

# 4 hole cover mold

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It's a common way to assemble plastic components or achieve functionality by creating hole features, Location and measurement of holes need to be carefully designed to minimize the complexity of mold manufacturing and negative influence to the part strength, in this part we will introduce what elements that our customer should consider when doing design.

The distance between two holes feature or between a hole feature and other features must not less than the diameter of the holes. Meanwhile, the thickness of the hole should be as bigger as possible otherwise it would be easily broken. When it comes to a threaded holes, the design becomes very complex, inner stress will be easily generated around the threaded area, which make the plastic parts fragile, usually, distance between hole feature to the edge of the part must 3 times bigger than the diameter of the hole.







## Project development

Intertech Machinery is good at manufacturing plastic *mold components* used in industrial and packaging applications. Per customer' s demand, we will discuss the *raw material* required, the *color* master batch requires, *mold making size* required, *molding machine size* required, *cycle time* estimation, *production time* calculation report...etc with customers. After that, *parts design* service, *mold engineering* service, *mass production* arrangement, *post assembly* service or *post machining* service are also provided.

Each mold and molding projects case, we will see client specifications to serve the needs of a wide variety of industries. Our injection mold technology have D&B D-U-N-S compliant working system and meets high industry standards. We can mold any *plastic, metal and rubber projects* for customers. We have advanced machinery equipment to provide *small to larger mold projects* and also manufacture thermoplastic, engineering *plastics, silicone rubber and metal parts*.

## ***Highlight Points:***

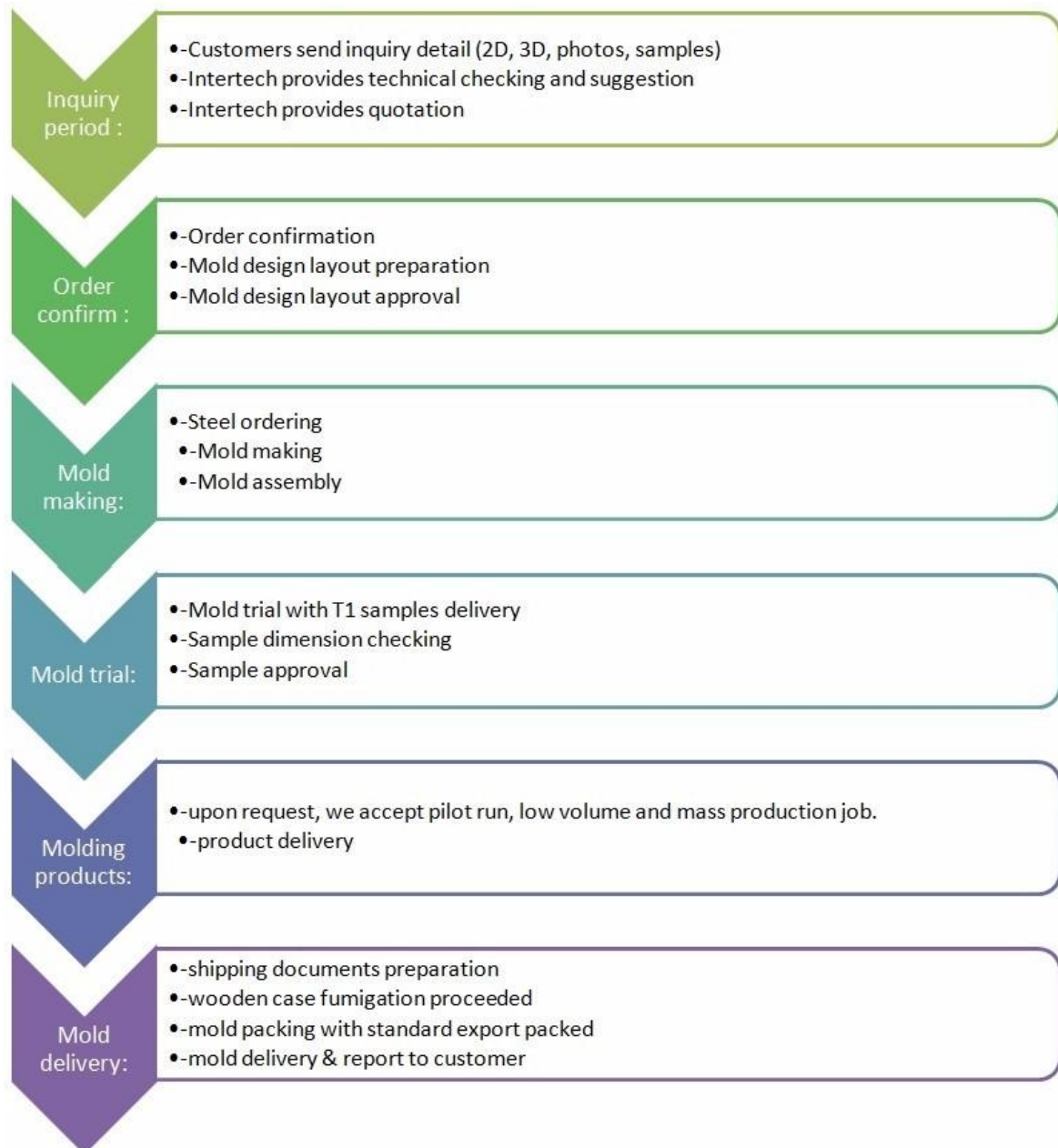
- Our professional service includes engineering, mold making, prototyping and tooling
- From single prototype to OEM and ODM high professional volume production, We can manage all our clients plastic injection molding requirements.
- Except making mold, we also provide [injection molding service](#), compression molding service (especial for silicone rubber material compounding with various colors matching and production job for specific product need) or [punch die](#) production service.
- our injection mold testing machine available 50~250T in house, 300~3000T in associated party.
- per each project need, we also design and provide fixture and jig making service for stabilizing some easy deformed parts need.
- per customer' s need, we also provide chrome plated, painting, ultra-sonic welding, assembly or packing/printing service.

