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Power On

Mould Limited.

时间	活动内容	组织者	备注
11.13 下午	1, 实习生到厂 2, 安排住宿	行政人事部	
11.14 上午	1, 实习启动大会 2, 公司员工守则学习 3, 签订实习协议	行政人事部	
11.14 下午	1, 实习生入职面试; 2, 宣讲基本注意事项	行政人事部	
11.15	参观实习	各相关部门	
11.15 16:30-17:30	竞岗	行政人事部	
11.16- 结束	岗位实习	各相关部门	

注:

1 中期不中期的培训研讨会, 向实习生开放。

1	中期不中期的培训研讨会, 向实习生开放。
2	参观实习活动由各相关部门具体安排。
3	实习生入职面试由行政人事部负责。
4	竞岗由各相关部门负责。
5	岗位实习由各相关部门负责。



Power On Mould

Limited.



Professional Word For Mould

	Flash/burr
	Step/mismatch
	Short shot
	Eject mark
	Welding line
	Flow marks
	Over size
	Under size
	Error
	Scratch line/Scratch
	Deformation/War page
	Sink mark
	Raise
	Plastic material
	Warp / Bending

	Critical Surface
	Stress line
	Enlarging draft
	Sharp
	Lead time
	Get damage
	Hard to be filled
	Postpone
	Silver streaks
	Ripples
	Burn mark
	Brittleness
	Add material
	Reduce material
	Strength

	Cell
	Size
	Split line
	Check
	Torsion
	Bite
	Edge
	Straight tuning
	Surging
	Scrap
	Scrap jam
	Pit
	Blow hole
	Pock
	Aberration
	Fissure
	Weld mark
	Color mottle
	Burn mark
	Gloss

	Wall thickness
	Sticking problem
	Jetting mark
	Undercut
	Ejector force
	Double ejection
	Tool life
	Stress crack
	Texture spec.
	Intervene
	Stuck on a stickle
	Air traps
	Crater
	Vent
	Shut-off
	Clear/transparen cy
	Boss
	Whitening
	Wrinkle
	Plate mark

	Peeling
	Glazing
	Grinding peel
	Orange peel
	Sweat out

	Riding
	Scar
	Shrinkage pool
	Webbing
	Grease/oil stains
	Corrosion

	Dowel pin
	Lock block
	Locking block
	Mold base
	Eject block
	Core pin
	Draft
	Screw plug
	Fixed bolster plate
	Water junction
	Locating ring
	Wear plate
	Cylinder (air/oil)
	Rib
	Core
	Cavity
	Insert
	Slide
	Lifter

	Holding pressure
	Bonding strength
	Sprue bushing
	Injection nozzle
	Cull
	Cure
	Ductility
	Elastomer
	Injection nozzle
	Injection plunger
	Injection ram
	Lubricant
	Mould release agent
	Nozzle
	Pellet
	Plasticizer
	Post cure
	Resilience
	Resin injection

	Tension link
	Part drawing
	Mold drawing
	Thermo pin
	Self tapping screw
	Ejector blade
	Date indicator
	Part drawing
	Stripper plate
	Eject limited
	Support pillar
	Supporting plate
	Angular pin
	Return pin
	Ejector sleeve
	Gas expeller
	Eye bolt
	Ejector guide pin
	Ejector guide

	Shot
	Shot cycle
	Slip agent
	Gunk

	Assembly
	Spray paint
	EML shielding
	Printing
	Engraving
	Laser machining
	Coating
	Chrome plating
	Nickel plating
	Tin-gloating(tinrin g)
	Gad ranize(zinc)
	Copper plating

	bushing
	Ejector pin

	Gild plating with gold



Professional Word For Mould

	Barrel
	Broaching
	Centering
	Cutting
	Cylindrically lathe cutting
	EDM
	Electrolytic grinding
	Texture
	Hand finishing
	CNC
	Hobbling
	Drilling


	Banana gate
	Direct gate
	Pin point gate
	Film gate
	Fan gate
	Diaphragm gate
	Dish gate
	Side gate/edge gate
	Slit gate
	Sprue gate
	Sub gate

