

MOLDOLT

**ENJOY THE
PROCESS**

MOLDING SOLUTIONS



Mold management



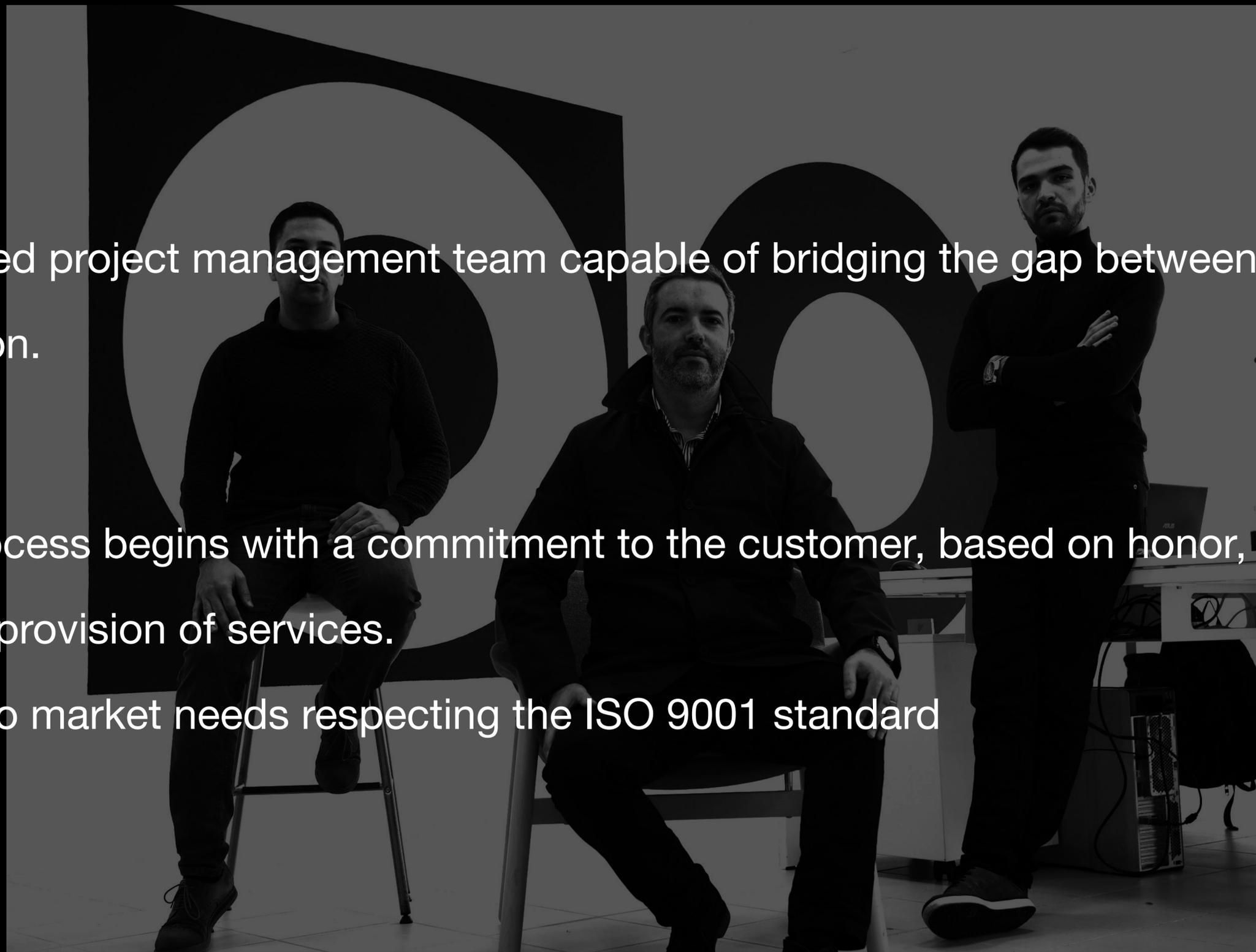
TEAM

An experienced project management team capable of bridging the gap between end customer and production.

