*注意事項:

色差值同 M3537-2BAD6930032,如下圖所示

RD 已確認,如 mail 說明



設計驗證工程課
2026 -08- 14
發行

蘇州佳世達 DQ9

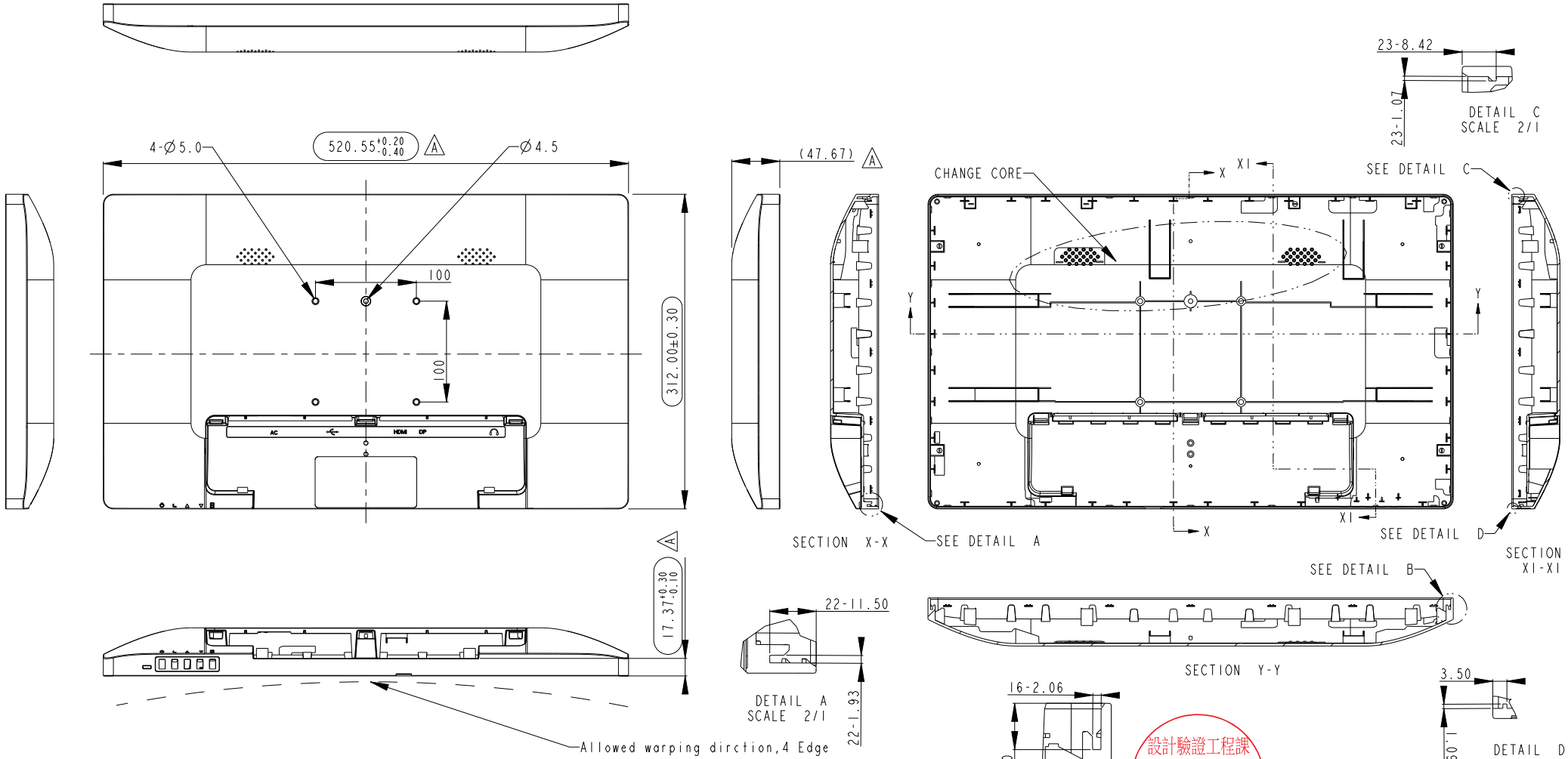
承認書

客戶 : DIVA
料號 : 3MD693P2010(M3540)
品名 : REAR COVER (BLACK QD2 21.5")
日期 : 2026/8/4

QISDA No.:3J.6G701.B11

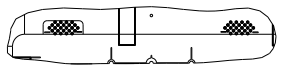
設計驗證工程課
2026 -08- 14
發行

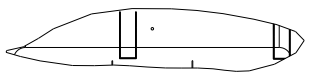
REV.	DATE	DESCRIPTION	BY	APVD
A	2025/9/18	PRODUCTION RELEASE	Owen	Laslie
B	2026/4/13	Change control dimensions & tolerances ⚠	Owen	Laslie



