

DOUSH rubber moulds

斗士橡胶模具

best choice for production

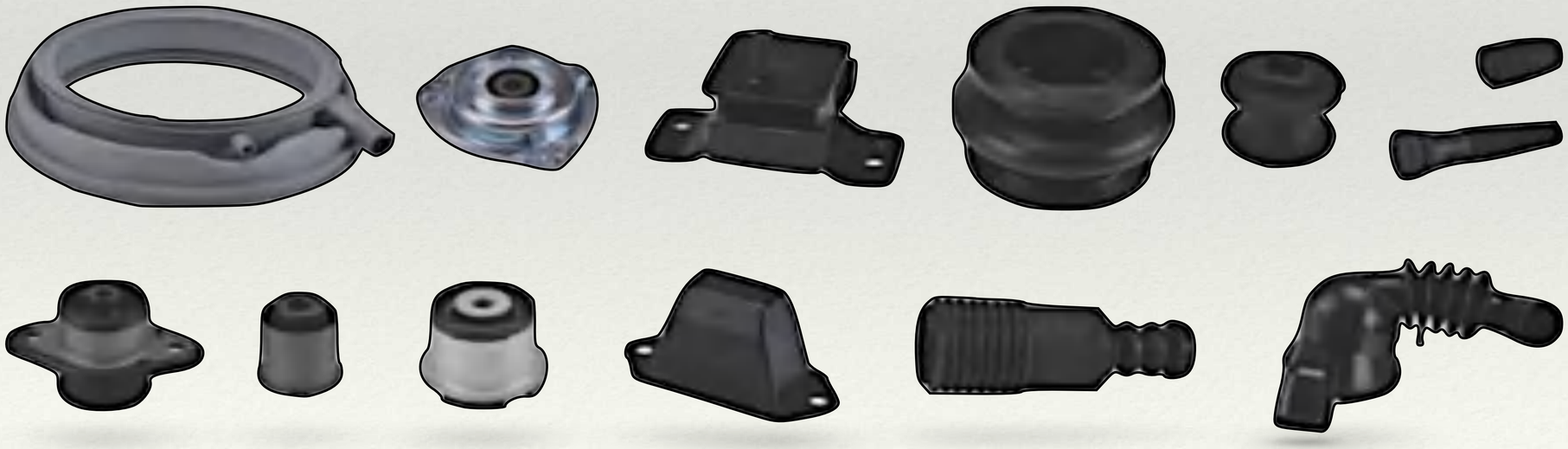
为您提供生产最优选

- **We have over 30 years experience in rubber moulds**

Big range of rubber moulds

模具种类

- O ring O型腔
- Oil Sealing 油封
- Seal strip 密封条
- Bush 衬套
- Gasket 垫圈
- Cover 尘封
- Shock-absorber减震块



