



protospain.com

# MOLDS – PROTOTYPE AND SERIES

Service offered by:



**PRODICEX**  
SOLUTIONS

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1. Main differences: Prototype and Serial Molds
2. Different types of molds and materials
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# MAIN DIFFERENCES

## PROTOTYPE MOLDS - SERIAL MOLDS

The differences between prototype molds and serial molds are the following:

- Less durable steel: P20
- Less guaranteed injections: <10,000
- Quality of parts: Similar to serial molds in guaranteed injected parts.
- Mold manufacturing led times: 10% shorter
- Price: From 20% to 30% lower

# DIFFERENT TYPES OF MOLDS AND MATERIALS

**We can offer the following types of molds:**

1. One level plastic injection molds
2. Multi-level plastic injection molds
3. Double injection molds (different color or material)
4. High performance thermoplastics molds
5. Precision molds
6. Precision molds - Automotive
7. Precision molds - Medicine
8. Home electrical appliances and industrial products molds

To get more info about this kind of molds, feel free to visit our site:  
[www.protospain.com](http://www.protospain.com)

**With respect to injection materials, we offer a wide range, including: PP, ABS, PC, PA, PA+GF, PBT, POM, etc..**

# QUOTATION PROCESS

Normally, we can elaborate a quote in 24-72 hours from the reception of the required information, consisting of:

1. **3D files.-** Files in format IGS, STEP or CATIA are chiefly required.
2. **Surface finishes.-** We need to know if there are surface finishes implying mold texturing.
3. **Additional special finishes.-** Painted, screen printed, UVI treatment, etc.
4. **Number of units to be injected.** Number of units to be injected each time and number of units expected of the product.
5. **Material.** Material chosen to be injected into the parts.
6. **Other requirements.** Including inserts, threaded inserts, added or assembled parts, dimensional reports, etc.
7. **Non-Disclosure Agreement.** We have a model NDA in case the client wishes to sign it and does not have its own.
8. **Quotation.-** The quotes will detail all the points aforementioned.

# MANUFACTURING PROCESS

1. **Quotation approval.-** All manufacturing conditions are detailed here, and it must be signed and sealed by the client, and sent back to us in order to proceed with the next steps.
2. **DFM.- Design For Manufacturing.-** In this process, we analyze the part to be produced and we agree on the final design so the product can be injected seamlessly. This stage normally takes 2 or 3 days.
3. **Mold Flow.-** A report is made with the injection flow to determine the joint and injection points. This stage is carried out simultaneously with the previous one, and both take 2-3 days.
4. **3D mold approval.-** The mold design starts only when the DFM and the Mold Flow are approved by the client, **and it will take around 4 days.**
5. **Manufacturing.-** The manufacturing process starts and it depends on the part to be injected.
6. **Test.-** When the mold is finished, in a 2 days led time, the first run of parts is made to be approved by the client.
7. **Later modificactions.-** Required samples will be carried out for injection of parts final approval.
8. **Samples approval.-** When the parts are approved, the mold will be ready for injection.

# ALTERNATIVES FOR LATER INJECTION

1. **Injection in Prodicex facilities.-** We have injection machines to carry out series and pre-series.
2. **Injection in client facilities.-** This is key since the mold design must be defined in accordance with the the right settings in the client's injection machine, so we need the technical data sheet of the machine where the parts are to be injected.

# SAMPLES

Here you will find a sample of the parts made with prototype molds or serial molds, with different materials and surface finishes, stating manufacturing led times of the mold and of the DFM and 3D mold definitions.

Signing NDAs with our clients prevents us from showing the parts assembled for them, and the parts we show is because we have their prior consent to disclosure.



