



Oracle Plastic Tool Specification Form

Document Number and Revision: 913-3565 rev 03

Part Name: _____ Part Number: _____ Rev Level: _____

Est. Pieces/Year: _____ Est. Tool Life: _____ Tool Class: _____

Mold Type (Production)

Component

	Quantity
Single Cavity:	
Multiple Cavity (number of cavities):	
Family Mold:	
Prototype Mold:	

Cavities:
Cores:
Strippers:
Side Action:
A Plate:
B Plate:

Tool Steels	Hardness (Rc)	Finish SPE/SP#

Mold Construction

Standard 2 Plate:	
3 Plate Mold:	
HotRunner Mold:	
Cavity/Core Inserts:	
Mold Size:	

Aluminum Insertable:
Composite Tools:
Mud Frame Tooling:
Other:

Mold Type (Short Run)

Aluminum Tools, Prototypes and small volumes

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

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								

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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				Grand Total Pc Cost:	\$0.00			

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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