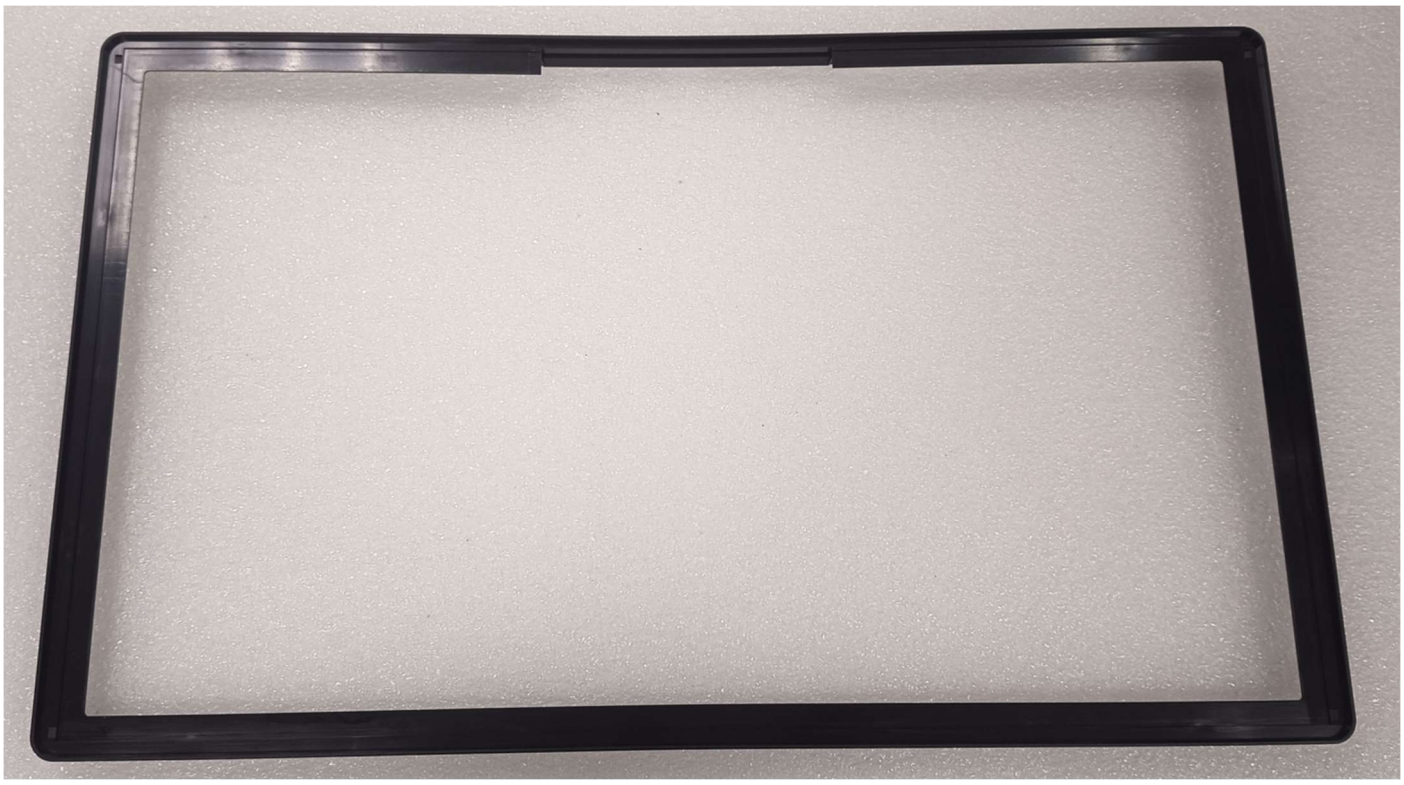




設計驗證工程課
2026 -08- 12
發行
[illegible]科技[illegible]股份有限公司

蘇州佳世達 DQ9