# PLATE - SUPPORT



Mold	-----	Prototyping mold
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Hot Runner	-----	No
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Nº Cavities	-----	1 + 1
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Mold life (Cycles)	-----	20.000
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Material	-----	PC + ABS
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Surface finishing	-----	Texturized
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Sector	-----	Informatic
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Leadtime - Total	-----	42 Days
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DFM + 3D	-----	7 Days
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Mold	-----	35 Days
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Notes	-----	Metal inserts
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# SPEAKER - CENTRAL



Mold	-----	Prototyping mold
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Hot Runner	-----	No
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Nº Cavities	-----	1 X 1
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Mold life (Cycles)	-----	20.000
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Material	-----	ABS
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Surface finishing	-----	Painted - Rubbery
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Sector	-----	Informatic
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Leadtime - Total	-----	27 Days
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DFM + 3D	-----	7 Days
----------	-------	--------

Mold	-----	20 Days
------	-------	---------



Notes	-----	nted - Rubbery - Serigraphy
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# PROTECTOR 1



Mold	-----	Prototyping mold
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Hot Runner	-----	No
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Nº Cavities	-----	1 X 1
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Mold life (Cycles)	-----	10.000
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Material	-----	ABS (BLACK) UV
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Surface finishing	-----	Polished
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Sector	-----	Several
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Leadtime - Total	-----	27 Days
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DFM + 3D	-----	7 Days
----------	-------	--------

Mold	-----	20 Days
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Notes	-----	
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# COVER



Mold	-----	Prototyping mold
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Hot Runner	-----	No
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Nº Cavities	-----	1 + 1
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Mold life (Cycles)	-----	20.000
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Material	-----	PC + ABS
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Surface finishing	-----	Polished
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Sector	-----	Several
--------	-------	---------



Leadtime - Total	-----	32 Days
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DFM + 3D	-----	7 Days
----------	-------	--------

Mold	-----	25 Days
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Notes	-----	
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# PROTECTOR 2



Mold	-----	Prototyping mold
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Hot Runner	-----	No
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Nº Cavities	-----	1 + 1
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Mold life (Cycles)	-----	15.000
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Material	-----	PA66 + 30%GF
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Surface finishing	-----	Polished
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Sector	-----	Several
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Leadtime - Total	-----	37 Days
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DFM + 3D	-----	7 Days
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Mold	-----	30 Days
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Notes	-----	
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# DATA BOX



Mold	-----	Prototyping mold
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Hot Runner	-----	No
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Nº Cavities	-----	1 + 1
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Mold life (Cycles)	-----	10.000
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Material	-----	ABS (BLACK) UV
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Surface finishing	-----	Texturized
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Sector	-----	Informatic
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Leadtime - Total	-----	27 Days
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DFM + 3D	-----	7 Days
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Mold	-----	20 Days
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Notes	-----	Metal inserts
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# PIN + SENSOR SCANNER



Mold	-----	Prototyping mold
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Hot Runner	-----	No
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Nº Cavities	-----	1 + 1
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Mold life (Cycles)	-----	50.000
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Material	-----	PC + ABS
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Surface finishing	-----	Polished
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Sector	-----	Informatic
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Leadtime - Total	-----	32 Days
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DFM + 3D	-----	7 Days
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Mold	-----	25 Days
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Notes	-----	
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# COVER SENSOR SCANNER



Mold	-----	Prototyping mold
Hot Runner	-----	No
Nº Cavities	-----	1 X 1
Mold life (Cycles)	-----	50.000
Material	-----	PC + ABS
Surface finishing	-----	Texturized
Sector	-----	Informatic
Leadtime - Total	-----	32 Days
DFM + 3D	-----	7 Days
Mold	-----	25 Days
Notes	-----	





# PIECE - ARMREST



Mold	-----	Prototyping mold
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Hot runner	-----	No
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Nº Cavities	-----	1 X 1
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Mold life (Cycles)	-----	10.000
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Material	-----	PA66 + 30%GF
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Surface finishing	-----	Polished
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Sector	-----	Automotive
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Leadtime - Total	-----	32 Days
DFM + 3D	-----	7 Days
Mold	-----	25 Days



Notes	-----	
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# GLOVE BOX - DOOR



Mold	-----	Formal mold
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Hot runner	-----	Moldmasters 2 valve gates change to sub gate
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Nº Cavities	-----	1 + 1
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Mold life (Cycles)	-----	500.000
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Material	-----	PE-MD15
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Surface finishing	-----	Graining / Technical polish
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Sector	-----	Automotive
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Leadtime - Total	-----	49 Days
DFM + 3D	-----	7 Days
Mold	-----	42 Days