QISDA P/N	QISDA DESCRIPTION	DIVA P/N	DIVA DESCRIPTION	CHANGE CORE	CORE P/N
3J.6G701.B01	RC TOOLING QD 2181A1-P	N/A	N/A	N/A	N/A
3J.6G701.B11	RC QD2181A1-P ✓	3MD693P2010	REAR COVER (BLACK QD2_21.5")	THROUGH HOLE	BN8/BN9
3J.6G701.B21	RC WHITE QD2181A1-P	3MD693P2020	REAR COVER (WHITE QD2 21.5")	THROUGH HOLE	BN8/BN9
3J.6G702.B11	RC BVH QD2181A1-P	3MD693P2030	REAR COVER (BLACK QD2_21.5",BVH)	BLIND HOLE	BN10/BN11

Notes:
1.Material:PC+ABS,Bayblend FR3010 HF
2.Resin Color:
2-1.DI8007-R(approx.RAL 9004).
2-2.90273 White(approx.RAL 9003)
3.Texruer:MT-11010.
4.Generally Thickness:2.5mm.
5.Warpage and flatness:<1.2mm.
6.◯Inspection dimension.
7.Unspecified dimension refer to CAD drawing file.
8.DIVA QC Inspection Document NO.:QW1-020(Plastic)


THROUGH HOLE


BLIND HOLE

設計驗證工程課
2026 -08- 14
發行
鈺邁科技開發股份有限公司

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-18-25
CHK by		
APVD by	Laslie	SEP-18-25

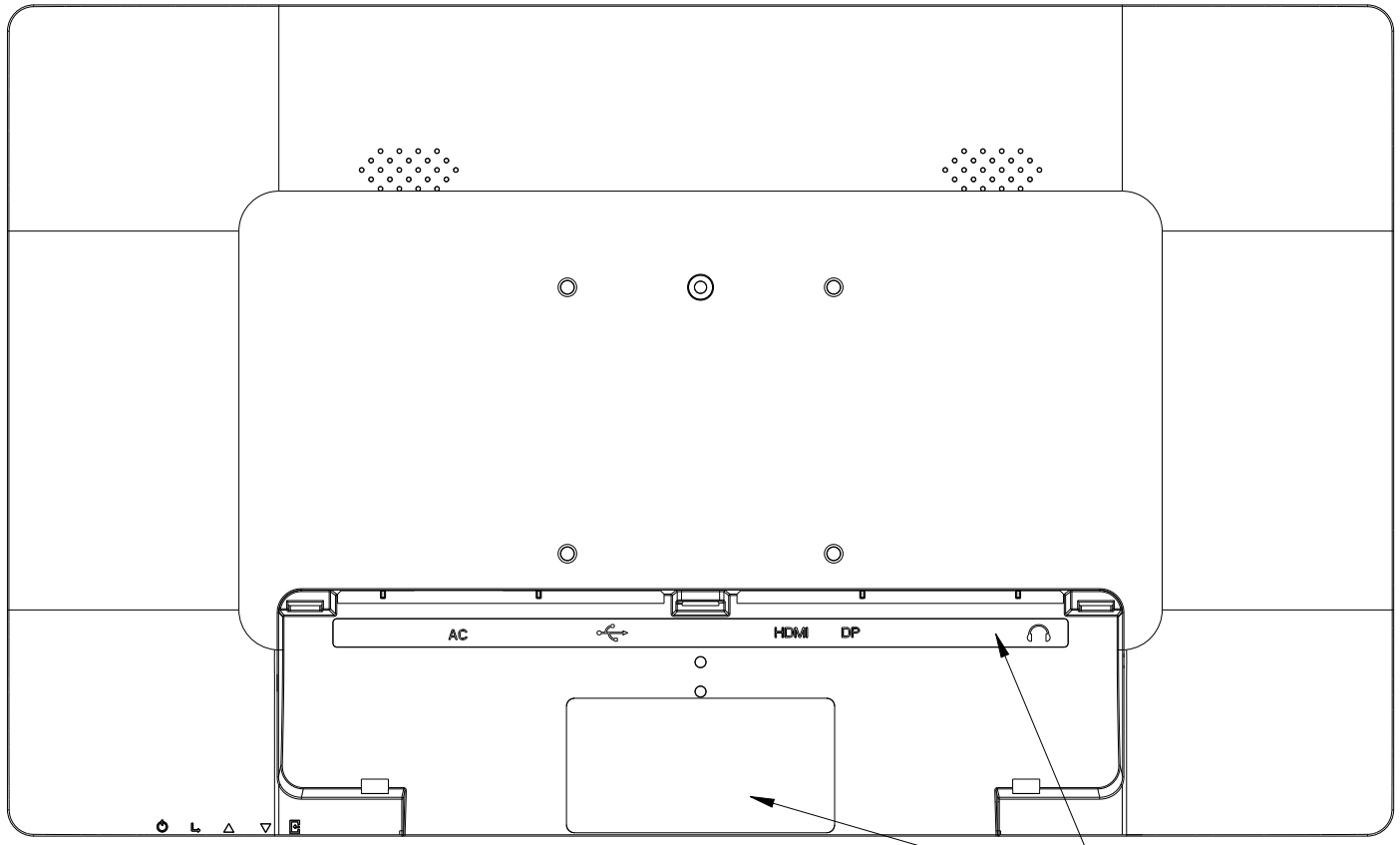
PART NAME: REAR COVER
DIVA P/N: See table
Qisda NO.: See table