	Lapping/skiving
	Polishing
	Lathe cutting
	Sanding blast
	Polishing
	Rough machining
	Rounding
	Sawing
	Wire cut
	Shaping
	Heat treatment

	Tab gate
	Tunnel gate
	Valve gate
	Ring gate

	LDPE	
	HDPE	
	UHMPE	
	EVA	
	PS	
	HIPS	
	ABS	
	SAN	
	EPS	
	PA 6	

	PA 12	
	PA 66	
	PAST	
PVC	PVC	
	PVC	
	PP	
	PMMA	
	POM	
	POM	
PC	PC	
PMMA	PMMA	
	PE	
	PPO	

 PowerOn Mould 广东力人科技模具 企业标准	制表	审核	批准
	彭松和		
	ISO 编号	版本	页次
标准尺寸公差等级表	POM-EN-1.13.01	A00	

标准尺寸公差等级表

基本尺寸	IT0	IT1	IT2	IT3	IT4	IT5	IT6	IT7	IT8	IT9	IT10	IT11	IT12	IT13	IT14	IT15	IT16	IT17	IT18	
≥	<	μm (1μm = 0.001mm)										mm								
-	3	0.5	0.8	1.2	2	3	4	6	10	14	25	40	60	0.1	0.14	0.25	0.4	0.6	1	1.4
3	6	0.6	1	1.5	2.5	4	5	8	12	18	30	48	75	0.12	0.18	0.3	0.48	0.75	1.2	1.8
6	10	0.6	1	1.5	2.5	4	6	9	15	22	36	58	90	0.15	0.22	0.36	0.58	0.9	1.5	2.2
10	18	0.8	1.2	2	3	5	8	11	18	27	43	70	110	0.18	0.27	0.43	0.7	1.1	1.8	2.7
18	30	1	1.5	2.5	4	6	9	13	21	33	52	84	130	0.21	0.33	0.52	0.84	1.3	2.1	3.3
30	50	1	1.5	2.5	4	7	11	16	25	39	62	100	160	0.25	0.39	0.62	1	1.6	2.5	3.9
50	80	1.2	2	3	5	8	13	19	30	46	74	120	190	0.3	0.46	0.74	1.2	1.9	3	4.6
80	120	1.5	2.5	4	6	10	15	22	35	54	87	140	220	0.35	0.54	0.87	1.4	2.2	3.5	5.4
120	180	2	3.5	5	8	12	18	25	40	63	100	160	250	0.4	0.63	1	1.6	2.5	4	6.3
180	250	3	4.5	7	10	14	20	29	46	72	115	185	290	0.46	0.72	1.15	1.85	2.9	4.6	7.2
250	315	4	6	8	12	16	23	32	52	81	130	210	320	0.52	0.81	1.3	2.1	3.2	5.2	8.1
315	400	5	7	9	13	18	25	36	57	89	140	230	360	0.57	0.89	1.4	2.3	3.6	5.7	8.9
400	500	6	8	10	15	20	27	40	63	97	155	250	400	0.63	0.97	1.55	2.5	4	6.3	9.7