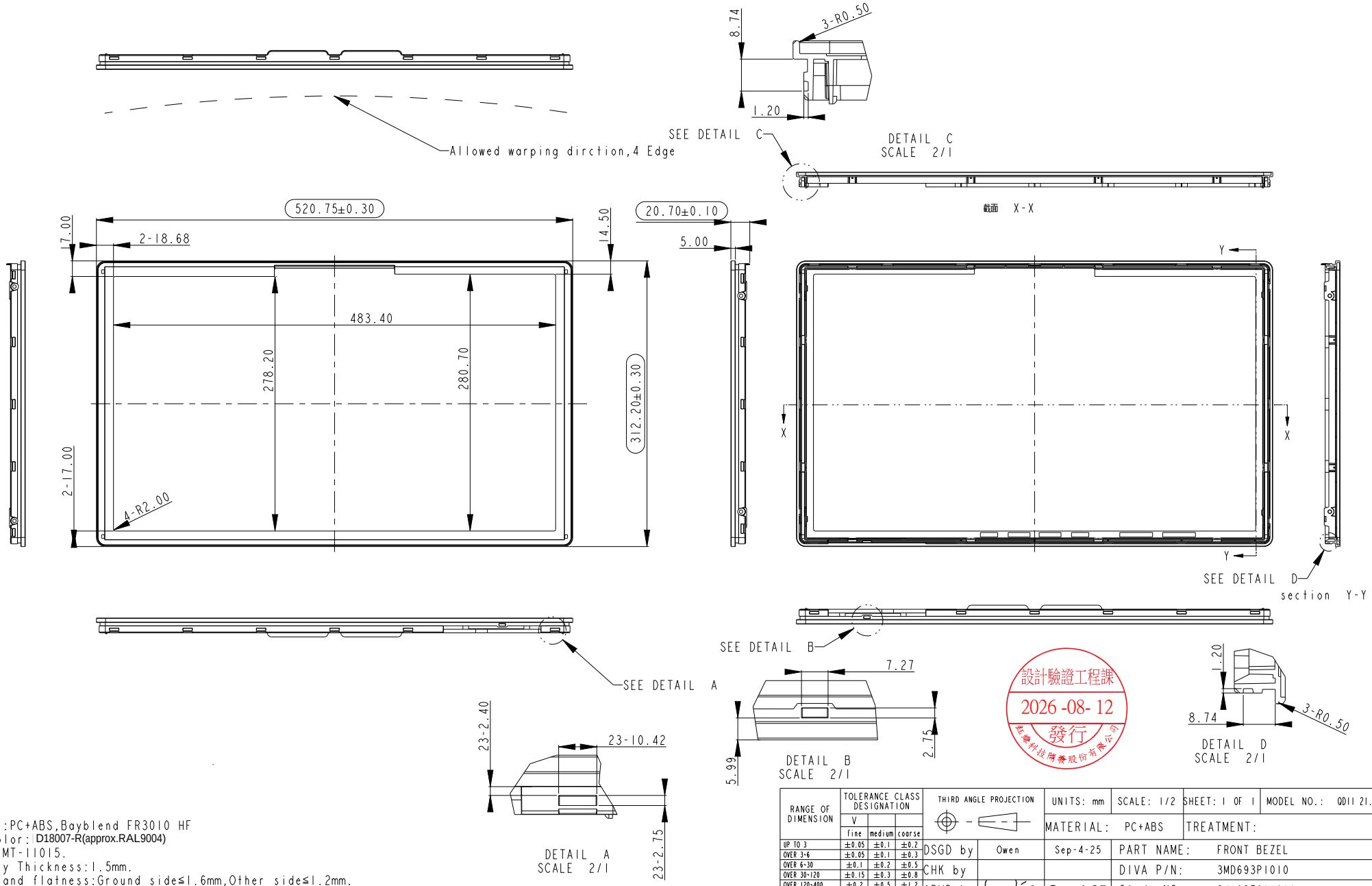
承認書

客戶 : DIVA
料號 : 3MD693P1010(M3540)
品名 : BEZEL INNER (BLACK QD2 21.5")
日期 : 2026/8/4

