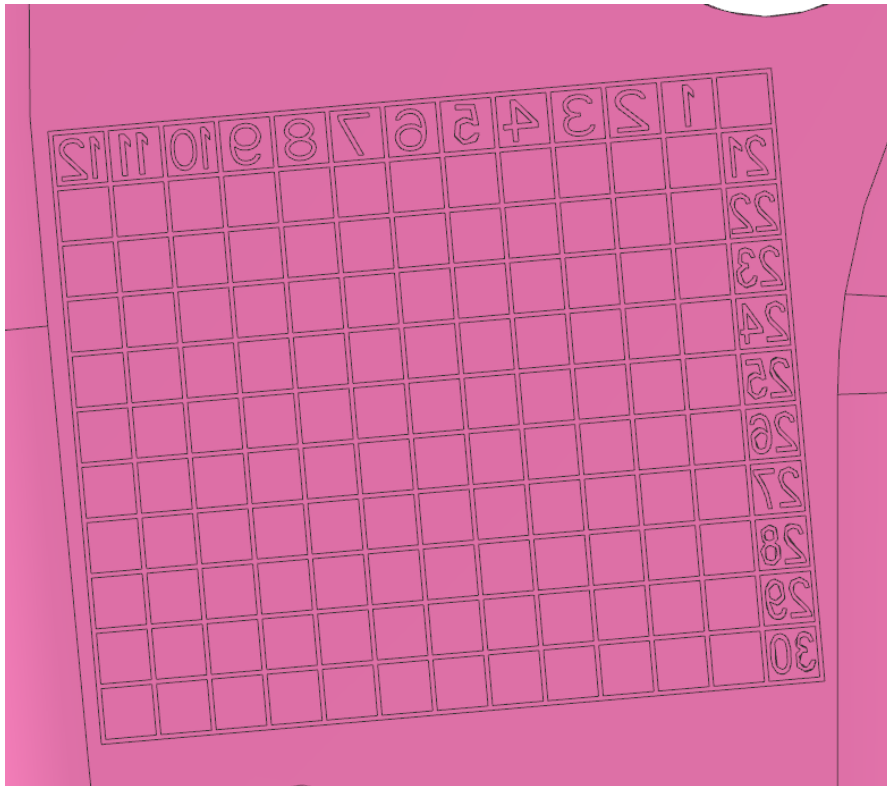
Mold



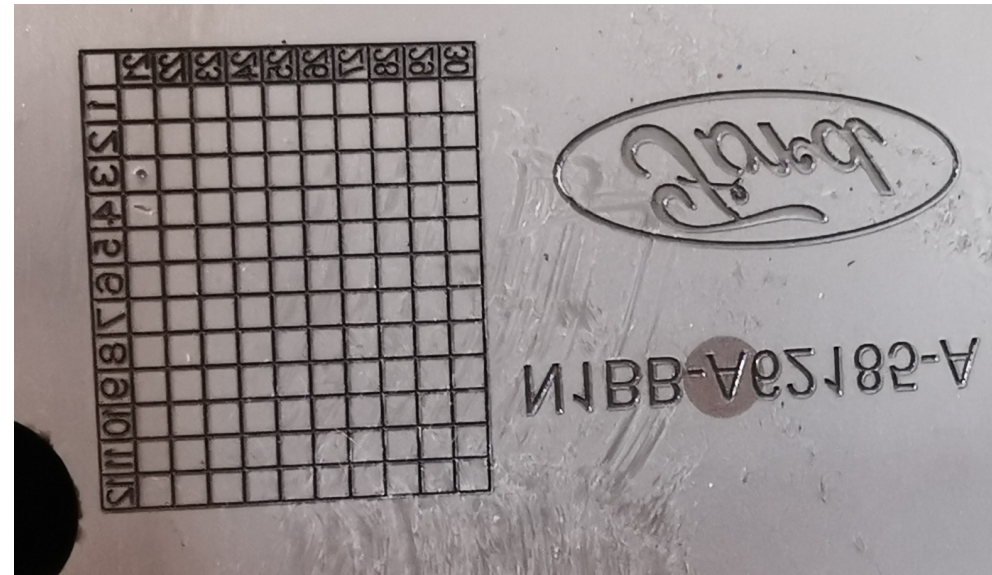
Cooling

Engravings

Design



