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Stefan Fritsche

YIZUMI Speeds up Die Casting Technology Development under Global Pandemic Hit

YIZUMI

YIZUMI Thixomolding Machines are now welcomed in China, Germany and American Market

RUNXINGTAI

RUNXINGTAI A Bright Future: DM4000H Die Cast Cell + Rheocasting Technology Combination



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YIZUMI Speeds up Die Casting Technology Development under Global Pandemic Hit

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YIMES: Begin the Digital Transformation Journey

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TAIRISHENG: YIZUMI DM4000HA Die-Casting Production Line for 5G Filter Housings successfully put into operation

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Embrace the Intelligent Manufacturing Era after the Pandemic

In 2020, an unexpected pandemic reflected the current dilemma and future of Chinese manufacturing industry.

Traditional manufacturers who highly rely on manpower are facing crisis. On the other hand, enterprises with higher level of automation manufacturing technology, were resuming production quickly. Thanks to the data management, which decreases enterprises' dependency on people, and guarantees their competitiveness to the full extent.

The outbreak of pandemic also exposes some defects for SMEs who do not have high level of manufacturing system. It also reminds more enterprises and industries the importance of automation, digitization, and intelligent transformation.

In addition, the epidemic prevention and control situation is now witnessing positive changes, and China seems to be well on track to recovery of the economy. However, it still takes time to reach full recovery, the situation that enterprises have to face in short term is complicated and severe. The first step for SEMs is to get through the difficult time relying on public subsidies, but for further development, they should take advantage of automation and internet technologies, to improve digitalization level in order to strengthen risk resistance capacity.

YIZUMI has accumulated years of experience in automation and Industry Internet field. YIZUMI not only could provide a full set of robotic automation system, which is able to reduce labor cost and improve production efficiency for die casting industry, but also fulfill the needs of enterprises to develop digitalization and intelligence. Based on Yi-CMS system and YiMES intelligent manufacturing execution system, Yi+ platform (YIZUMI Intelligent Equipment Industry Internet Platform), able to realize real-time monitoring, production plan optimization, production management, product tracing and other functions.

As an enterprise deeply exploring in die casting field, YIZUMI knows better about the industry's demands and compassion. This pandemic is a big challenge for production and management. YIZUMI is committed to provide customers higher cost-effective automation and digital solutions, to assist enterprises with improvement of quality, cost reduction, increase of productivity, and finally acquire competitive advantages.

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With our goal to become a leader in our field we do need to understand how to further develop our products, services and solutions on our own.

+ /

Stefan Fritsche

Yizumi CSO (Die Casting & Metal Forming)



YIZUMI Speeds up Die Casting Technology Development under Global Pandemic Hit

In 2020, the global spread of the COVID-19 pandemic has sent the world economy into severe recession, automobile, cellphone, aerospace, and other industries have been suffering heavy losses. There is still great uncertainty in the market. Facing difficulties, how does YIZUMI move forward in this adversity?

Stefan Fritsche, YIZUMI CSO for die casting & metal forming said YIZUMI will use the current, difficult times to prepare well for the next growth period, “Our aspiration at YIZUMI die casting will not be changed by the current situation. We do focus on providing our customers worldwide with die casting solutions of high productivity at fair prices allowing our customers to achieve the best return on investment.”

European Die Casting Industry revenue is expected to drop considerably

The automotive industry is one of the most important customers for the die casting industry worldwide. Therefore, the condition of the automotive industry is highly relevant to gauge the health of the die casting industry in these challenging times. Based on various forecast we have to expect that the global automotive sales volume for 2020 will have a large year-on-year decline, among which the decline of the US and European markets will be greater than that of the Chinese market. Therefore, the order intake of die casting machine producers worldwide is certainly significantly reduced. Mr. Fritsche said:

“My discussions with managers in the European die casting industry confirm above situation as these managers do expect their revenue in 2020 will greatly decrease than 2019.”