QISDA No.:3J.6G701.A11



REV.	DATE	DESCRIPTION	BY	APVD
A	2025/9/4	PRODUCTION RELEASE	Owen	



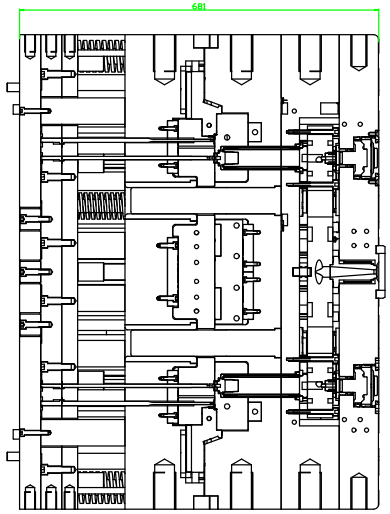
設計驗證工程課
2026 -08- 12
發行
鈺鐵科技開發股份有限公司

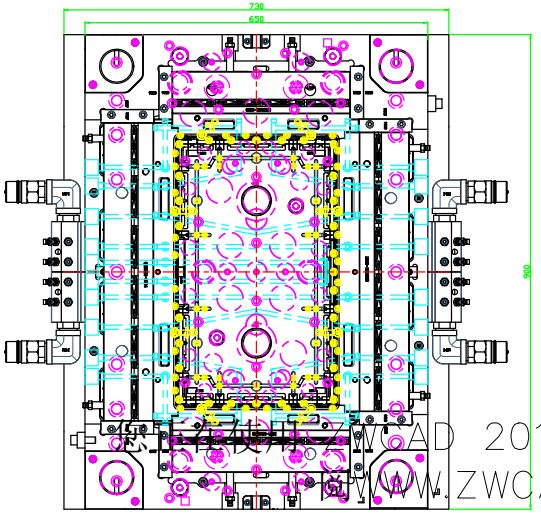
Notes:
1.Material:PC+ABS,Bayblend FR3010 HF
2.Resin Color: D18007-R(approx.RAL9004)
3.Texruer:MT-11015.
4.Generally Thickness:1.5mm.
5.Warpage and flatness:Ground side≤1.6mm,Other side≤1.2mm.
6.◯ Inspection dimension.
7.Unspecified dimension refer to CAD drawing file.
8.DIVA QC Inspection Document NO.:QWI-020(Plastic)

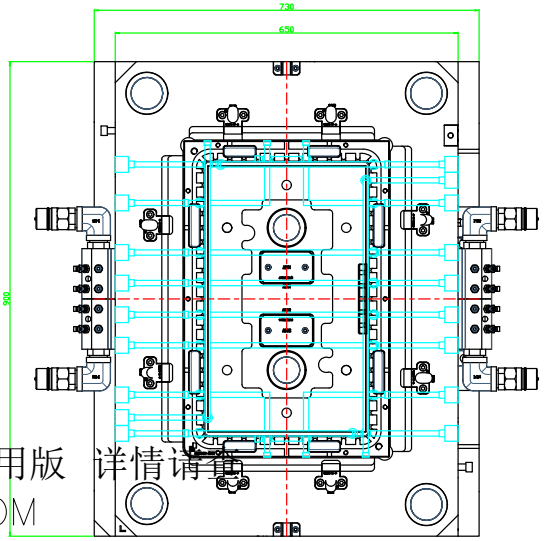
RANGE OF DIMENSION	TOLERANCE CLASS DESIGNATION V fine	medium	coarse
UP TO 3	±0.05	±0.1	±0.2
OVER 3~6	±0.05	±0.1	±0.3
OVER 6~30	±0.1	±0.2	±0.5
OVER 30~120	±0.15	±0.3	±0.8
OVER 120~400	±0.2	±0.5	±1.2
OVER 400~1000	±0.3	±0.8	±2.0
OVER 1000~2000	±0.5	±1.2	±3.0
OVER 2000~4000	-	±2.0	±8.0
ANGLE ±1° (±1.75/100)			