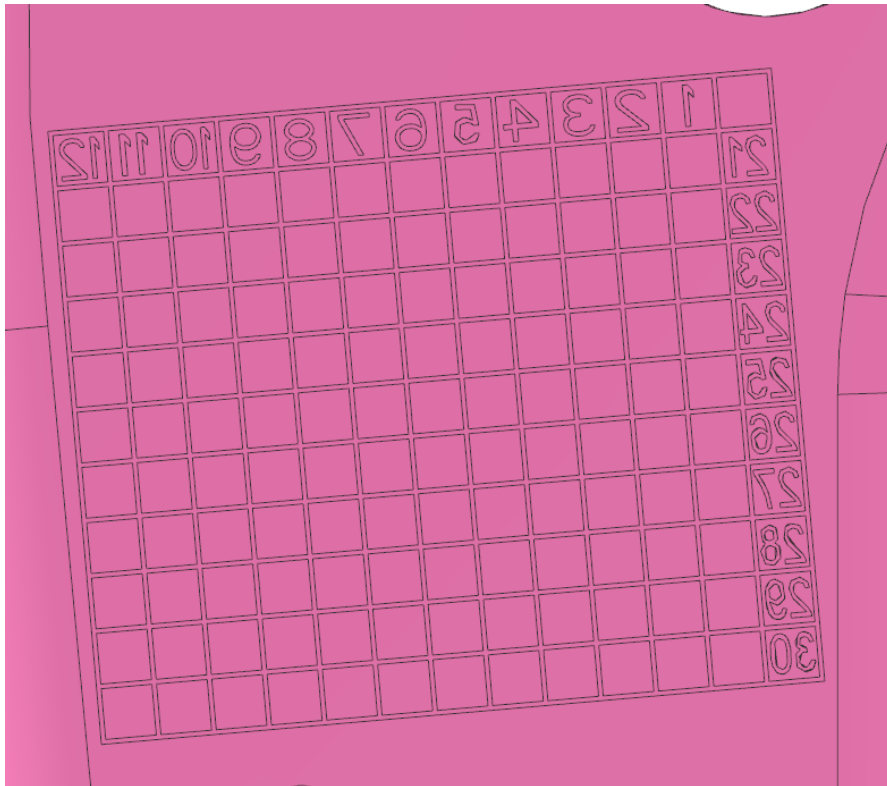
Mold



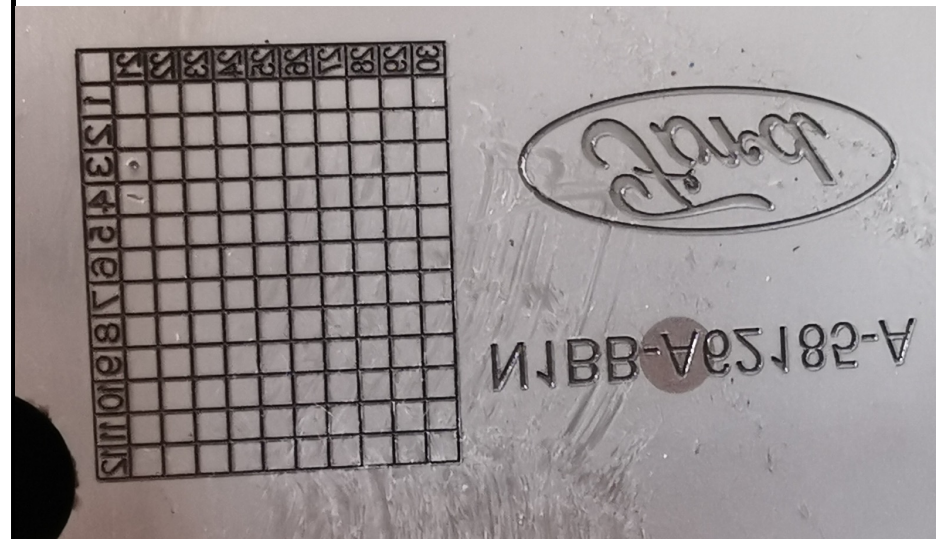
Position of original CUMSA date clocks

Engravings

Design