According to Fritsche’s assumption, the global die casting machine order will dramatically decrease, and the current 2020 order book of die casting machine manufacturers in Europe and North America will sharply fall compared to the previous year.

Fritsche said “If markets pick-up towards the end of 2020 the order intake situation might improve, however there is still great uncertainty to establish any meaningful forecast at this time.”

It is encouraging to see that China seems to be well on track to recovery of the economy. In June, the automotive sales year on year grew by about 11.6% based on preliminary data released by China Association of Automobile Manufacturers (CAAM). Europe is in the middle of easing the lockdown, automotive manufacturers have been back to resuming production. Fritsche said “I think the first signs are positive. If a recovery sets in, confidence will return and that would certainly also increase demand.”



Preparing for the Next Growth Period

Although the die casting industry has slowed down because of the pandemic, in China industries such as 5G, lightweight and new energy vehicles are growing and investments in these areas are realized.

As a die casting machine- and automation solution provider, YIZUMI is at this time focusing on preparing for the next growth period. YIZUMI's goal is to aggressively improve its highly cost-efficient die casting solutions further to provide our customers with highest OEE's at fair investment costs.

An example is the new YIZUMI D-Speed 350 High Speed Die-Casting machine introduced this year which is focusing to provide highest production efficiencies for ultra-thin-walled aluminum alloy die castings as used for 5G mobile phone mid-boards demanding highest dimensional quality requirements.

In addition, YIZUMI invested heavily in upgrading its manufacturing plant for heavy-duty large die casting machines to cope with the strong growth in 5G base station component manufacturing. This investment was completed and doubles the manufacturing capacity of large die casting machines.

Fritsche explained that "China is the leader in 5G technology. This ensures that there is still growth in the market for die casting machines above 3000t of locking force. So, there are still great opportunities for our domestic team in this growing market segment."

Speed up Die Casting Technology Development

In order to provide our customers with ever better solutions and technology, YIZUMI invested in building a die casting Product and Process Application Center (PPAC). This technology center featuring a fully automatic 3000t die casting cell allows the YIZUMI technology team to develop crucial die casting process knowhow which will result in improving our die casting equipment design and its technological performance. The PPAC also offers a great platform to do casting trials for our customers as well as providing die sampling. Our mutually beneficial cooperation with Guangzhou Die & Mold generates additional knowhow for YIZUMI in the area of tooling and die design. Future projects include customer training courses in die casting process optimizations as well as training in tooling design.

The PPAC facilitates a "technology learning process" assisting our engineers to further understand die casting technology from the

customers' perspective. This extends our knowledge base to further optimize the design of our die casting equipment and automation solutions for our customers.

"It is our aim to helping customers to achieve a better Overall Equipment Effectiveness (OEE) on their use of our equipment in order to be highly competitive in the market" Fritsche said.

Our PPAC has been received well by our customer base and has led to interesting discussions about future technology projects.

As for the tech center's future operation, Fritsche firmly expressed that: "With our goal to become a leader in our field we do need to understand how to further develop our products, services and solutions on our own. So, the goal is to establish a strong skill set in our organization. To execute well we do need to start however in training our teams to a high knowhow level. Only with highly trained specialists will we be able to provide crucial support to our customers making a difference between our competitors and us."



Connecting technology between China and Europe, YIZUMI Thixomolding Machines are now welcomed in China, Germany and American Market

After successfully production performance test on first unit of YIZUMI 1250T Thixomolding Magnesium machine at HETTICH Germany. HETTICH had confirmed purchased additional two more units of UN1250MGII to integrate into their production facilities. At the same time, customers in China, Germany and America had also show great interest with application of YIZUMI Thixomolding machines for production of large lightweight design components.

Sui Tiejun, Product's Manager responsible for YIZUMI Thixomolding project, comments that: "YIZUMI Thixomolding machine had consolidating the technologies within Germany and China. Level of Technologies for YIZUMI's Thixomolding machine has been improved. We are confident its performance has reached the state of art Thixomolding Technologies.

