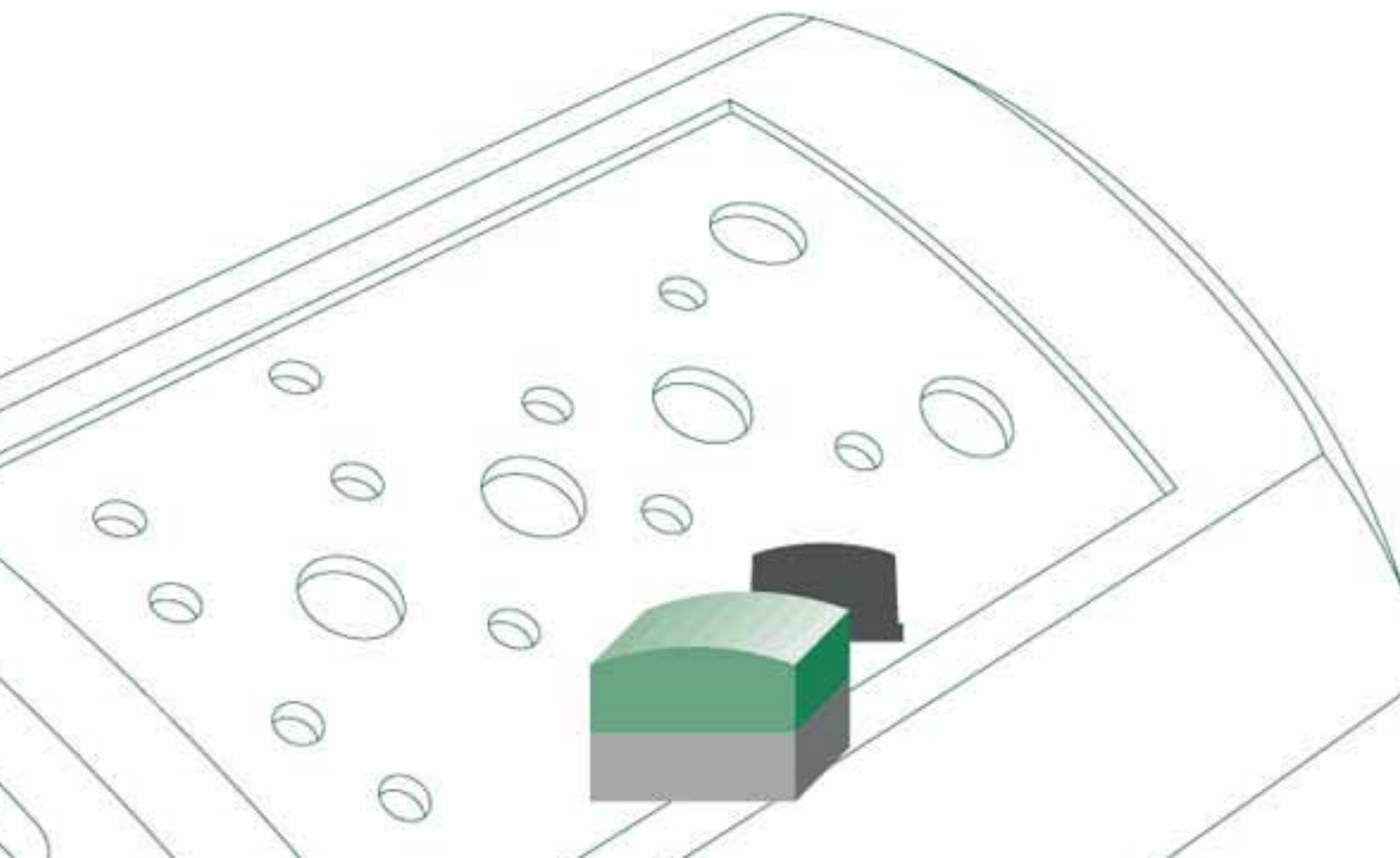


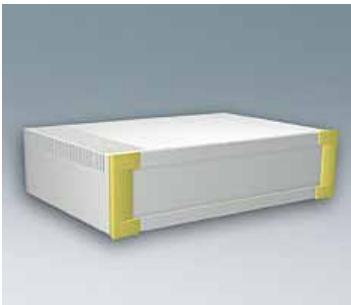
DEEP DRAWING / MILLING AND BENDING TECHNOLOGY



SERVICES

We are in a position to produce small quantities of deep-drawn and flexible parts from laminated material. In conjunction with standard parts, you can benefit from their advantages and at the same time have more scope for your company-specific product design. In the following we introduce the processes and possibilities.

DESIGN EXAMPLES



Individual design parts



Protective cover / packaging



Covers with coating

PROCESS

In the deep-drawing process, a positive or negative mould is created from the plastic part. Depending on whether the mould is to be positive or negative, a preheated thermo-elastic plastic plate is either pressed against the mould or drawn into the mould, with the help of pressure or of a vacuum. This method can be used to produce not only the cases themselves but also their packaging.

The bending process also uses the thermo-elastic properties of the plastics. The plastic plates are first milled and then bent into the required shape. In this way, case parts can be produced very easily. It is also possible to weld individual case components as required.

Differences between this and injection moulding:

- very low tooling costs (deep-drawing process), not applicable in the bending process
- parts must be over painted (similar surface quality to standard part)
- higher part costs due to mechanical processing

CAD DATA

Readable file formats for data import (WIN): Solid Works
Alternatively: preparation of drawing for processing by OKW Gehäusesysteme against calculation.

Data medium:

E-Mail, 3 1/2" Disk, CD-Rom, DVD, Zip (100 MB)

TOOLS FOR DEEP-DRAWING

- no indentation possible
- draft angle min. 3 degree
- wood, epoxy resin, aluminium or steel

When required tool construction on demand. We charge you with proportional tooling costs.

MATERIAL

Possible materials for the deep-drawing process:

PS/ABS/PC

Thickness of the panels: from 0.3 mm (depends on the part contour)

Possible materials for the bending process:

PS/ABS/PC

Thickness of the panels: 3/4/5/6 mm (depends on the part contour)

ADDITIONAL MODIFICATIONS

Lacquering

Printing

Glueing

Milling

Countersinking

Punching

ALVACOAT[®] (aluminium coating)

QUALITY

Lacquered surface (adhesion: test according to grid cutting method „GT2“).

DIMENSIONAL TOLLERANCE

Deep-drawing and bending process:

Outside contour ± 1 mm

FIXED COSTS

According quotation.

PACKAGING

Packed in PE-bags and/or in layers in the carton.

Special agreements possible.

Quantity differencies + 10 % possible.

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