举例：尺寸 $\varnothing 28$ IT7级 极限偏差为 $\pm 21\mu\text{m} = \pm 0.021\text{mm}$

举例：尺寸 $\varnothing 90$ IT8级 极限偏差为 $\pm 54\mu\text{m} = \pm 0.054\text{mm}$



PowerOn Mould

广东力人科技模具企业标准 公英制尺寸换算表

制定	审核	批准
彭松和		
ISO编号	版本	页次
POM-EN-1.14.01	A00	1

inch	φ	R	'分	inch	φ	R	'分
1/64	0.40	0.100		33/64	13.10	6.55	
1/32	0.787	0.198	0.5	35/64	13.65	6.82	
3/64	1.181	0.298	0.75	37/64	14.28	7.14	
5/64	1.574	0.397	1.0	39/64	14.91	7.41	
7/64	1.967	0.496	1.25	41/64	15.54	7.68	
9/64	2.360	0.595	1.5	43/64	16.17	7.95	
11/64	2.753	0.694	1.75	45/64	16.80	8.22	
13/64	3.146	0.793	2.0	47/64	17.43	8.49	
15/64	3.539	0.892	2.25	49/64	18.06	8.76	
17/64	3.932	0.991	2.5	51/64	18.69	9.03	
19/64	4.325	1.090	2.75	53/64	19.32	9.30	
21/64	4.718	1.189	3.0	55/64	19.95	9.57	
23/64	5.111	1.288	3.25	57/64	20.58	9.84	
25/64	5.504	1.387	3.5	59/64	21.21	10.11	
27/64	5.897	1.486	3.75	61/64	21.84	10.38	
29/64	6.290	1.585	4.0	63/64	22.47	10.65	
31/64	6.683	1.684	4.25	65/64	23.10	10.92	
33/64	7.076	1.783	4.5	67/64	23.73	11.19	
35/64	7.469	1.882	4.75	69/64	24.36	11.46	
37/64	7.862	1.981	5.0	71/64	24.99	11.73	
39/64	8.255	2.080	5.25	73/64	25.62	12.00	
41/64	8.648	2.179	5.5	75/64	26.25	12.27	
43/64	9.041	2.278	5.75	77/64	26.88	12.54	
45/64	9.434	2.377	6.0	79/64	27.51	12.81	
47/64	9.827	2.476	6.25	81/64	28.14	13.08	
49/64	10.220	2.575	6.5	83/64	28.77	13.35	
51/64	10.613	2.674	6.75	85/64	29.40	13.62	
53/64	11.006	2.773	7.0	87/64	30.03	13.89	
55/64	11.399	2.872	7.25	89/64	30.66	14.16	
57/64	11.792	2.971	7.5	91/64	31.29	14.43	
59/64	12.185	3.070	7.75	93/64	31.92	14.70	
61/64	12.578	3.169	8.0	95/64	32.55	14.97	
63/64	12.971	3.268	8.25	97/64	33.18	15.24	
65/64	13.364	3.367	8.5	99/64	33.81	15.51	
67/64	13.757	3.466	8.75	101/64	34.44	15.78	
69/64	14.150	3.565	9.0	103/64	35.07	16.05	
71/64	14.543	3.664	9.25	105/64	35.70	16.32	
73/64	14.936	3.763	9.5	107/64	36.33	16.59	
75/64	15.329	3.862	9.75	109/64	36.96	16.86	
77/64	15.722	3.961	10.0	111/64	37.59	17.13	
79/64	16.115	4.060	10.25	113/64	38.22	17.40	
81/64	16.508	4.159	10.5	115/64	38.85	17.67	
83/64	16.901	4.258	10.75	117/64	39.48	17.94	
85/64	17.294	4.357	11.0	119/64	40.11	18.21	
87/64	17.687	4.456	11.25	121/64	40.74	18.48	
89/64	18.080	4.555	11.5	123/64	41.37	18.75	
91/64	18.473	4.654	11.75	125/64	42.00	19.02	
93/64	18.866	4.753	12.0	127/64	42.63	19.29	
95/64	19.259	4.852	12.25	129/64	43.26	19.56	
97/64	19.652	4.951	12.5	131/64	43.89	19.83	
99/64	20.045	5.050	12.75	133/64	44.52	20.10	
101/64	20.438	5.149	13.0	135/64	45.15	20.37	
103/64	20.831	5.248	13.25	137/64	45.78	20.64	
105/64	21.224	5.347	13.5	139/64	46.41	20.91	
107/64	21.617	5.446	13.75	141/64	47.04	21.18	
109/64	22.010	5.545	14.0	143/64	47.67	21.45	
111/64	22.403	5.644	14.25	145/64	48.30	21.72	
113/64	22.796	5.743	14.5	147/64	48.93	21.99	
115/64	23.189	5.842	14.75	149/64	49.56	22.26	
117/64	23.582	5.941	15.0	151/64	50.19	22.53	
119/64	23.975	6.040	15.25	153/64	50.82	22.80	
121/64	24.368	6.139	15.5	155/64	51.45	23.07	
123/64	24.761	6.238	15.75	157/64	52.08	23.34	
125/64	25.154	6.337	16.0	159/64	52.71	23.61	
127/64	25.547	6.436	16.25	161/64	53.34	23.88	
129/64	25.940	6.535	16.5	163/64	53.97	24.15	