IDONEITY

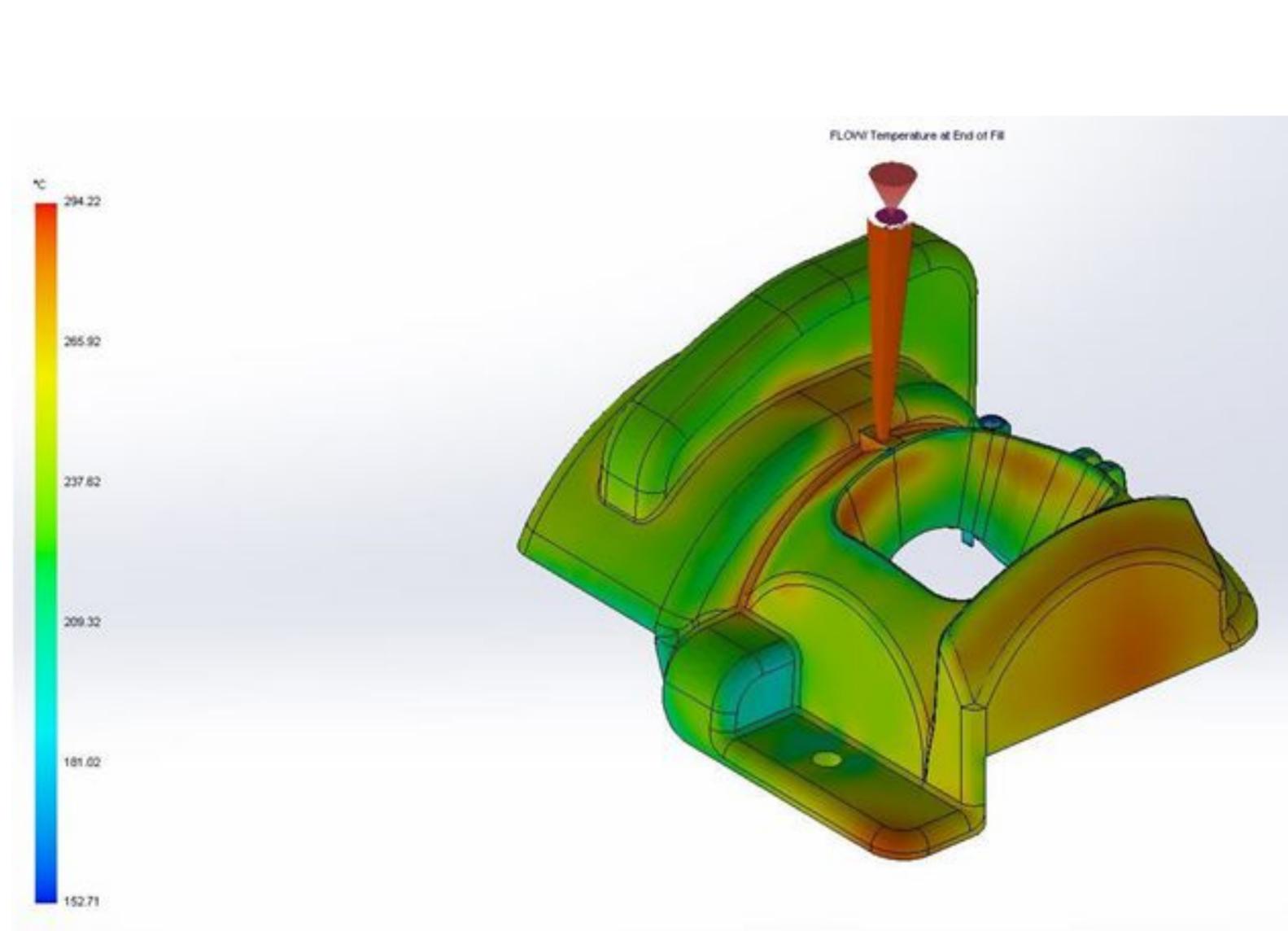
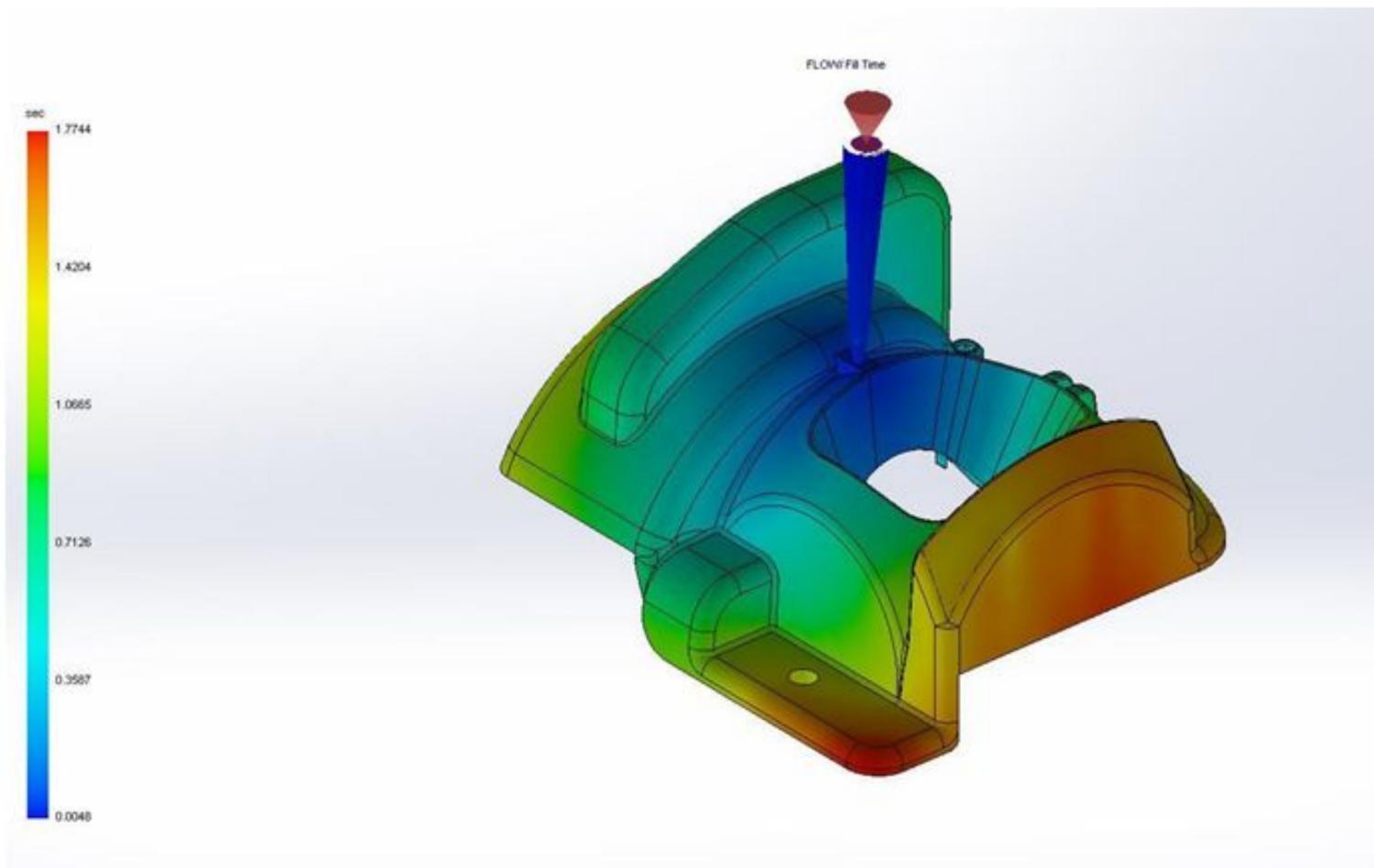
Our entire process begins with a commitment to the customer, based on honor, honesty and quality in the provision of services.