Notes	-----	
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# CAR REAR VIEW MIRRORS



Mold

-----

Formal mold



Hot runner

-----

JDO 1 open gates to side gate



Nº Cavities

-----

1 + 1



Mold life (Cycles)

-----

500.000



Material

-----

ASA + PC



Surface finishing

-----

Cavity NH-573



Sector

-----

Automotive



Leadtime - Total

-----

42 Days

DFM + 3D

-----

7 Days

Mold

-----

35 Days



Notes

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# FRONT BODY PILLARS



Mold	-----	Formal mold
------	-------	-------------



Hot runner	-----	DO 1 open gates to sub gate
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Nº Cavities	-----	1 + 1
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Mold life (Cycles)	-----	500.000
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Material	-----	P/E-TD10
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Surface finishing	-----	Cavity grain: 203.61 Core: Polish
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Sector	-----	Automotive
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Leadtime - Total	-----	49 Days
DFM + 3D	-----	7 Days
Mold	-----	42 Days



Notes	-----
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# CENTRAL CONSOLE



Mold	-----	Formal mold
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Hot runner	-----	UDO 1 open gates to sub gate
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Nº Cavities	-----	1 + 1
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Mold life (Cycles)	-----	500.000
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Material	-----	PP T20
----------	-------	--------



Surface finishing	-----	VOIDmaster not runner b valve gate direct into the part
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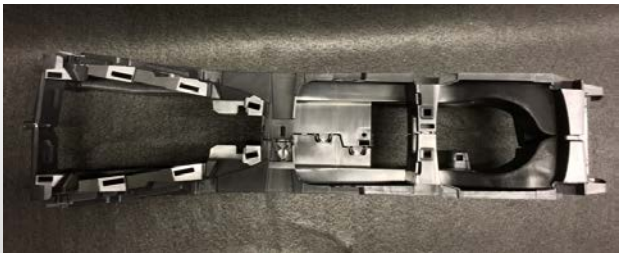
Sector	-----	Automotive
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Leadtime - Total	-----	56 Days
DFM + 3D	-----	7 Days
Mold	-----	49 Days



Notes	-----	
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# ARMREST - BASE



Mold	-----	Formal mold
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Hot runner	-----	JDO 1 hot tip to cold runner
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Nº Cavities	-----	1 + 1
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Mold life (Cycles)	-----	500.000
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Material	-----	PP-AS-004
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Surface finishing	-----	Cavity grain: 800# Core grain: 400#
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Sector	-----	Automotive
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Leadtime - Total	-----	49 Days
DFM + 3D	-----	7 Days
Mold	-----	42 Days



Notes	-----
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# ARMREST - BOX



Mold	-----	Formal mold
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Hot runner	-----	No
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Nº Cavities	-----	1 + 1
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Mold life (Cycles)	-----	500.000
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Material	-----	ABS-IC2-2
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Surface finishing	-----	Cavity grain: 800# Core grain: 400#
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Sector	-----	Automotive
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Leadtime - Total	-----	49 Days
DFM + 3D	-----	7 Days
Mold	-----	42 Days



Notes	-----	
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# CENTRAL PILLARS 1



Mold	-----	Formal mold
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Hot runner	-----	Synventive hot runner 6 valve gates
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Nº Cavities	-----	1 + 1
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Mold life (Cycles)	-----	500.000
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Material	-----	PC+ABS
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Surface finishing	-----	Polish grain: 240#
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Sector	-----	Automotive
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Leadtime - Total	-----	84 Days
DFM + 3D	-----	7 Days
Mold	-----	77 Days



Notes	-----	
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## CENTRAL PILLARS 2



Mold	-----	Formal mold
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Hot runner	-----	No
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Nº Cavities	-----	1 + 1
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Mold life (Cycles)	-----	500.000
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Material	-----	PP T25
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Surface finishing	-----	Polish grain: 240#
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Sector	-----	Automotive
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Leadtime - Total	-----	42 Days
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DFM + 3D	-----	7 Days
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Mold	-----	35 Days
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Notes	-----	
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# SEAT BELT TRIM



