



台州市椒江利豪塑料模具厂

地址：浙江省台州市椒江区洪家上金线2号

Add: No.2, Shangjin Line, Hongjia, Jiaojiang District, Taizhou, Zhejiang, China

Tel: 86-13706564686/8613605765374

Fax: 86-576-88669237

E-mail: lihaomould@163.com

Web: <http://www.lihaomould.com>

• 专业薄壁模具设计及制造商



Expert in

Thin Wall Product Mould Design & Manufacture



PP Thin-wall
PS Thin-wall

Our vision

To be a leading solutions provider in thin wall mould making.

We'll achieve our vision by partnering with customers to provide value-added products and services with unsurpassed innovation.



We focus on:

- PS Thin-wall mould
- PP Thin-wall mould
- Thin wall mould for disposable dishware

公司简介 Profile

台州市利豪塑料模具厂位于新兴城市——浙江台州，地理位置优越，自90年代创建以来，我们一直致力于塑料模具的加工，专注于PS薄壁模具、PP薄壁模具、一次性餐具系列模具、洁具系列模具和厨房系列模具的研发制造模具加工精度达0.05mm甚至更高。

我厂占地面积2000多平方米，拥有完善的制造设备，科学的质量管理体系，丰富的模具生产实践经验，专业的研发队伍，全面实施CAD/CAM/CAE系统的设计，运用高精度的高速加工中心，实现模具的加工高标准，配合精湛的加工工艺，保证模具精度的同时，我们更注重模具的使用寿命。工厂目前拥有高精度磨床2台，数控铣3台，数控车床5台与高速注塑机2台，有力保障了模具的加工与试模。我们根据客户的要求，开发、设计、制造模具，注重模具的每一个细节。

我们的客户遍及全国，浙江、江苏、上海、北京等大城市；并积极开拓国际市场，与马来西亚、哥伦比亚、土耳其等国家的厂商建立了良好的合作关系，模具质量深受国内外客户的好评。

“以人为本，质量为先，真诚服务”是我们的企业宗旨，其中保证质量是我们企业的精髓。我们与时俱进，在不断引进先进技术的同时，也更好总结经验，关注模具及模具相关行业动态，抓住机遇，在激烈的竞争中，脱颖而出。

“专业、高品质、合理价格以及准时交货”是我们服务宗旨，我们真诚欢迎新老客户莅临惠顾！

Taizhou Lihao Plastic Mould Factory is located in the emerging city - Zhejiang Taizhou, the geographical position is superior, since 1990's to create, we have been committed to the production of plastic mold, R & D is focused on the PS thin wall mold, PP series thin wall mold, mold, disposable tableware series pump series, sanitary ware series mold and kitchen series mold manufacturing.

Our factory covers an area of 2000 square meters, with equipment manufacturing complete, scientific quality management system, rich practical experience, professional R & D team, the full realization of CAD/CAM/CAE system design, using the high-speed machining center high precision machining, high standard mold, with exquisite processing technology, ensure mold precision at the same time, we pay more attention to the service life of the die. According to the requirements of our customers, development, design, mold manufacturing, pay attention to every detail mold.

Our customers all over the country, Zhejiang, Jiangsu, Shanghai, Beijing and other big city, and obtains a long-term partnership with Liao shen, in international, Malaysia, Columbia and other countries have established good relations of cooperation, the mold quality, praised by domestic and foreign customers, we based on the current, is committed to expanding the global.

"People-oriented, quality first, sincere service" is our business purposes, the quality assurance is the essence of our enterprises. We keep pace with the times, constantly introducing advanced technology at the same time, also better to sum up experience, pay attention to mold and die industry trends, seize the opportunity, in the fierce competition in the talent showing itself.

"Professional, high quality, reasonable price and delivery on time" is our principle of service, we sincerely welcome new and old customers to visit the Lihao!



海天注塑机一台

复力注塑机一台

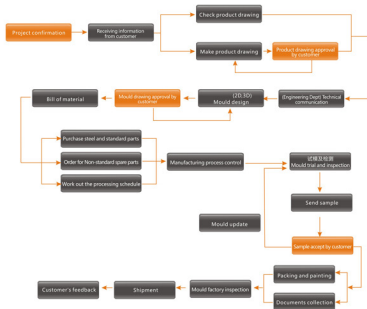
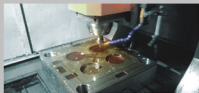


Advanced Equipments

Lihao is proud of its advanced equipments, such as DKFUS surface grinder lathe, high-speed CNC machine, Lathe, Haitian injection molding machine.

