NC MACHINING

MASTER GRAPHITE MACHINING

VACUUM HEAT TREATMENT

Aging treatment pattern and hardness results
Roughness of final discharge machining: about Rma x 8μm

Coordinate measuring

Analysis by program. Comparing coordinate measuring machine data with CAD data.
Cavity Surface Shape & Finishing

Finishing should be done until the hardened area is completely removed with grindstone.

Slide core movement shall be good & sliding portion clearance shall be appropriate.

For Dies of BPI I/M FLG and COLL LWR:
After running water and plugged at outlet, than pressurize (0.5MPa) from inlet.
No water leakage shall be observed.
Water channel position, depth and cooling pipe length check.

<table>
<thead>
<tr>
<th>MOLDING CONDITION</th>
<th>MOLDING COND (FINAL)</th>
<th>MOLDING COND (TRIAL)</th>
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</thead>
<tbody>
<tr>
<td></td>
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<tr>
<td>FIRST INJECTION PRESSURE</td>
<td>500 kPa</td>
<td>550 kPa</td>
</tr>
<tr>
<td>SECOND INJECTION PRESSURE</td>
<td>450 kPa</td>
<td>450 kPa</td>
</tr>
<tr>
<td>INJECTION SPEED (A/V)</td>
<td>10 m/s</td>
<td>10 m/s</td>
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</tbody>
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Joint inspection will be conducted based on "PCD Die Inspection check sheet" and the measurement data.

Sample dimension Inspection Record