Mold	-----	Formal mold
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Hot runner	-----	Synventive hot runner 2 open gates to cold runner sub gate
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Nº Cavities	-----	1 * 2
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Mold life (Cycles)	-----	500.000
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Material	-----	PC+ABS
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Surface finishing	-----	Cavity grain: Textilnarbe N 65 Core grain 240#
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Sector	-----	Automotive
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Leadtime - Total	-----	49 Days
DFM + 3D	-----	7 Days
Mold	-----	42 Days



Notes	-----	
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# SUPPORT - LIGHTING 1



Mold	-----	Formal mold
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Hot Runner	-----	Yudo 1 Drop
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Nº Cavities	-----	1 + 1
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Mold life (Cycles)	-----	1.000.000
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Material	-----	PE-TD10
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Surface finishing	-----	Polished
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Sector	-----	Automotive
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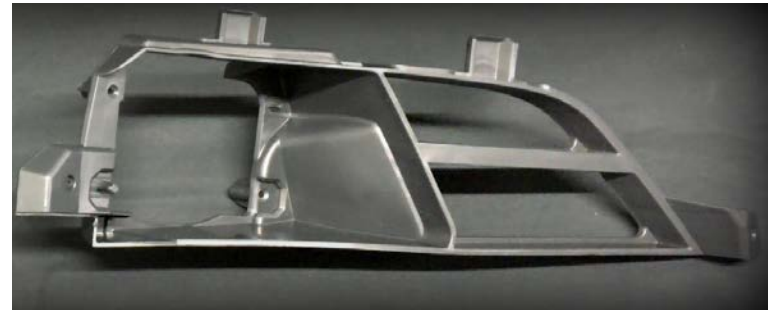
Leadtime - Total	-----	47 Days
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DFM + 3D	-----	7 Days
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Mold	-----	40 Days
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Notes	-----	
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## SUPPORT - LIGHTING 2



Mold	-----	Prototyping mold
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Hot Runner	-----	No
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Nº Cavities	-----	1 X 1
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Mold life (Cycles)	-----	20.000
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Material	-----	P G30 + Santoprene 101-50
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Surface finishing	-----	Polished
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Sector	-----	Automotive
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Leadtime - Total	-----	57 Days
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DFM + 3D	-----	7 Days
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Mold	-----	50 Days
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Notes	-----	Overmoulding: 2 Molds
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# SUPPORT - LIGHTING 3



Mold	-----	Formal mold
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Hot Runner	-----	Yudo 2 Drops
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Nº Cavities	-----	1 + 1
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Mold life (Cycles)	-----	1.000.000
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Material	-----	PE
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Surface finishing	-----	Polished
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Sector	-----	Automotive
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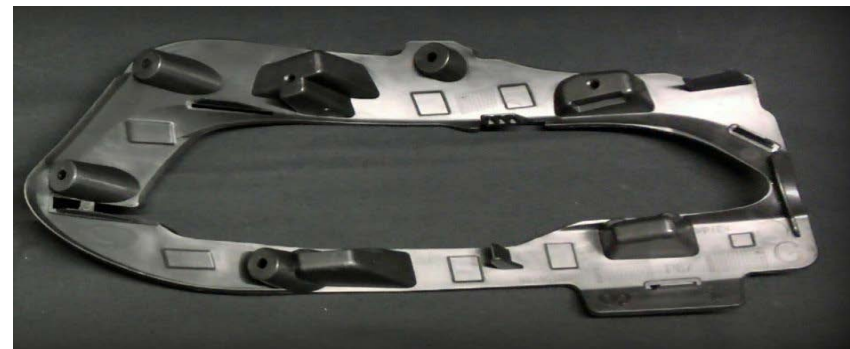
Leadtime - Total	-----	55 Days
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DFM + 3D	-----	7 Days
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Mold	-----	48 Days
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Notes	-----	
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# FILTERS 1



Mold	-----	Formal mold
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Hot Runner	-----	Synventive 1 Drop
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Nº Cavities	-----	1 + 1
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Mold life (Cycles)	-----	500.000
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Material	-----	PC
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Surface finishing	-----	Polished
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Sector	-----	Automotive
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Leadtime - Total	-----	47 Days
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DFM + 3D	-----	7 Days
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Mold	-----	40 Days
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Notes	-----	
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## FILTERS 2