We respond to market needs respecting the ISO 9001 standard



1- Analysis of parts for molding process

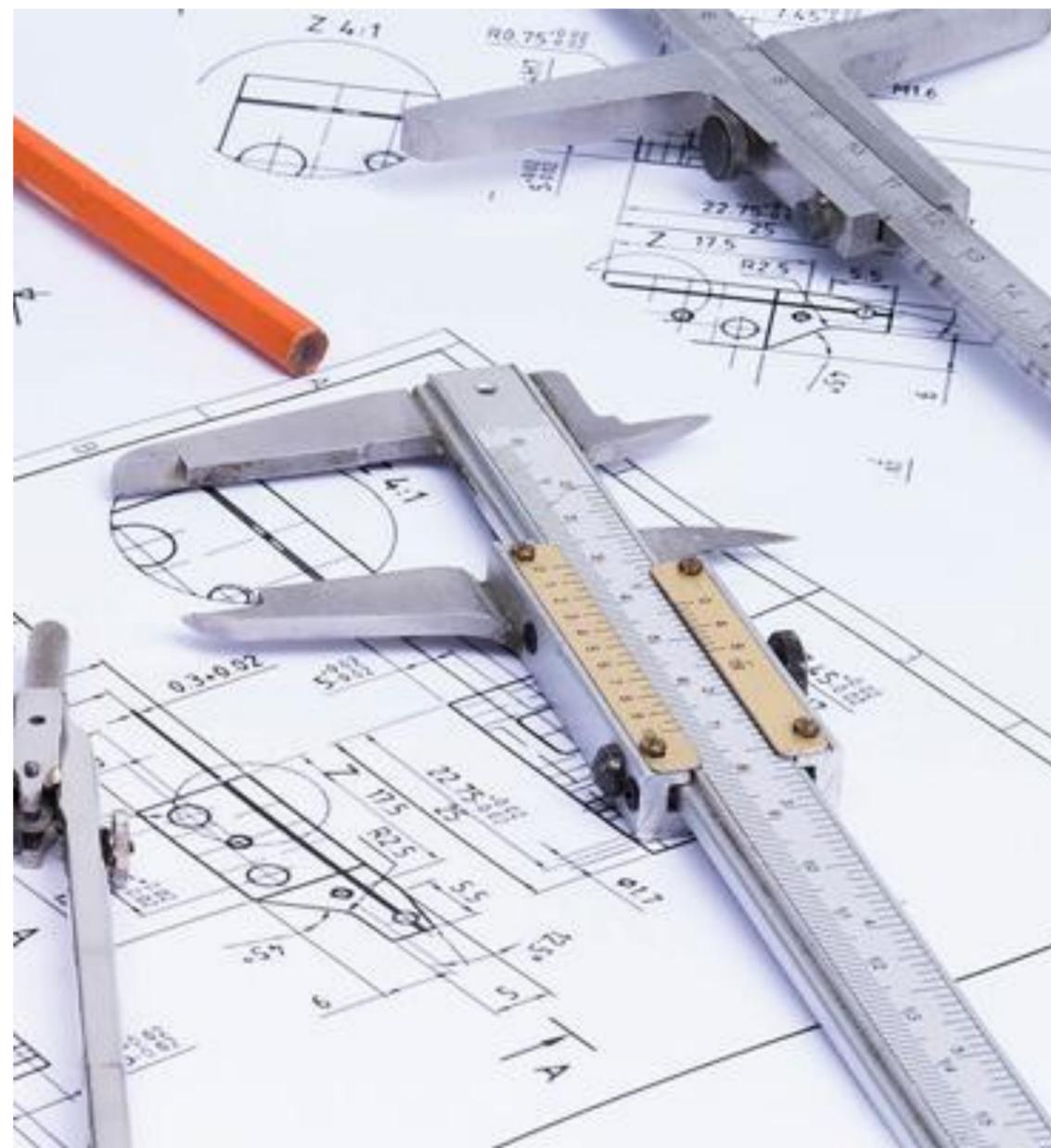
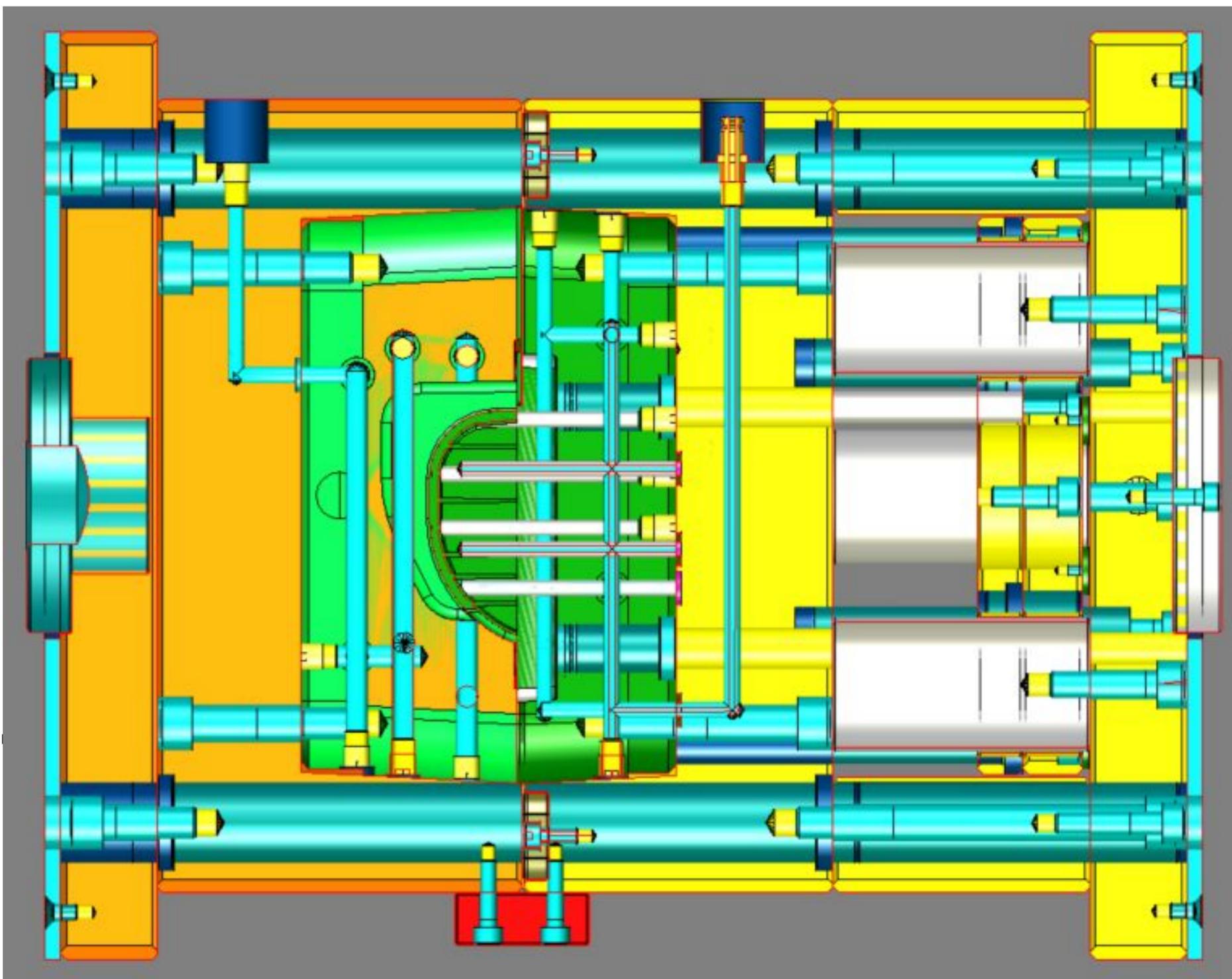
Using the various resources that technology offers to solve problems, among them we present the technical analysis of the part filling or rheology study (Mold Flow), thus being able to anticipate problems even before the tool design.



