

**Product Classification (as customary)****Size Range(mm)****1**

## Axial fans blade mold:

1. Household appliance mold
  - 1) Blower shaft flow wheel  $\varnothing 20-150 \times H$
  - 2) Air conditioner axial flow wheel  $\varnothing 200-600 H$
  - 3) Range hood axial flow wheel  $\varnothing 200-400 H$
  - 4) Other axial flow wheel  $\varnothing 50-1000 H$
2. Automobile axial flow wheel mold
  - 1) Household automobile radiator axial flow wheel  $\varnothing 40-1000 H$
  - 2) Heavy truck axial flow wheel  $\varnothing 450-1000 H$

**2**

## Centrifugal impeller mold

1. Single head centrifugal blade mold
  - 1) Air purifier single head centrifugal impeller  $\varnothing 50-350 \times H$
  - 2) Air filler single head centrifugal impeller  $\varnothing 50-350 \times H$
  - 3) Auto air conditioner single head centrifugal impeller  $\varnothing 150-400 \times H$
  - 4) Cabinet air conditioner single-head centrifugal impeller  $\varnothing 200-500 \times H$
2. Double head centrifugal wind wheel mold
  - 1) Air conditioner double head centrifugal impeller  $\varnothing 120-350 \times H$
  - 2) Fan coil double head centrifugal impeller  $\varnothing 120-350 \times H$
  - 3) Air purifier double head centrifugal impeller  $\varnothing 120-300 \times H$
  - 4) Dryer double head centrifugal impeller  $\varnothing 120-300 \times H$

**3**

## Vortex wind turbine mold

1. Forward-leaning vortex wind turbine mold
  - 1) Water pump wind wheel  $\varnothing 20-200 \times H$
  - 2) Refrigerator cooling wind wheel  $\varnothing 20-350 \times H$
  - 3) TV cooling wind wheel  $\varnothing 25-300 \times H$
2. Back-leaning vortex wind turbine mold
  - 1) With motor heat dissipation system  $\varnothing 100-500 \times H$
  - 2) Huawei base station heat dissipation system  $\varnothing 100-400 \times H$
  - 3) Ventilation duct system  $\varnothing 100-700 \times H$
  - 4) Wind curtain wall system  $\varnothing 100-700 \times H$
  - 5) Tunnel ventilation system  $\varnothing 100-1000 \times H$

# 4 tubular fan blade mould

1. Hanging air conditioning impeller Ø 96/98/102/106/108/90. 4/92
2. The vertical air conditioning impeller Ø 96/98/102/106/108/90. 4/92
3. The wind curtain machine impeller Ø 96/98/102/106/108/90. 4/92

QC standard by Tianyi Mould

Performance 性能	fan diameter 叶片直径	value 数量
Run out measurement 跳动	≤200mm	≤0.15mm
	200-500mm	≤0.2-0.5mm
	500--1000mm	≤0.4--0.7mm
	≥1000mm	≤0.7mm-1mm
Tolerance of the center of circle move 偏心误差		≤0.02mm
the data of dynamic balance 动平衡	fan weight 重量	gram/gram 克/克
	≤0.5kg	1/3000---1/4000
	0.5----1kg	1/2000---1/3000
	≥1kg	1/1500---1/2500
Calculation of machining dimensions 加工尺寸计算	According Material forming shrinkage rate to calculate the precise dimensions on machining to follow above data 根据所用材料收缩比精确计算加工尺寸使成品符合上述指标	