

**PART NUMBER:**  
**152545**

**MATERIAL: PA6**

YES	NO	ITEM	DESCRIPTION
<input checked="" type="checkbox"/>	<input type="checkbox"/>	1).	Have all certificates been sent to MMG or are they being sent to MMG? (i.e. Steel, cert's, electronic 2D & 3D design, certificate of origin, commercial invoice, bill of lading, etc.)
<input checked="" type="checkbox"/>	<input type="checkbox"/>	2).	Are all bolts Hasco standard?
<input checked="" type="checkbox"/>	<input type="checkbox"/>	3).	Are all leader pins, ejector pins/sleeves, guide bushings HASCO standard?
<input checked="" type="checkbox"/>	<input type="checkbox"/>	4).	Have all mold components (removable) been stamped with mold number and corresponding location in the mold?
<input checked="" type="checkbox"/>	<input type="checkbox"/>	5).	Do the cavity and core have specified finishes per the customer's design?
<input checked="" type="checkbox"/>	<input type="checkbox"/>	6).	Are all ribs and bosses draw polished?
<input checked="" type="checkbox"/>	<input type="checkbox"/>	7).	Does the guided ejector system move freely?
<input checked="" type="checkbox"/>	<input type="checkbox"/>	8).	Has a 200-300 cycle dry run been performed and tool inspected for metal dust, shavings or gauling?
<input type="checkbox"/>	<input checked="" type="checkbox"/>	9).	Are all ejector pin ream not more than .75" before they are relived?
<input checked="" type="checkbox"/>	<input type="checkbox"/>	10).	Does the cavity and core inserts have proper clearance of .080"-.100: from each other when mold is closed? Has a .100" x .100" chamfer been put on all cav/core plock (insert) edges?
<input checked="" type="checkbox"/>	<input type="checkbox"/>	11).	Are all dwelling steels different hardnesses or materials for proper wear?
<input checked="" type="checkbox"/>	<input type="checkbox"/>	12).	Are return pins free to rotate and is their length higher than parting line by .010"-.015"?
<input checked="" type="checkbox"/>	<input type="checkbox"/>	13).	Has the mold been tested for water leaks with 100-200 psi water/air pressure? Have all chips been removed? Have all circuits been properly stamped number & in/out?
<input checked="" type="checkbox"/>	<input type="checkbox"/>	14).	Does each cavity have it's own independent water circuit?
<input type="checkbox"/>	<input checked="" type="checkbox"/>	15).	Are water manifolds included.
<input checked="" type="checkbox"/>	<input type="checkbox"/>	16).	Do all leader pins enter their bushings before any part of the mold touches?
<input checked="" type="checkbox"/>	<input type="checkbox"/>	17).	Are all KO holes the correct pattern for the specified press? Do all KO's have extensions to make them flush with the back side of the clamp plate? Do KO bolt is made per MMG's request
<input type="checkbox"/>	<input checked="" type="checkbox"/>	18).	Do all slides have spring return or ample detents so they will stay in their position when the mold is open (and set in any direction)?
<input type="checkbox"/>	<input checked="" type="checkbox"/>	19).	Do all slides/Lifters have water lines and independent circuits?
<input type="checkbox"/>	<input checked="" type="checkbox"/>	20).	If the sprue is offset, have the KO holes been offset also?
<input type="checkbox"/>	<input checked="" type="checkbox"/>	21).	Have eyebolt holes been provided on all (4) sides and are an metric thread?

Inspected by: Baozhong Huang

Checked by: Kaiqin Zhang

Approved by: Iris Chen

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<input checked="" type="checkbox"/>	<input type="checkbox"/>	22).	Is the mold test process sheet been supplied to MMG?
<input checked="" type="checkbox"/>	<input type="checkbox"/>	23).	Has the mold name plate been installed and reads the correct information?
<input checked="" type="checkbox"/>	<input type="checkbox"/>	24).	Has the mold number been engraved on the operator side, top exterior in minimum .5" tall letters/ numbers? Has "TOP OF MOLD" been identified and labelled accordingly?
<input checked="" type="checkbox"/>	<input type="checkbox"/>	25).	Are micro switches installed if needed?
<input checked="" type="checkbox"/>	<input type="checkbox"/>	26).	Is the sprue bushing 15.5mm Radius and the location ring 125mm Dia ?
<input type="checkbox"/>	<input checked="" type="checkbox"/>	27).	If the mold has a hot runner, has 7.0mm thick insulator plate been added to the cavity clamp plate?
<input type="checkbox"/>	<input checked="" type="checkbox"/>	28).	Have safety straps been installed?
<input checked="" type="checkbox"/>	<input type="checkbox"/>	29).	Will the mold fit and run in the press specified in MMG's Machine Spec tab?
<input checked="" type="checkbox"/>	<input type="checkbox"/>	30).	Is the mold vented adequately?
<input checked="" type="checkbox"/>	<input type="checkbox"/>	31).	Is the ejector stroke adequate to eject the part fully plus .25"?
<input type="checkbox"/>	<input checked="" type="checkbox"/>	32).	Does the mold cavity's have proper markings:
<input type="checkbox"/>	<input checked="" type="checkbox"/>		Part number
<input type="checkbox"/>	<input checked="" type="checkbox"/>		Mold number
<input type="checkbox"/>	<input checked="" type="checkbox"/>		Cav number
<input type="checkbox"/>	<input checked="" type="checkbox"/>		Material code
<input type="checkbox"/>	<input checked="" type="checkbox"/>		Date tracking:
<input type="checkbox"/>	<input checked="" type="checkbox"/>		Logo
<input checked="" type="checkbox"/>	<input type="checkbox"/>	33).	Are there grease grooves on all leader pins, guide pins, ej blades, slide gibs/keepers and wear plates?
<input checked="" type="checkbox"/>	<input type="checkbox"/>	34).	Has the mold been sprayed with rust preventative prior to crating for shipment?
<input checked="" type="checkbox"/>	<input type="checkbox"/>	35).	Have critical release areas (core pins, bosses, steep walls/ribs, etc) been draw polished to remove all EDM scale or cutter marks?
<input type="checkbox"/>	<input checked="" type="checkbox"/>	36).	Are contoured ejector pins keyed in the ejector plate?
<input checked="" type="checkbox"/>	<input type="checkbox"/>	37).	Are all electrical components wired per MMG's Tool Spec.
<input type="checkbox"/>	<input checked="" type="checkbox"/>	38).	All special components must have a back-up set made and shipped with the mold. Also an extra set of manifold tips need be shipped with the mold or directly to MMG?

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If any item is marked "NO" please explain below. Give the item number and explanation.

Item #	Explanation
9	All the EP holes were wirecut by three times, no need for reaming.
15	No request for water manifold.
18	No spring for this mold, but there is cylinder for return.
19	The slider is small, so no water circuit.
20	As request.
21	Only top and bottom surfaces have eyebolt holes.
27	No hot runner, but have isolation sheet.
28	No safety strap, but there is lifting block on the top as request.
32	No request.
36	The ejection surface is flat, no need for keyed ejector pins.
38	No special components.

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