Our commitment to servicing our customers with quality product at competitive price and on-time delivery is backed by our continued investment in our equipment.Our employees and in our systems . ABIS is a full service molding that a 12 000 square foot facility housing our molding department in-housing mold making , quality control. Warehousing secondary operations and offices , If we find a client’s product concept would be too costly to manufacture . We will assist the customer in designing parts that not only can be manufacture but one that can be made cost-effectively from prototype to production.With our extensive experience we are confident .We have the solution to your next injection molding application.







Product Description

Part Name	Plastic golf ball
Description	Sports Toy
Country of Original	ShenZhen, China (Mainland)
Brand Name	ABIS
Lead Time	10-25Days

Payment Terms

1. T/T: 40% Deposit,30% upon T1 Sample,30% Balance before ship ment
2. L/C: irrevocable 100% L/C at sight.

General Information

Item#	Item	Description
1	Product Name	Plastic golf ball
2	M o l d b a s e	LKM;HASCO;DME
3	Diameter	42mm
4	Material	HDPE/LDPE/EVA
5	Weight	4.5g
6	Logo	On the mold
7	N.W/G.W	13.5KG/14.5KG
8	Design software	UG,PROE,CAD,SOLIDWORK
9	Color	Various color
10	Hardness	70

11	Using	Use for the indoor golf practice
12	Transportation	By sea, by air or by land as you request
13	Package	According to clients requirement
14	Plastic Type	PE

Processing Equipment

NAME OF MACHINE	BRAND	Q'TY	PLACE OF ORIGIN
CNC	DMG	1	Germany
CNC	YCM-FP66A	2	Taiwan
EDM AQ35L	SODICK	3	Japan
Wire EDM AQ327L	SODICK	2	Japan
EDM	CHARMILLES-35P	2	Swiss
EDM	TAIWAN NUMERIC CONTROL	6	Taiwan
Wire cutting machine	QIGNYUAN	4	Shanghai
digital display milling machine	YINGSHUN	8	Taiwan
digital display grinding machine	SUHRE	8	Taiwan
Injection molding machine	HAITIAN	11	China
3 Dimension Coordinate	DABAO	1	Taiwan
JD 12-300digital display projection apparatus	PROJECTOR	1	China

Dimension Report and Sampling Parameter

ABIS Tooling & Molding

TEL: +86-755-89984896 EXT:821 • FAX:+86-755-28960682 • Building B,Ying-Ke-Li Indust
Area,Long-Gang District.Shenzhen City,Guang-Dong Province,China P.C:518116

Dimension Inspection Report

Customer	SMR	Mold Trial #	T1	Unit	Metric	Picture	
Project #	Phase 2	Trial date	2014.12.29	Inspection date	2015.01.08		
Part Name	B876_SCALP without TS_RH	Mold number	ABIS 20141128	Inspector	Mr. Li		
Part / Draw #	60063006D #2	Material	ABS MP0160R	Manager	/		

Inspection Tools: Block gauge (BG), Caliper (CP), Coordinate Measuring Machine (CMM), Height gauge (HG), Micrometer (MM), Projector (PJ), Pin gauge (PG), Rad (RG), Thickness gauge (TG)