APVD NO.:

3D FILE NAME: 0215.000.RC.QD2_1P65.V4.T.CUT

DIVA Laboratories ,Ltd.

REV.	DATE	DESCRIPTION	BY	APVD



此兩處凹槽不咬花

其餘外觀面皆需咬花：MT-11010

(Polish#1000)

設計驗證工程課
2026 -08- 14
發行
鈺鎏科技開發股份有限公司

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: 1/1 | SHEET: 1 OF 1 | MODEL NO.: QD11_21.5"

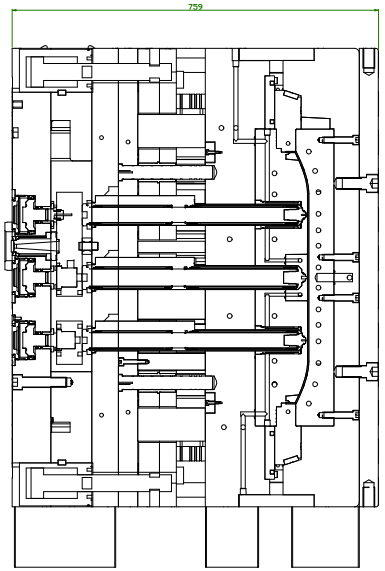
MATERIAL: | TREATMENT:

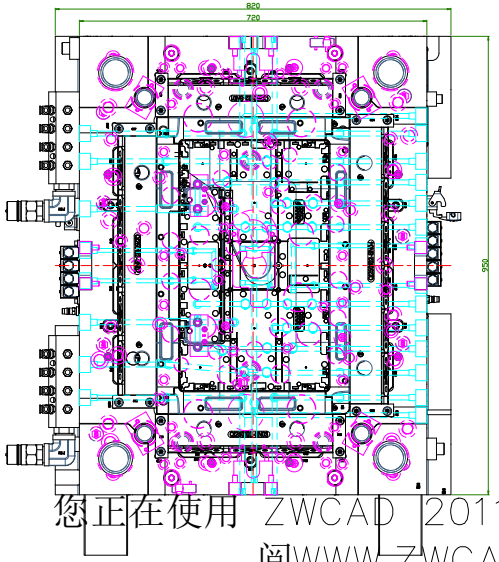
DSGD by	Owen	Jun-02-25	PART NAME: Rear Cover
CHK by			DIVA P/N: 3MD693P2010
APVD by			Qisda NO.: 3J.6G701.B11

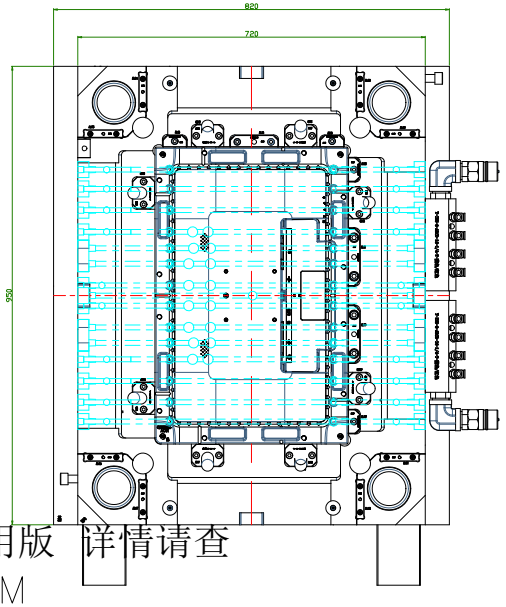
APVD NO.:

3D FILE NAME: 0215_000_RC_QD2_1P65_V4_T_CUT

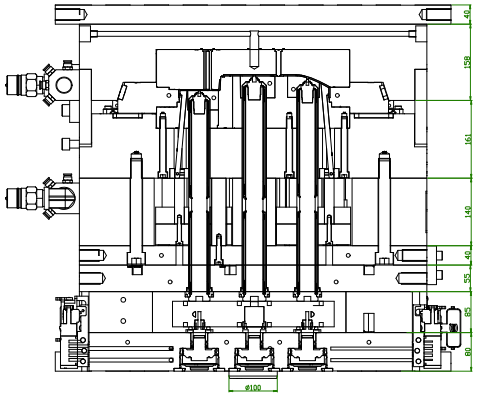
DIVA Laboratories ,Ltd.