加工设备

公司拥有先进的生产设备：DKFUS高精度磨床2台，普通铣床3台，高速铣床2台，数控车床2台，卧床若干台以及高速注塑机2台。



研发设计 Development Ability



LIHAO has ten reasons to make you have confidence to choose us....

1. Each project is charged by designated engineer;
2. Rapid prototyping is available if required;
3. Moldflow is available if required;
4. General mould assembly (2D/3D) Drawing will be provided for customer to check and confirm;
5. Weekly mould progress/timeline will be provided in Excel file, meanwhile we will take some mould pictures or video to show the progress;
6. We will do special treatment for each customer, in order to meet different requirement;
7. If required, we can provide certification of steel chemical composition and hardness;
8. LKM, JUFAN, YUDO, DME, HASCO AND HANDLING are our long-time supplier;
9. Our pursuing spirit is: detail decides quality, innovation creates progress;
10. We do everything as our promise, short lead-time, first-class quality, excellent service for before-sale, through manufacturing and after-sale.

选择利豪的十大理由

1. 每一个项目我们全心服务，品质口碑是我们的骄傲；
2. 我们可以免费提供注塑模具技术咨询服务；
3. 我们可以提供注塑产品注塑加工技术支持服务；
4. 在模具开始加工之前，我们会提供模具的总装配图（2D/3D）给客户检查确认；
5. 每个星期，我们都会提供模具加工进度表，同时还附上模具加工进度的照片或者视频；
6. 为了满足不同客户的需求，我们将会进行一对一的处理；
7. 如果有需要，我们可以提供模具钢材成分证明；
8. 海天、复力、泰瑞、贝斯特都是我们长期战略合作伙伴；
9. 我们一直以来追求的宗旨是：细节决定质量，创新促进发展；
10. 做任何事情，我们都遵守我们的承诺，我们一向以高质量，及时的交货时间，以及优质的售前，售中以及售后服务来满意每一位客户朋友。

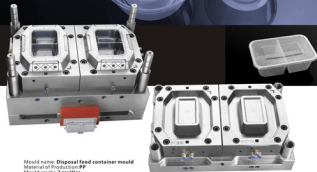


Work Progress Reporting Form 工作进度汇报表

Schedule Job	LIHAOMOLD20140035	制作范围 Lead time of 1st trial samples							
Project name:	PP CUP-MOULD								
PID No.:	LT20140211								
Lead time issued on PM:	1st trial samples will be sent within 40days after receiving 20% deposit, mold design approval and all specs being confirmed. (the mold shipment will be subject the customer approval / inspection & final payment)	2014 3/24-3/29	2014 3/31-4/5	2014 4/2-4/12	2014 4/14-4/20	2014 4/21-4/27	2014 4/28-5/4	2014 5/5-5/11	
序号 Item	PROCEDURE 流程								
1	order raw material								
2	order and received cavity block								
3	order and received core block								
4	order and received base block								
5	order and receive CYLINDER								
6	order and received accessories								
7	Incoming parts inspection and accept								
8	CNC machining cavity								
9	CNC machining core								
10	current impulse machining/wire cutting								
11	Normal machine(drill holes,grinding)								
12	Modify and re-check the machining work								
13	Assembly and inspection								
14	Try out 1								
说明 NOTE:		原设计 Original Plan	实际进度 Actual Progress	计划调整 Current Status (Adjust according to the current status)	节假日 Holiday				

PP系列一次性塑料餐具模具

PP Disposal food container mould



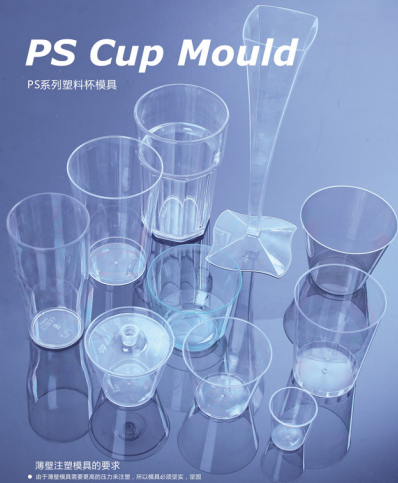
Mould name: Disposal food container mould
Material of Production: PP
Mould cavity: 2 cavities
Mould material: 2344
Mould life: > 5 million
Runner type: hot runner
Ejection system: air pressure
Mould rating: auto drop with robot
Cycle time: < 5s



