

## Plastic injection mould checklist

### 塑料注塑模具检查清单

Date: \_\_\_\_\_

Revision: \_\_\_\_\_

Project Name: \_\_\_\_\_

Project Number: \_\_\_\_\_

Part Name: \_\_\_\_\_

Part Number: \_\_\_\_\_

Tool Name: \_\_\_\_\_

Tool Number: \_\_\_\_\_

Tool source: \_\_\_\_\_

Customer: \_\_\_\_\_

Tool Steel: \_\_\_\_\_

No of Cavities: \_\_\_\_\_

Resin: \_\_\_\_\_

Machine Size: \_\_\_\_\_

#### Inspection Appearance and Dimension for Plastic Injection Mold (塑料注塑模具外观尺寸检验)

1:Water connector type is correct?The hole clearance for the water connector is enough?

The out edge of the hole need chamfered and be constant.

☐ YES

☐ NO

1: 水管接头型号是否正确？水管接头安装孔的间隙是否足够？孔的外缘是否需要倒角并保持一致？

2:Mark the water lines with ‘IN,’OUT’ and numbered clearly and tidily. e.g.INT1,OUT1.

☐ YES

☐ NO

2: 水管路上要标明 ‘IN’ 、 ‘OUT’ ，并清晰整齐地编号。如：INT1、OUT1。

3:Oil connector or pneumatic connector need be numbered with prefix “O” or “G”,e.g. G IN1, O IN1.

☐ YES

☐ NO

3: 油接口或气接口需以 “O” 或 “G” 前缀编号，如：G IN1、O IN1。

4:The screw thread of water plug,oil plug and gas plug meet Tooling data sheet.

☐ YES

☐ NO

4: 水塞、油塞、气塞的螺纹符合模具数据表。

5:Is there any components outside the mold surface? If so, the stand off shoud be installed.

☐ YES

☐ NO

5: 模具表面外是否有任何部件？如果有，则需要安装支架。

6:KO pattern and size meet requirment?

☐ YES

☐ NO

6: K0图案和尺寸符合要求吗？

7:The fixing style and diameter of Locating ring meet Tooling data sheet.

☐ YES

☐ NO

7: 定位环的安装方式及直径符合模具数据表。

8:Sprue bushing sphere radius must meet Tooling data sheet.

☐ YES

☐ NO

8: 浇口套球面半径必须符合模具规格书要求

9:Mould overall size need meet the customer’s press( tie bar space),

and clamping method meets customer’s requirement?

☐ YES

☐ NO

9: 模具外形尺寸必须满足客户压力（拉杆间距）要求，锁模方式必须满足客户要求

10:An arrow with “UP” marked should be engraved in the cavity plate or

core plate for those molds for which installing direction is required.

☐ YES

☐ NO

10: 对于有安装方向要求的模具，应在A板或B板上刻上标有 “UP” 的箭头。

11:All the components need be numbered. And standard mold datum should be engraved.

☐ YES

☐ NO

11: 所有零件均需编号。并雕刻标准模具基准。

12:All the components are not allowed to be made in house,Otherwise,

the detailed checking report should be submitted to KAWHI.

☐ YES

☐ NO

12: 所有组件均不得自行生产，否则，应向 KAWHI 提交详细的检查报告。

13:Correct steel should be used, the steel certification need be submitted.

☐ YES

☐ NO

13: 应使用正确的钢材，并需提交钢材证明。

14:Screw thread for all the connector need be correct including eyebolts hole, K.O. hole.

☐ YES

☐ NO

14: 所有连接器的螺纹都需要正确，包括吊环螺栓孔、K. O. 孔。

15:No sharp edge,corner and burr outside the mold.