We are strong in

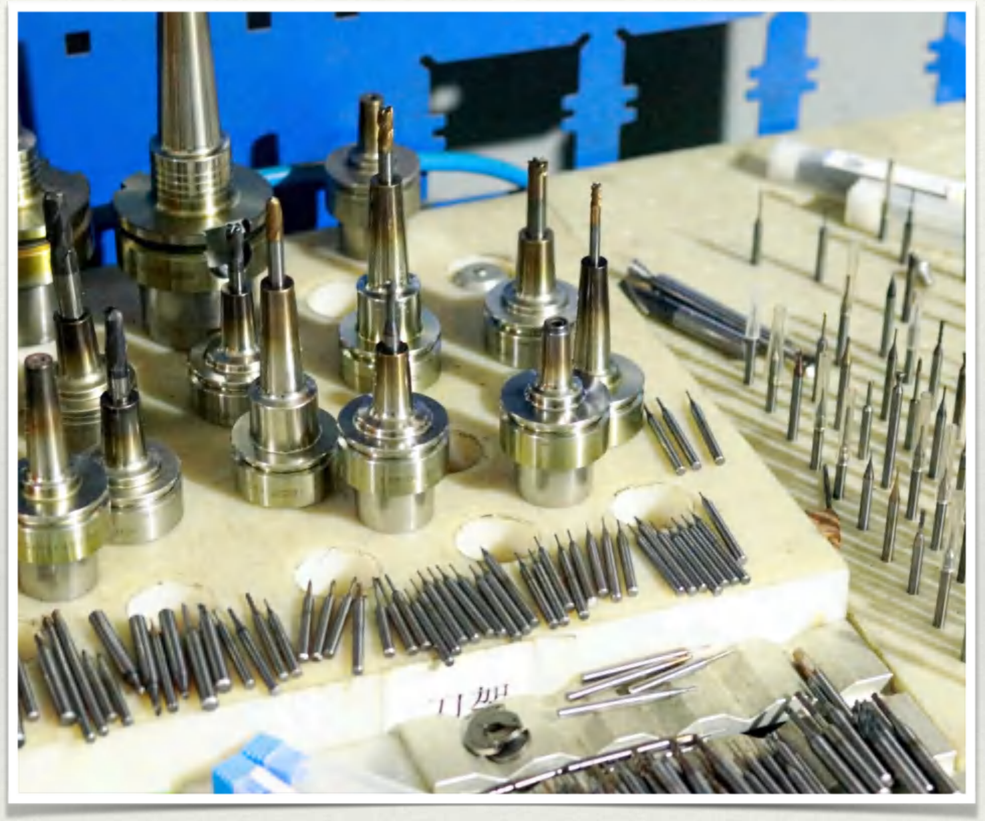
- Injection process understanding
- Mould design
- Cavities balance control
- Flash-less
- High precision machining process
- Mould test— we have different types machine for different mould tests, we have good experience in injection technology and production process