2- Analysis and validation of tool preliminaries (2D and 3D)

The preliminary analysis of the tool allows the choice of material for the tool to be the most appropriate and consequently a possible reduction in costs associated with it, as well as planning the best way to execute it in the shortest possible time.

We use 3D development software such as SolidWorks, CATIA.



3- Complete customer documentation

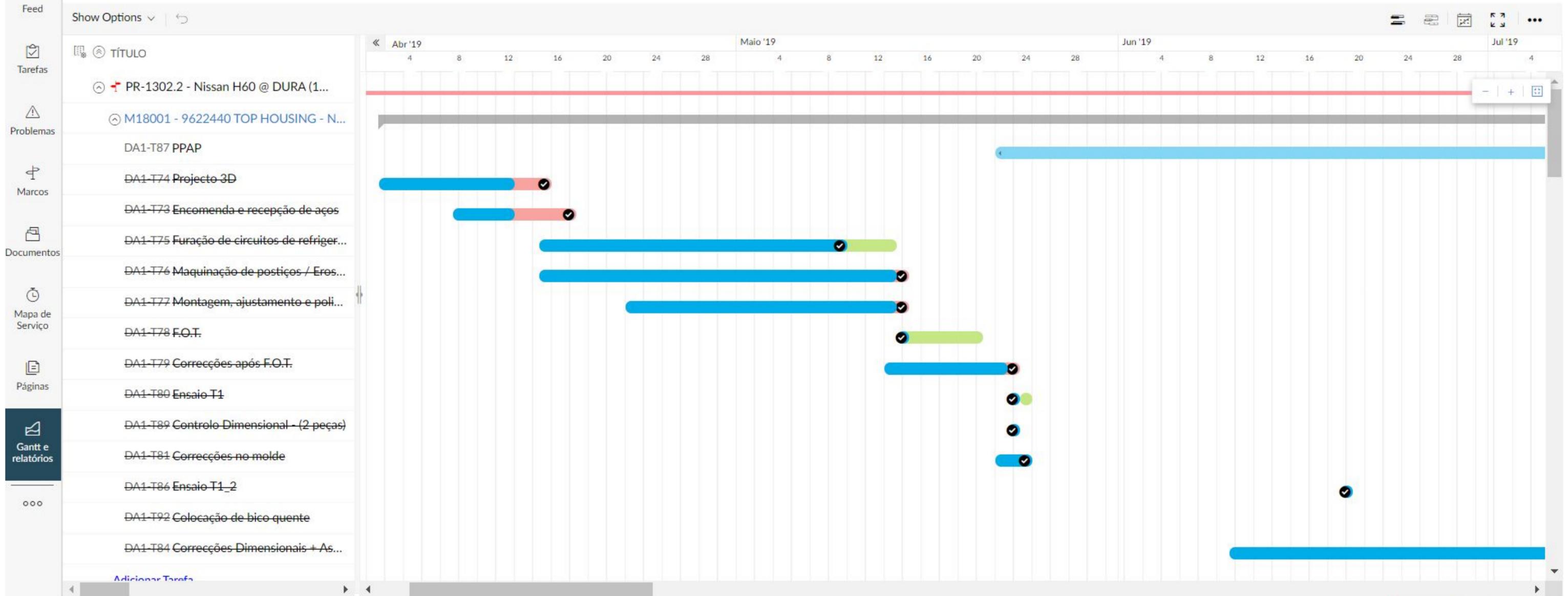
The completion of a technical dossier will accompany the project so that there is always a non-digital way to consult the process, from 2D drawings to test reports as well as certificates of raw material are some of the elements present in the documentation.

4- Management of tool construction and daily status

In the follow-up of the project, we have a very important assistance on our side, Zoho Projects allows us to be in constant connection with the client and share the daily status of the project even from a distance, as well as the entire plan of execution of tasks through the GANTT Map. It also allows the client to comment whatever his position on the project or attach important documents for the project.

Molde | M1801
 Nº Orçamento | 571/2018
 Peça | TOP HOUSING
 Nº de Peça | 9622440

grupo	NA	elemento técnico / ponto a verificar	especificado	realização	controlo
1. CONSIDERAÇÕES GERAIS	1.1	A contracção está correcta		executada	OK
	1.2	Referência dos ficheiro(s) de peça utilizado(s)		executada	OK
	1.3	Revisão da ficha técnica utilizada no projecto		executada	OK
	1.4	No. de cavidades de acordo com o pedido		executada	OK
	1.5	Existe estudo MOLDFLOW com análises do enchimento e empenas		executada	OK
	1.6	Nome do ficheiro do estudo MOLDFLOW aprovado para avançar com o sistema de injeção		executada	NAK
	1.7	Existe estudo térmico		executada	OK
	1.8	Existe informação relativamente ao acabamento das peças (textura / polimentos)		anulada	
	1.9	Em caso das superfícies com textura, as saídas são suficientes para o grão de textura pretendido		anulada	
	1.10	Acessórios standard de acordo com o fornecedor principal mencionado pelo cliente		executada	OK
	1.11	O molde tem placa isolante do lado da injeção		executada	OK
	1.12	O molde tem placa isolante do lado da extracção		executada	OK
2. AÇOS	1.13	Tipo de aço está definido no desenho e lista de materiais conforme ficha técnica		executada	OK
	2.1	Informação sobre tratamentos térmicos das diversas peças mencionada na lista de materiais		executada	NAK
	2.2	Placa de textura (referência 400) encomendada em simultâneo com a placa a texturizar (aço do mesmo lote)		anulada	
	2.3	As dimensões (comprimento x largura x espessura) do molde adequam-se à máquina de injeção		executada	OK
	3.1	Espessura molde mínima / máxima do molde de acordo com as especificações do cliente		executada	OK
	3.2	Curso de abertura molde cumpre os requisitos da máquina de injeção		executada	OK
	3.3	Altura superior e inferior em relação ao centro molde		executada	NAK
	3.4	As colunas das máquinas de injeção estão mencionadas no desenho de molde e modelação		executada	NAK



4- Customer Connection

The proximity to the customer for us is very important.

Supported in technology uses a Google MEET tool to meet with the customer

5- Management the first tests of the tool until final approval.

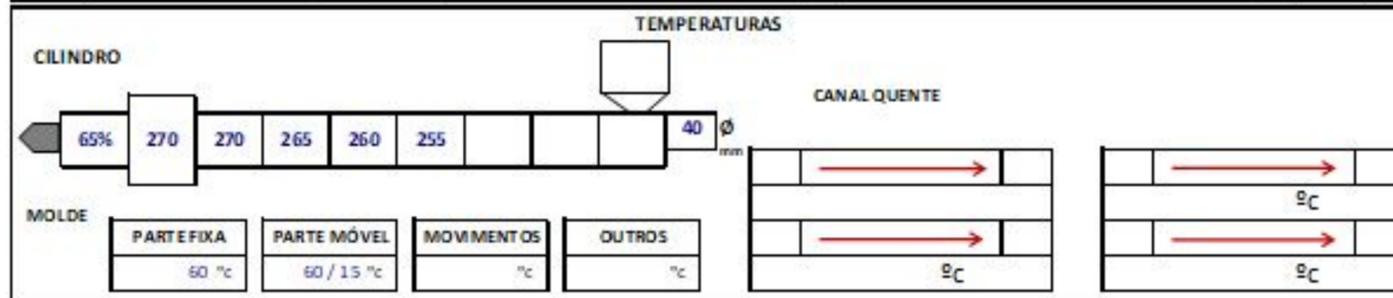
The entire process is accompanied by specialized technicians from start to finish.