131/64	26.333	6.634	16.75	165/64	54.60	24.42	
133/64	26.726	6.733	17.0	167/64	55.23	24.69	
135/64	27.119	6.832	17.25	169/64	55.86	24.96	
137/64	27.512	6.931	17.5	171/64	56.49	25.23	
139/64	27.905	7.030	17.75	173/64	57.12	25.50	
141/64	28.298	7.129	18.0	175/64	57.75	25.77	
143/64	28.691	7.228	18.25	177/64	58.38	26.04	
145/64	29.084	7.327	18.5	179/64	59.01	26.31	
147/64	29.477	7.426	18.75	181/64	59.64	26.58	
149/64	29.870	7.525	19.0	183/64	60.27	26.85	
151/64	30.263	7.624	19.25	185/64	60.90	27.12	
153/64	30.656	7.723	19.5	187/64	61.53	27.39	
155/64	31.049	7.822	19.75	189/64	62.16	27.66	
157/64	31.442	7.921	20.0	191/64	62.79	27.93	
159/64	31.835	8.020	20.25	193/64	63.42	28.20	
161/64	32.228	8.119	20.5	195/64	64.05	28.47	
163/64	32.621	8.218	20.75	197/64	64.68	28.74	
165/64	33.014	8.317	21.0	199/64	65.31	29.01	
167/64	33.407	8.416	21.25	201/64	65.94	29.28	
169/64	33.800	8.515	21.5	203/64	66.57	29.55	
171/64	34.193	8.614	21.75	205/64	67.20	29.82	
173/64	34.586	8.713	22.0	207/64	67.83	30.09	
175/64	34.979	8.812	22.25	209/64	68.46	30.36	
177/64	35.372	8.911	22.5	211/64	69.09	30.63	
179/64	35.765	9.010	22.75	213/64	69.72	30.90	
181/64	36.158	9.109	23.0	215/64	70.35	31.17	
183/64	36.551	9.208	23.25	217/64	70.98	31.44	
185/64	36.944	9.307	23.5	219/64	71.61	31.71	
187/64	37.337	9.406	23.75	221/64	72.24	31.98	
189/64	37.730	9.505	24.0	223/64	72.87	32.25	
191/64	38.123	9.604	24.25	225/64	73.50	32.52	
193/64	38.516	9.703	24.5	227/64	74.13	32.79	
195/64	38.909	9.802	24.75	229/64	74.76	33.06	
197/64	39.302	9.901	25.0	231/64	75.39	33.33	
199/64	39.695	10.000	25.25	233/64	76.02	33.60	
201/64	40.088	10.099	25.5	235/64	76.65	33.87	
203/64	40.481	10.198	25.75	237/64	77.28	34.14	
205/64	40.874	10.297	26.0	239/64	77.91	34.41	
207/64	41.267	10.396	26.25	241/64	78.54	34.68	
209/64	41.660	10.495	26.5	243/64	79.17	34.95	
211/64	42.053	10.594	26.75	245/64	79.80	35.22	
213/64	42.446	10.693	27.0	247/64	80.43	35.49	
215/64	42.839	10.792	27.25	249/64	81.06	35.76	
217/64	43.232	10.891	27.5	251/64	81.69	36.03	
219/64	43.625	10.990	27.75	253/64	82.32	36.30	
221/64	44.018	11.089	28.0	255/64	82.95	36.57	
223/64	44.411	11.188	28.25	257/64	83.58	36.84	
225/64	44.804	11.287	28.5	259/64	84.21	37.11	
227/64	45.197	11.386	28.75	261/64	84.84	37.38	
229/64	45.590	11.485	29.0	263/64	85.47	37.65	
231/64	45.983	11.584	29.25	265/64	86.10	37.92	
233/64	46.376	11.683	29.5	267/64	86.73	38.19	
235/64	46.769	11.782	29.75	269/64	87.36	38.46	
237/64	47.162	11.881	30.0	271/64	87.99	38.73	
239/64	47.555	11.980	30.25	273/64	88.62	39.00	
241/64	47.948	12.079	30.5	275/64	89.25	39.27	
243/64	48.341	12.178	30.75	277/64	89.88	39.54	
245/64	48.734	12.277	31.0	279/64	90.51	39.81	
247/64	49.127	12.376	31.25	281/64	91.14	40.08	
249/64	49.520	12.475	31.5	283/64	91.77	40.35	
251/64	49.913	12.574	31.75	285/64	92.40	40.62	
253/64	50.306	12.673	32.0	287/64	93.03	40.89	
255/64	50.699	12.772	32.25	289/64	93.66	41.16	
257/64	51.092	12.871	32.5	291/64	94.29	41.43	
259/64	51.485	12.970	32.75	293/64	94.92	41.70	
261/64	51.878	13.069	33.0	295/64	95.55	41.97	
263/64	52.271	13.168	33.25</				