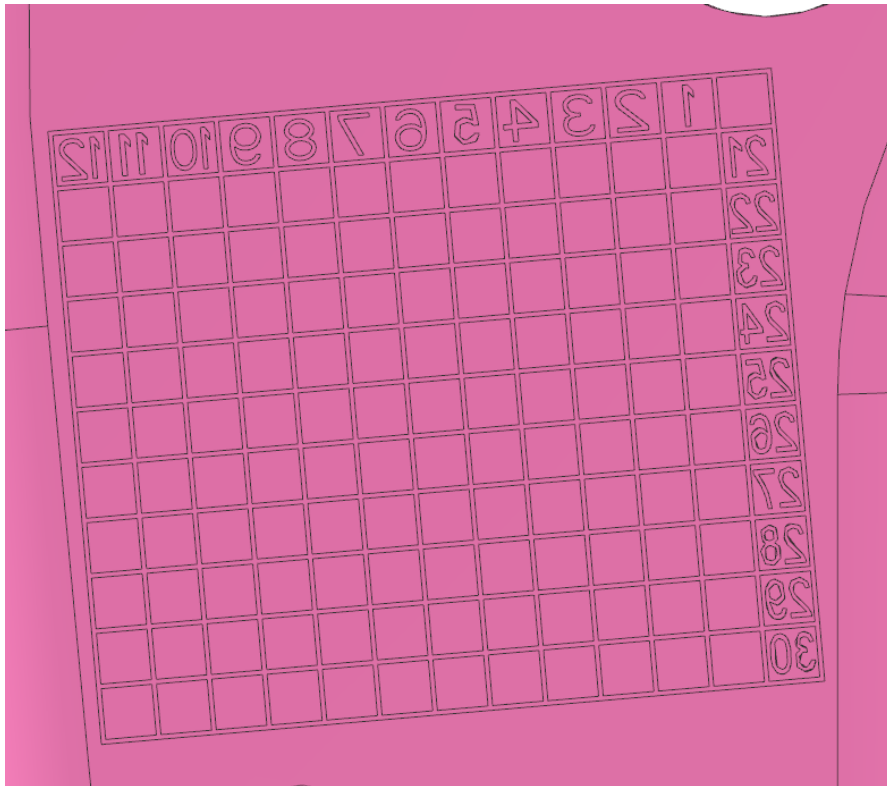
Mold



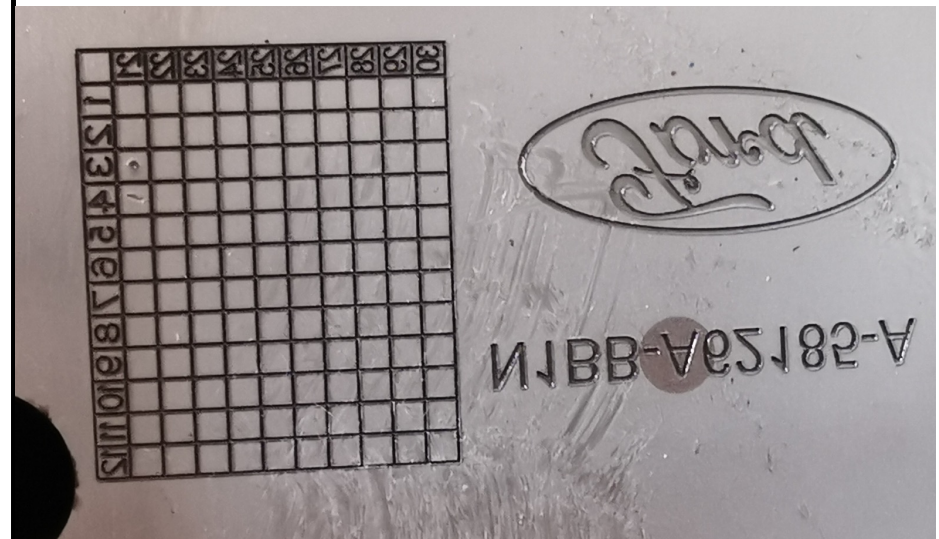
Dimensions of original CUMSA date clocks