Long-term Strategic Collaboration Partnership with Customers

Components could be lighter, larger and

more precise with application of Thixomolding technology, which comply to the HETTICH's investment philosophy with environmental and conserve resources as well. HETTICH is now confidence and confirmed to establish strategy partnership with YIZUMI. Follow by purchased additional two more units of UN1250MGII. Second unit of UN1250MGII has arrived to HETTICH so far.

Jointly development by YIZUMI China Headquarter and YIZUMI Germany R & D Center, UN1250MGII with a large shot weight model, adopts the advantaged European hot drop technology. This not only result with increase of shot weight dramatically, but also improves the filling behavior and the overall part quality.

Sui Tiejun expressed that: "We hope we could assist to solve the problems of having only one supplier for the customers, reduce their cost of investment, and ensure every customer result with quick and successful return of investment."

With understanding of the Philosophy & Strategy of YIZUMI Thixomolding technology,

Molded Magnesium Products, LLC. an American company, which main business includes magnesium light weight parts for automotive, aerospace, electronics, LED Lighting and medical care, are now also established as strategic partner with YIZUMI and confirmed purchase of one unit UN1250MGII machine recently.



Mr. Philipp Ochotta with Chinese Thixomolding team member (Back ground with YIZUMI UN1250MGII Thixomolding machine).



Chinese customer Wuxi LANGSHION Lightweight Technology Co., Ltd., a well-established leader in lightweight metal design had purchased 1 unit of UN650MGII. At present, several performance tests have been arranged, performance of machine has passed through the acceptance test, now is in process of steady production. Sui introduced that LANGSHION is one of the strategic partners with YIZUMI in both die casting and Thixomolding technology. By introducing larger injection screw, shot weight and product's quality has been improved. UN650MGII obtains positive feedback from the customers.

Next, during the recent 2020 CHINA DIECASTING fair in July, Taishan China Magnesium Technology Co., Ltd. signed up a contract with YIZUMI on site, confirm purchased two units of Thixomolding machines model UN650MGII & UN1250MGII. These machines, are planned to produce structural parts for drone, moving parts for bicycle, and prepared for the large-scale drone structural parts as well as new energy vehicle industry.

In addition to manufacturing enterprises, R&D institutes are also YIZUMI's important strategic partners. Located in University of Kassel, Germany, the lightweight foundries technology and project engineering center GTK has been keeping close cooperation

with YIZUMI. One unit of UN1250MGII will arrive at GTK in September 2020.

By collaborating with GTK, YIZUMI can further present its Thixomolding technology to European and global customers, "It will be the best show case. Besides, GTK is going to conduct many physical function and performance test on the machine, this will further improve level of technology of YIZUMI equipment." Sui Tiejun said.

Customers with Quick Return of Investment

By collaboration with continuous technology development with Chinese, German and American customers, YIZUMI is confident the level of Thixomolding technology were achieved the international standard. Philipp Ochotta, Product Manager of lightweight and multi-component manufacturing system in YIZUMI Germany admitted: "We would like to take the technological lead in the field of Thixomolding."

Considering of lightweight design trend in European automotive market, Philipp Ochotta believes the demand of Thixomolding technology will grow steadily. "Thixomolding processes make it possible to produce components with high dimensional stability, high functional

integration and low post-processing requirements. This lowers the total component costs." At the same time, there is also a desire to produce components, which were previously made up of several parts as assemblies, as a single piece. For this purpose, shot weights must be processed which could not be provided so far."

As for the equipment development plan, Sui Tiejun said besides the present UN650MGII & UN1250MGII, YIZUMI will further develop the next incoming model UN300MGII and UN2000MGII. "We will continuously develop and complete product lines of Thixomolding machine and improve the technology, such as increasing capacity of machine, introducing multiple gate hot runner system, IMKS New Injection unit and other Thixomolding technologies."

