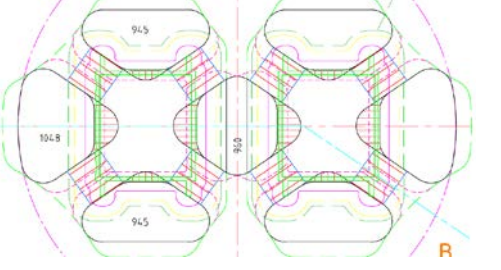
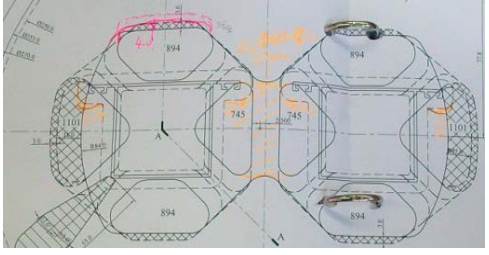
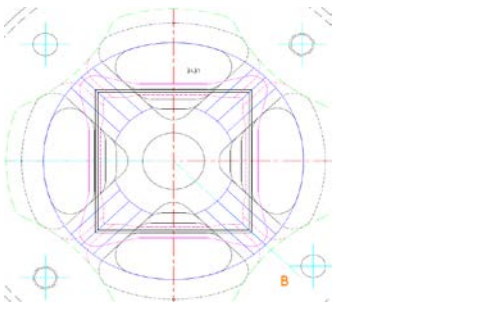
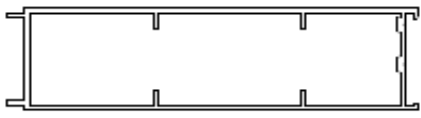
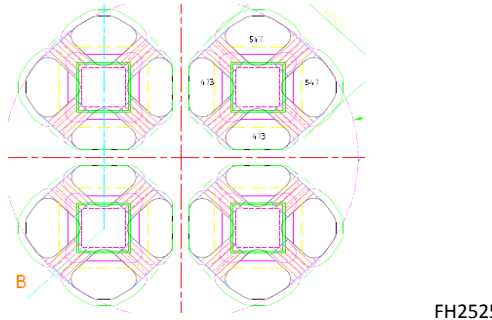
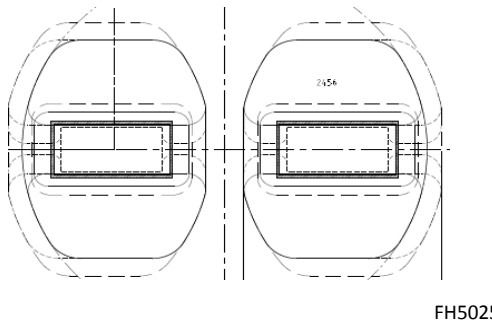
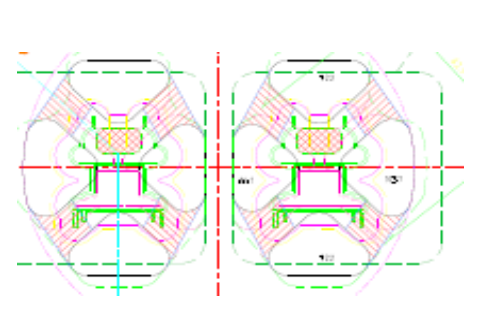
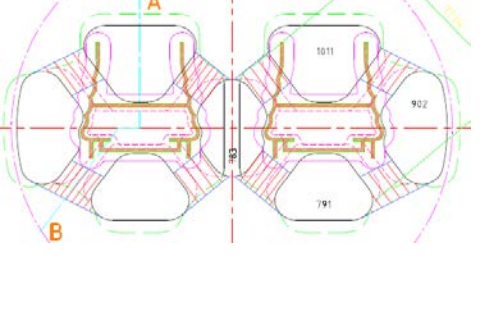


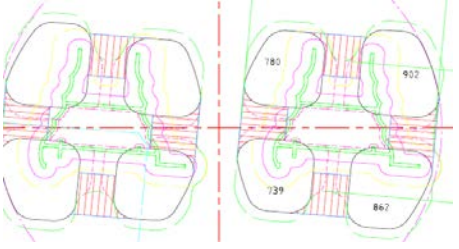
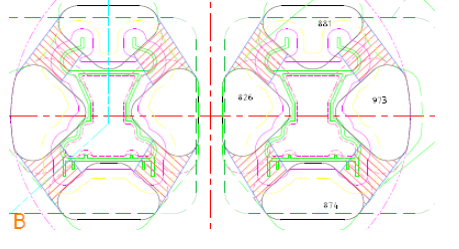
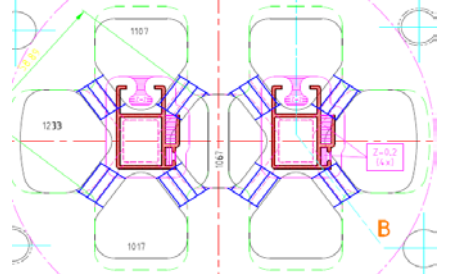
design Rules each Profile Typ