Engravings

Design



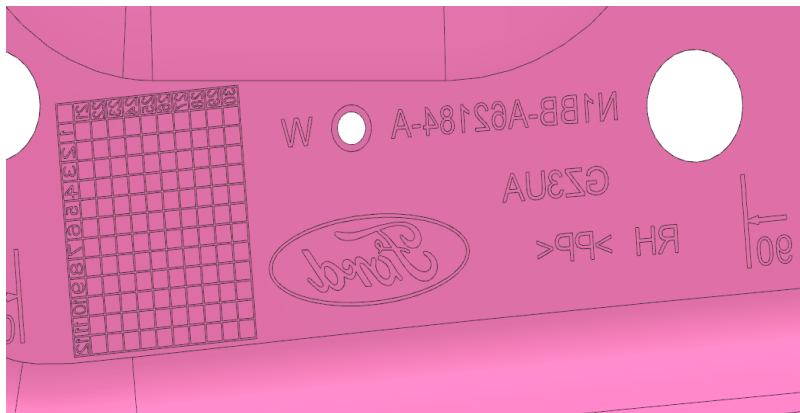
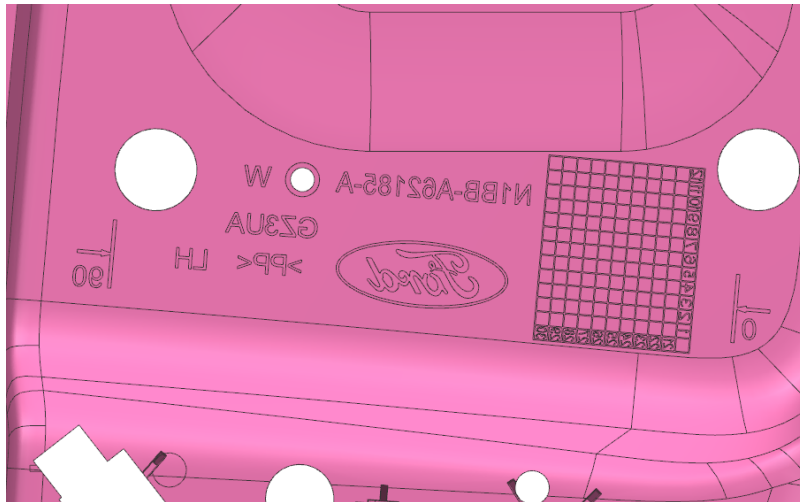
Mold