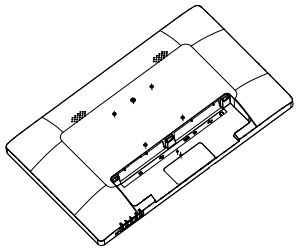


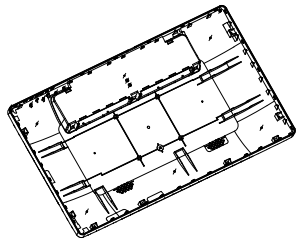




您正在使用 ZWCAD 2011 试用版 详情请查阅WWW.ZWCAD.COM







未注公差 0. ±0.2 .0 ±0.1 .00 ±0.01 000 ±0.005	设计	WF	3D		模号	QI250102	比例 1:1
	绘图		塑料	PC+ABS	图名	QD2181AI-P	分机
	校对		缩水率	4.8/1000	品名	REAR-COVER	视角
页次 1/1 版别 A	承认		苏州佳世达				

Qisda

Dimension Approval Sheet

Model Name:	QD2181AL-P	**Sample Approval Sheet NO.:**	
Part Name:	REAR COVER	**Material:**	PC+ABS Bayblend FR3010
Part Number:	3J.6G701.B11 **REV:** A0	**Color:**	BLACK
Vendor:	DQ9	**Date:**	2025.09.08