模具技术培训资料

标题: 模具基础知识

主讲: Pines

www.poweron-mould.com
sales@poweron-mould.com

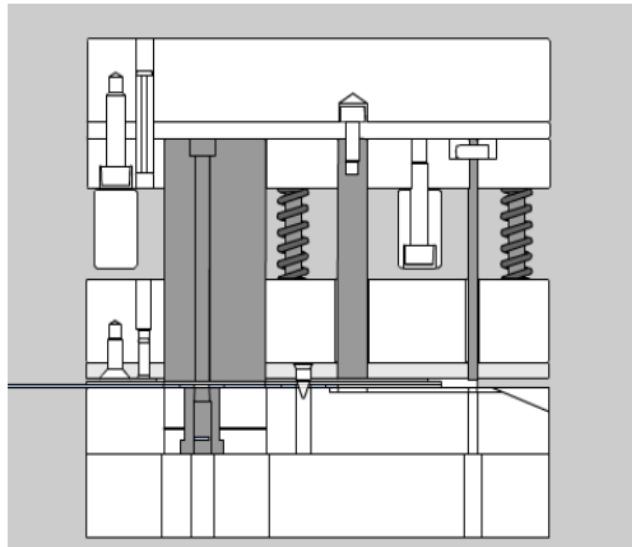
1

模具是什么？

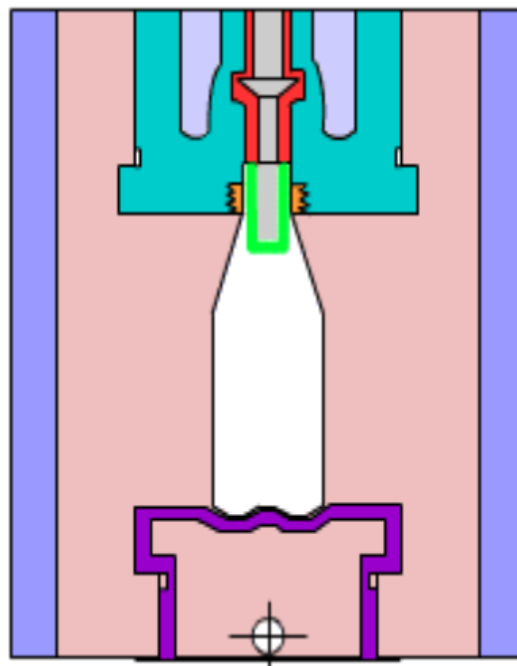
工业生产上用以注塑、吹塑、挤出、压铸或锻压成型、冶炼、冲压、拉伸等方法得到所需产品的各种模子和工具。