High precision machining equips 加工设备

- Tooling center

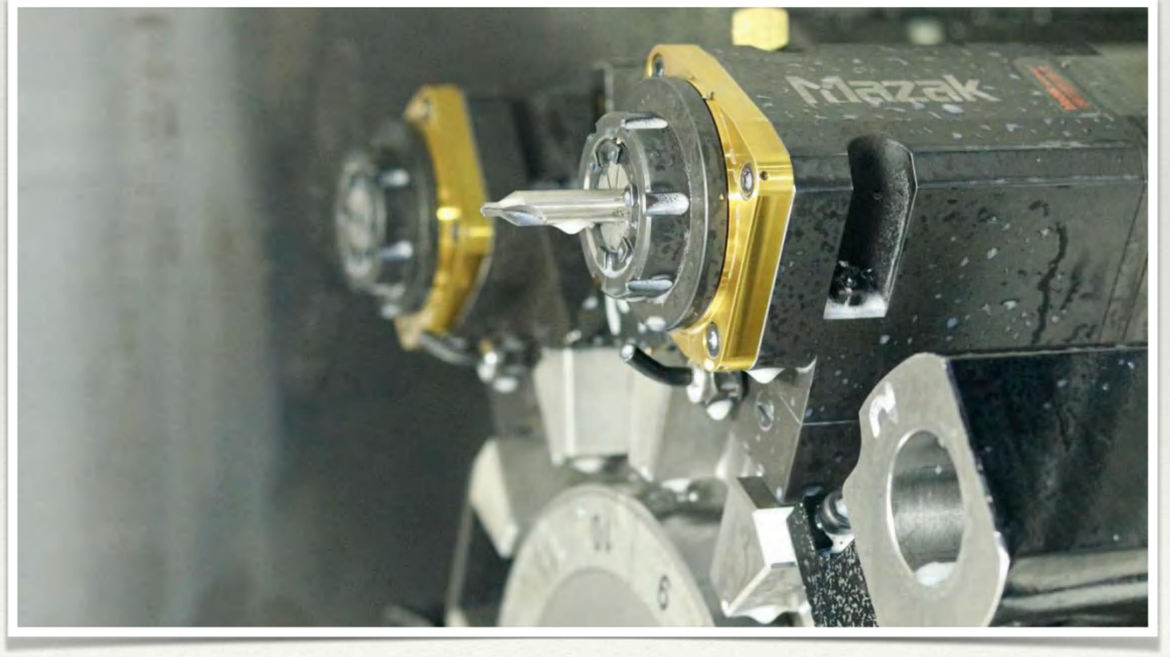




- High precision machining result high quality moulds

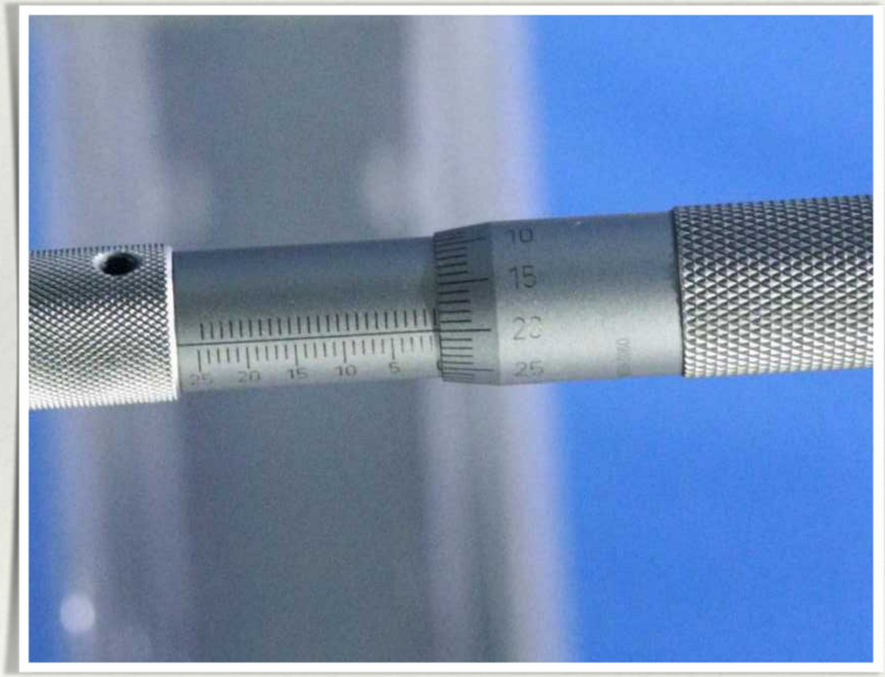

+GF+
AgieCharmilles
4
MIKRON HSM 800 LP




Mazak

Inspection equips 检测设备

- Quality under control






ZEISS
CONTURA G2
MSR multi
Multi Sensor Rack




smile 820/8
5S标准图

Process management 流程管理

Project questionnaire

- parts drawing
- material info
- quantities request
- machine info
- existing production info
  - curing time
  - cycle time
  - auto loading
  - auto de-molding

Customer answer

Mould design

- Mould's layout
- cavity Nu.
- Material choice
- production forecast
  - curing time and cycle tine
  - Production capacity
  - Core and ejector
  - automation
  - material use ratio

Customer confirm

Machining and control

- choice right process machine
- heat treatment
- mould assembly
- quality Control
  - Dimension Measuring
  - Hardness
  - size and tolerance on fit

DOUSH inter control

Test and samples

- dimension
- connections with machine
- vacuum and air out
- Core and eject
- Samples checking
  - performance test
  - appearance
  - flash
  - cycletime

DOUSH test coustomer confirm

Project questionnaire 项目信息调查表

- **Get information from you**

✓ quantities request per months or per year

✓ curing time ?

✓ parts drawing

✓ auto de-molding request ?

✓ material info

✓ if use CRB

✓ existing production info

✓ auto loading ?

✓ Production machine info

Design analysis 设计分析

- **Goal for design forecast**

✓ Cycle time

✓ Injection gate

✓ satisfy to quantity request

✓ Production movements sequence

✓ Vacuum and air out

✓ cavities Nu.