Mold ----- Formal mold



Hot Runner ----- Synventive 1 Drop



Nº Cavities ----- 1 + 1



Mold life (Cycles) ----- 500.000



Material ----- PC



Surface finishing ----- Polished



Sector ----- Automotive



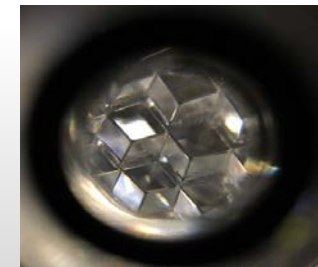
Leadtime - Total ----- 47 Days

DFM + 3D ----- 7 Days

Mold ----- 40 Days



Notes -----



## FILTERS 3



Mold	-----	Formal mold
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Hot Runner	-----	Synventive 1 Drop
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Nº Cavities	-----	1 X 1
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Mold life (Cycles)	-----	500.000
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Material	-----	PC
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Surface finishing	-----	Polished
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Sector	-----	Automotive
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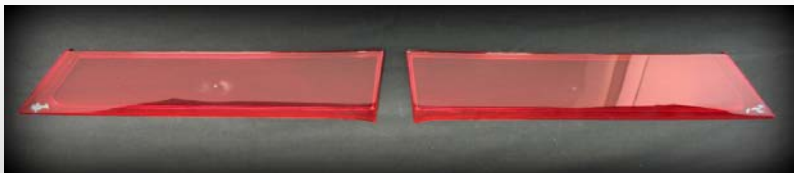
Leadtime - Total	-----	47 Days
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DFM + 3D	-----	7 Days
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Mold	-----	40 Days
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Notes	-----	
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# FILTERS 4



Mold	-----	Formal mold
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Hot Runner	-----	Nozzle HRS
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Nº Cavities	-----	1 + 1
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Mold life (Cycles)	-----	500.000
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Material	-----	PC HT APEC 1895 (BAYER)
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Surface finishing	-----	Polished
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Sector	-----	Automotive
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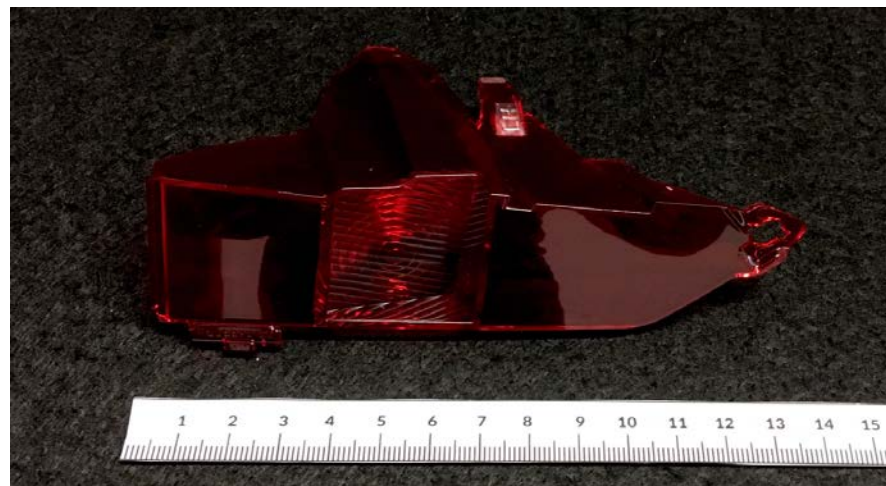
Leadtime - Total	-----	49 Days
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DFM + 3D	-----	7 Days
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Mold	-----	42 Days
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Notes	-----	Optical polished - Diamond paste
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# FILTERS 5



Mold	-----	Formal mold
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Hot Runner	-----	Nozzle HRS
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Nº Cavities	-----	1 + 1
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Mold life (Cycles)	-----	500.000
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Material	-----	PC HT APEC 1895 (BAYER)
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Surface finishing	-----	Polished
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Sector	-----	Automotive
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Leadtime - Total	-----	49 Days
------------------	-------	---------

DFM + 3D	-----	7 Days
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Mold	-----	42 Days
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Notes	-----	Optical polished - Diamond paste
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# LIGHT GUIDE 1