Dimension spec					Shot 1		Shot 2		Shot 3		Shot 4		Judgment	
Dim #	Dimension	Tolerance		Inspection Tools	1	2	1	2	1	2	1	2	OK / NG	Rem
1-1	1.20	+	0.20	CP	1.19	1.23	1.22	1.24	1.22	1.23	1.20	1.21	OK	
		-	0.20											
1-2	1.20	+	0.20	CP	1.21	1.22	1.20	1.20	1.21	1.23	1.22	1.20	OK	
		-	0.20											
2-7	1.50	+	0.20	CP	1.51	1.52	1.52	1.53	1.51	1.50	1.49	1.52	OK	
		-	0.20											
2-8	1.50	+	0.20	CP	1.52	1.52	1.52	1.52	1.51	1.53	1.49	1.51	OK	
		-	0.20											
2-9	1.50	+	0.20	CP	1.51	1.52	1.52	1.52	1.51	1.50	1.49	1.50	OK	
		-	0.20											
3-1	1.70	+	0.20	PJ	1.72	1.69	1.70	1.69	1.70	1.71	1.73	1.70	OK	
		-	0.20											
3-2	1.70	+	0.20	PJ	1.71	1.72	1.69	1.70	1.71	1.72	1.71	1.72	OK	
		-	0.20											
3-3	1.70	+	0.20	PJ	1.71	1.72	1.71	1.70	1.69	1.70	1.69	1.71	OK	
		-	0.20											
3-4	1.70	+	0.20	PJ	1.69	1.70	1.70	1.71	1.72	1.71	1.73	1.71	OK	
		-	0.20											
3-5	1.70	+	0.20	PJ	1.71	1.71	1.72	1.73	1.71	1.71	1.72	1.73	OK	
		-	0.20											
3-6	1.70	+	0.20	PJ	1.71	1.72	1.73	1.71	1.72	1.71	1.71	1.72	#REF!	

Prepared	Mr. Lillian	Checked	Mr. Li	Approved	Mr. Zhang
Date	2015.01.10	Date	2015.01.08	Date	2015.01.08

To be completed by customer:

Signature: _____

Result:	☐ Pass	☐ Fail	☐ Special Acceptance

ABIS MOLD INJECTION PARAMETER REPORT

>类型Shot Type:	☑ 单色One shot mold	☐ 双色第一次1st shot of 2-shot	☐ 双色第二次2nd shot of 2-shot

模具编号 Tool No.		产品名称 Part Name		模具规格(mm) Tool L*W*H		试模次数 Test times	
模腔数量 N° Cavity		塑胶原料 Raw Material		颜色 Color		项目负责人 Project Manager	
产品总重量 Gross Wt(g)		机台型号 Press Type		试模数量(啤数) Shot Qty		设计工程师 Design Engineer	
试模日期 Test Date		上机时间 Beginning Time		完成时间 Finish Time		审核Reviewed /日期Date	

*试模前的准备：试模单、产品图纸、物性表、卡尺、模温计、油温机、温胶枪、电子天平、照相机、打磨机（用于调整浇口直径）等工具

备注Comments:

>成型参数表Molding Parameter Sheet:

时间 Time(s)	周期时间Cycle Time		温度设定 Temp(℃) Setup	射嘴温度Nozzle Temp℃		
	填充时间Filling Time			一段温度Zone 1 Temp℃		
	保压时间Holding Time			二段温度Zone 2 Temp℃		
	冷却时间Cooling Time			三段温度Zone 3 Temp℃		
压力Pressure (Bar) (1Mpa=10Bar =145Psi)	射胶压力 Injection Pressure	一段1st Stage		四段温度Zone 4 Temp℃		
		二段2nd Stage		热流道温度Hot Runner Temp℃		
		三段3rd Stage		前模设定温度Cavity Temp. Setup		
		四段4th Stage		后模设定温度Core Temp. Setup		
	保压压力 Holding Pressure	一段1st Stage		行位设定温度Slide Temp. Setup		
		二段2nd Stage	速度或速率 Percent of Speed(mm/s) or Flow Rate(g/s)	射胶速率一段Injection Speed1		
		三段3rd Stage		射胶速率二段Injection Speed2		
	储料压力Charge Pressure			射胶速率三段Injection Speed3		
	背压Back Pressure			射胶速率四段Injection Speed4		
位置 Position(mm)	射胶位置1st Inj. End Position			保压速率一1st Holding Speed		
	射胶位置2nd Inj. End Position			保压速率二2nd Holding Speed		
	射胶位置3rd Inj. End Position			保压转换Turn Hold(time/pos.)		
	射胶终止位置Inj. End Position			熔胶速率Charge Speed		
	熔胶终止位置Melt End Position		原料干燥 Raw Material	干燥温度Drying Temp(℃)		
	射退位置Suck Back End Position			干燥时间Drying Time(H)		
模具 Tool	锁模压力Clamp Pressure		实际模温 Actual Temperature (℃)	前模表面 Cavity Surface	机水Normal Water	
	开模压力Opening Pressure				热油Hot Oil	
	顶出行程Ejection Stroke				冻水Cool Water	
	顶出次数Count of Ejection			后模表面 Core Surface	机水Normal Water	
	抽芯机构Side Action(组Unit)				热油Hot Oil	
顶出 Ejection (%)	托模进 Forward	压力Pressure			冻水Cool Water	
		速度Speed		行位表面 Slide Surface	机水Normal Water	
	托模退 Backward	压力Pressure			热油Hot Oil	
		速度Speed			冻水Cool Water	