简而言之，模具是用来成型物品的工具，这种工具由各种零件构成，不同的模具由不同的零件构成。它主要通过所成型材料物理状态的改变来实现物品外形的加工。

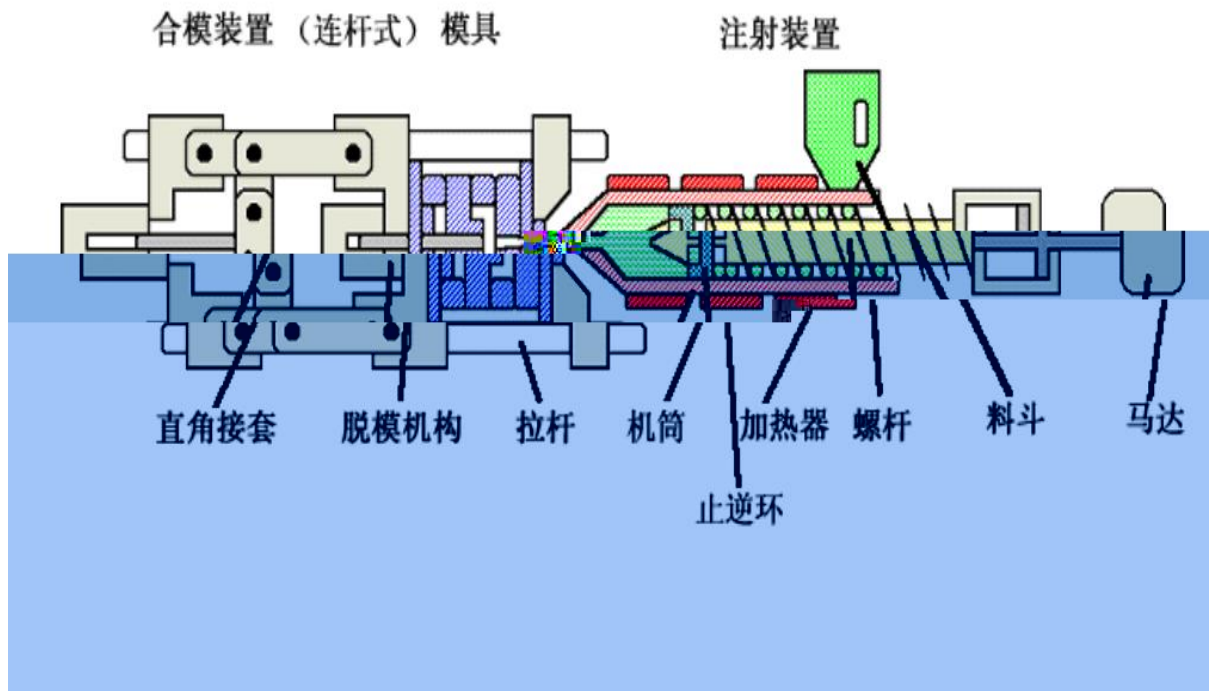
五金冲压模：