				Rules and discription			
Profile Typ	Rule No.	nearly the same	Picture	Cavity	Area	Precamber ("2nd Step")	Spraedering
A	1	F12 F09A F67 FH5025	 F09	2	a) outside 11% bigger then Center Area b) Center und up and downside same Area	1 Step 3x2mm only	6-8°
A	1a		 F57	2			
A	1b	FH8080	 FH1010	1	all around the same Max. Inlaid at 7" for this Type max 160mm	1 Step 5x3mm only <b>But under the Bridge open it totally</b>	<b>after 5mm straight</b> 45°x25mm deep than 6,5°
A	1b	F07A FH8025 FH1046 FH5025 F70 FH8045	 F07B	1	a) Area outside to Center should be outside >15% bigger Area b) Butterfly design; if the Center is milling down increase outside Area more then >20%!!	1 Step 3x2mm and open under the Bridge, or 1 Step 5x3mm and open under the Bridge	8°

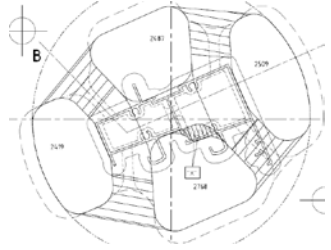
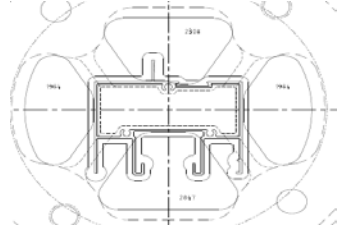
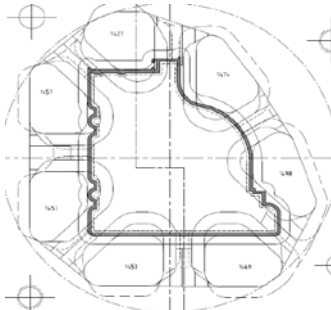
design Rules each Profile Typ

A1	simple hollow multi Cavity	1d		4	<p>a) outside Area should be 15% bigger than Center Parts! b) How big should be the smallest Area????</p>	
A2	simple hollow multi Cavity	1e		2		
B	hollow with long legs separate Center Inlaid	2	<p>F123 F127</p> 	2	a) outside to Center same Area	1 Step 3x2mm only 6-8°
B	hollow with long legs same center Inlaid	2a	<p>F104 F141 F149 F155 F33</p> 	2	<p>a) outside 11% bigger then Center Area b) upside 25% bigger then downside Area</p>	1 Step 3x2mm only 6-8°

design Rules each Profile Typ

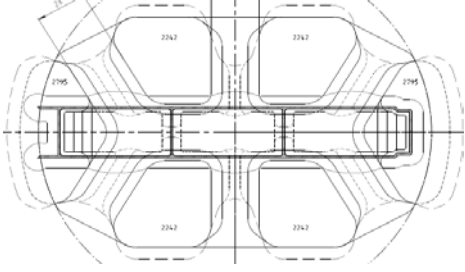
B	hollow with long legs 4 Bridges like a cross	2b	F148 F124 F69		2	<p>a) outside 11% bigger then Center Area b) upside 25% bigger then downside Area</p>	2 Step 3x2mm only	6-8°
C	hollow with SHORT legs separate Center Inlaid	2c	F133 FW8567 FW7657 FW8957 FW8662 FW8655 FY9065		2	<p>a) outside to Center same Area b) up and down also the same (max. 10% different)</p>	1 Step 3x2 mm	6-8°
C	hollow with SHORT legs same center Inlaid	3	FW9056 FW8566		2	<p>a) Inside to outside Area should be nearly the same b) Upside should be 15% bigger because the bigger Profile Area</p>	Open the Precamber at the small parts around 3mm and make sure, that in Center Part this Area is big enough!	6-8°
C	hollow with SHORT legs 2 or 3 Bridges	3a	FW8955	<div data-bbox="991 1367 1213 1467" style="border: 1px solid black; padding: 5px; width: fit-content; margin: auto;">no PDF</div>	2			

design Rules each Profile Typ


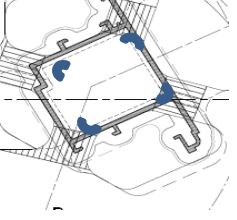
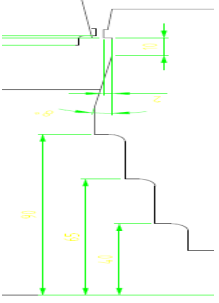
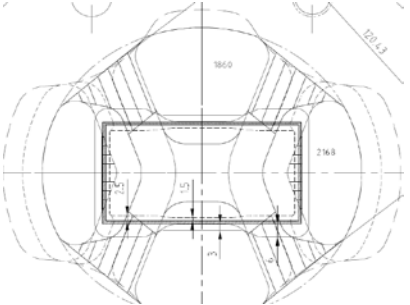
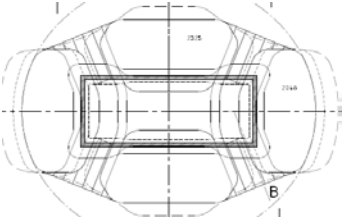
D	hollow with long legs	4			1	<p>a) downside 25% bigger Area, because the Profile Area is also bigger!</p> <p>b) left and right should be 10 to 15% bigger than upside</p>	only 1 Step 3x2mm and mil down at the tough	6-8°
D	hollow with long legs	4a			1	<p>a) downside 25% bigger Area</p> <p>b) left and right should be 10 to 15% bigger than upside</p>	only 1 Step 3x2mm and mil down at the tough	
D	flat with long legs	4b						
E	Special hollow	5	F119 ?		1			

