

 EVK INVENTION APS Design Report/设计报告		Order no. <u>2012-01-12 a</u>		Part no.				
		Part name: Flower		Die no. Flower 2012-01				
Part alloy/材料		ADC 12		Projection area/投影面积		170	cm ²	
Part weight/零件重量		222	g	Specific pressure/压力		500	Kg/c m ²	
Casting weight/带料把重量		500	g	Die casting machine/压铸机吨位		180	ton	
Cavity fill time/填充时间		0,025	s	position		130	cm	
Inlet velocity/进浇速度		37	m/s	Plunger diameter/料筒直径		50	mm	
Inlet area/进料面积		90	mm ²	Shoot length/压射距离		6,5	cm	
Gate thickness/进浇口厚度		1,2	mm	Shoot cylinder/degree of filling/填料比例		25	%	
Cooling channels at the part/ 零件冷却总长		water oil	50	cm cm	Plunger speed/压射速度		1,7	m/s
Heating channels at the mould base Ø 15		oil	200	cm	Vacuum trap/真空排气面积		no	mm
Required venting area/排气面积		12	mm ²	Shrinkage/收缩率		0,5	%	
 EVK INVENTION APS Die check list		Designer Ye		Date		sign		
		Toolmaker Ye						
	CHECK			CHECK		CHECK		
Gate area	70mm	Gate thickness	1,2mm	Inlet R		OK		
Gate geometry	OK	Runner geometry	OK	Plunger size		50mm		
overflow area	16mm	overflow thickness	0,6mm	Venting area		OK		
Venting thickness	0,12mm	Part surface	OK	Part radius		OK		
Part engraving	missing	Slide tolerance	Too tight	Tempering oil water		Heating missing		
Steel Hardness test	Die part	Fixed insert	Moving insert	slides		Cores		
	Steel quality	H13	H13	H13		H13		
	Specified Rc	47	47	47		47		
	Hardness Rc							
	EVK	Rockwell hardness testing			date		Sign	
 EVK INVENTION APS Process check list		Die caster Ye		Date		sign		
		Machine 180T						
	Check 1	Check 2		Check 1	Check 2			
Die temperature/模温 (动 , 定)	100	°	90	°	Metal temperature/料温	521	°	
Biscuit size/料柄厚度	16	mm			Shoot length/压射距离	5	cm	
Plunger speed/压射速度	1,4	m/s			Vacuum clean/真空机构清理	-		
Comments: Red marked is not ok and shall be changed. See Change report.								