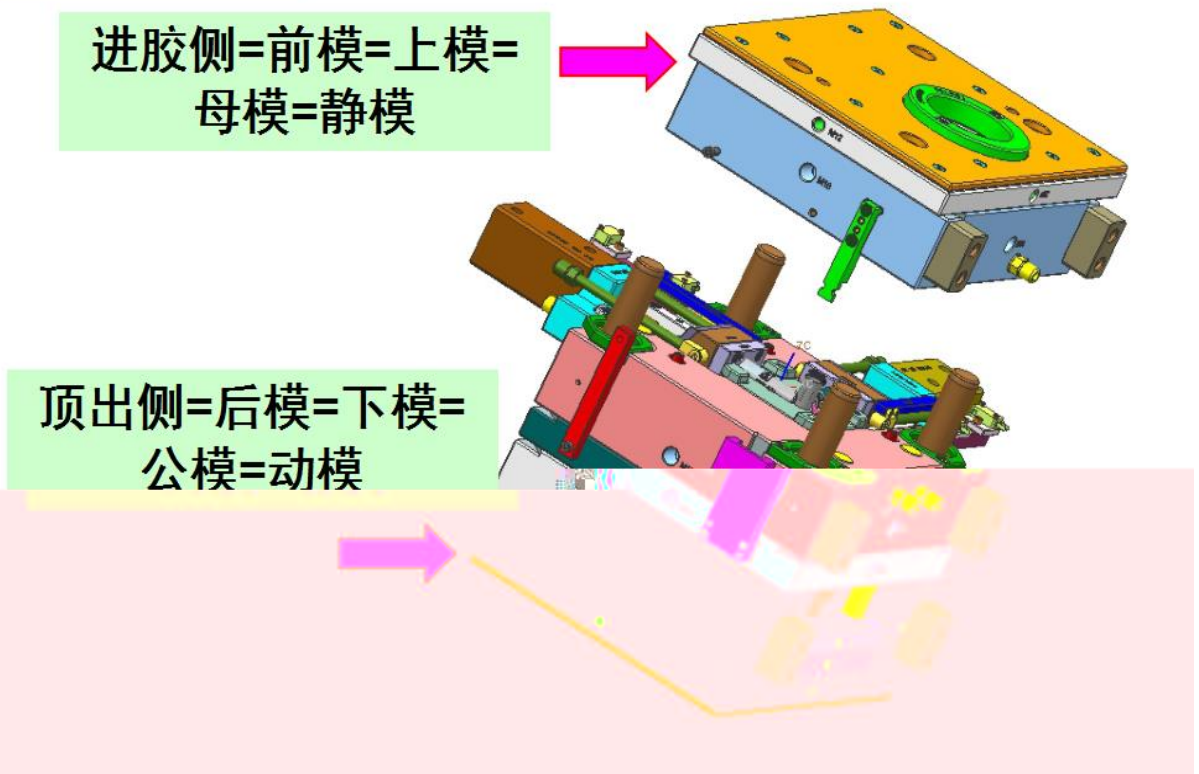
吹塑模：



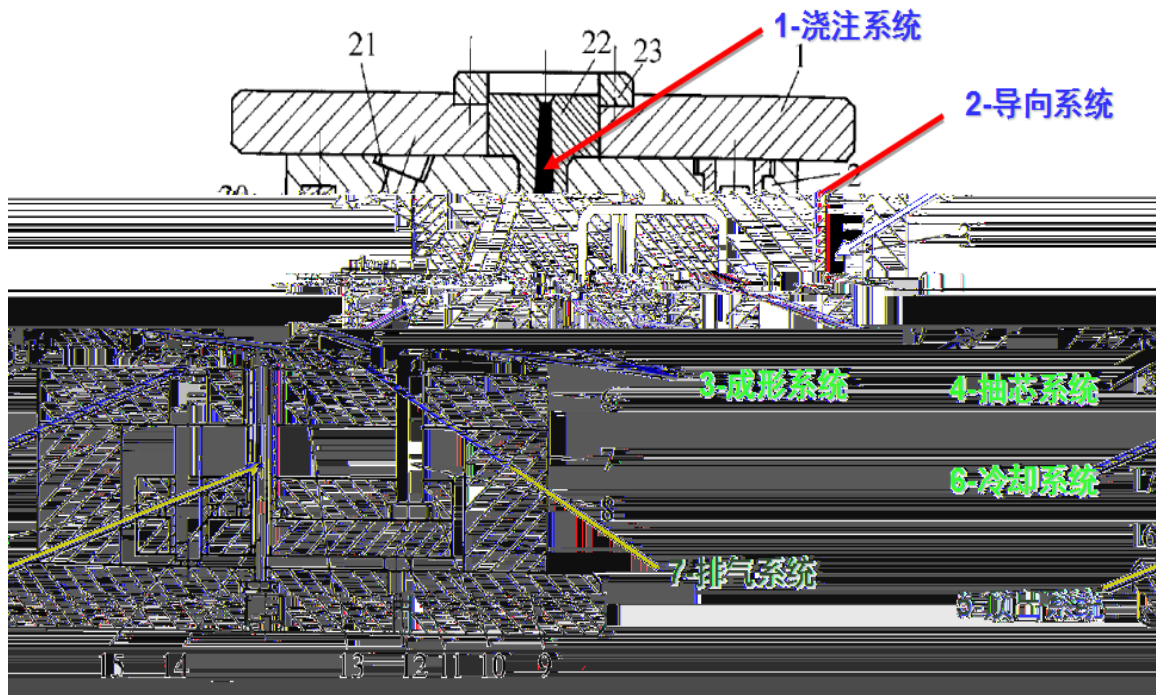
注塑成型原理:



模具是这样的:



注塑模七大系统：



模具生产一般流程：

■ 模具生产一般流程：