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	520.55	0.3	0.3	520.85	520.25		520.440	520.460	520.430	520.480	520.4525	OK	0.019		
2		C	2	312	0.3	0.3	312.3	311.7		312.021	312.020	312.010	312.150	312.05025	OK	0.058		
3		CMM	3	47.67	0.3	0.1	47.97	47.57		47.970	47.920	47.880	47.910	47.92	OK	0.032		
4		CMM		5	0.05	0.05	5.05	4.95		4.960	4.970	4.980	4.990	4.975	OK	0.011		
5		CMM		5	0.2	0.2	5.2	4.8		4.920	4.910	4.930	4.980	4.935	OK	0.027		
6		CMM		5	0.2	0.2	5.2	4.8		4.920	4.910	4.910	4.970	4.9275	OK	0.025		
7		CMM		5	0.1	0.1	5.1	4.9		4.920	4.920	4.910	4.900	4.9125	OK	0.008		
8		CMM		4.5	0.1	0.1	4.6	4.4		4.500	4.510	4.490	4.520	4.505	OK	0.011		
9		CMM		100	0.15	0.15	100.15	99.85		99.920	99.930	99.970	99.980	99.95	OK	0.025		
10		CMM		100	0.15	0.15	100.15	99.85		100.020	100.040	100.020	100.030	100.0275	OK	0.008		
11		CMM		8.42	0.1	0.1	8.52	8.32		8.485	8.476	8.469	8.480	8.4775	OK	0.006		
12		CMM		8.42	0.1	0.1	8.52	8.32		8.502	8.514	8.493	8.470	8.49475	OK	0.016		
13		CMM		8.42	0.1	0.1	8.52	8.32		8.441	8.436	8.429	8.450	8.439	OK	0.008		
14		CMM		8.42	0.1	0.1	8.52	8.32		8.490	8.481	8.475	8.480	8.4815	OK	0.005		
15		CMM		8.42	0.1	0.1	8.52	8.32		8.469	8.472	8.436	8.460	8.45925	OK	0.014		
16		CMM		8.42	0.1	0.1	8.52	8.32		8.434	8.426	8.437	8.440	8.43425	OK	0.005		
17		CMM		8.42	0.1	0.1	8.52	8.32		8.369	8.396	8.365	8.410	8.385	OK	0.019		
18		CMM		8.42	0.1	0.1	8.52	8.32		8.476	8.462	8.474	8.420	8.458	OK	0.023		
19		CMM		8.42	0.1	0.1	8.52	8.32		8.341	8.356	8.367	8.470	8.3835	OK	0.051		
20		CMM		8.42	0.1	0.1	8.52	8.32		8.464	8.435	8.476	8.490	8.46625	OK	0.020		
21		CMM		8.42	0.1	0.1	8.52	8.32		8.520	8.490	8.478	8.510	8.4995	OK	0.016		
22		CMM		8.42	0.1	0.1	8.52	8.32		8.427	8.460	8.434	8.440	8.44025	OK	0.012		
23		CMM		8.42	0.1	0.1	8.52	8.32		8.449	8.472	8.462	8.490	8.46825	OK	0.015		
24		CMM		8.42	0.1	0.1	8.52	8.32		8.361	8.365	8.382	8.370	8.3695	OK	0.008		
25		CMM		8.42	0.1	0.1	8.52	8.32		8.359	8.426	8.435	8.410	8.4075	OK	0.029		
26		CMM		8.42	0.1	0.1	8.52	8.32		8.422	8.423	8.345	8.400	8.3975	OK	0.032		
27		CMM		8.42	0.1	0.1	8.52	8.32		8.389	8.391	8.436	8.420	8.409	OK	0.020		
28		CMM		8.42	0.1	0.1	8.52	8.32		8.426	8.438	8.361	8.440	8.41635	OK	0.032		
29		CMM		8.42	0.1	0.1	8.52	8.32		8.448	8.436	8.420	8.460	8.441	OK	0.015		