This step is important for the validation and approval of the tool, since there may be corrections to be made.

MOOLT FICHA DE PARAMETROS DE INJEÇÃO DATA: 21/11/2018

MOLDE: M18001 DESIGNAÇÃO: 96224440 CUENTE: NISSAN
 LOCAL ENSAIO: PORTUGAL - TRYCENTER LTDA TÉCNICO: GUSTAVO MAQUINA: KRAUSS MAFFEI 80 TONS.
 ENSAIO Nº 0 OBJECTIVO ENSAIO: T1
 PRESENTES NO ENSAIO CARLOS; PEDRO; GUILHERME; SERGIO

MATERIAL: PA66 GF 30 REFERÊNCIA: TECHNYL A218 V30 N. LOTE: ESTUFAGEM Y SECADOR
 TEMP. 100 °C DURAÇÃO: 5 HORAS CORANTE Y DESUMIDIFICADOR
 DESIGNAÇÃO: UTILIZAÇÃO %



PLASTIFICAÇÃO

SEQUENCIAL				INIECÇÃO DINAMICA				COMPACTAÇÃO				
Nº	Inl.	Fim	Dur.	Nº	Inl.	Fim	Dur.	VELOCIDADE	PRESSÃO	CURSO	PRESSÃO	TEMPO
1				9				<input checked="" type="checkbox"/> mm/sec	<input checked="" type="checkbox"/> bar	<input checked="" type="checkbox"/> mm	<input checked="" type="checkbox"/> bar	<input checked="" type="checkbox"/> sec.
2				10				<input type="checkbox"/> 1/100	<input type="checkbox"/> 1/100	<input type="checkbox"/> 1/100	<input type="checkbox"/> 1/100	<input type="checkbox"/> 1/100
3				11				1	50	91	50	15
4				12				2	10	91		
5				13				3				
6				14				4				
7				15							Comutação	25
8				16							Almofada (mm)	16

DOSAGEM

VELOCIDADE	CONTRA PRESSÃO	CURSO
<input type="checkbox"/> RPM	<input checked="" type="checkbox"/> bar	<input checked="" type="checkbox"/> mm
<input checked="" type="checkbox"/> 1/100	<input type="checkbox"/> 1/100	<input type="checkbox"/> 1/100

TEMPOS

1	125	10	100
2			

FORÇA DE FECHO UTILIZADA: 80 Tons. 1/100

ABRIR MOLDE	---	S
EXTRACÇÃO	---	S
FECHAR MOLDE	---	S
ARREFECIMENTO	35	S
CICLO TOTAL	60	S

PESO DA PEÇA 1 (ESQ.)	118	Gramas
PESO DA PEÇA 2 (DIR.)		Gramas
PESO DA PEÇA 3		Gramas
PESO DA PEÇA 4		Gramas
CANAL INIECÇÃO	8	Gramas
Nº DE PEÇAS PRODUZIDAS	20	UNIDADES