☐ YES

☐ NO

15: 模具外部无锐利边缘、角和毛刺。

## Inspection Eject, Return for Plastic Injection Mold (塑料注塑模具的检测顶出、返回)

- 1:Ejecting smoothly, No get stick, no special sound. \_\_\_\_\_ ☐ YES ☐ NO  
1. 顶出顺畅，无卡滞，无特殊声音
- 2:Lifter surface need be polish,lubricate slot need be manufactured, and heat or nitride treatment need be done (according to customer's requirement). \_\_\_\_\_ ☐ YES ☐ NO  
2: 顶杆表面需抛光，需制造润滑槽，需进行热处理或氮化处理（根据客户要求）。
- 3:Slide or lifter stroke must be enough to meet requiremnt. \_\_\_\_\_ ☐ YES ☐ NO  
3. 滑块或斜顶行程必须足够满足要求。
- 4:Lifter design must accord with KAWHI standard unless otherwise specified. \_\_\_\_\_ ☐ YES ☐ NO  
4: 除非另有规定，斜顶设计必须符合KAWHI标准。
- 5:irregular ejector pin must be located. \_\_\_\_\_ ☐ YES ☐ NO  
5: 必须定位不规则的顶杆。
- 6:Ejecting plate shoud return completely. \_\_\_\_\_ ☐ YES ☐ NO  
6: 顶出板应完全返回。
- 7:Space block with flat surface need be used for ejecting stroke. \_\_\_\_\_ ☐ YES ☐ NO  
7. 需要使用具有平面的垫块来增加顶出行程。
- 8:Return spring need be standard component, No polish,no split. \_\_\_\_\_ ☐ YES ☐ NO  
8: 回位弹簧需为标准件，无抛光，无裂纹。
- 9:The material for lifter, wedge block and gib need be heat-treated or Nitride treated, It meets customer's requirement? \_\_\_\_\_ ☐ YES ☐ NO  
9: 斜顶、楔块和楔块的材料需要进行热处理或氮化处理，是否符合客户要求？
- 10:Install limited switch for slide or hydraulic cylinder. \_\_\_\_\_ ☐ YES ☐ NO  
10: 为滑块或液压缸安装限位开关。

## Inspection Eject, Return for Plastic Injection Mold (塑料注塑模具的检测顶出、返回)

- 1:Ejector pins need be standard,No pillow is allowed under the pin shoulder. \_\_\_\_\_ ☐ YES ☐ NO  
1. 顶针需为标准件，顶针肩部下方不允许有枕状物
- 2:Top surface for return pin need be flat without weld;  
Neither Pillow nor weld is allowed in the bottom surface.The holes's clearance need be 0.07mm. ----- ☐ YES ☐ NO  
2. 回程销顶面需平整且无焊缝；底面不允许有枕状物或焊缝。孔的间隙需为0.07mm。
- 3:The clearance between return pin and B plate&ejector plate should accord with KAWHI standard, ( Note: for B plate, 0.07mm) \_\_\_\_\_ ☐ YES ☐ NO  
3: 回料销与B板、顶出板的间隙应符合KAWHI标准，（注：B板为0.07mm）
- 4:The clearance between ejector guide pin and B plate would be 0.05mm unless otherwise specified.(Accord with KAWHI design standard) \_\_\_\_\_ ☐ YES ☐ NO  
4: 若无特殊说明，顶出导柱与B板间隙均为0.05mm。（符合KAWHI设计标准）
- 5:Part removal must be smooth. \_\_\_\_\_ ☐ YES ☐ NO  
5: 零件拆卸必须平稳。
- 6:Runner stripper plate goes smoothly with enough stroke. \_\_\_\_\_ ☐ YES ☐ NO  
6: 流道脱料板移动平稳且有足够的行程
- 7:Need inspect the steel dimensions and steel check report need be provided. \_\_\_\_\_ ☐ YES ☐ NO  
7: 需要检查钢材尺寸并提供钢材检验报告。