Mold	-----	Formal mold
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Hot Runner	-----	Synventive 1 Drop
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Nº Cavities	-----	1 + 1
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Mold life (Cycles)	-----	500.000
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Material	-----	PC
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Surface finishing	-----	Polished
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Sector	-----	Automotive
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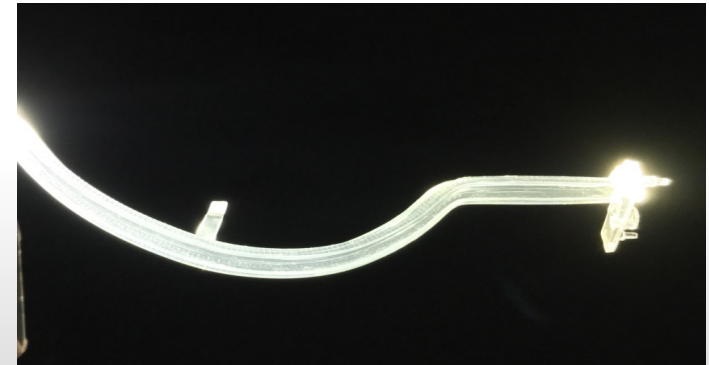
Leadtime - Total	-----	57 Days
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DFM + 3D	-----	7 Days
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Mold	-----	50 Days
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Notes	-----	
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# LIGHT GUIDE 3



Mold	-----	Formal mold
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Hot Runner	-----	Moldmaster 2 open gates to side gate
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Nº Cavities	-----	1 + 1
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Mold life (Cycles)	-----	500.000
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Material	-----	PMMA
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Surface finishing	-----	Polished
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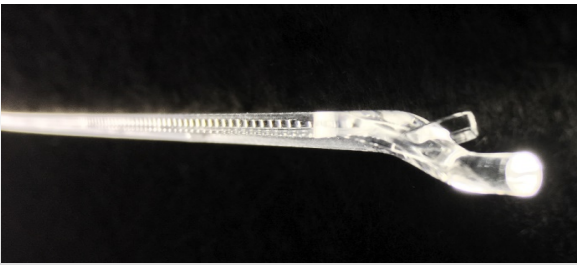
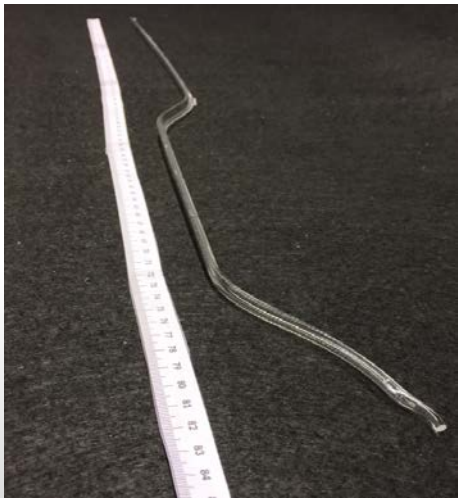
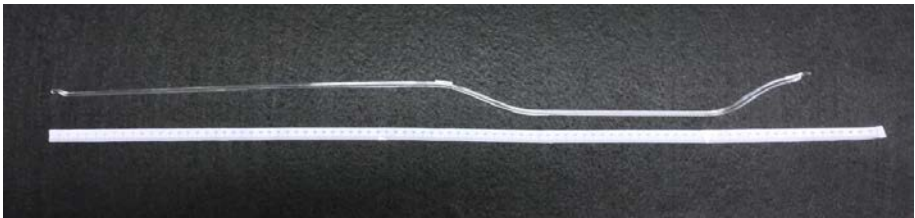
Sector	-----	Automotive
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Leadtime - Total	-----	49 Days
DFM + 3D	-----	7 Days
Mold	-----	42 Days



Notes	-----	Interchangeable insert
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# LIGHT GUIDE 4