MOOLT MOLD CORRECTION REPORT

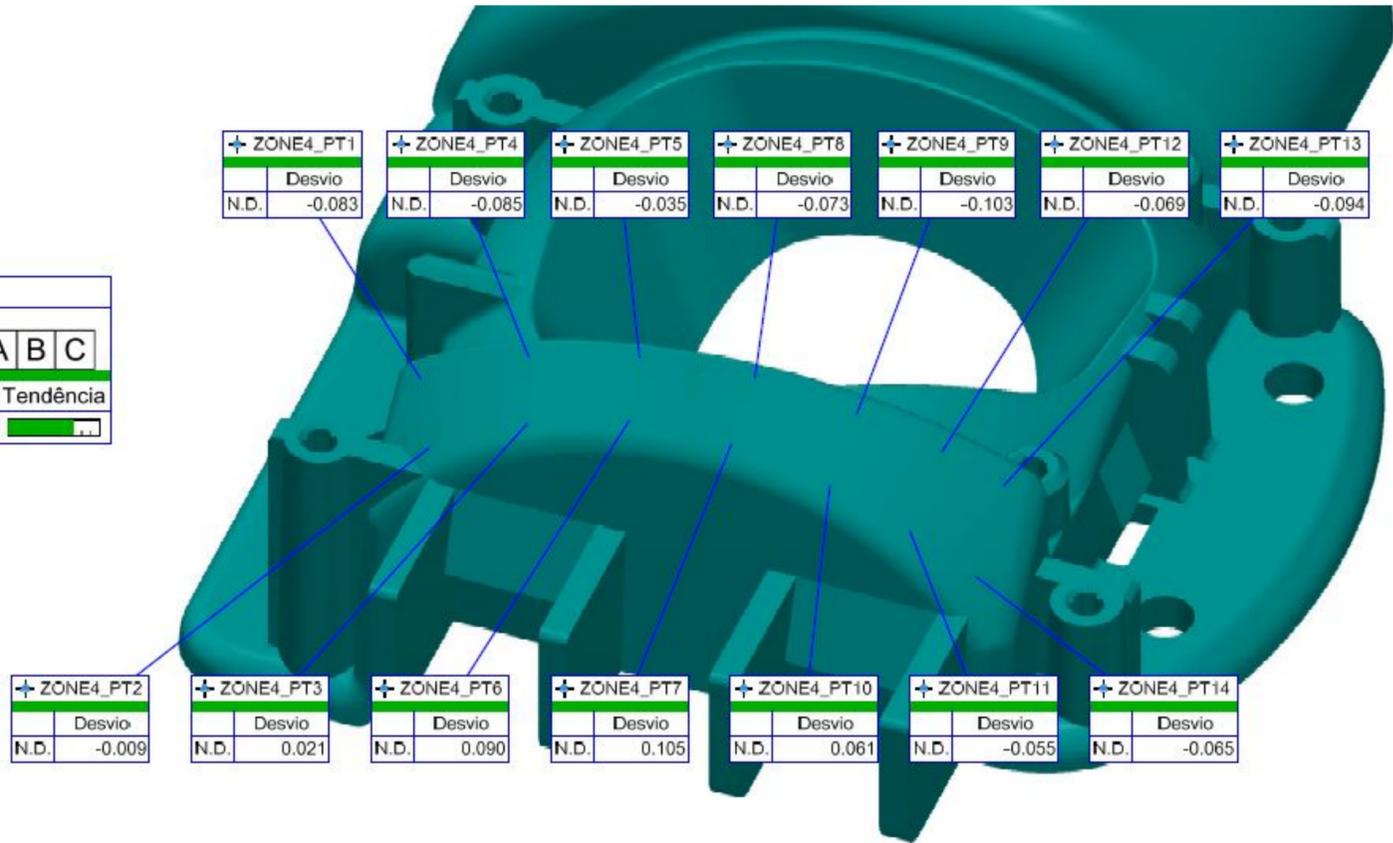
Project NISSAN H60
Part Ref 9622440

Date	Item	Photo	Comments	OK	NOOK
21/nov	1		Eliminar rebarbas nos furos assinalados	X	
07/dez	2		Melhorar acabamento nos frisos		X
07/dez	3		Superfície do clip ligeiramente deformada. Verificar no aço e melhorar.		X
