

T99X171 SKBB OTT box

Sample issues



Top cover issue 1

Issue 1: Welding lines

Occurrence period: T1/T2/T3/T4

Cause: In order to improve gas marks of top surface and burr of light pipe hole, reduce the injection speed and pressure. So welding lines has not been improved.

Action: T2>T3>T4: Because there were other problems(gas mark/burr) at the same time, it was impossible to do much about this problem.

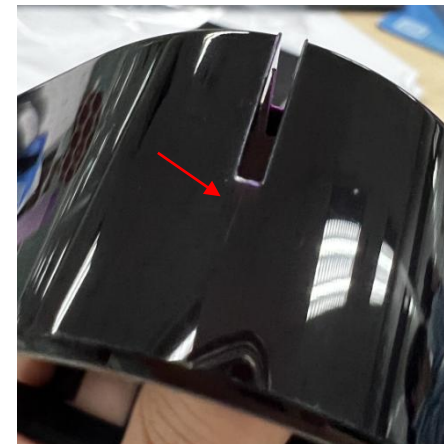
Now: Tooling modification to add material on the mold gate for gas marks improvement. We will add injection speed and pressure for next tooling tryout. But due to characteristic of injection mold there is always weld line around hole. We will do the best to follow the previous samples (PC).



T3



T4



T3



T4

Top cover issue 2

Issue 2: Gas Marks

Occurrence period: T4

Cause: Because the texture was finer than T3, The gas marks were more obvious than T3.

Action: Tooling modify to add material on the mold gate for gas mark improvement. Due to characteristic of injection mold and structure of this part, there will be gas marks, stress marks on the cosmetic surfaces, But We will do the best to follow the previous samples (PC).

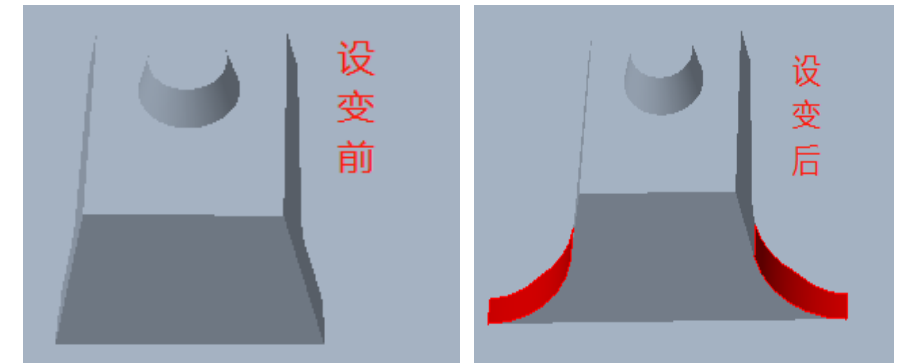


T4



T4

Tooling modification for T5



Before

After

Top cover issue 3

Issue 3: A. Burrs and drags on top cover light pipe hole. B. Large gap between top cover and light pipe.

Occurrence period: T1/T2/T3/T4

Action: T2>T3: Burrs and drags were very serious on T2 samples, so the core and insert fit clearance were improved. Burrs had been improved on T3. But the drags issue still existed.

T3>T4: Improved the core and insert fit clearance again, burrs and drags had been improved. But the size of the hole was uneven and rather large(3D spec:1.5mm(draft root), 1.55mm(draft tail)); Measured size:1.5-1.54mm(draft root), about 1.60-1.75mm(draft tail)).

Now: Tooling modify to reduce material of the insert to ensure the dimension of the hole.



T2



T2

T3



T4



T3

T4

Top cover issue 4(close)

Issue 5: The texture of top case surface is rough.

Occurrence period: T2/T3

Action: T2>T3: Redo the texture, the texture of T3 sample is finer than T2, but it is rougher than PC samples.

T3>T4: Follow the samples(PC material) to do texture. The texture of T4 sample is okay.



T2-NG



T3-NG



T4-OK

Top cover issue 5(close)

Issue 6: The Btv logo has to be flat with a top cover surface.

Occurrence period: T2/T3

Action: T2>T3: Reduce the mold material, But the concavity of logo is still exist on T3 samples.

T3>T4: Modified logo technological process. The logo of T4 sample is okay.



T2-NG



T3-NG



T4-OK

Light pipe issue

Issue : The chamfer of light pipe is not smooth.

Occurrence period: T1/T2/T3

Action: T1>T2: The chamfer is severe drag on T1. Checked and modified the corner of mold. T2 samples had much improved, but it is still exist on T2 samples.

T2>T3: Re-checked and modified the corner of mold again and redo the texture. The chamfer of T3 sample is okay.

- LED leans

- The light emitting surface is not uniform
- Make this point surface the same as the other

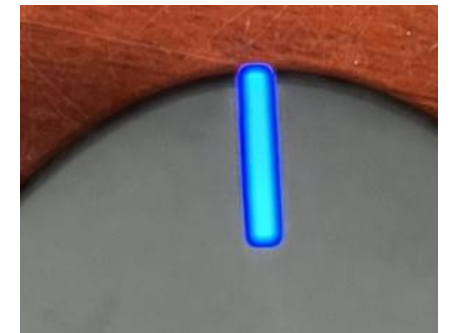
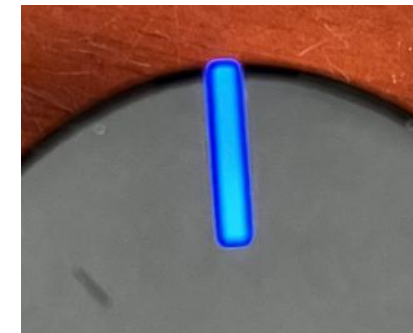
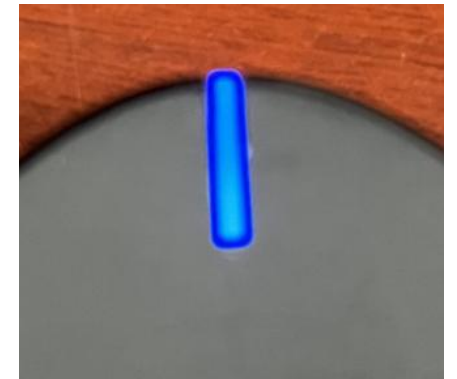
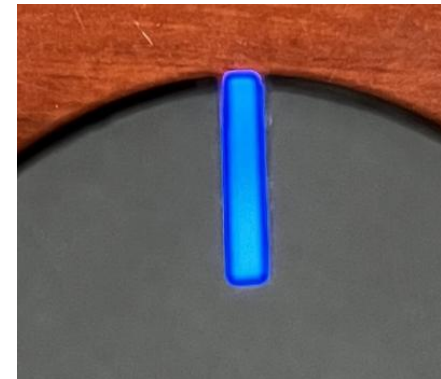


LED on



LED off

Confidential



The light in the picture is blue instead of red because the PCBA is broken.