30		CMM		8.42	0.1	0.1	8.52	8.32		8.410	8.431	8.324	8.430	8.39875	OK	0.044		
31		CMM		8.42	0.1	0.1	8.52	8.32		8.449	8.450	8.460	8.480	8.45975	OK	0.012		
32		CMM		8.42	0.1	0.1	8.52	8.32		8.333	8.420	8.410	8.420	8.39575	OK	0.036		
33		CMM		8.42	0.1	0.1	8.52	8.32		8.444	8.460	8.450	8.460	8.4535	OK	0.007		
34		CMM		1.07	0.05	0.05	1.12	1.02		1.040	1.066	1.070	1.080	1.064	OK	0.015		
35		CMM		1.07	0.05	0.05	1.12	1.02		1.050	1.056	1.050	1.060	1.054	OK	0.004		
36		CMM		1.07	0.05	0.05	1.12	1.02		1.060	1.042	1.050	1.070	1.0555	OK	0.011		
37		CMM		1.07	0.05	0.05	1.12	1.02		1.036	1.040	1.040	1.040	1.039	OK	0.002		
38		CMM		1.07	0.05	0.05	1.12	1.02		1.043	1.045	1.045	1.050	1.04575	OK	0.003		
39		CMM		1.07	0.05	0.05	1.12	1.02		1.035	1.054	1.042	1.030	1.04025	OK	0.009		
40		CMM		1.07	0.05	0.05	1.12	1.02		1.043	1.045	1.032	1.030	1.0375	OK	0.007		
41		CMM		1.07	0.05	0.05	1.12	1.02		1.026	1.034	1.050	1.040	1.0375	OK	0.009		
42		CMM		1.07	0.05	0.05	1.12	1.02		1.045	1.036	1.050	1.060	1.04775	OK	0.009		
43		CMM		1.07	0.05	0.05	1.12	1.02		1.035	1.028	1.042	1.050	1.03875	OK	0.008		
44		CMM		1.07	0.05	0.05	1.12	1.02		1.036	1.048	1.049	1.030	1.04075	OK	0.008		
45		CMM		1.07	0.05	0.05	1.12	1.02		1.072	1.073	1.073	1.080	1.0745	OK	0.003		
46		CMM		1.07	0.05	0.05	1.12	1.02		1.078	1.072	1.056	1.080	1.0715	OK	0.009		
47		CMM		1.07	0.05	0.05	1.12	1.02		1.075	1.076	1.068	1.090	1.07725	OK	0.008		
48		CMM		1.07	0.05	0.05	1.12	1.02		1.058	1.059	1.065	1.070	1.063	OK	0.005		
49		CMM		1.07	0.05	0.05	1.12	1.02		1.067	1.061	1.064	1.060	1.063	OK	0.003		
50		CMM		1.07	0.05	0.05	1.12	1.02		1.054	1.062	1.067	1.070	1.06325	OK	0.006		
51		CMM		1.07	0.05	0.05	1.12	1.02		1.058	1.046	1.052	1.040	1.049	OK	0.007		
52		CMM		1.07	0.05	0.05	1.12	1.02		1.035	1.049	1.075	1.090	1.06225	OK	0.022		
53		CMM		1.07	0.05	0.05	1.12	1.02		1.072	1.085	1.076	1.080	1.07825	OK	0.005		
54		CMM		1.07	0.05	0.05	1.12	1.02		1.081	1.082	1.079	1.080	1.0805	OK	0.001		
55		CMM		1.07	0.05	0.05	1.12	1.02		1.076	1.076	1.078	1.090	1.08	OK	0.006		

Qisda

Dimension Approval Sheet

Model Name:	QD2181AL-P	**Sample Approval Sheet NO.:**	
Part Name:	REAR COVER	**Material:**	PC+ABS Bayblend FR3010
Part Number:	3J.6G701.B11 **REV:** A0	**Color:**	BLACK
Vendor:	DQ9	**Date:**	2025.09.08

