Bestcreating Design and Manufacture

PRODUCT DFM REPORT
(产品结构设计评审)

Project Name (项目名称):	Phone case IML guide line	Checked By (审核):	Mr.Qiu
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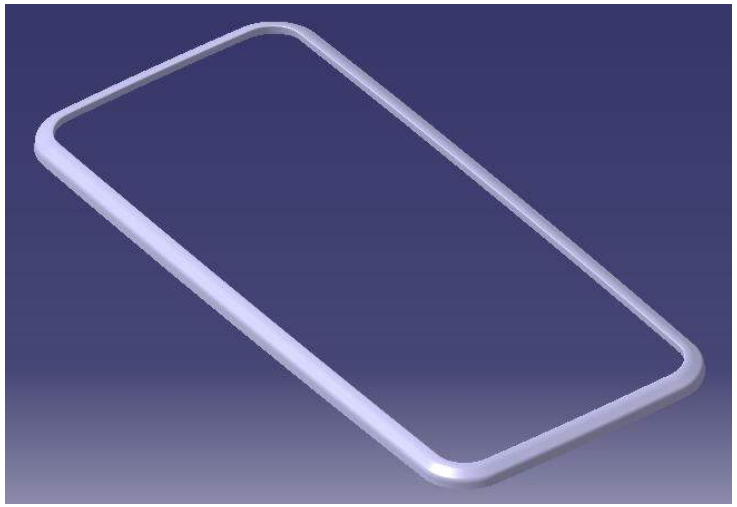
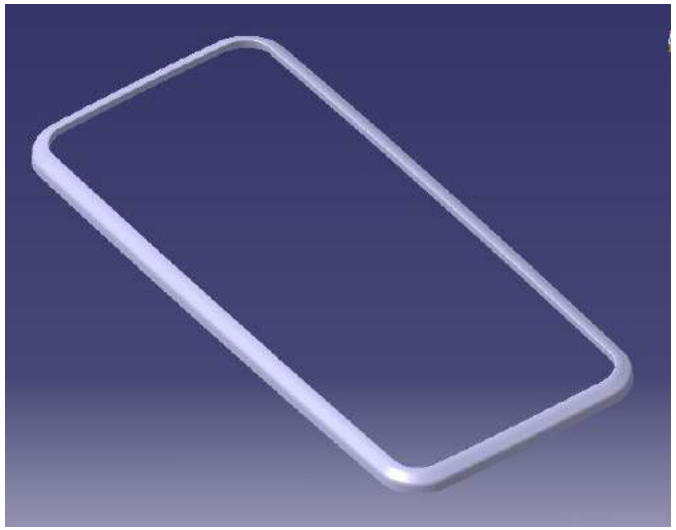
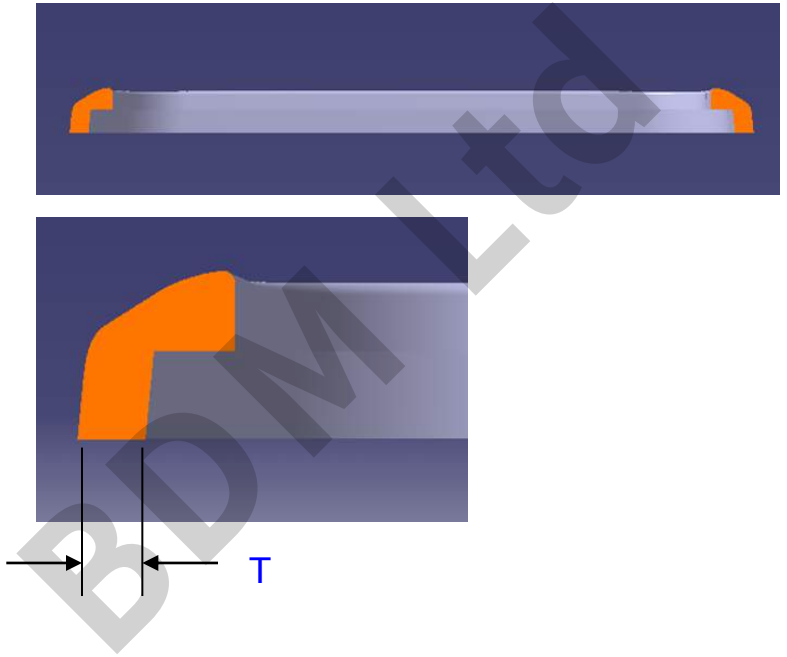


