

Best times mould & plastic products technology Ltd. is a trusted supplier & partner for [mould making in China](#) with strong capabilities of making high quality mould ranging from SPI Mould Specifications. SPI Mould Specifications cover class 101 mould, class 102 mould, class 103 mould, class 104 mould and class 105 mould. From prototype mould to mass production mould with mold life up to 1 million cycles or more.

GENERAL SPI Mould SPECIFICATIONS

- 1. Customer to approve mould design prior to start of construction.
- 2. All moulds, with the exception of prototype, to have adequate channels for temperature control.
- 3. Wherever feasible, all details should be marked with steel type and Rockwell hardness approximately .005 deep.
- 4. Customer name, part number, and mould number should be steel stamped on mould.
- 5. All moulds should have eyebolt holes on the top side. There should be one above and one below the parting line to facilitate mould removal, if required, in halves.

CLASS 101 Mould

- - Cycles: One million or more.
 - Description: Built for extremely high production. This is the highest priced mould and is made with only the highest quality materials.

Detailed mould design required.

- Mould base to be minimum hardness of 28 R/C.
- Moulding surfaces (cavities and cores) must be hardened to a minimum of 48 R/C range. All other details, such as sub-inserts, slides, heel blocks, gibs, wedge blocks, lifters, etc. should also be of hardened tool steels.
- Ejection should be guided.

- Slides must have wear plates.
- Temperature control provisions to be in cavities, cores and slide cores wherever possible.
- Over the life of a mould, corrosion in the cooling channels decreases cooling efficiency thus degrading part quality and increasing cycle time. It is therefore recommended that plates or inserts containing cooling channels be of a corrosive resistant material or treated to prevent corrosion.
- Parting line locks are required on all moulds.

CLASS 102 Mould

- - Cycles: Not exceeding one million
 - Description: Medium to high production mould, good for abrasive materials and/or parts requiring close tolerances. This is a high quality, fairly high priced mould.

Detailed mould design required.

- Mould base to be minimum hardness of 28 R/C.
- Moulding surfaces should be hardened to a 48 R/C range. All other functional details should be made and heat treated.
- Temperature control provisions to be directly in the cavities, cores, and slide cores wherever possible.
- Parting line locks are recommended for all moulds.
- The following items may or may not be required depending on the ultimate production quantities anticipated. It is recommended that those items desired be made a firm requirement for quoting purposes:
 - a. Guided Ejection
 - b. Slide Wear Plates
 - c. Corrosive Resistant Temperature Control Channels
 - d. Plated Cavities

CLASS 103 Mould

- *Cycles: Under 500,000
- Description: Medium production mould. This is a very popular mould for low to medium production needs. Most common price range.
- Detailed mould design recommended.
- Mould base must be minimum hardness of 8 R/C.
- Cavity and cores must be 28 R/C or higher.
- All other extras are optional.

CLASS 104 Mould

- *Cycles: Under 100,000
- Description: Low production mould. Used only for limited production preferably with non-abrasive materials. Low to moderate price range.
- Detailed mould design recommended.
- Mould base can be of mild steel or aluminum.
- Cavities can be of aluminum, mild steel or any other agreed upon metal.

CLASS 105 Mould

- Cycles: Not exceeding 500
- Description: Prototype only. This mould will be constructed in the least expensive manner possible to produce a very limited quantity of prototype parts. It may be constructed from cast metal or epoxy or any other material offering sufficient strength to produce minimum prototype pieces.

For more information on how Best times mould & plastic products technology Ltd. can support your plastic injection molds , call us at 0086-755-23571734 or e-mail us.