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		1.07	0.05	0.05	1.12	1.02		1.076	1.074	1.071	1.080	1.07525	OK	0.003		
57		CMM		11.5	0.1	0.1	11.6	11.4		11.560	11.520	11.520	11.530	11.5325	OK	0.016		
58		CMM		11.5	0.1	0.1	11.6	11.4		11.570	11.540	11.526	11.540	11.544	OK	0.016		
59		CMM		11.5	0.1	0.1	11.6	11.4		11.486	11.492	11.472	11.580	11.5075	OK	0.042		
60		CMM		11.5	0.1	0.1	11.6	11.4		11.525	11.510	11.536	11.570	11.53525	OK	0.022		
61		CMM		11.5	0.1	0.1	11.6	11.4		11.476	11.558	11.586	11.550	11.5425	OK	0.041		
62		CMM		11.5	0.1	0.1	11.6	11.4		11.530	11.543	11.526	11.530	11.53225	OK	0.006		
63		CMM		11.5	0.1	0.1	11.6	11.4		11.481	11.482	11.492	11.520	11.49375	OK	0.016		
64		CMM		11.5	0.1	0.1	11.6	11.4		11.530	11.524	11.524	11.510	11.522	OK	0.007		
65		CMM		11.5	0.1	0.1	11.6	11.4		11.552	11.524	11.534	11.540	11.5375	OK	0.010		
66		CMM		11.5	0.1	0.1	11.6	11.4		11.563	11.546	11.585	11.570	11.566	OK	0.014		
67		CMM		11.5	0.1	0.1	11.6	11.4		11.536	11.524	11.536	11.530	11.5315	OK	0.005		
68		CMM		11.5	0.1	0.1	11.6	11.4		11.492	11.483	11.468	11.480	11.48075	OK	0.009		
69		CMM		11.5	0.1	0.1	11.6	11.4		11.485	11.524	11.537	11.510	11.514	OK	0.019		
70		CMM		11.5	0.1	0.1	11.6	11.4		11.468	11.475	11.496	11.520	11.48975	OK	0.020		
71		CMM		11.5	0.1	0.1	11.6	11.4		11.523	11.524	11.549	11.530	11.5315	OK	0.010		
72		CMM		11.5	0.1	0.1	11.6	11.4		11.495	11.486	11.520	11.490	11.49775	OK	0.013		
73		CMM		11.5	0.1	0.1	11.6	11.4		11.526	11.514	11.518	11.510	11.517	OK	0.006		
74		CMM		11.5	0.1	0.1	11.6	11.4		11.536	11.524	11.514	11.520	11.5235	OK	0.008		
75		CMM		11.5	0.1	0.1	11.6	11.4		11.524	11.522	11.501	11.540	11.52175	OK	0.014		
76		CMM		11.5	0.1	0.1	11.6	11.4		11.560	11.552	11.542	11.580	11.5585	OK	0.014		
77		CMM		11.5	0.1	0.1	11.6	11.4		11.526	11.514	11.520	11.560	11.53	OK	0.018		
78		CMM		11.5	0.1	0.1	11.6	11.4		11.523	11.563	11.534	11.530	11.5375	OK	0.015		
79		CMM		11.5	0.1	0.1	11.6	11.4		11.528	11.498	11.514	11.490	11.5075	OK	0.015		
80		CMM		11.5	0.1	0.1	11.6	11.4		11.536	11.546	11.528	11.550	11.54	OK	0.009		
81		CMM		11.5	0.1	0.1	11.6	11.4		11.527	11.489	11.492	11.560	11.517	OK	0.029		
82		CMM		11.5	0.1	0.1	11.6	11.4		11.536	11.549	11.528	11.550	11.54075	OK	0.009		
83		CMM		11.5	0.1	0.1	11.6	11.4		11.526	11.514	11.524	11.570	11.5335	OK	0.022		
84		CMM		1.93	0.05	0.05	1.98	1.88		1.951	1.925	1.946	1.950	1.943	OK	0.011		
85		CMM		1.93	0.05	0.05	1.98	1.88		1.946	1.925	1.936	1.930	1.93425	OK	0.008		
86		CMM		1.93	0.05	0.05	1.98	1.88		1.928	1.926	1.945	1.940	1.93475	OK	0.008		
87		CMM		1.93	0.05	0.05	1.98	1.88		1.936	1.945	1.948	1.910	1.93475	OK	0.015		
88		CMM		1.93	0.05	0.05	1.98	1.88		1.926	1.948	1.935	1.900	1.92725	OK	0.018		
89		CMM		1.93	0.05	0.05	1.98	1.88		1.935	1.927	1.924	1.940	1.9315	OK	0.006		
90		CMM		1.93	0.05	0.05	1.98	1.88		1.946	1.925	1.927	1.970	1.942	OK	0.018		
91		CMM		1.93	0.05	0.05	1.98	1.88		1.927	1.936	1.934	1.890	1.92175	OK	0.019		
92		CMM		1.93	0.05	0.05	1.98	1.88		1.908	1.924	1.926	1.910	1.917	OK	0.008		
93		CMM		1.93	0.05	0.05	1.98	1.88		1.932	1.915	1.928	1.930	1.92625	OK	0.007		
94		CMM		1.93	0.05	0.05	1.98	1.88		1.926	1.927	1.924	1.950	1.93175	OK	0.011		
95		CMM		1.93	0.05	0.05	1.98	1.88		1.927	1.964	1.924	1.970	1.94625	OK	0.021		
96		CMM		1.93	0.05	0.05	1.98	1.88		1.941	1.933	1.954	1.950	1.9445	OK	0.008		
97		CMM		1.93	0.05	0.05	1.98	1.88		1.936	1.924	1.928	1.930	1.9295	OK	0.004		
98		CMM		1.93	0.05	0.05	1.98	1.88		1.924	1.928	1.934	1.910	1.924	OK	0.009		
99		CMM		1.93	0.05	0.05	1.98	1.88		1.926	1.931	1.911	1.900	1.917	OK	0.012		
100		CMM		1.93	0.05	0.05	1.98	1.88		1.935	1.946	1.925	1.920	1.9315	OK	0.010		
101		CMM		1.93	0.05	0.05	1.98	1.88		1.925	1.924	1.955	1.940	1.936	OK	0.013		
102		CMM		1.93	0.05	0.05	1.98	1.88		1.927	1.964	1.944	1.960	1.94875	OK	0.015		
103		CMM		1.93	0.05	0.05	1.98	1.88		1.931	1.928	1.927	1.940	1.9315	OK	0.005		
104		CMM		1.93	0.05	0.05	1.98	1.88		1.933	1.944	1.942	1.920	1.93475	OK	0.009		
105		CMM		1.93	0.05	0.05	1.98	1.88		1.924	1.954	1.945	1.950	1.94325	OK	0.012		
106		CMM		2.06	0.05	0.05	2.11	2.01		2.046	2.043	2.041	2.050	2.045	OK	0.003		
107		CMM		2.06	0.05	0.05	2.11	2.01		2.032	2.048	2.048	2.060	2.047	OK	0.010		
108		CMM		2.06	0.05	0.05	2.11	2.01		2.035	2.056	2.045	2.080	2.054	OK	0.017		
109		CMM		2.06	0.05	0.05	2.11	2.01		2.041	2.046	2.047	2.090	2.056	OK	0.020		
110		CMM		2.06	0.05	0.05	2.11	2.01		2.048	2.056	2.057	2.010	2.04275	OK	0.019		