A cover

B cover

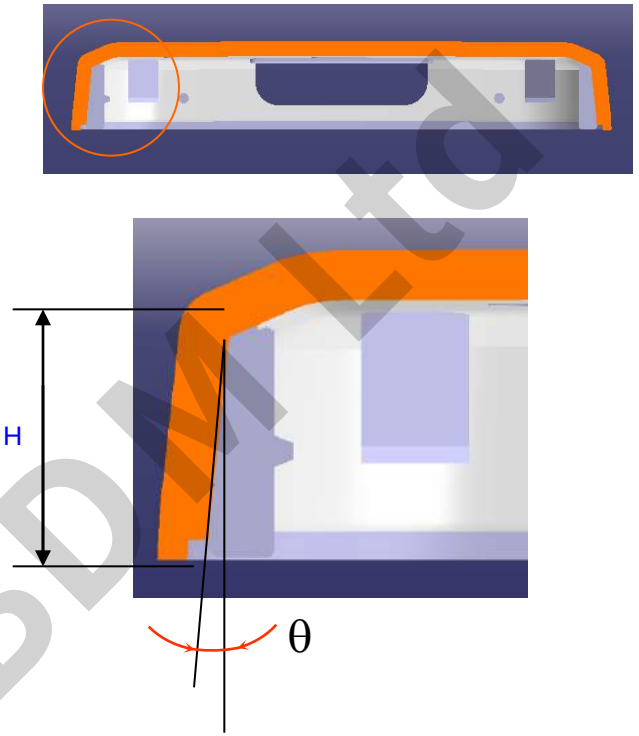
IML Process:
Printing - high pressure forming – cutting - Injection