THIRD ANGLE PROJECTION

UNITS: mm	SCALE: 1/2	SHEET: 1 OF 1	MODEL NO.: QD11 21.5
MATERIAL: PC+ABS		TREATMENT:	
DSGD by	Owen	Sep-4-25	PART NAME: FRONT BEZEL
CHK by			DIVA P/N: 3MD693P1010
APVD by		Sep-4-25	Qisda NO.: 3J.6G701.A11
APVD NO.: M3540	3D FILE NAME: BZL_FNT-20250327		DIVA Laboratories ,Ltd.







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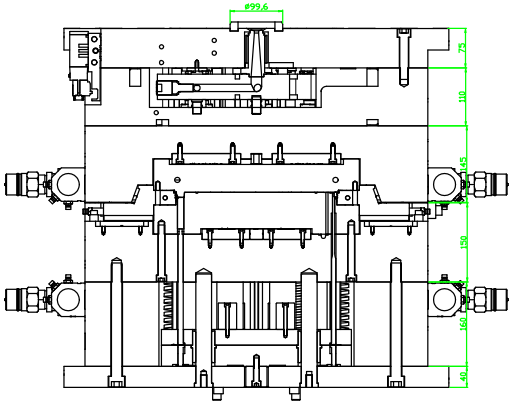
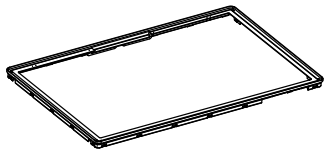
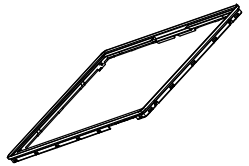
WWW.ZWCAD.COM







未注公差 0. ±0.2 .0 ±0.1 .00 ±0.01 .000 ±0.005	设计		3D		模号	QI250101	比例 1:1
	绘图		塑料	PC+ABS	图名	QD2181AI-P	分机
	校对		缩水率	3.8/1000	品名	FRONT-BEZEL	视角
页次 1/1 版别 A	承认		苏州佳世达				A4

Qisda

Dimension Approval Sheet

Model Name:	QD2181AL-P	**Sample Approval Sheet NO.:**	
Part Name:	FRONT BEZEL	**Material:**	PC+ABS Bayblend FR3010
Part Number:	3J.6G701.A11 **REV:** A0	**Color:**	BLACK
Vendor:	DQ9	**Date:**	2025.05.20

Inspection Gauge:

Coordinate Measuring Machine	(CMM)	Micro Scope	(M)	Radius Gauge	
Caliper	(C)	Height Gauge	(HG)	Block Gauge	
Micrometer	(M)	Projector	(P)	Visual	
Pin Gauge	(PG)	Thickness Gauge	(T)	Lever Type Dial Test	

