



# Oracle Plastic Tool Specification Form

Document Number and Revision:	913-3565 rev 03
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Part Name: \_\_\_\_\_ Part Number: \_\_\_\_\_ Rev Level: \_\_\_\_\_

Est. Pieces/Year: \_\_\_\_\_ Est. Tool Life: \_\_\_\_\_ Tool Class: \_\_\_\_\_

## Mold Type (Production)

## Component

	Quantity		Tool Steels	Hardness (Rc)	Finish SPE/SP#
Single Cavity:		Cavities:			
Multiple Cavity (number of cavities):		Cores:			
Family Mold:		Strippers:			
Prototype Mold:		Side Action:			
		A Plate:			
		B Plate:			

## Mold Construction

## Mold Type (Short Run)

### Aluminum Tools, Prototypes and small volumes

Standard 2 Plate:		Aluminum Insertable:	
3 Plate Mold:		Composite Tools:	
HotRunner Mold:		Mud Frame Tooling:	
Cavity/Core Inserts:		Other:	
Mold Size:			



## Auxiliary Equipment

Robot Grippers:  
 Assembly Fixtures:  
 Ultrasonic Horns:  
 Nesting Fixtures:  
 Silkscreen, Pad Printing, Heat, Tape Xfr  
 Fixtures:  
 Silkscreen, Pad Printing, HeatTape Xfr Tools,  
 A/W:  
 Degating Tools:  
 Ultrasonic Horns - Inserts:  
 Ultrasonic Horns-Other components:  
 Heat Staking Fixtures:  
 Painting/Metalizing Fixtures, Masks:


## Cooling

Core Inserts:  
 Cavity Blocks:  
 Side Action:  
 A Plate:  
 B Plate:  
 Other:


## Mold Plates

Type#1 SAE 1030  
 Type#2 AISI 4130:  
 Type#3 P-20:  
 Type#4:  
 Type#5 AISI H13:  
 Type#6 420SS:


## Special Tool Features

Guided Ejection:  
 Spring Return KOP:  
 Front Ejection:  
 Accelerated KO:  
 Second Stage Eject:  
 PL Interlocks:  
 Angle Pin Side Action:  
 Hydraulic Slide Action:  
 Lifters:  
 Gale Inserts:


## Ejection

KO Pins:  
 Blade Eject:  
 Sleeve Eject:  
 Lifters:  
 Stripper Plate:  
 Air Eject:


**Gating Method**

Edge Gate:	
Center Sprue Gate:	
Sub Gate:	
Sub to Post Gate:	
Hot Sprue Gate:	
Hot Multi-Drop:	
Valve Gate:	

**Special Finishes**

Cavity Plating:	
Core Plating:	
Textured Cavity:	
Water Plates:	
Other (Specify)	

**Mold Machine Specs**

Machine Size	
Distance b/w bars:	
Shut height:	

**Documentation**

Mold Design:	
Mold Flow:	
Shrink Rate:	

**Requirements**

Please specify expected DPM for this tool:

Expected Delivery Date:

Please list the SPC dims to be monitored (if different from the CTFs on print):

Agree to tolerances on 2D Print?

If no, please specify problem dims/desired tol:


**US \$ Price (FOB Toolmaker)**

Tooling:	
Spares:	
Auxiliaries:	
Shipping:	
Tool Design:	
Other (Specify):	
Total:	\$0

**Comments**

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Approvals for Tool Construction

Design Engineering: \_\_\_\_\_ Date\_\_\_\_\_

Operations Engineering: \_\_\_\_\_ Date\_\_\_\_\_

Supply Program Manager: \_\_\_\_\_ Date\_\_\_\_\_

Piece Costing Data

Raw Resin(s):	Piece Cost	Raw Matl \$/Pound	Material Type	Qty	Total Cost	DPM	Cap./Mo.	Leadtime
Item:_____								

Hardware/Other Matl	Piece Cost	Standard/Unique	Hardware #'s	Qty	Total Cost	DPM	Capacity	Leadtime
Item:_____								
Item:_____								
Item:_____								
Packaging, if not used directly in a top level assembly								

Labor Costs	Burden Piece\$	Burdened Rate	Notes	Qty	Total Cost	DPM	Capacity	Leadtime
Press Machine (Initial)								
Degating, if not@ press								
Hardware Ultrasonic Install								
Component Ultrasonic Install								
Marking (silkscreen, pad, heat transfer)								
Painting/Metalization Operations								
Scrap allowance allocated								
Lead Times should be shown in business days <b>Grand Total Pc Cost:</b>					<b>\$0.00</b>			

## Approvals for Tool Construction or Change

Design Engineering: \_\_\_\_\_ Date \_\_\_\_\_

Operations Engineering: \_\_\_\_\_ Date \_\_\_\_\_

Supply Program Manager: \_\_\_\_\_ Date \_\_\_\_\_

External Manufacturer  
(if applicable): \_\_\_\_\_ Date \_\_\_\_\_

	Requested	PRQ Number	P.O. Number	Asset Tag Number
Purchase Requisition:				

## Document History

REV	DATE	DESCRIPTION OF CHANGE	CHANGE ORIGINATOR
01	April 4, 2004	Initial release	N/A
02	12/4/2013	Updated from Sun to Oracle	N/A
03	01/10/2022	Updated from WWOPS SPARC Engineering to Oracle. Moved to Redwood format. No content changes.	N/A

## Related Information

Review Version:	A	Reason for Review:	Updated from WWOPS SPARC Engineering to Oracle. Moved to Redwood format. No content changes.

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