## Inspection Cold Runner System for Plastic Injection Mold (塑料注塑模具检测冷流道系统)

- 1:Internal surface of sprue bushing must be polished to drawing standard. \_\_\_\_\_ ☐ YES ☐ NO  
1: 浇口套内表面必须抛光至图纸标准。
- 2:Runner channel must be polished to drawing standard. \_\_\_\_\_ ☐ YES ☐ NO  
2: 流道必须抛光至图纸标准。
- 3:The shape and size for runner channel need meet customer's requirement,  
The steel check report for gate must be provided by shop. \_\_\_\_\_ ☐ YES ☐ NO  
3: 流道的形状和尺寸需要满足客户的要求，浇口的钢质检测报告必须由工厂提供。

### Inspection Hot Runner System for Plastic Injection Mold （塑料注塑模具检测热流道系统）

- 1:The wiring layout numbered correspondingly is suitable? And it should be easy to repair. .... ☐ YES ☐ NO  
1: 相应编号的线路布局是否合适？并且应易于维修
- 2:Hot runner type must be correct and be inspected prior to arrival at the shop. .... ☐ YES ☐ NO  
2: 热流道类型必须正确，并在到达车间之前进行检查。
- 3:The assigned type and size of sockets need be specified with protective setting installed. .... ☐ YES ☐ NO  
3: 指定插座的型号和尺寸需注明，并安装防护装置。
- 4:The wiring need match the drawing provided by shop. .... ☐ YES ☐ NO  
4: 线路需要与车间提供的图纸相符
- 5:Wires need be bundled and covered by plate to avoid breaking. .... ☐ YES ☐ NO  
5: 电线需要捆扎并用挡板覆盖以防止断裂
- 6:Connectors need be marked clearly to avoid assembling wrongly when both size are same. .... ☐ YES ☐ NO  
6: 连接器需要标记清楚，以避免在尺寸相同时装配错误。
- 7:Control wire need protective cover,and No any damage. .... ☐ YES ☐ NO  
7: 控制线需要保护套，并且不能有任何损坏。
- 8:Wires exposed outside the mold surface is not allowed. .... ☐ YES ☐ NO  
8: 不允许电线裸露在模具表面之外
- 9:The transition slot to allow the wire in the plate and manifold need be round to avoid any damage. .... ☐ YES ☐ NO  
9: 用于允许电线在挡板和歧管中穿过的过渡槽必须是圆形的，以避免任何损坏。

### Inspection Packing for Plastic Injection Mold （塑料注塑模具检验包装）

- 1:Steel type,certification and heat-treatment must meet customer's requirement. .... ☐ YES ☐ NO  
1: 钢材类型、认证和热处理必须符合客户的要求。
- 2:Spread antirust in cavity and core. .... ☐ YES ☐ NO  
2: 在前模和后模处涂抹防锈剂。
- 3:Spread butter in sliding components. .... ☐ YES ☐ NO  
3: 在滑块部件上涂抹黄油。
- 4:Safety locks(at least 2 pcs) should meet designing requirement. And rest hole should be made. .... ☐ YES ☐ NO  
4: 安全锁（至少2个）应符合设计要求，并留有固定孔。
- 5:The files in CD are full? (see item E-9 in “project process flow”)  
5: 刻录的CD碟中的文件是否齐全？（见“项目工艺流程”中E-9项） .... ☐ YES ☐ NO
- 6:Is there any special requirement for mold exterior surface? .... ☐ YES ☐ NO  
6: 模具外观表面有什么特殊要求吗？
- 7:Spare parts are full? And a detailed list need be provided. .... ☐ YES ☐ NO  
7: 备件齐全吗？并提供详细清单。
- 8:Mold need be packed in plastic membrane when shipment. .... ☐ YES ☐ NO  
8: 模具发货时需用塑料膜包装。
- 9:Spread mold # with lacquer and marked the direction of placement. .... ☐ YES ☐ NO  
9: 模具编号涂清漆，并标明放置方向。
- 10:Wooden box need be fixed firmly. .... ☐ YES ☐ NO  
10: 木箱需固定牢固。
- 11:All the things in the packing list need be full. .... ☐ YES ☐ NO  
11: 装箱单上所有物品必须齐全。

Completed by(完成人): .....

Date(日期): .....