attached all the plug models for the EVO project. Please review and let me know your comments. We can potentially make changes if necessary.

Some things for you to consider:

1. In our mould making process we fully enclose the plugs in a big envelope vacuum bag, inner bag pressure will be around ~1-5mbars. Not sure the permeability of your material/process but this could cause printing of the endfill to the surface of plug and create printing on the mould. Thicker skins might help avoid this issue. If the end fill is very minimal it could cause complete collapse or major distortion of surface if the inner cavity loses atmospheric pressure.
2. Exotherm will roughly be upwards of 80+C for up to an hour. This may also create printing from endfill depending on the skin thickness and endfill type. We can try running a fan across the surface to help keep the temperature down but it will still get fairly hot for a period of time.
3. We will surface the plug with a PE surface primer. Will you be filing the surface roughness there, or will we be? Where in the roughness of the surface is the target surface? Is it the outer of the filament bead? This would be important to understand so that we can achieve the correct surface without rework.
4. After primer sanding we will 3D scan the plug to validate the surface geometry. Depending on the part we target better than +/-1mm global best fit tolerance at RT. We can accept upwards of +/-1.5mm depending where the deviation is. Beyond that we typically will have to fix/correct the surface. Not sure what is achievable in your process but just to be considered.
5. After 24 hours at RT we will precure the mould on the plug up to 60C for 8 hours minimum, under vacuum, before demoulding