>产品外观问题/Product Appearance Faults:

☐	粘前模Sticking in Cav	☐	抛光不良Poor Polishing	☐	披锋Flash	☐	裂痕Stress Crack	☐	熔合线Weld L
☐	粘后模Sticking in Core	☐	顶出不顺Uneven Ejec.	☐	顶白Ejector Marks	☐	喷射痕Jetting	☐	黑点Dark Sp
☐	水印Water Wave Marks	☐	拖花Scratch Marks	☐	变形Deformation	☐	缺胶Short Filling	☐	烧焦Burn Mar
☐	冷料流痕Cold Slug Marks	☐	困气Gas Trap Effect	☐	缩水Sink Marks	☐	段差Gap	☐	气泡Air Bubbl

>试模过程检查/Tryout Process Check:

开合模动作检查		模具进水检查		流动平衡检查，填充30%、60%、90%	
模具顶出动作检查		快速填充检查模具排气		填充99%检查毛边、缩水与变形	

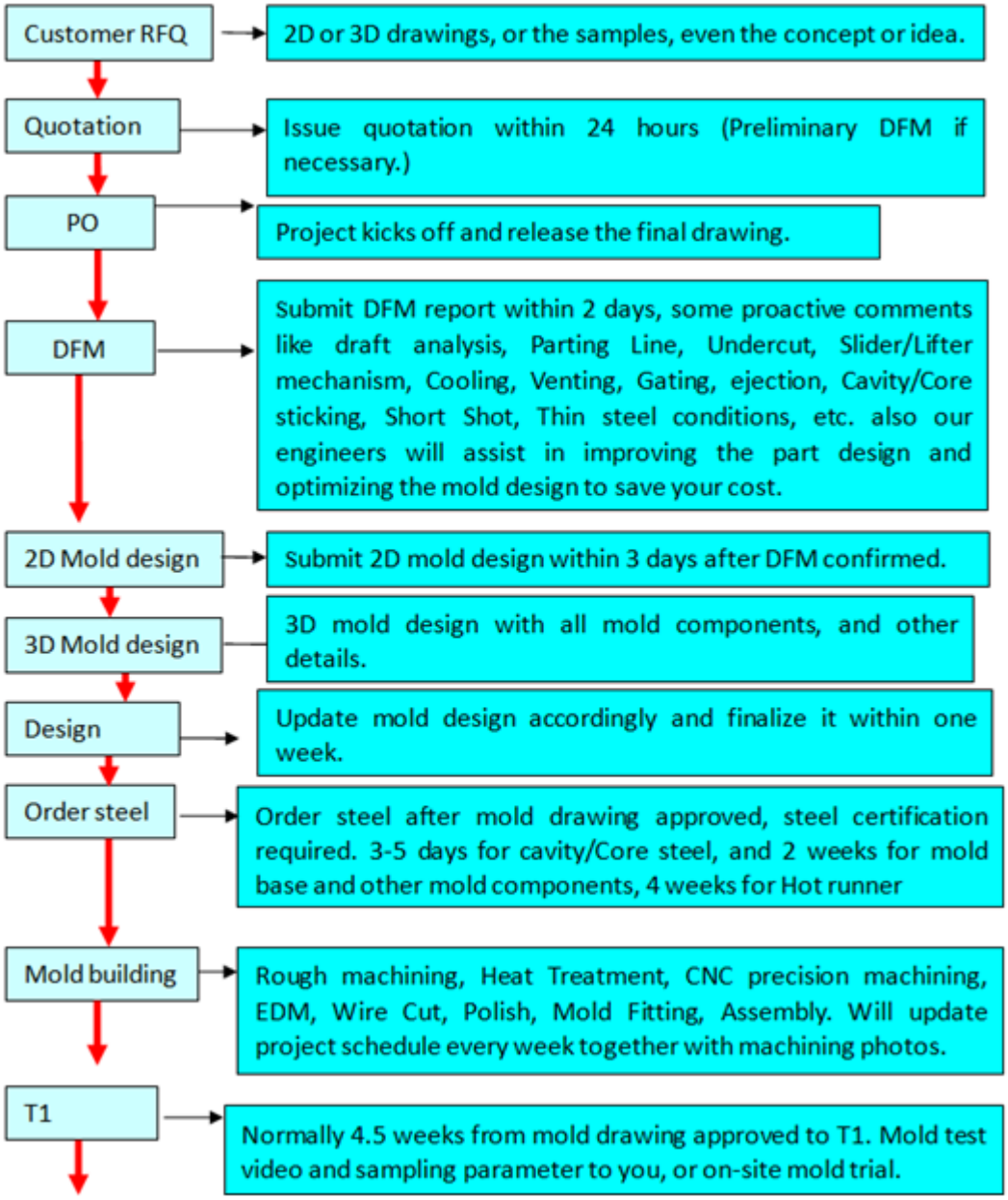
>试模问题点描述及建议/Comments:

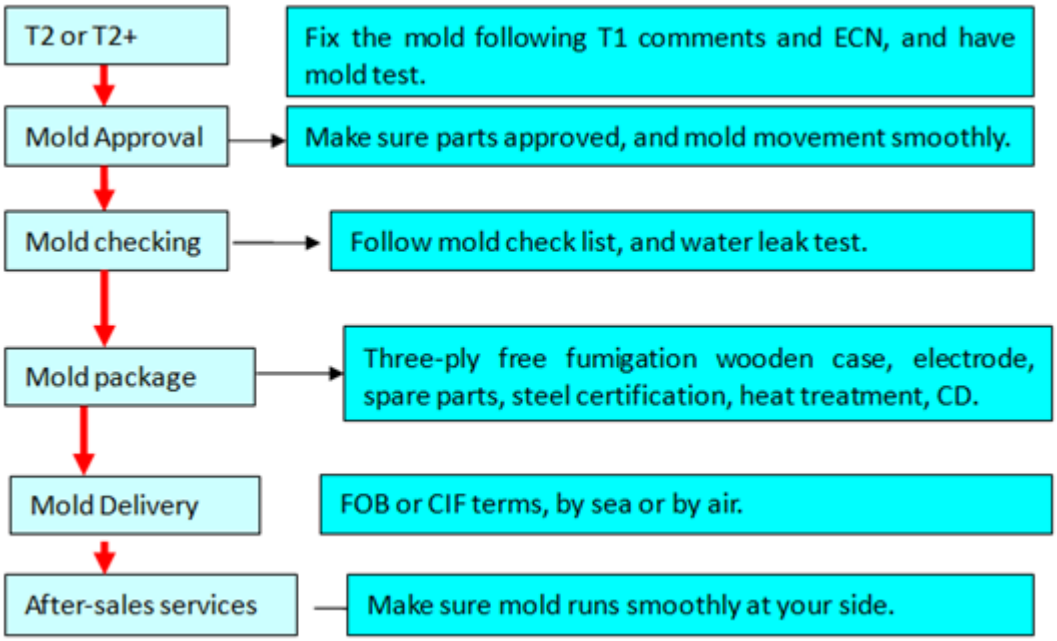
问题：产品毛边/玻纤纹

对策：飞模/流道加大/进胶口加大/冷料井加大

记录Record		日期Date		审核Reviewed		日期Date	

Working process:





Company Information

ABIS was founded in Shenzhen China, adjacent to Hong Kong, in 1996, has its own factory of 12,000 square meters. With the advanced facilities from Germany, Swiss and Japan, and a highly experienced design and engineering team, ABIS builds multi-cavity molds to exacting tolerances, providing the critical structural foundation for leading manufacturing companies to produce high precision mold.