✓ heat treatment

✓ Insert loading device

✓ material use ratio

✓ fit to existing machine injection volume and heating platen size

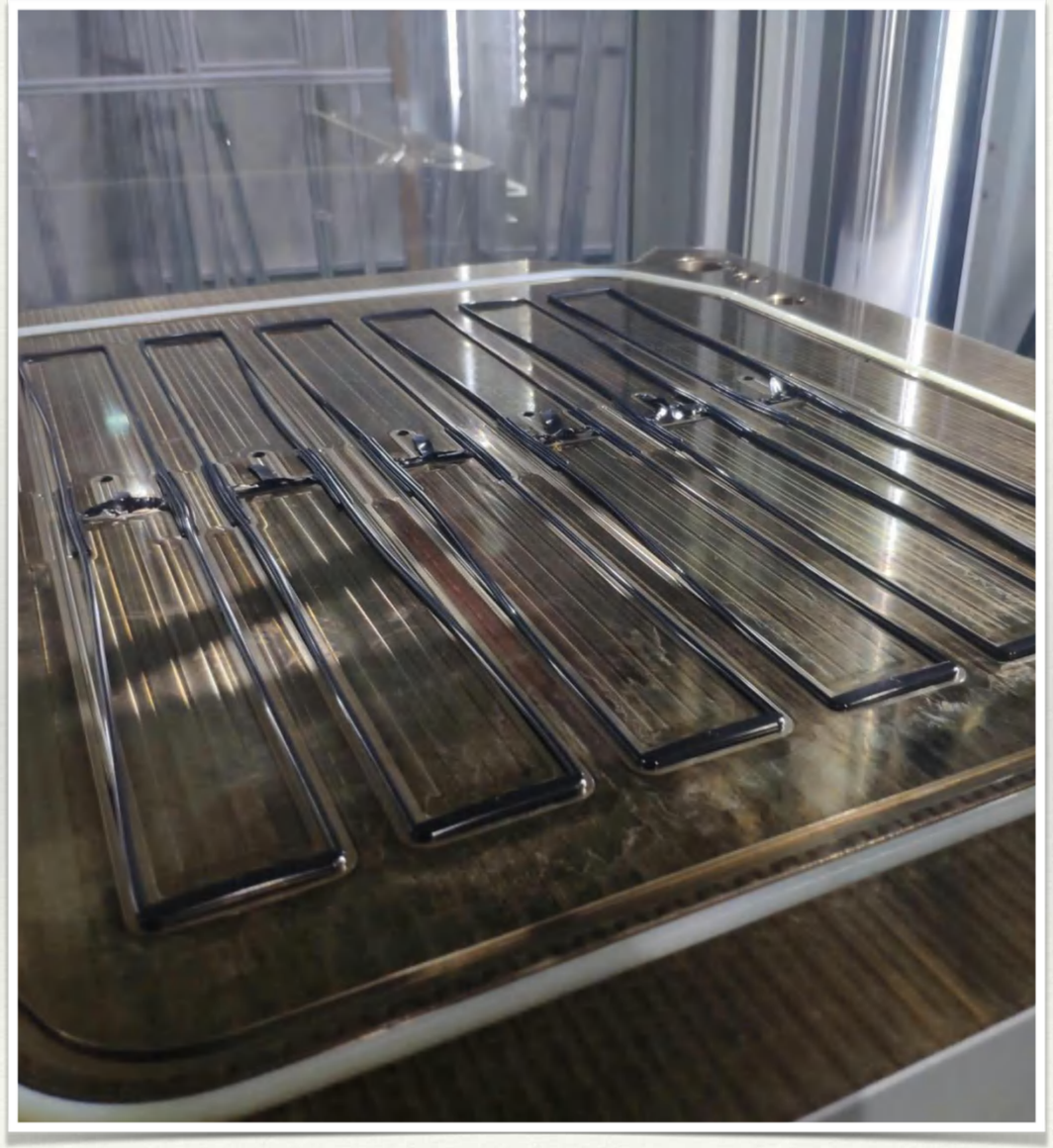
✓ connection with machine

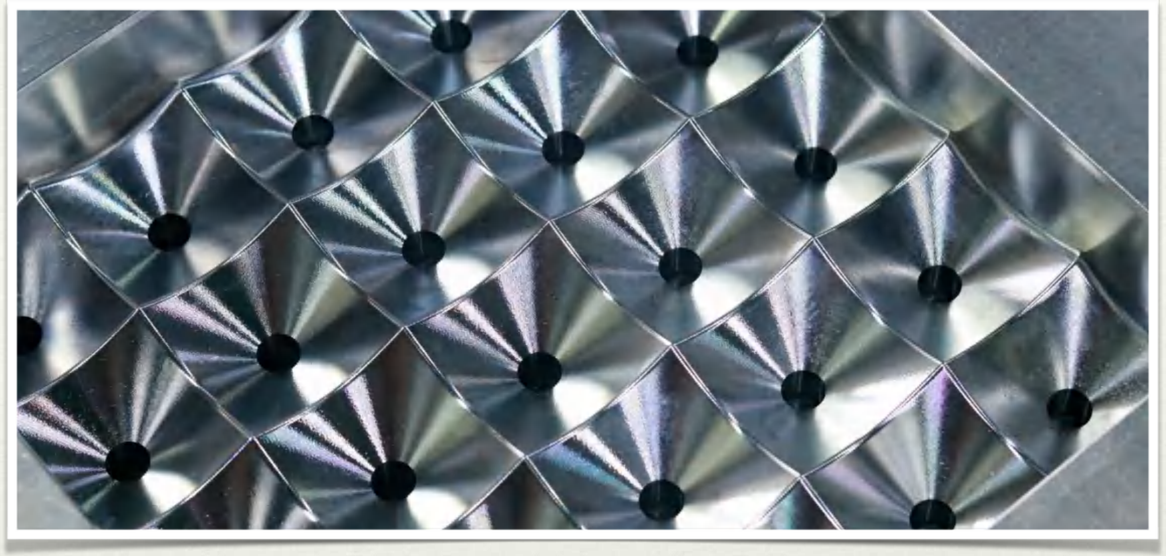
✓ ejector and core

Choice the right material 选择正确的材料

Material材料	Hardness硬度	Feature特点	Application应用
P20HH	HRC32-38	High hardness, high finish and wear resistance	sample mould, test mould, mould life less than 200,000 cycles
NIMAX	HRC36-40	Good machining performance, good weldability, good polishing and skin texture performance	
SKD61	HRC48-53	High carbon and high chromium alloy tool steel, after heat treatment, has high hardness and wear resistance, and has the characteristics of strong hardenability and good dimensional stability, suitable for high precision and long life	Mould life between 200,000 - 500,000 cycles
D2	HRC58-61	Die steel cold work die steel with high wear resistance and slight deformation	Fit to flash-less moulds