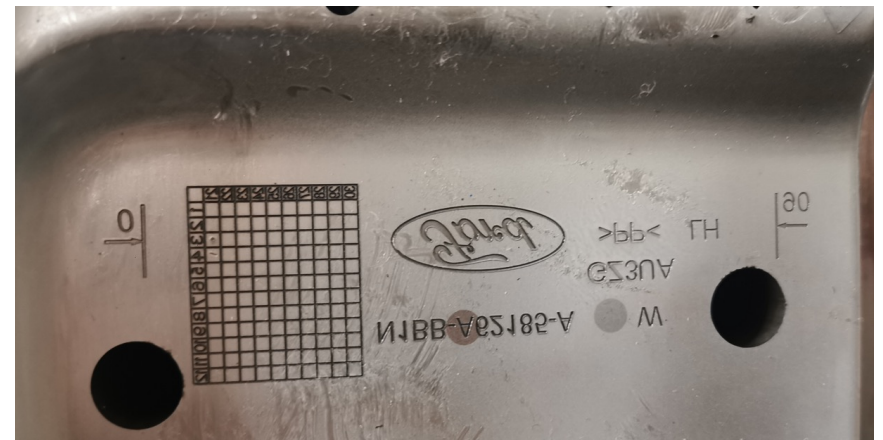
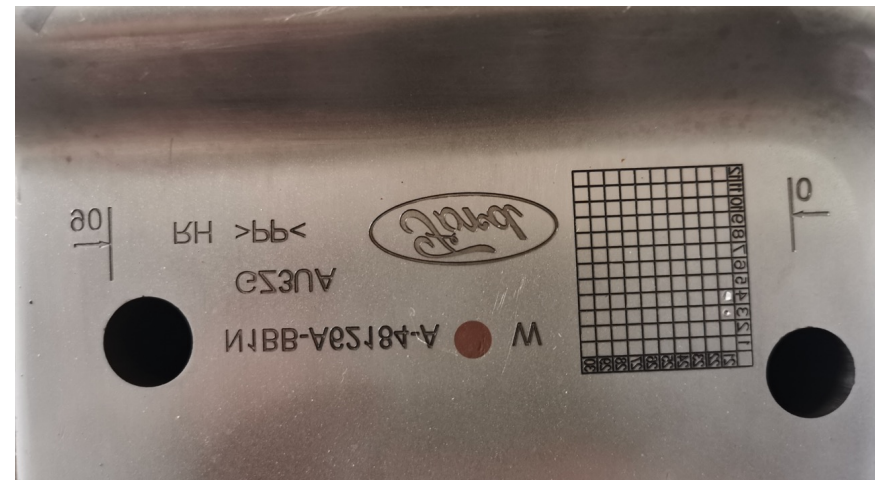
Functioning of original CUMSA date clocks

Engravings

Design






















Mold

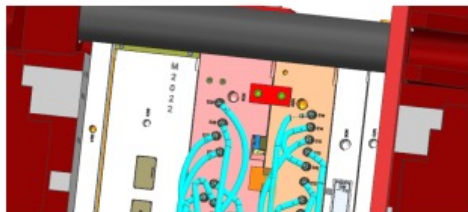


Part reference

Engravings

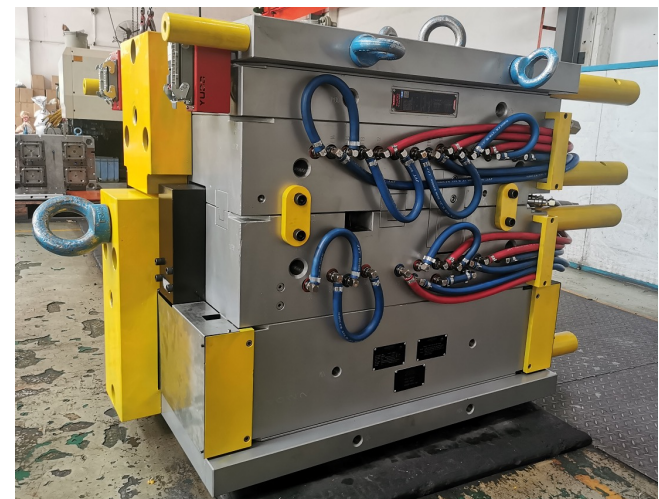
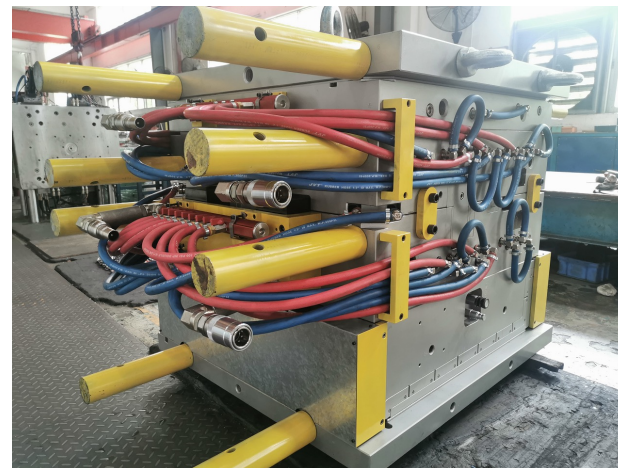
Standard