Distribution

R&D	
QC	
Purchase	
Vendor	

Vendor Input | **Low** | **High**

If the Range is Greater Than 50% of the Total Tolerance the Cell will be RED

Item	Dim. Loc.	Gage Code	Cav. No	Spec.	Upper Tol	Lower Tol	Upper Limit	Lower Limit		Sample 1#	Sample 2#	Sample 3#	RD Check	Average	Status	Range	Disposition	Comments
1		C	1	520.75	0.3	0.3	520.85	520.45		520.650	520.650	520.640	520.630	520.6425	OK	0.008		
2		C	2	312.2	0.3	0.3	312.5	311.9		312.120	312.140	312.160	312.180	312.15	OK	0.022		
3		CMM	3	20.7	0.1	0.1	20.8	20.6		20.670	20.650	20.640	20.630	20.6475	OK	0.015		
4		CMM		483.4	0.3	0.3	483.7	483.1		483.264	483.292	483.318	483.520	483.3485	OK	0.101		
5		CMM		278.2	0.2	0.2	278.4	278		278.009	278.060	278.059	278.250	278.0945	OK	0.092		
6		CMM		280.7	0.2	0.2	280.9	280.5		280.520	280.563	280.544	280.680	280.57675	OK	0.062		
7		CMM		17	0.1	0.1	17.1	16.9		17.010	17.020	17.020	17.050	17.025	OK	0.015		
8		CMM		18.68	0.1	0.1	18.78	18.58		18.670	18.650	18.680	18.620	18.655	OK	0.023		
9		CMM		14.5	0.1	0.1	14.6	14.4		14.480	14.490	14.480	14.580	14.5075	OK	0.042		
10		CMM		17	0.1	0.1	17.1	16.9		17.030	17.030	17.020	17.060	17.035	OK	0.015		
11		CMM		2	0.05	0.05	2.05	1.95		2.030	2.040	2.050	2.020	2.035	OK	0.011		
12		CMM		8.74	0.1	0.1	8.84	8.64		8.704	8.716	8.724	8.760	8.726	OK	0.021		
13		CMM		0.5	0.05	0.05	0.55	0.45		0.550	0.550	0.550	0.550	0.55	OK	0.000		
14		CMM		1.2	0.05	0.05	1.25	1.15		1.240	1.236	1.246	1.227	1.23725	OK	0.007		
15		CMM		5	0.05	0.05	5.05	4.95		5.020	5.010	5.010	4.950	4.9975	OK	0.028		
16		CMM		2.4	0.05	0.05	2.45	2.35		2.388	2.386	2.365	2.390	2.38225	OK	0.010		
17		CMM		2.4	0.05	0.05	2.45	2.35		2.411	2.413	2.431	2.420	2.418775	OK	0.008		
18		CMM		2.4	0.05	0.05	2.45	2.35		2.385	2.378	2.374	2.430	2.39175	OK	0.022		
19		CMM		2.4	0.05	0.05	2.45	2.35		2.378	2.391	2.396	2.410	2.39375	OK	0.011		
20		CMM		2.4	0.05	0.05	2.45	2.35		2.402	2.406	2.408	2.380	2.399	OK	0.011		
21		CMM		2.4	0.05	0.05	2.45	2.35		2.352	2.356	2.354	2.360	2.3555	OK	0.003		
22		CMM		2.4	0.05	0.05	2.45	2.35		2.358	2.356	2.354	2.400	2.367	OK	0.019		
23		CMM		2.4	0.05	0.05	2.45	2.35		2.362	2.367	2.368	2.390	2.37175	OK	0.011		
24		CMM		2.4	0.05	0.05	2.45	2.35		2.412	2.416	2.422	2.440	2.4225	OK	0.011		
25		CMM		2.4	0.05	0.05	2.45	2.35		2.368	2.368	2.368	2.371	2.36875	OK	0.001		
26		CMM		2.4	0.05	0.05	2.45	2.35		2.357	2.354	2.356	2.355	2.3555	OK	0.001		