Mould projects







Mould projects



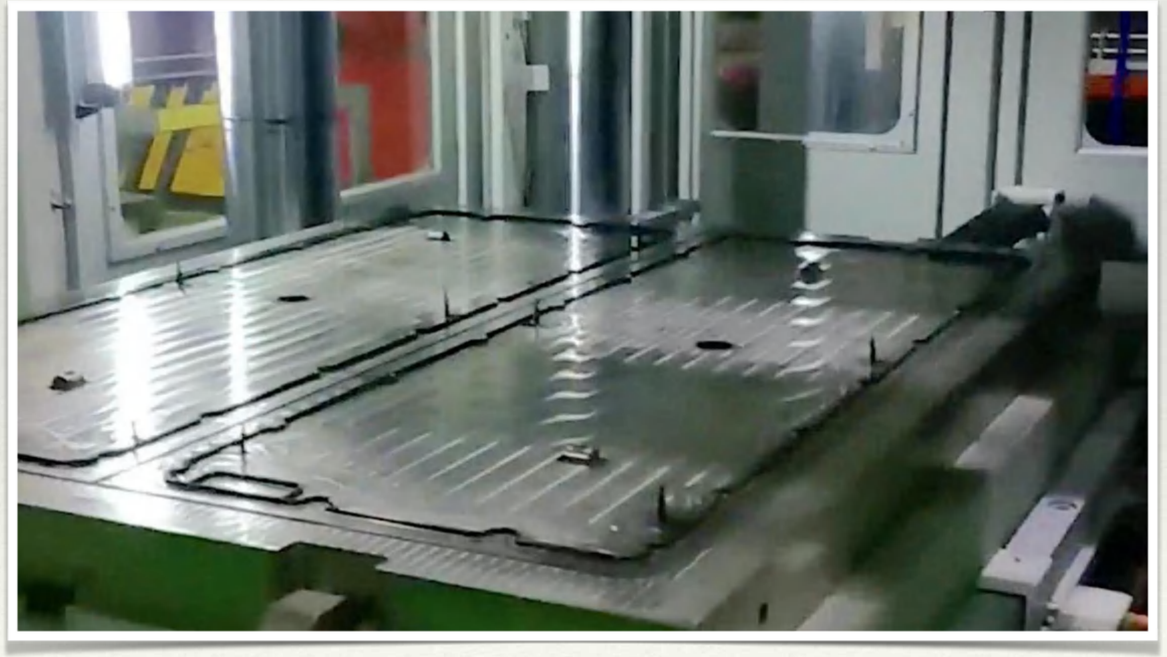




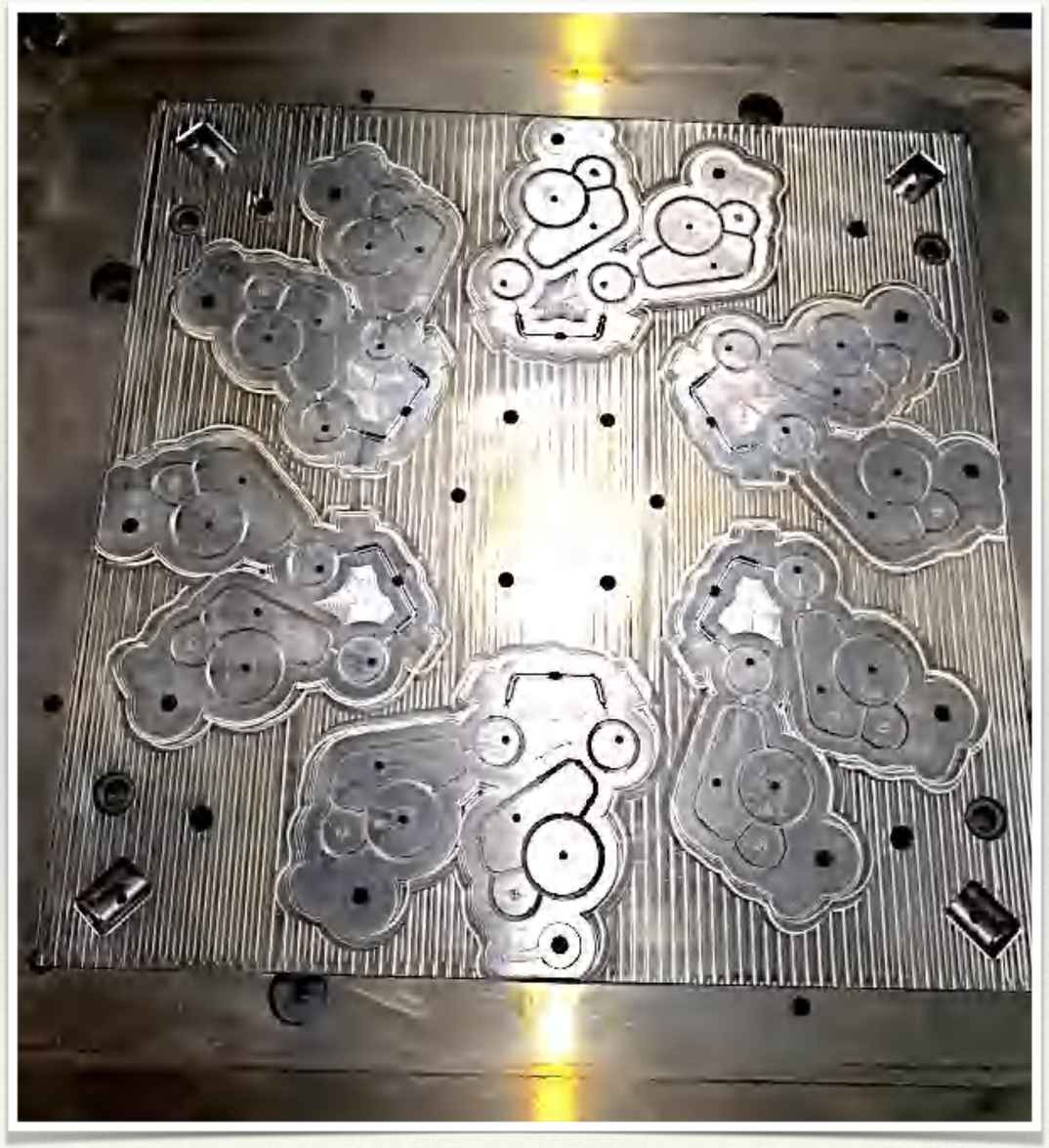
Mould projects







Mould projects

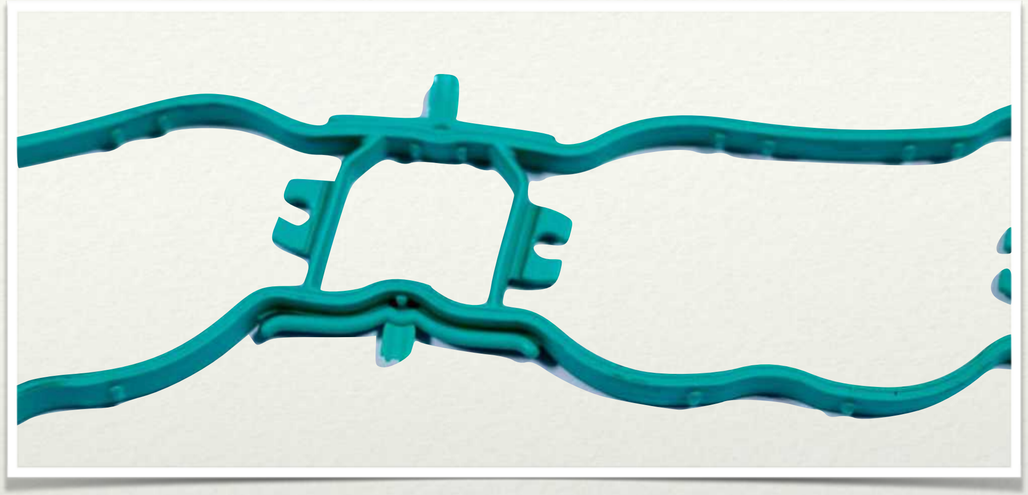






❖ Flash-less projects