Mold	-----	Formal mold
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Hot Runner	-----	No
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Nº Cavities	-----	1 + 1
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Mold life (Cycles)	-----	500.000
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Material	-----	PMMA
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Surface finishing	-----	Polished
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Sector	-----	Automotive
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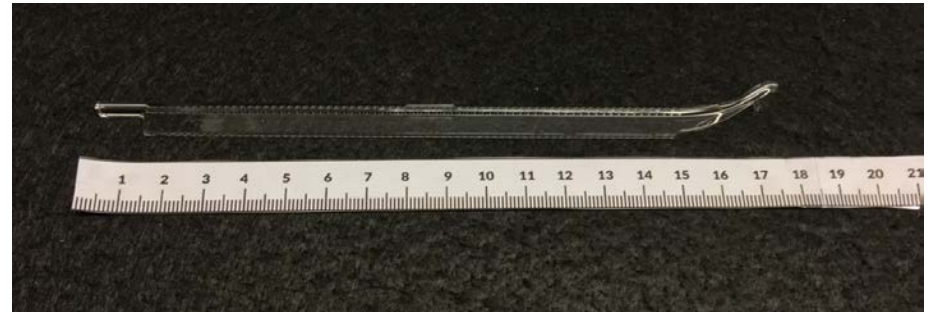
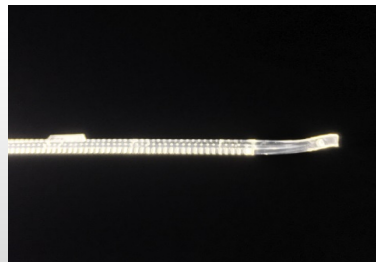
Leadtime - Total	-----	42 Days
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DFM + 3D	-----	7 Days
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Mold	-----	35 Days
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Notes	-----	Interchangeable insert
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# LIGHT GUIDE 6



Mold	-----	Formal mold
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Hot Runner	-----	No
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Nº Cavities	-----	1 + 1
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Mold life (Cycles)	-----	500.000
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Material	-----	PMMA (PLEXIGLAS 8N)
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Surface finishing	-----	Polished
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Sector	-----	Automotive
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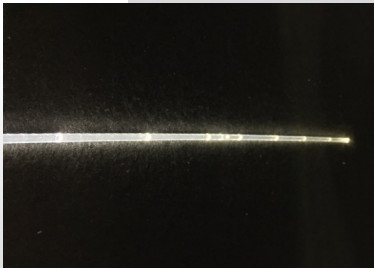
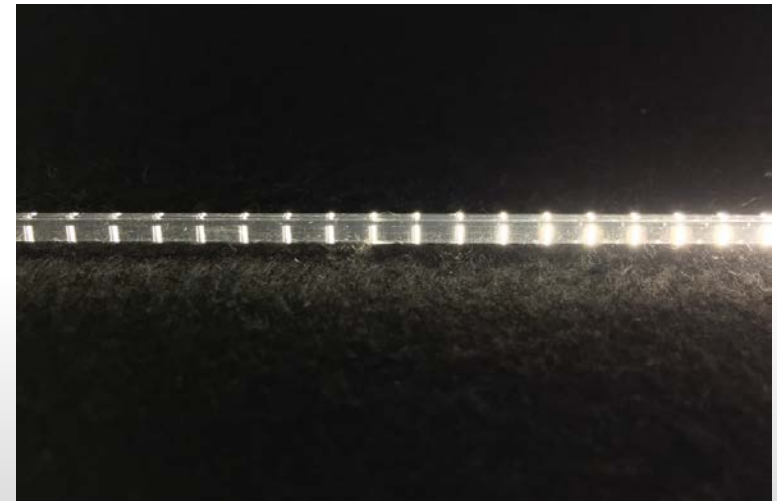
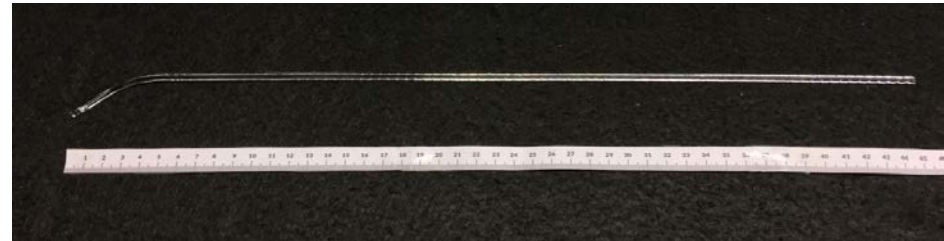
Leadtime - Total	-----	42 Days
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DFM + 3D	-----	7 Days
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Mold	-----	35 Days
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Notes	-----	
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# LIGHT GUIDE 8