27		CMM		2.4	0.05	0.05	2.45	2.35		2.372	2.378	2.368	2.380	2.3745	OK	0.005		
28		CMM		2.4	0.05	0.05	2.45	2.35		2.430	2.423	2.415	2.420	2.422	OK	0.005		
29		CMM		2.4	0.05	0.05	2.45	2.35		2.392	2.376	2.388	2.405	2.39025	OK	0.010		
30		CMM		2.4	0.05	0.05	2.45	2.35		2.368	2.356	2.358	2.373	2.36375	OK	0.007		
31		CMM		2.4	0.05	0.05	2.45	2.35		2.378	2.372	2.370	2.388	2.377	OK	0.007		
32		CMM		2.4	0.05	0.05	2.45	2.35		2.350	2.360	2.366	2.364	2.36	OK	0.006		
33		CMM		2.4	0.05	0.05	2.45	2.35		2.356	2.356	2.367	2.384	2.36575	OK	0.011		
34		CMM		2.4	0.05	0.05	2.45	2.35		2.365	2.386	2.365	2.377	2.37325	OK	0.009		
35		CMM		2.4	0.05	0.05	2.45	2.35		2.356	2.356	2.367	2.389	2.367	OK	0.013		
36		CMM		2.4	0.05	0.05	2.45	2.35		2.376	2.382	2.386	2.412	2.389	OK	0.014		
37		CMM		2.4	0.05	0.05	2.45	2.35		2.358	2.367	2.362	2.397	2.371	OK	0.015		
38		CMM		10.42	0.1	0.1	10.52	10.32		10.380	10.365	10.373	10.440	10.3895	OK	0.030		
39		CMM		10.42	0.1	0.1	10.52	10.32		10.370	10.365	10.375	10.460	10.3925	OK	0.039		
40		CMM		10.42	0.1	0.1	10.52	10.32		10.370	10.360	10.380	10.450	10.39	OK	0.035		
41		CMM		10.42	0.1	0.1	10.52	10.32		10.350	10.364	10.372	10.410	10.374	OK	0.022		
42		CMM		10.42	0.1	0.1	10.52	10.32		10.330	10.360	10.340	10.370	10.35	OK	0.016		
43		CMM		10.42	0.1	0.1	10.52	10.32		10.380	10.345	10.380	10.390	10.37375	OK	0.017		
44		CMM		10.42	0.1	0.1	10.52	10.32		10.506	10.450	10.460	10.430	10.4615	OK	0.028		
45		CMM		10.42	0.1	0.1	10.52	10.32		10.433	10.426	10.437	10.480	10.444	OK	0.021		
46		CMM		10.42	0.1	0.1	10.52	10.32		10.460	10.480	10.456	10.380	10.444	OK	0.038		
47		CMM		10.42	0.1	0.1	10.52	10.32		10.369	10.368	10.374	10.420	10.38275	OK	0.022		
48		CMM		10.42	0.1	0.1	10.52	10.32		10.360	10.382	10.376	10.390	10.377	OK	0.011		
49		CMM		10.42	0.1	0.1	10.52	10.32		10.380	10.378	10.356	10.340	10.3635	OK	0.017		
50		CMM		10.42	0.1	0.1	10.52	10.32		10.510	10.452	10.436	10.480	10.4695	OK	0.028		
51		CMM		10.42	0.1	0.1	10.52	10.32		10.436	10.428	10.436	10.420	10.43	OK	0.007		
52		CMM		10.42	0.1	0.1	10.52	10.32		10.425	10.416	10.372	10.380	10.39825	OK	0.023		
53		CMM		10.42	0.1	0.1	10.52	10.32		10.380	10.362	10.384	10.370	10.374	OK	0.009		
54		CMM		10.42	0.1	0.1	10.52	10.32		10.460	10.416	10.423	10.430	10.43225	OK	0.017		
55		CMM		10.42	0.1	0.1	10.52	10.32		10.324	10.346	10.345	10.330	10.33625	OK	0.009		