ABIS Mold which engaged in :

1. Cold&Hot Runner/ Single&Multi- Cavity-Injection moulding
2. Single&Multi- Shot
3. Die Cast-Aluminum&Zinc
4. Inserting Mold
5. Overmolding
6. Prototype Tooling
7 Mass Production

ABIS applies advanced software for mold design-Auto CAD, UG, Solid works and ProE etc. So far, ABIS has received the “ISO 9001” ,"ROHS" green, SGS certificate.



Certification



认证证书

深圳市艾比精密王企图股有限公司

符合 ISO/TS 16949:2009 质量管理体系标准

认证范围：

弹胶制品（把手）的生产（不包括 7.3 产品设计）

Certificate of Registration

Shenzhen ABIS Precision Hardware Plastic Co. Ltd

Floor1, Building C, Sha Bei Li Ying Keli Industrial Park LongDong Community, Longgang Street, Longgang District , Shenzhen City, Guangdong Province, China

ISO/TS 16949:2009

Manufacture of Plastic Parts (Handles) (Excludes Product Design unc Clause 7.3)



BEIJING HANGXIE CERTIFICATION CENTER CO.

QUALITY MANAGEMENT SYST
CERTIFICATION

ABIS MOLD TECHNOLOGY(HK)CO.,L

Organization Code: 55388449-

No.102,Building B, Ying Keli Industry Area, Longgang District, Shenzhen,China. P.C 518

is in conformity with

GB/T19001-2008（ISO9001:2008）

This certificate is covering the following product scope

Plastic Mold Development and Manufacturing; Plastic Products P

(Not Include the Products With Administrative Licensing

Registration No. 03415Q20263ROM

The Duration of Validity :Feb . 10, 2015—Feb . 09, 2018

CNAS

MANAGEMENT SYSTEM
CNAS C034-Q

General Manager:

BEIJING HAN
CERTIFICATION CEN

After this certificate is issued, there should be at least 2 surveillance audits within the 3 year period of validi
validity of the certificate can be checked on （www.bhscc.com.cn） The certificate information is avail
official website of the National Certification and Accreditation Administration （www.cnca.gov.
It is also available by scanning the two-dimensional code at the bottom right corner.

Address : NO.7 Jingshun Road,Chaoyang District,Beijing,China.

EACC

Certificate

Certificate No.: 114175

This is to certify that the Occupational Health and Safety Managemen

SHENZHEN ABIS PRECISION HARDW
PLASTIC CO., LTD.

Unified Social Credit Code: 91440300553884491N

Registered/Production/Office Address: Yingkeli Industrial Distric B Building No. 102, Shabe
Longdong Community, Longgang Street, Longgang I
Guangdong Province, China

Sales Address: Yingkeli Industrial District C Building 1/F, Shabeili Village, Longdong Comm
Street, Longgang District, Shenzhen, Guangdong Province, China

Has been audited to conform to the following Occupational Health
Management System standard

GB/T 28001-2011 idt OHSAS 18001:2(

This Occupational Health and Safety Management System is vali
Development and production of plastic mould; sales
plastic parts and related Occupational health and saf
management activities of involved sites

Initial issueddate: May. 16, 2017
Date of issue: May. 15, 2017
Date of expiry: May. 15, 2020

Issued by:

Beijing East Allreach Certification Cer

EACC
OHSMS

CNAS

The certificate will remain valid only if the certified organization
accepts surveillance audit at regular intervals and is audited to be
qualified. Please apply for surveillance audit reviewing mark on the
designated position of the certificate. The information of the certificate
is available at EACC website (www.eacc.com.cn) and CNCA website
(www.cnca.gov.cn).

