METHODE ELECTRONICS

SPECIFICATION SHEET FOR:
Tooling of Purchased Components
To be completed for every component quoted

☐ Quotation ☐ ORDER

Supplier Part Reference/Number:

Component Name: **Plastic material:**

Component No.: **Colour:** **Supplier:**

Serial No.: **No. of cavities:**

Machine type (Pls Specify): **Date:** **Approved (supplier):**

RUNNER AND GATE: (Please Specify as applicable)			COOLING:	
☐ Yes ☐ No	Cold runner		☐	With cooled cores
☐ Yes ☐ No	Central hot bush with cold runner - Supplier:		☐	With cooled inserts
☐ Yes ☐ No	Hot runner with cold runner - Supplier:	No. of hot bushes	☐	With cooled plates
☐ Yes ☐ No	Complete hot runner - Supplier:			
☐ Yes ☐ No	Tunnel gate			
☐ Yes ☐ No	Edge gate			
☐ Yes ☐ No	Sprue bush flat seating/other.			
☐ Yes ☐ No	Sprue bush spherical seating /other			
☐ Yes ☐ No	Other (Please specify- use space provided on sheet 2 under remarks)			

CONNECTIONS: (Please Specify as applicable)	
☐ Yes ☐ No	If hot runner is used specify type of Connector ……..
☐ Yes ☐ No	Pin out. No of Pins…….. .
☐ Yes ☐ No	Thermo couple type FeCuNi. If other please specify type……..
☐ Yes ☐ No	Mould temperature sensor
☐ Yes ☐ No	Temp Sensor hole is on both halves of mould……Specify if otherwise
☐ Yes ☐ No	Cooling nipples; Specify type……..
☐ Yes ☐ No	Other (Please specify- use space provided on sheet 2 under remarks)

MATERIAL: Please specify as applicable →											
Mould plates ☐	☐	☐	☐	☐	☐	☐	☐		☐	☐	☐
Clamping plates ☐	☐	☐	☐	☐	☐	☐	☐		☐	☐	☐
Intermediate plates ☐	☐	☐	☐	☐	☐	☐	☐		☐	☐	☐
Ejector plate ☐	☐	☐	☐	☐	☐	☐	☐		☐	☐	☐
Inserts ☐	☐	☐	☐	☐	☐	☐	☐		☐	☐	☐

MISCELLANEOUS: (Please Specify as applicable)	
☐ Yes ☐ No	Do you plan cavities in jaws to be manufactured out of separate inserts
☐ Yes ☐ No	Do you plan Pressure Blocks to be one solid piece from the mould plate
☐ Yes ☐ No	Cavity identification (numbers…….. or letters……..)
☐ Yes ☐ No	Engraving is done on separate inserts
☐ Yes ☐ No	Insulating plates are on both halves
☐ Yes ☐ No	Locating rings are on both halves - Diameter: N/A
☐ Yes ☐ No	Tool base a standard item Supplier……
☐ Yes ☐ No	Do you use individual Cavity Pressure Sensors
☐ Yes ☐ No	Shot weight inc runner …….. grms
☐ Yes ☐ No	Shot weight w/o runner …….grms
☐ Yes ☐ No	Estimated cycle time ……(Enquiry-Based on your experience with similar components) Note-The cycle time to be adequate to meet the Projected annual demand in weekly shipments and irrespective of the shipment quantity/demand maintain a consistent part quality
☐ Yes ☐ No	Actual cycle time ……..(OEE) Note-The cycle time to be adequate to meet the Projected annual demand in weekly shipments and irrespective of the shipment quantity/demand maintain a consistent part quality
☐ Yes ☐ No	Life time of tool to be ☐ M Shots ☐ M Parts

Do not hesitate to contact us if there are any queries regarding this information.

Retention period: Production + 1yr
Retention method: Soft Copy

GENERAL REQUIREMENTS:

1.	Complete original tool drawings (hard copies) to be available with Component release for tooling of purchased parts (refer to MMD 29)
2.	2D drgs that must be submitted on final payment application (ref clause 12 of MMB38) 2D Assembly drawing of Mould 2D drawings of the inserts and cores 2D drawings of the Plates Note; Submit drgs on CD (refer to MMD 29)
3.	3D CAD data that must be submitted on final payment application (ref clause 12 of MMB38) 3D Models of the cores and inserts 3D models of the Plates and mould components Note; Submit CAD models on CD (refer to MMD 29)
4.	Data for the drawings to be on individual sheets refer to the CAD data sheet MMD 29
5.	Drawings to be in 1st angle projection.
6.	All dimensions to be in mm.
7.	Parts list to be included with the hardness in HRC of the specified steels.
8.	Injection machine parameters as set on OEE ;Thereafter on demand First sampling is to include 60 pieces from each cavity accompanied with a full measurement report, subsequently if corrections are required sampling again of 60 pieces from each cavity is required including a measurement report on the corrected dimensions until part is dimensionally in order and released.
9.	*N.B. All dimensions indicated as NIO on the dimensional report being submitted must have the correct by date included.*
10.	Any information/notes on the drawings to be available in English.
11.	Progress update to be supplied weekly starting from release of order
12.	**Any discrepancies between the model and the associated drawing are to be discussed with Methode Electronics Malta Ltd.**
13.	No warpage and sink marks are allowed on the finished component particularly in areas of significant importance such as A surfaces and functional features. The subcontractor shall perform at his expense whatever type of research and verifications necessary to ascertain the part drg/design does not contribute to a tool design allowing for such conditions.
14	The full release of the tool will be granted after 8 hours continual running of tool according to OEE Release Procedure (MMW 69) . production Samples will be injected at Supplier's premises under Purchaser's supervision. The price of these production samples is to be determined at quoting stage. Should the tool not be suitable for release and if further samples are required, these will be supplied and shipped by courier at Supplier's cost.

INITIAL SAMPLES - definition of the Production representative component

15.	The product (component) complete from all the sub processes as applicable inc finishes such as Paint/Chrome/Symbols, correct to the drawing specifications (any reasonable deviations to be communicated to the customer for discussion) and fit for function. Furthermore the component must be representative of a significant production run of min 2% of the annual volume or as otherwise agreed in writing. PPAP package applies Note : Sub processes needing validation are to be taken in hand from the outset the tooling Kick-off is officially initiated

REMARKS:

METHODE ELECTRONICS

Supplier Data Gathering Package
Tooling Cost Detail Sheet

Part Number		**Supplier Name**	
Part Name		**Source Country**	

Note: Please use one sheet for each tool — **Local Currency**

	x	y	z	
Component size				mm

Tool description

(Cavities, Capacity, No of stages, etc.)

Tool No (ref to process)

Material Cost

	Weight or amount	**Rate (per part or per kg)**	**Cost**
Tool steel gross			
Std. parts			
Bought out components			
Copper			
Other (pls specify)			
		Total Material Cost	

Process Cost

	Hours	**Rate/hour**	**Cost**
CAD / Computer work			
CNC programming			
Machine setup			
Milling CNC			
Grinding			
Spark erosion			
Spark ersosion Wire			
Other Machines (Centre Lathe)			
Heat treatment			
Assembly (Toolmaker)			
Tool try out			
Testing / Gages			
Other (pls specify)			
		Total Process Cost	

Tool cost Summary

Other (pls specify)		
	Total Toolcost	

Tooling status information

Order received	Date	
Material order placed	Date	
Design ready	Date	
Process/Machining status	%	
Assembly status	%	
Testing	Date	
Tool ready	Date	

For more tools, please use additional form / Please use one sheet per currency