

Mold Sampling Options

	Description	Deliverables
Level 1 Tool Function Testing	Mold trial to primarily test tool function. Process engineer will set-up the mold and use an existing process to verify that the mold is functional.	<ul style="list-style-type: none"> • Sample report • 25 -50 nominal samples
Level 2 T1 Mold Trial	Tool function verification with initial process development.	<ul style="list-style-type: none"> • Sample report • Short shot progression • 25 -50 nominal samples • Mold process parameters sheet
Level 3 T1 Mold Trial with Process Development	Site acceptance test (SAT) for new molds, where the mold will be tested and a basic process is developed.	<ul style="list-style-type: none"> • Sample report • Short shot progression • Scientific molding process development • Process characterization - 5 parts at high/5 parts at low • Number of nominal parts produced in two hours of run time • Mold process parameters sheet • 3 piece/cavity nominal FAI with report
Level 4 T1 with Rigorous Mold Trial and Capability Study	Site acceptance test (SAT) and a rigorous trial with OQ capability study. A process window study and high-low challenge will be performed and will be followed with a capability analysis at the process limits.	<ul style="list-style-type: none"> • Sample report • Short shot progression • Scientific molding process development • Process characterization - 5 parts at high/5 parts at low • Number of nominal parts produced in two hours of run time • 3-piece/cavity FAI (1 High/1 Nom/1 Low) • Process window study • One-hour run at low and high settings • 30-piece/cavity capability study/report (Nom/High/Low) • OQ parts for customer • Mold process parameters sheet
Level 5 Customer Specific	Any customer specified sampling bundle that does not fit levels 1 – 4.	<ul style="list-style-type: none"> • As specified in the customer supplied RFQ for sampling