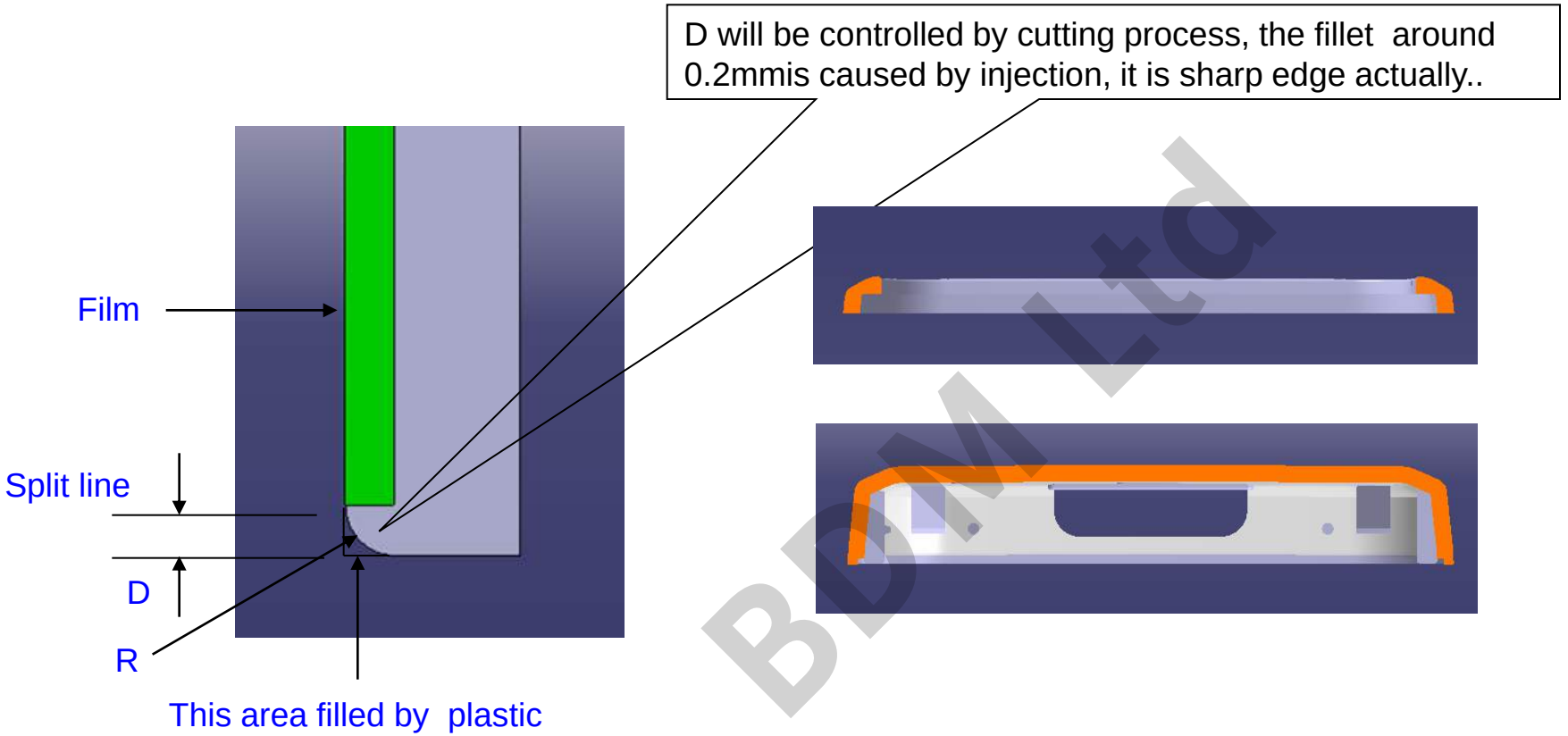


Wall thickness typically can be designed to 1.2mm, including film and oil layer.

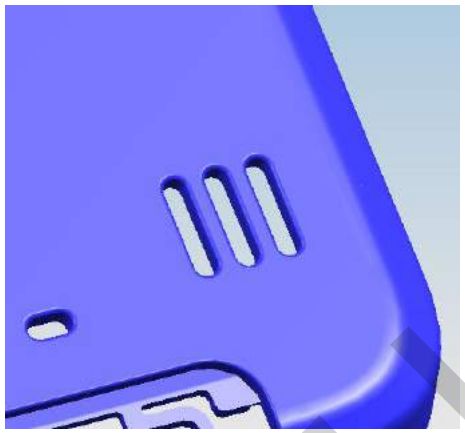
If it is less than 1.2mm, mechanical strength is not enough and high injection pressure will leads to oil diffusion.

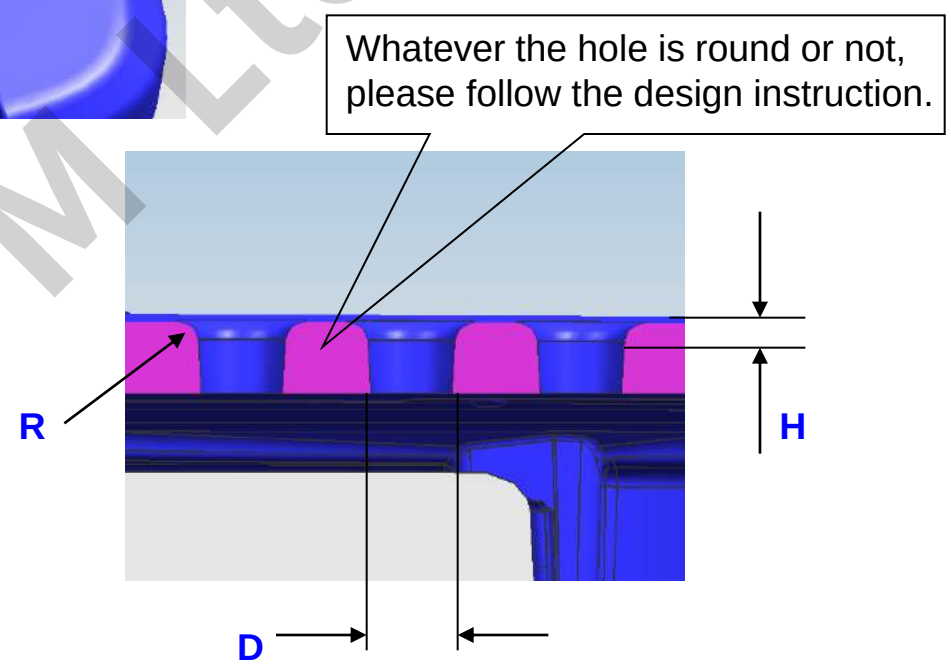


1. Big H value and small θ vale shouldn't exist at the same time.
For a big H value, film is made by high pressure; other situations should apply thermoforming process.
2. θ≥4° is high recommended, it is good for the appearance of the cutting edge.