We provide low volume, pilot run of production job and mass production for customer.

Product Name	mold
Plastic Material	PP , PE , ABS , POM , PET, PBT, Nylon + GF····etc. PC, PMMA Acraylic for transpartent product.
Steel of Cavity & Core	Up to customer' s budget and productivity required, we suggest the following steel grade: Pre- harden steel : P20 (1.2311), P20+Ni····etc Harfen Steel : H13 (1.2344) / NAK80····etc. Stainless steel : ASSAB Stavax····etc
Steel of Mold Base	Up to customer' s budget and requirement , we suggest different mold base steel to clients. Normal used material S50C, or P20
No. of Cavity	Customized
Hardness of Cavity & Core	Pre-Hardenss Steel : HRC 30~32+-1* Heat Treatment Steel : HRC 50~52+-1*
Core pulling or Ejection system	Depends on the Products. Commonly used :Motor , oil cylinder, stripping plate, angel pin, ejector pin····etc
Mould Accessories	Compatible to DME/ HASCO Standard.
Cooling System	In Core : Baffle or By pass cooling In Cavity Plate: Chain drilling type colling

Surface Finish	Up to the product's requirement, Normal used : Texture, EDM machining , Polishing
Mold Life	Up to mold steel grade, under ideal operation condition, 1. Pre-harden steel, min. 20~300000 shots 2. Harden / heat treatment steel : 60~800000 shots. 3. Stainless steel : 1 million shots.
Runner	1. Cold runner 2. Hot runner 3.cold runner +hot runner
Delivery time	40~50 days , presenting T1 samples
Packing	Standard Wooden Case
Production	We can also provide Pilot Run production and molding production

## Mold Order Process



## Mold Finish



## Spare Parts



## Boxing



## When you receive



For Mold Inquiry, Customer Must prepare:



1. Product drawing with 2D(.dwg)and 3D (.igs, .stp...etc)?
2. Advise product material (ex. Plastic ,rubber, silicone rubber or metal...etc )?
3. Molding machine tonnage size and platen size?
4. The cavity number of the mold that you want us to quote?
5. Mold steel grade that you want us to quote?
6. Hot runner or cold runner mold required?
7. Mold gating inlet preferred?
8. Mold ejection way preferred?
9. Other related information required ...(ex. Polishing , texture, engraving ...etc)

### For Molding Products Inquiry , customer must prepare:

1. Products material required? (ex. Plastics, rubber , silicone , metal...etc)
2. Products quality required in total?
3. Delivery time required?
4. Post machining or not information? (ex. Chromed plate..., painting ...etc)
5. Assembly or not information?
6. Packing or not information?

-Contact Information—

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