Qisda

Dimension Approval Sheet

Model Name:	QD2181AL-P	**Sample Approval Sheet NO.:**	
Part Name:	FRONT BEZEL	**Material:**	PC+ABS Bayblend FR3010
Part Number:	3J.6G701.A11 **REV:** A0	**Color:**	BLACK
Vendor:	DQ9	**Date:**	2025.05.20

Inspection Gauge:

Coordinate Measuring Machine	(CMM)	Micro Scope	(M)	Radius Gauge	
Caliper	(C)	Height Gauge	(HG)	Block Gauge	
Micrometer	(M)	Projector	(P)	Visual	
Pin Gauge	(PG)	Thickness Gauge	(T)	Lever Type Dial Test	

Distribution

R&D	
QC	
Purchase	
Vendor	

Vendor Input | Low | High

If the Range is Greater Than 50% of the Total Tolerance the Cell will be RED

Item	Dim. Loc.	Gage Code	Cav. No	Spec.	Upper Tol	Lower Tol	Upper Limit	Lower Limit		Sample 1#	Sample 2#	Sample 3#	RD Check	Average	Status	Range	Disposition	Comments
56		CMM		10.42	0.1	0.1	10.52	10.32		10.430	10.426	10.435	10.440	10.43275	OK	0.005		
57		CMM		10.42	0.1	0.1	10.52	10.32		10.430	10.416	10.408	10.420	10.4185	OK	0.008		
58		CMM		10.42	0.1	0.1	10.52	10.32		10.432	10.413	10.423	10.430	10.4245	OK	0.007		
59		CMM		10.42	0.1	0.1	10.52	10.32		10.400	10.413	10.426	10.430	10.41725	OK	0.012		
60		CMM		10.42	0.1	0.1	10.52	10.32		10.369	10.365	10.373	10.380	10.37175	OK	0.006		
61		CMM		2.75	0.05	0.05	2.8	2.7		2.730	2.710	2.720	2.730	2.7225	OK	0.008		
62		CMM		2.75	0.05	0.05	2.8	2.7		2.720	2.700	2.730	2.740	2.7225	OK	0.015		
63		CMM		2.75	0.05	0.05	2.8	2.7		2.720	2.715	2.710	2.710	2.71375	OK	0.004		
64		CMM		2.75	0.05	0.05	2.8	2.7		2.730	2.710	2.710	2.720	2.7175	OK	0.008		
65		CMM		2.75	0.05	0.05	2.8	2.7		2.720	2.710	2.710	2.760	2.725	OK	0.021		
66		CMM		2.75	0.05	0.05	2.8	2.7		2.710	2.710	2.700	2.770	2.7225	OK	0.028		
67		CMM		2.75	0.05	0.05	2.8	2.7		2.700	2.710	2.701	2.710	2.70525	OK	0.005		
68		CMM		2.75	0.05	0.05	2.8	2.7		2.720	2.710	2.710	2.730	2.7175	OK	0.008		
69		CMM		2.75	0.05	0.05	2.8	2.7		2.720	2.710	2.700	2.740	2.7175	OK	0.015		
70		CMM		2.75	0.05	0.05	2.8	2.7		2.710	2.700	2.700	2.700	2.7025	OK	0.004		
71		CMM		2.75	0.05	0.05	2.8	2.7		2.710	2.720	2.730	2.780	2.735	OK	0.027		
72		CMM		2.75	0.05	0.05	2.8	2.7		2.720	2.730	2.710	2.750	2.7275	OK	0.015		
73		CMM		2.75	0.05	0.05	2.8	2.7		2.710	2.740	2.720	2.730	2.725	OK	0.011		
74		CMM		2.75	0.05	0.05	2.8	2.7		2.720	2.720	2.710	2.720	2.7175	OK	0.004		
75		CMM		2.75	0.05	0.05	2.8	2.7		2.710	2.720	2.710	2.740	2.72	OK	0.012		
76		CMM		2.75	0.05	0.05	2.8	2.7		2.710	2.710	2.720	2.730	2.7175	OK	0.008		
77		CMM		2.75	0.05	0.05	2.8	2.7		2.720	2.710	2.710	2.750	2.7225	OK	0.016		
78		CMM		2.75	0.05	0.05	2.8	2.7		2.720	2.720	2.710	2.740	2.7225	OK	0.011		
79		CMM		2.75	0.05	0.05	2.8	2.7		2.710	2.720	2.720	2.760	2.7275	OK	0.019		
80		CMM		2.75	0.05	0.05	2.8	2.7		2.720	2.720	2.710	2.730	2.72	OK	0.007		
81		CMM		2.75	0.05	0.05	2.8	2.7		2.720	2.710	2.710	2.750	2.7225	OK	0.016		
82		CMM		2.75	0.05	0.05	2.8	2.7		2.720	2.710	2.730	2.770	2.7325	OK	0.023		
84		CMM		7.27	0.1	0.1	7.37	7.17		7.230	7.236	7.240	7.250	7.239	OK	0.007		
85		CMM		5.99	0.05	0.05	6.04	5.94		5.966	5.956	5.952	6.010	5.97095	OK	0.023		
86		CMM		2.75	0.05	0.05	2.8	2.7		2.700	2.715	2.721	2.770	2.7265	OK	0.026		
87		CMM		1.2	0.05	0.05	1.25	1.15		1.250	1.230	1.230	1.240	1.2375	OK	0.008		
88		CMM		8.74	0.1	0.1	8.84	8.64		8.756	8.781	8.742	8.760	8.75975	OK	0.014		
89		CMM		0.5	0.05	0.05	0.55	0.45		0.483	0.480	0.513	0.530	0.5015	OK	0.021		