Mold	-----	Formal mold
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Hot Runner	-----	Moldmaster 2 valve gates direct to the part
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Nº Cavities	-----	1 + 1
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Mold life (Cycles)	-----	500.000
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Material	-----	PMMA (PLEXIGLAS 8N)
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Surface finishing	-----	Polished
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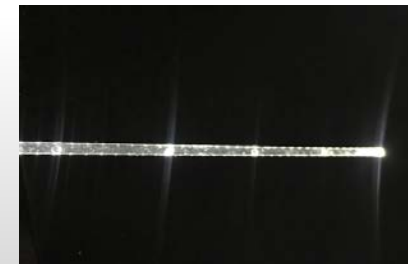
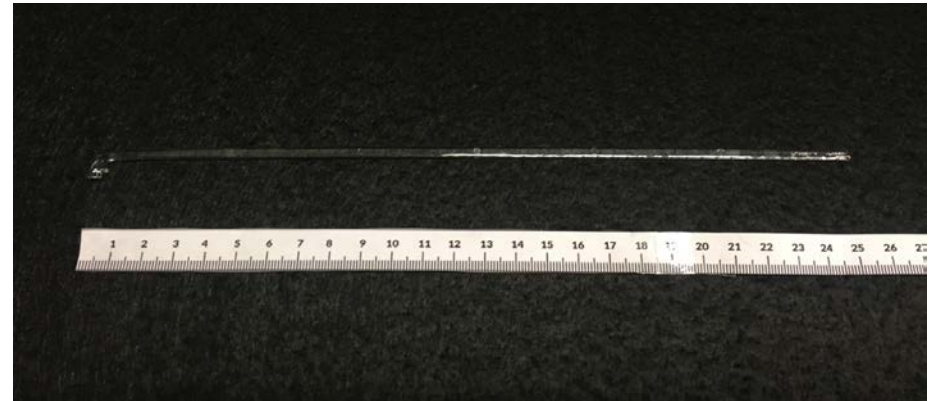
Sector	-----	Automotive
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Leadtime - Total	-----	49 Days
DFM + 3D	-----	7 Days
Mold	-----	42 Days



Notes	-----	
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# LIGHT GUIDE 9



Mold	-----	Formal mold
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Hot Runner	-----	Moldmaster 2 valve gates direct to the part
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Nº Cavities	-----	1 + 1
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Mold life (Cycles)	-----	500.000
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Material	-----	PMMA (PLEXIGLAS 8N)
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Surface finishing	-----	Polished
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Sector	-----	Automotive
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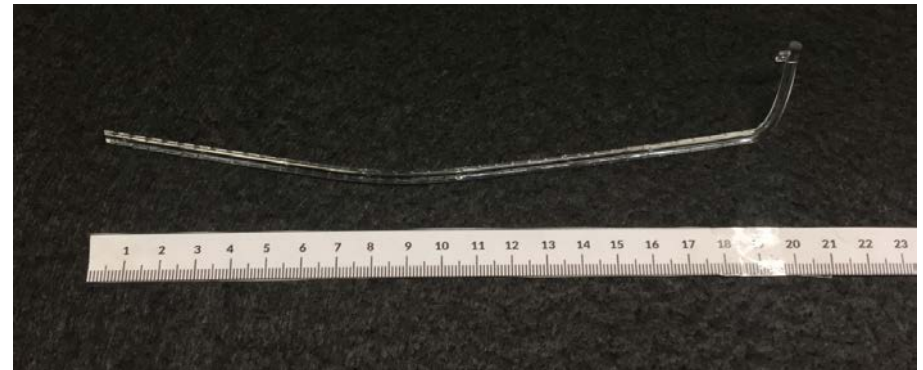
Leadtime - Total	-----	49 Days
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DFM + 3D	-----	7 Days
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Mold	-----	42 Days
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Notes	-----
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