F119

design Rules each Profile Typ

E	Special hollow needs to sprayder the Inlaid	5a	F13		1	outside Area should be 25% bigger than Center Parts!	Only 1-Step, straight, no mill down under the Bridge.	>8°
E	Special hollow big Mandrel Area	5b						

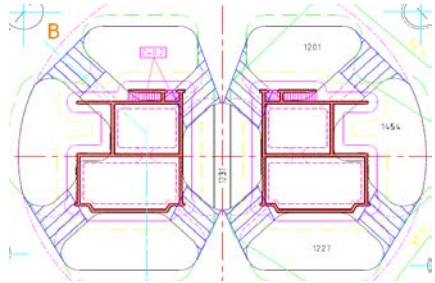
**Rules and discription**

Bearing length difference	Bearing length	Bearing length at the Profile Endpart!	specials		other nearly same Profile (Picture)		
max. Bearing difference in Center from <b>0,0</b> mm to max. 0,2mm longer Bearing			At the corners undercut on the Mandrel should be a Radius <b>&gt;R3</b>				
	whall thicknes round about 1,2 mm 2,5 to 2,8 times should be the bearing length	whall thicknes round about 1,2 mm PK 1,8mm at 4-6mm long Area	At the corners undercut on the Mandrel should be a Radius <b>&gt;R3</b>				
			For low pressure and bigger Inlaid Port, better work with Steps as to work on an Angle!				
No bearing length difference at the Die Plate, because Color difference Problems. Bearing on Mandrel at the edges 0,5mm longer as at the Center.	Small Part 1,8mm bearing length and 3-5mm distance.	At the corners undercut on the Mandrel should be a Radius <b>&gt;R2</b>	if it is possible use a Butterfly design!  The Inlaid shuold be outside from the Profile, No direct flow!			FH8045	FH1046

design Rules each Profile Typ

			Center Part needs best support so try to go to biggest possible Area. So no deflection about the Mandrel!			
			Center Part needs best support so try to go to biggest possible Area. So no deflection about the Mandrel!			
max. difference at Center 0-0,2mm longer Bearing	whall thickness round about 1,2 mm 2,8 Times should be the bearing length	whall thicknes round about 1,2 mm 1,8mm at 4-6mm distance	Blind Mandrel should be very small!			
max. difference Center 0-0,2mm longer Bearing	whall thicknes round about 1,2 mm 2,5 to 2,8 times should be the bearing length	whall thickness round about 1,2 mm 1,8mm at 4-6mm distance	at the tongue mill down the precamber 1mm			

design Rules each Profile Typ

<p>max. difference Center 0-0,2mm longer Bearing</p>	<p>whall thicknes round about 1,2 mm 2,5 to 2,8 times should be the bearing length</p>	<p>whall thickness round about 1,2 mm 1,8mm at 4-6mm distance</p>	<p>at the tongue mill down the precamber 1mm</p>			
<p>max. difference at Center 0-0,2mm longer Bearing</p>	<p>whall thicknes round about 1,2 mm 2,5 to 2,8 times should be the bearing length</p>	<p>whall thickness round about 1,2 mm 1,8mm at 4-6mm distance</p>				
<p>No difference between Center and outside Part, should make the difference from the Inlaid Area!</p>	<p>whall thicknes round about 1,2 mm 2,5 to 2,8 times should be the bearing length</p>	<p>1,8 mm maybe (1,5mm) and move to a longer Area smothly!</p>	<p>About two Mandrel with different high, make sure, that both get the same Distance to to Incoming Area!</p>	<p>At the corners undercut on the Mandrel should be a Radius <b>&gt;R3</b></p>		



design Rules each Profile Typ

	In Center Part do the Bearing 0,3 to 0,5mm longer then outside		in case of two Mandrel make outside 0,5mm more undercut			
	In Center Part do the Bearing 0,3 to 0,5mm longer then outside		in case of two Mandrel make outside 0,5mm more undercut			

design Rules each Profile Typ

No Bearing length difference from Center to outside, because Risk of Color difference			Outside Area mill down with Steps!	We should try a Bridge started with 3° Conical, than go to 20° Angle		

design Rules each Profile Typ




design Rules each Profile Typ


design Rules each Profile Typ


design Rules each Profile Typ


design Rules each Profile Typ