07/dez	4		Eliminar desencontros na linha de junta.		X

6- Dimensional Control

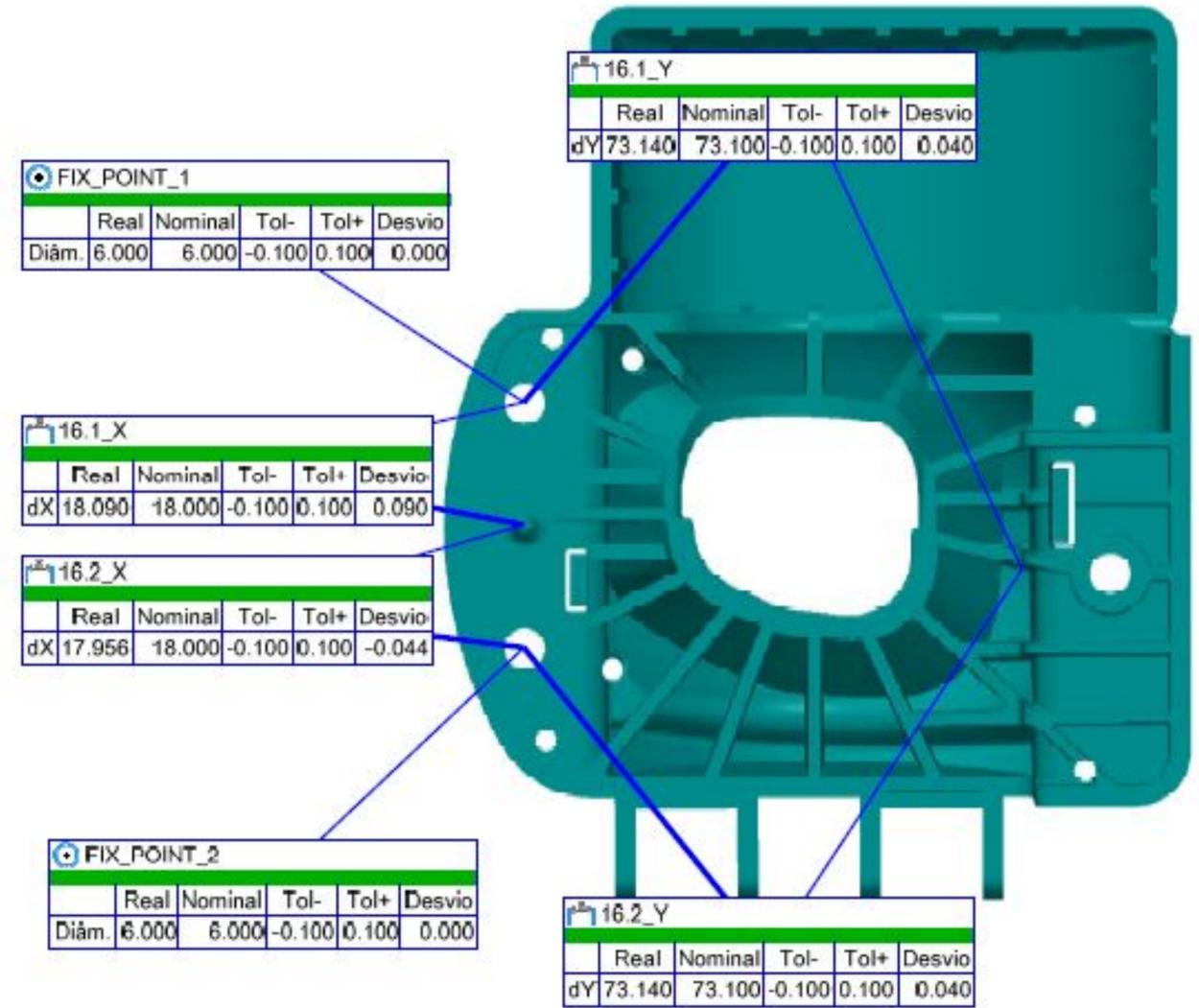
Dimensional control is part of our offer, using 3D or three-dimensional Scan technologies that allow the validation of geometric characteristics of objects proposed by the customer.