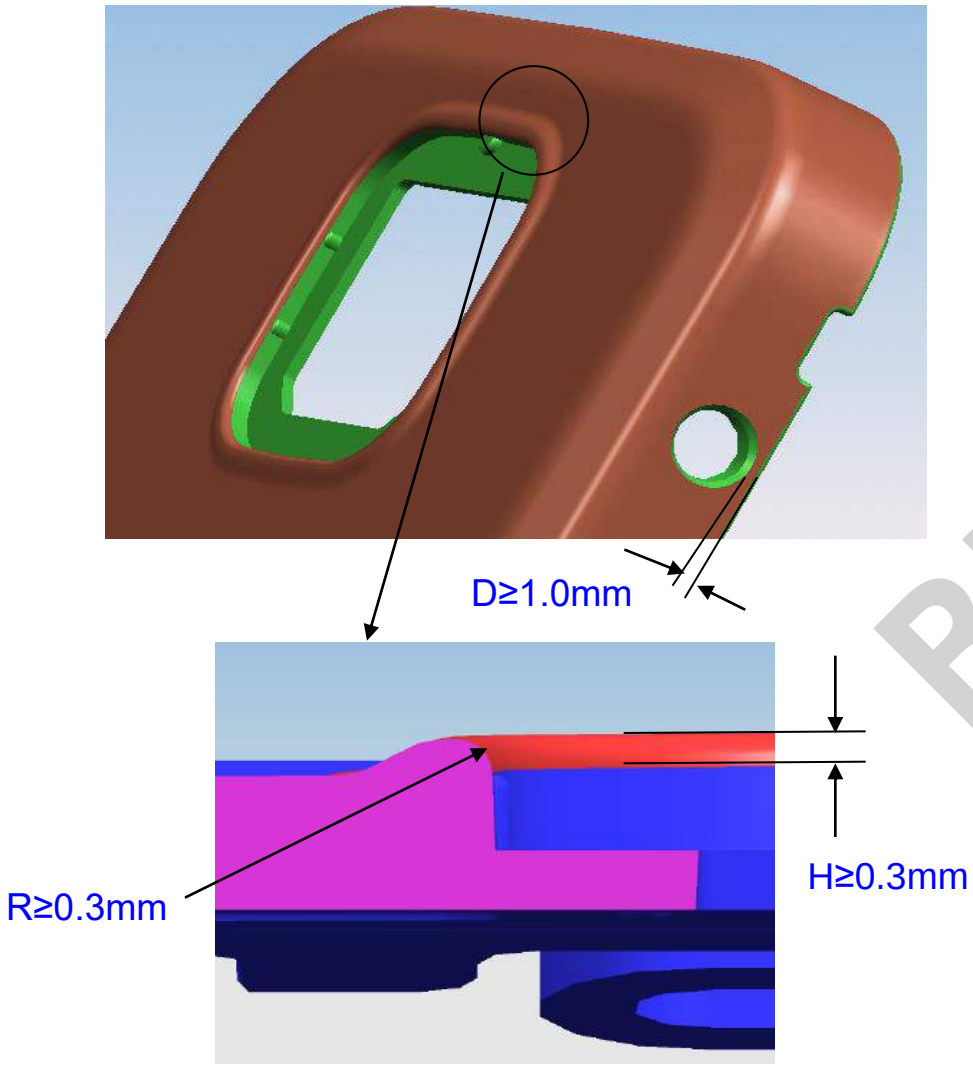
The distance between the edge of film and the plastic D can be designed between R～R+0.2mm.