EACC address: at Floor, No. 121 building, No. 17 ,Jinghongyuan
Street, Jinjian Science & Technology Industrial Park, Fengmao Park of

The 1st Surveillance Conformity Mark

The 2nd Surveillance Conformity Mark

Tooling Shop



QC Control

Mold Making QC main steps

Mould Design Control : Design review checklist before submitting to the customer. We will not start the steel purchasing work until get your written approval on our mold drawing.

Incoming quality control: all steel material and outsourcing standard components will be checked to ensure that they are in accordance with the BOM(QTY and material/components name specified).

In process quality control: all the machining and assembling process is under control, we have QC team to check and supervise the tolerance and processed surface to satisfy the requirements. (Mould Steel Hardness Inspection, Mould Electrodes Inspection, Mould Core and Cavity Steel Dimension Inspection , Mould Pre-Assembly Inspection)

Final quality control: within 3 days the completion of the plastic mold, we will have a thorough check for the main size of the molded plastic sample and mold to ensure that the critical or full dimension (if required) are within tolerance.

Mould Pre-Shipment Final Inspection : Free-fumigation three-plywood case packing; make sure the mold is conformity to the approved mold drawing. The spare components and easily broken components and the electrode (if required) are packaged, as well as the mold drawing and some certificated.

Plastic Molding QC main steps

Vernier caliper measurement is performe
trained operators when the first product
our machine, we check the contour dimer
assembly status (if exist) to identify if an

The molded parts are then inspected agai
experienced QA department for the full d
especially the critical dimensions set by c
quality result was recorded at the same ti
Result will be to our QC Supervisor direct
unqualified dimensions (if exist) are cause
uncontrolled factors or our mistakes and
the related actions to improve it.

We will trustily report the T1 result to cus
send T1 samples to customers for checki
sometimes T1 samples need improvemen
samples are required by customer at first
actions to improve the mold to make sure
have 0 defects. No shrinkage, warpage, fl
streak, air bubble, step line, ejector mark
dimension within tolerance.

Package inspection: make sure QTY/color
and weight are correct.

Packaging & Shipping









Our ABIS Family









Why choose us?:
1. More than 20-years experience.
2. ISO9001:2008 certificated.
3. Competitive price with high quality.
4. More than 50 machines support to run the business.
5. Custom R&D program coordination.
6. Expert technicians.
8. Diligent and loyal workforce.
9. Up-to-date software.
10. International standards, SAY, HASCO, DME, MISUMI, etc
11. Well-rounded after service.

Lynn Xiao

ABIS Mold Technology Co.,Ltd.

Add:B Building, YingkeLi Area, Longdong Community, Longgang District, ShenZhen, CHN.

Tel:0086-75589984896 ext 808

Mobile(Whatsapp):+8613924454678

Web:www(dot)abismold(dot)com

We will give our best service,quality, price and delivery time！
If you have any question just call me or send E-mail to me please!

FAQ

1. Are you factory?

Yes, we are direct factory, professional on plastic mould, plastic and hardware parts.

2. I have no drawing, how I should do to start the new project ?

You can supply a sample, we will help to finish the 3D drawing design.

3. What is your shipment way?

Sea shipment , air shipment, express shipment for small quantity.

4. Before shipment, how to make sure the products quality?

If you don't come to our factory and also don't have the third party for inspection, we will be as your inspection worker, we just require your trust. We will supply you a vedio for production process detail include process report, products size, structure and surface detail, packing detail and so on, so you will feel you are in our factory.

5. How is your after-sale service?

We have a very good reputation for our after-sale service, we bear all problem responsibility if they are ours, timely reply and satisfied solving is our strength. Your problems are ours too. So you never need worry the after-sale service.