面包夹 Bread tong

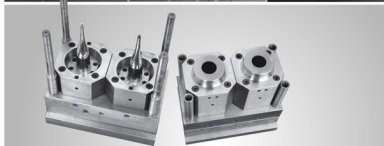
PS Cup Mould

PS系列塑料杯模具



薄壁注塑模具的要求

- 由于薄壁模具需要更大的压力来注塑，所以模具必须结实，坚固
- 选择较好的浇口类型（热流道较冷流道好）
- 高抛光的表面或者模具内表面镀层为了更好的脱模
- 顶出和吹气一定要均匀
- 排气一定要好
- 冷却一定要好



优势：

1. 100万模以上的模具寿命；
2. 优异的冷却系统；
3. 壁厚均匀；
4. 产品不变形；
5. 出模率高；
6. 产品绝不滴水；
7. 完美的产品合格率；
8. 堆叠性好；
9. 表面光洁度好；
10. 无气泡等；
11. 无伤痕

Mould Project: Red wine cup mould
Mould cavity: 2 cavities
Mould material: 2344/s136
Mould life: > 5 million
Runner type: hot runner
Ejection system: stripper plate
Mould turning: auto drop with robot
Cycle time: 7-10s

ADVANTAGE

1. mould life: ≥3,000,000;
2. excellent cooling system;
3. even wall thickness;
4. no distortion;
5. very short cycle time;
6. perfect lock system, water proof;
7. perfect parting line
8. good stacking
9. high surface quality
10. no air gaps/bubbles
11. no burn marks



PLATE MOULD

Thin wall Plastic plate mould

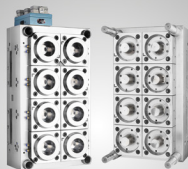
PS系列塑料餐具模具

优势：

- 1.500万模以上的模具寿命；
- 2.优秀的冷却系统；
- 3.壁厚均匀；
- 4.产品不变形；
- 5.总效率高；
- 6.产品无飞边；
- 7.完美的产品合模线；
- 8.叠叠性好；
- 9.表面光洁度好；
- 10.无气泡等；
- 11.无疤痕

ADVANTAGE

- 1.mould life: >5,000,000;
- 2.excellent cooling system;
- 3.even wall thickness;
- 4.no distortion;
- 5.very short cycle time;
- 6.perfect lock system,water proof ;
- 7.perfect parting line
- 8.good stacking
- 9.high surface quality
- 10.no air gaps/bubbles
- 11.no burn marks



Mould Project: 9oz Cup mould
Material of Production: PS
Mould cavity: 8 cavities
Mould material: 2344/S136
Mould life: >5 million
Runner type: hot runner
Ejection system: stripper plate
Mould running: auto drop with robot
Cycle time: 7-9s



Mould Project: Red wine cup mould
Material of Production: PS
Mould cavity: 2 cavities
Mould material: 2344/S136
Mould life: >5 million
Runner type: hot runner
Ejection system: stripper plate
Mould running: auto drop with robot
Cycle time: ~30s



THIN WALL MOULD FOR DISHWARE

厨房餐具系列薄壁模具

Plastic knife ,Plastic fork, Plastic Cup



PP THIN WALL MOULD & PS THIN WALL MOULD

PP/PS系列薄壁模具



Mould Project: Plastic bowls mould
Material of Production: PP
Mould cavity: 4 cavities
Mould material: 2344
Mould life: > 5 million
Runner type: hot runner
Ejection system: air pressure
Mould running: auto drop with robot
Cycle time: < 5s

Specification in mould design for "thin wall injection mouldings"

- Stronger and more stable design of moulds because of higher pressure and forces
- Choose the best gate type(hot runner is preferred compared to cold runner system)
- Special polishing or surface coating for easier parts release
- Equal ejection with air valve support
- Very good venting
- Very good cooling



Mould size: 570*570mm
Cavity: 28 cavities