27			
14x	0.300Ⓞ A B C		
	Nominal	Desvio	Tendência
Ⓞ	0.000	0.209	



16.1			
⊕	∅0.200Ⓞ A B C		
	Nominal	Desvio	Tendência
⊕	0.000	0.180	

16.2			
⊕	∅0.200Ⓞ A B C		
	Nominal	Desvio	Tendência
⊕	0.000	0.088	

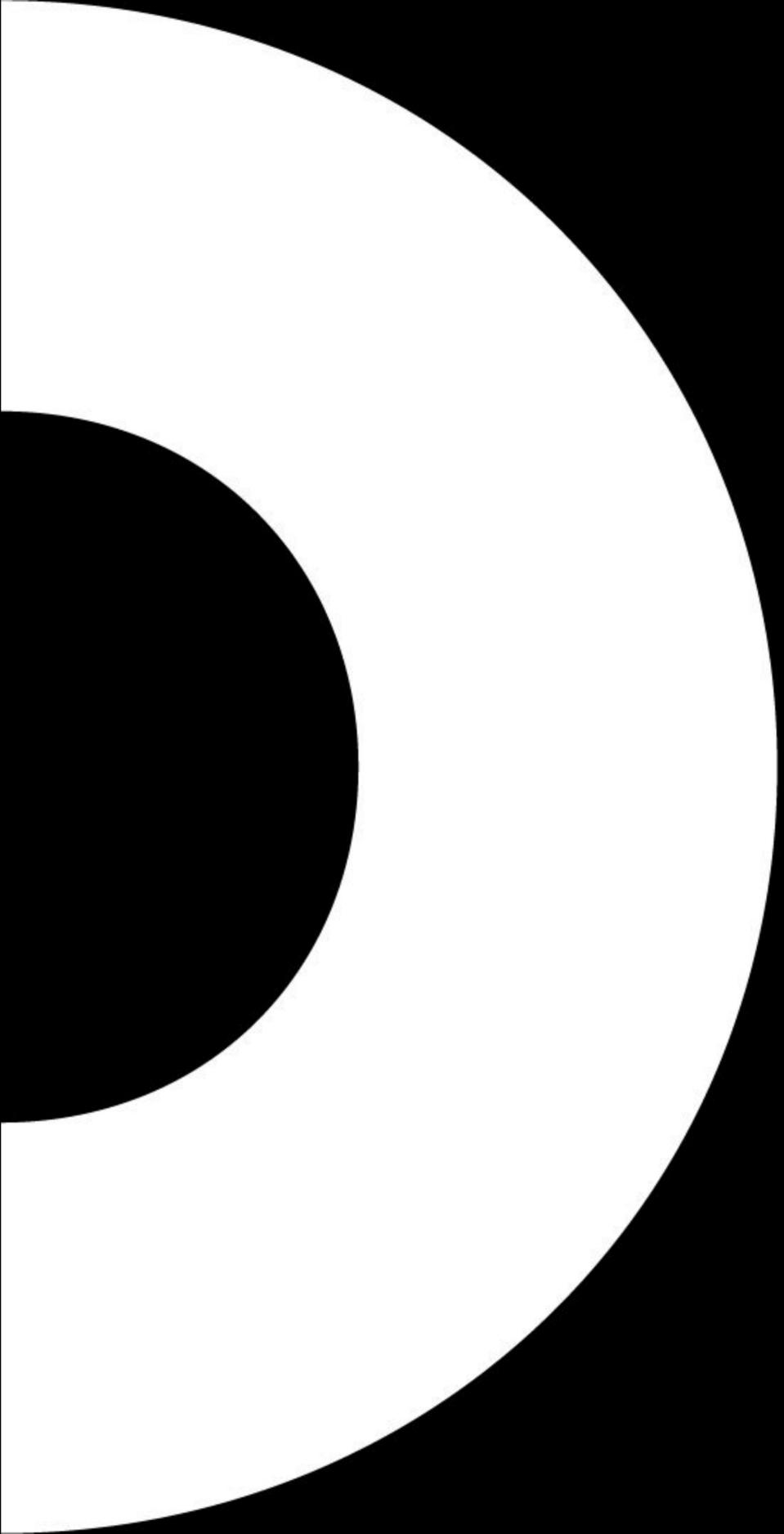


7- Quality control according to customer specifications

With the collaboration of specialized technicians, we were able to offer the availability of human resources to accompany the quality control and technical analysis processes of reports, as well as the completion of them.

8- Pre-series production

Continuing the test and if the customer so wishes, we are able to produce pre-series, since it is important for the customer to test the first parts in their working environment.



MOOLT

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www.moolt.pt

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