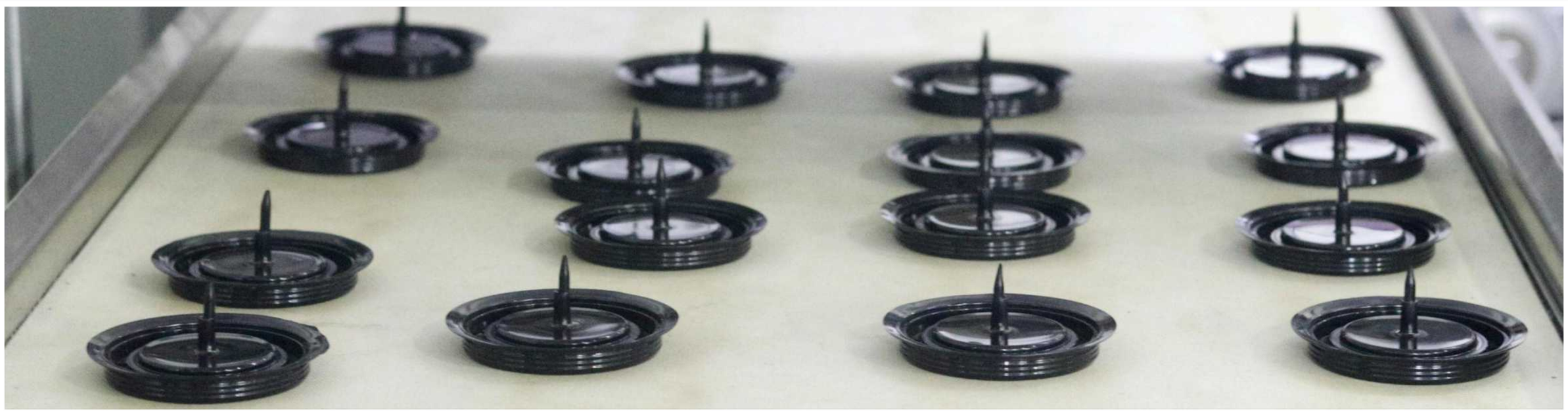


Bush projects









Oil seal projects







Covers projects













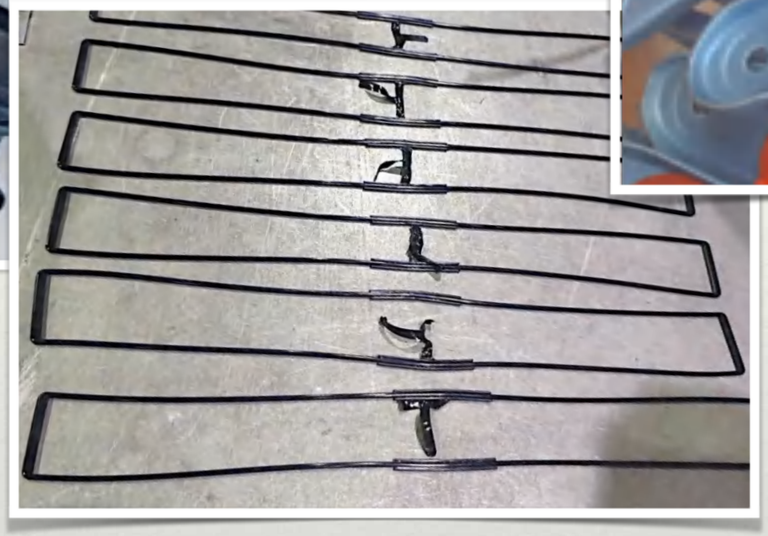




Shock-absorber



- bellows



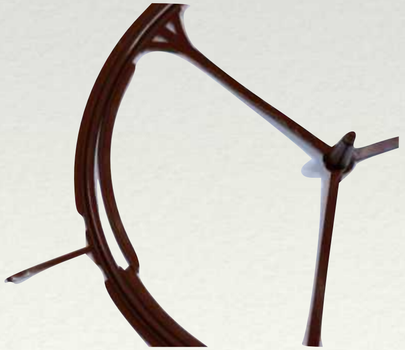
- sealing strip



- Silicon shackle
- Silicon sealing



More projects







Mould test video

- We have different kind of production video, please look on our YouTube: https://youtube.com/channel/UCyCxiEHnIcp7nBDWd4VjQSQ

Video list