Initiator:Guofeng Zhang Reviewed by :Carlos Q Chen Approve by: DLA/Owen Chiang/2025/9/11

SA成型条件表

成型厂	DQ9	模具厂	VST0	机台类型	电动	螺杆直径	70	版本：	A
机种	QD2181AL-P	料号	3J.6G701.A11	品名	前框	机台吨位	550T	机台编号	C15
模号	QJ250101	原料型号	PC+ABS	原料颜色	BLACK	模具类型	热流道	成型日期	2025/7/22

成型资讯及参数

温 度 设 定

烘料温度	90℃
烘料时间	4Hrs

段数	射嘴	一段	二段	三段	四段	五段	六段	
温度(℃)	260	260	250	240	230			
模温(℃)	设定	A	B	C	D			
公模	55度							
母模	55度							
温控箱温度设定								

成品重量	134G	料头重量	60G
模穴数	1穴		

时 间 压 力 速 度 设 定

锁模压力	5000T

射 出	一段	二段	三段	四段	五段	六段
压 力	185	0.81				
速 度	45	55	65	35		
射出位置	80	75	65	42		

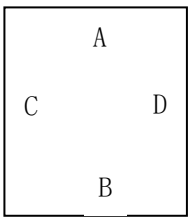
切换方式	位置				保压切换	38
保 压	一段	二段	三段	四段	射出时间	5.5
保压压力	20	80	90		冷却时间	18
保压时间	0.6	1		10	成型周期	55S
背压/射终	130/30.7		计量/松退		80/3.5	
是否全自动	□是 □否					

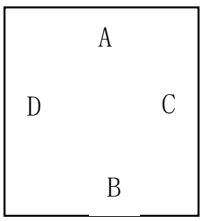
时序设定		1	2	3	4	5	6	7	8	9
	闭	全开								
	开	3.8s								

氮气设定		延时	1	2	3	4	5	6	7
	时间								
	压力								

水路图

公模 操作侧





母模 操作侧

佳世达TE审核： 冯浩　　成型主管：梁明　　工程：余新永　　技术员： 王锦兵

AP_GP BOM Report

Qisda P/N	3J.6G701.A11
Qisda Item description	BEZEL FRONT BLACK QD2181AI-P
Maker	Qisda Molding Factory
Maker P/N	3J.6G701.A11
Create date	2025/09/12

Component type	Description	Supplier	Subpart type	Subpart Description	Subpart Supplier	Sample Description	Remark	Report No.	Test Date	Cd	Pb	Hg	Cr6+	PBBs/PBDEs	Br	Cl	Br+Cl	DIBP	DEHP	BBP	DBP	F	I	Exemptions
Plastic Housing	FR3010HF 901510	航耀	Plastic Resin of Housing	FR3010HF 901510	航耀	黑色塑胶颗粒	航耀是Covestro(科思创)代理商	QHJ24030388802/CH;QHJ24030388 01/CH	2024/04/10;2024/04/03	N.D	N.D	N.D	N.D	N.D	N.D	N.D	N.D	N.D	N.D	N.D	N.D	1570	N.D	
Summary data										N.D	N.D	N.D	N.D	N.D	N.D	N.D	N.D	N.D	N.D	N.D	N.D	1570	N.D	