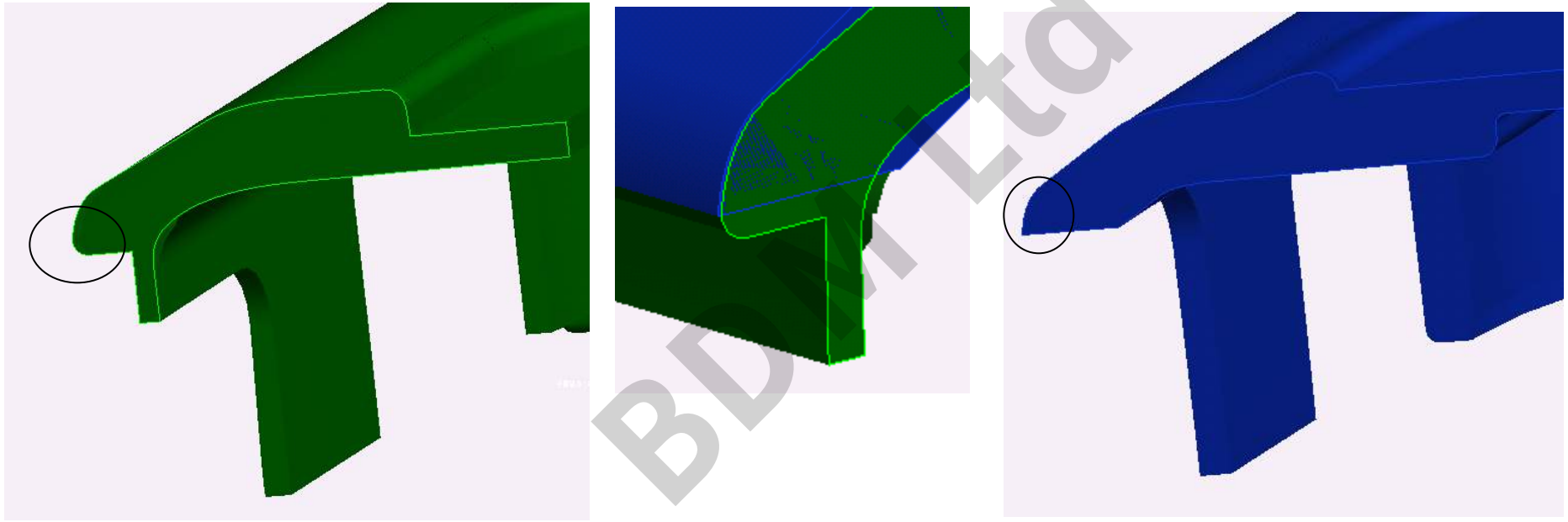


1 D≥0.8mm to ensure the strength of the cutter.

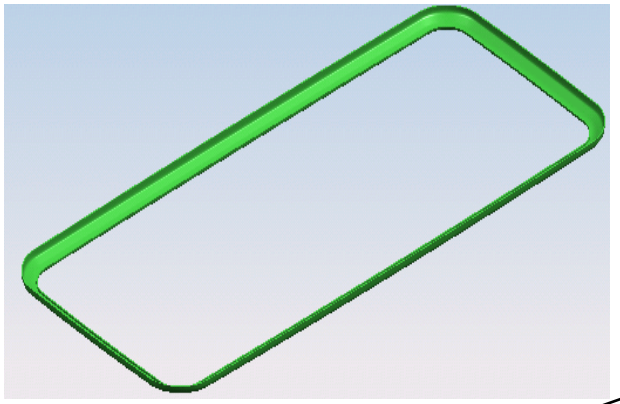
2 R≥0.3mm, H≥0.3mm, to ensure film will not be pressed by the mold core.



- The distance between the hole edge and the product edge should be at least 1mm, or the film can be easily broken.
- The emboss positions should be smoothly transition connection. Typically R≥0.3mm at least is no problem.
- H≥0.3mm.



Fillet at the edge of the film is not recommended, because flash will be a problem in future. It is advisable to design a sharp edge. And also the fillet has the risk to be harmful to the mold during injection.



Positioning should be taken into consideration in the product design. A common way is to design some holes in the product and use the dome in the mold to suspend the label.

Venting is not good enough for IML injection, so rough texture is highly recommended to help air venting.

THANKS