	Colour Name	Descripcion de Color	RAL
	Sulphur Yellow	Amarillo Azufre	1016
	Dahlia Yellow	Amarillo Dalia	1033
	Pure Orange	Naranja Puro	2004
	Wine Red	Rojo Vino	3005
	Light Pink	Rosa Claro	3015
	Traffic Red	Rojo Tráfico	3020
	Blue Lilac	Lila Azulado	4005
	Signal Violet	Violeta Señal	4008
	Magenta	Magenta	4010
	Light Blue	Azul luminoso	5012
	Turquoise Blue	Azul Turquesa	5018
	Pastel Green	Verde Blanquecino	6019
	Mint Green	Verde Menta	6029
	Traffic Grey A	Gris Tráfico A	7042
	Traffic Grey B	Gris Tráfico B	7043
	Ochre Brown	Marrón Ocre	8001
	Signal Brown	Marrón Señales	8002
	Jet Black	Negro Intenso	9005
	Pure White	Blanco Puro	9010



	Pearl Grey	Gris perla	7025	SPORT SEAT
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Mold



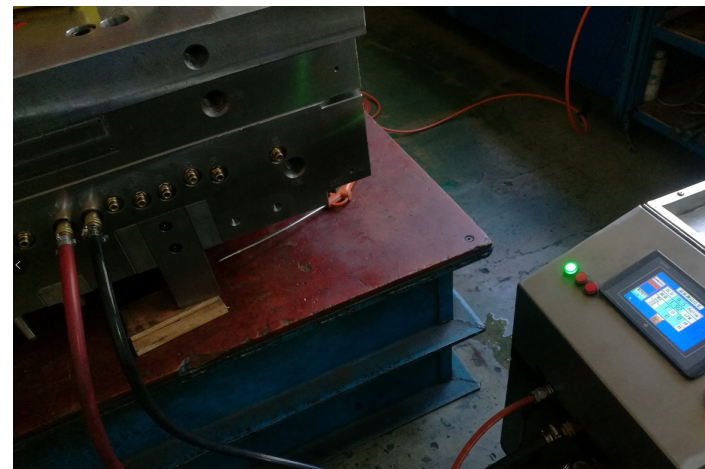
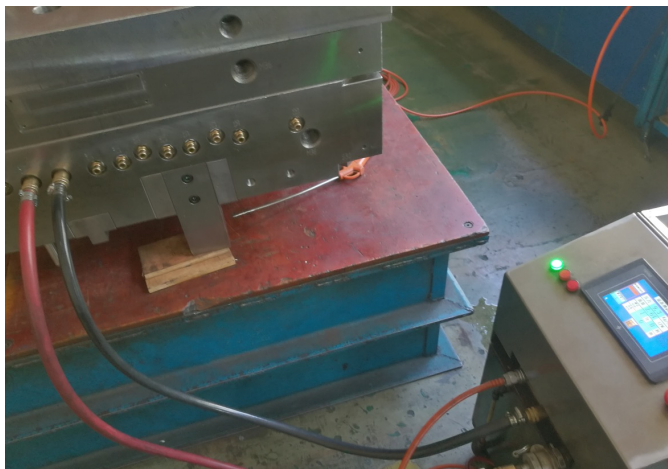
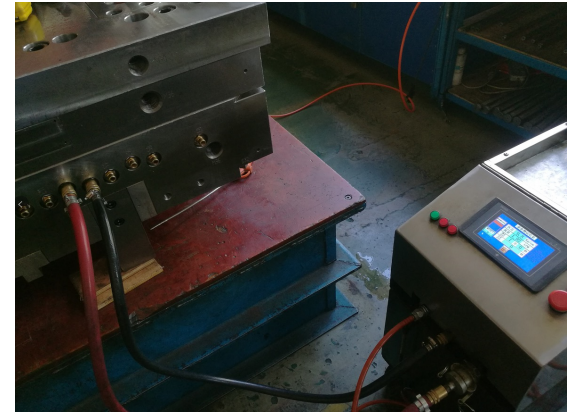
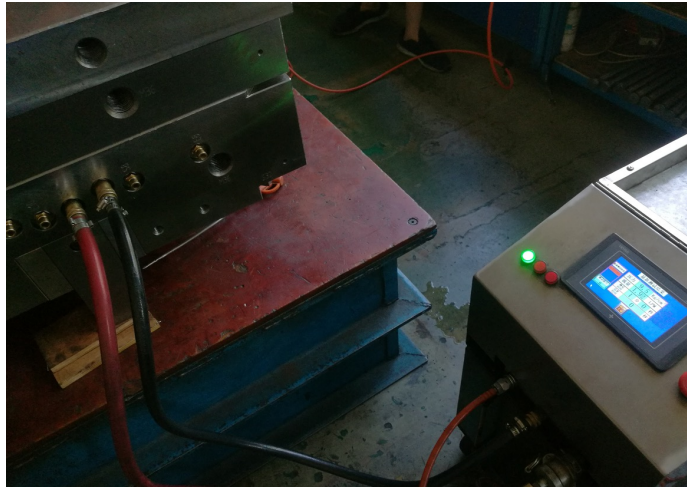
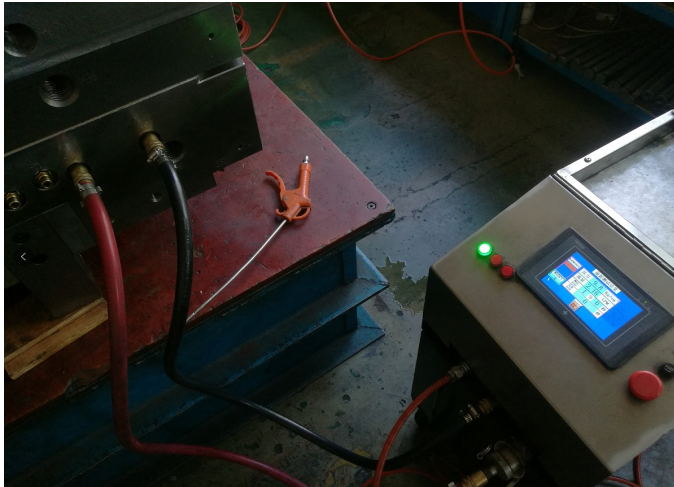
Mold color

Cooling test



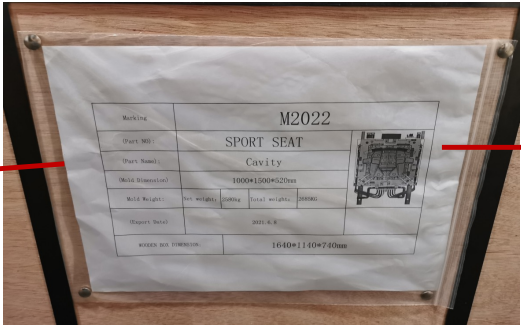
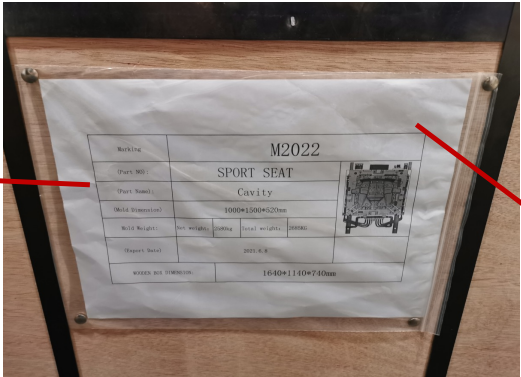
Core cooling test

Cooling test



Cavity cooling test

Packaging



Packaging