Qisda

Dimension Approval Sheet

Model Name:	QD2181AL-P	**Sample Approval Sheet NO.:**	
Part Name:	REAR COVER	**Material:**	PC+ABS Bayblend FR3010
Part Number:	3J.6G701.B11 **REV:** A0	**Color:**	BLACK
Vendor:	DQ9	**Date:**	2025.09.08

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
111		CMM		2.06	0.05	0.05	2.11	2.01		2.067	2.060	2.058	2.040	2.05625	OK	0.010		
112		CMM		2.06	0.05	0.05	2.11	2.01		2.065	2.068	2.068	2.030	2.05775	OK	0.016		
113		CMM		2.06	0.05	0.05	2.11	2.01		2.051	2.057	2.046	2.070	2.056	OK	0.009		
114		CMM		2.06	0.05	0.05	2.11	2.01		2.046	2.042	2.047	2.080	2.05375	OK	0.015		
115		CMM		2.06	0.05	0.05	2.11	2.01		2.048	2.070	2.038	2.050	2.0515	OK	0.012		
116		CMM		2.06	0.05	0.05	2.11	2.01		2.035	2.047	2.042	2.030	2.0385	OK	0.007		
117		CMM		2.06	0.05	0.05	2.11	2.01		2.063	2.065	2.046	2.020	2.0485	OK	0.018		
118		CMM		2.06	0.05	0.05	2.11	2.01		2.064	2.046	2.068	2.030	2.052	OK	0.015		
119		CMM		2.06	0.05	0.05	2.11	2.01		2.062	2.058	2.041	2.040	2.05025	OK	0.010		
120		CMM		2.06	0.05	0.05	2.11	2.01		2.066	2.051	2.048	2.060	2.05625	OK	0.007		
121		CMM		2.06	0.05	0.05	2.11	2.01		2.068	2.064	2.038	2.050	2.055	OK	0.012		
122		CMM		11.5	0.1	0.1	11.6	11.4		11.521	11.526	11.542	11.510	11.52475	OK	0.012		
123		CMM		11.5	0.1	0.1	11.6	11.4		11.526	11.524	11.547	11.530	11.53175	OK	0.009		
124		CMM		11.5	0.1	0.1	11.6	11.4		11.524	11.534	11.522	11.550	11.5325	OK	0.011		
125		CMM		11.5	0.1	0.1	11.6	11.4		11.574	11.522	11.534	11.570	11.55	OK	0.022		
126		CMM		11.5	0.1	0.1	11.6	11.4		11.534	11.544	11.547	11.590	11.55375	OK	0.021		
127		CMM		11.5	0.1	0.1	11.6	11.4		11.562	11.561	11.526	11.570	11.55475	OK	0.017		
128		CMM		11.5	0.1	0.1	11.6	11.4		11.533	11.510	11.534	11.550	11.53175	OK	0.014		
129		CMM		11.5	0.1	0.1	11.6	11.4		11.543	11.536	11.542	11.530	11.53775	OK	0.005		
130		CMM		11.5	0.1	0.1	11.6	11.4		11.535	11.526	11.547	11.510	11.5295	OK	0.014		
131		CMM		11.5	0.1	0.1	11.6	11.4		11.527	11.558	11.536	11.490	11.52775	OK	0.025		
132		CMM		11.5	0.1	0.1	11.6	11.4		11.534	11.546	11.524	11.470	11.5185	OK	0.029		
133		CMM		11.5	0.1	0.1	11.6	11.4		11.536	11.575	11.542	11.450	11.52575	OK	0.046		
134		CMM		11.5	0.1	0.1	11.6	11.4		11.563	11.586	11.574	11.470	11.54825	OK	0.046		
135		CMM		11.5	0.1	0.1	11.6	11.4		11.546	11.554	11.553	11.490	11.53575	OK	0.027		
136		CMM		11.5	0.1	0.1	11.6	11.4		11.558	11.596	11.574	11.510	11.5595	OK	0.032		
137		CMM		11.5	0.1	0.1	11.6	11.4		11.530	11.580	11.570	11.520	11.55	OK	0.025		
138		CMM		3.5	0.05	0.05	3.55	3.45		3.520	3.510	3.530	3.470	3.5075	OK	0.023		
139		CMM		1.09	0.05	0.05	1.14	1.04		1.080	1.120	1.140	1.120	1.115	OK	0.022		

Initiator:Guofeng Zhang Reviewed by :Carlos Q Chen Approve by: PDVA/Owen Chiang(2025/9/17)

SA成型条件表

成型厂	DQ9	模具厂	VST0	机台类型	电动	螺杆直径	80	版本：	A
机种	QD2181AL-P	料号	3J.6G701.B11	品名	后壳	机台吨位	650T	机台编号	D12
模号	QI250102	原料型号	PC+ABS	原料颜色	BLACK	模具类型	热流道	成型日期	2025/7/9

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(℃)	265	265	255	245	235			
模温(℃)	设定	A	B	C	D			
公模	机水	滑块50						
母模	65度							
温控箱温度设定								

成品重量	678G	料头重量	0G
模穴数	1穴		

时序设定		1	2	3	4	5	6	7	8	9
	闭	1.85	2	1.85	1.8	0.25	1.8	0.85	0	1.8
	开	2.5	2.5	2.5	4	4	4	1.5	3.8	1.5

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

时 间 压 力 速 度 设 定

锁模压力	6100T

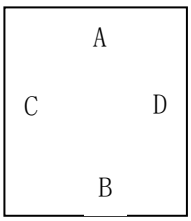
射 出	一段	二段	三段	四段	五段	六段
压 力	185	2.3				
速 度	45	50	85	75	45	10
射出位置	150	145	130	60	45	

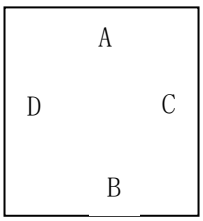
切换方式	位置			保压切换	50
保 压	一段	二段	三段	四段	射出时间	6S
保压压力	50	60		55	冷却时间	30S
保压时间	1.5	2			成型周期	65S

背压/射终	12/14.15	计量/松退	150/3.5
是否全自动	□是 □否		

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.B11
Qisda Item description	RC BLACK QD2181AI-P
Maker	Qisda Molding Factory
Maker P/N	3J.6G701.B11
Create date	2025/09/23

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	航躍	Plastic Resin of Housing	FR3010HF 901510	航躍	黑色塑胶颗粒	航躍是Covestro(科思创)代理商	QHJ2403038802/CH;QHJ2403038801/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	