With the continuous development & improvement of product line and upgrading of technology. YIZUMI are committed to ensure customers with quick return on investment. The reasonable low cost of investment. "YIZUMI is ready to work with global customers. YIZUMI is ready to establish Strategy collaboration partnership with customers. Let us work together and look forward to achieve the best success." Sui Tiejun said.



Philipp Ochotta

Product Manager of lightweight and multi-component manufacturing system, Germany Yizumi

“Yizumi Hot Drop Technology is Widely Applied by the Customers”

DIE CASTING Magazine: After more than a year's production of UN1250MGII machines, how has the German company HETTICH been using it so far?

Philipp Ochotta: Because of an increased demand for complex-shaped light weighted parts by their own customers, HETTICH used the UN1250MGII machine for producing several mini series of prototypes. By now, the machine shows a stable and reliable production behavior. Despite that, HETTICH provided us a few minor suggestions during the process. However, through continuous and good communication between HETTICH and our employees in Germany and China, we have been able to eliminate almost all difficulties to date.

DIE CASTING Magazine: What kind of products does UN1250MGII produce for HETTICH?

Philipp Ochotta: For reasons of confidentiality, I must not be too specific at this point. But, as much as I can reveal, products cover automotive and urban mobility (electric scooter). These include components with large aspect ratios, low wall thicknesses components with very complex and filigree geometries, as well as components that place high demands on dimensional accuracy. This is where the strengths of thixomolding become particularly apparent, as designs can be realized that are not possible with conventional die casting.

DIE CASTING Magazine: Does HETTICH have new requirements on UN1250MGII machines so far? And how does YIZUMI satisfy their new needs?

Philipp Ochotta: The complex parts that HETTICH is producing are setting high demands on the gating behaviour and the shot weights to be realized. I'm very happy to announce that HETTICH is using our YIZUMI hot drop technology to equip nearly all of their molds with a hot sprue system. The hot sprue is directly installed into the mold and works as an extension of the machine nozzle.

The semi-solid material can be directly injected into the parting plane of the cavity. This not only reduces the shot weight dramatically due to a smaller gating system, but also improves the filling behaviour and the overall part quality.

Besides that, HETTICH requests high standards on operator's safety and user friendliness on all of their machinery and equipment. Thanks to their valuable suggestions, we have already been able to significantly improve the control system software. We were also able to modify safety equipment from our YIZUMI injection molding machines, like e.g. a safety footboard for the mold area of the DP series, so it can be used in the rough foundry environment as well. This example shows one of the big advantages of YIZUMI and its diverse machine portfolio: We can take already proven technologies from a machine series and use them in novel application scenarios.

DIE CASTING Magazine: As one of the persons in charge of Yizumi thixomolding technology, could you share the future product development plans?

Philipp Ochotta: We would like to take the technological lead in the field of thixomolding. To this end, we will greatly expand our machine portfolio and establish a whole series of machines. This will include machines with smaller shot weights and clamping forces for the electrical industry as well as particularly large machines with wide tie bar spacing for the production of automotive parts with shot weights of more than 4 kg.

We will continue to develop our Hot Drop technology decisively and thus enable completely new component designs and also take a close look at the melting behaviour of the magnesium in the screw. From this we will derive new screw designs and improve the dosing capacity and filling capacity.



YiMES: Begin the Digital Transformation Journey

In today's manufacturing industry, most enterprises have established their own standardized, process-based production methods. But the real dilemma before us is the rising costs with production efficiency approaching a "ceiling." Traditional, optimized production methods become increasingly inadequate to fulfill the ever-rising expectations of the market.

In the face of these challenges, the transformation toward digitalization is imminent for the enterprises world-wide. YIZUMI has launched the YiMES intelligent manufacturing execution system designed specially for the small and medium-sized enterprises in the field of injection molding, die casting and rubber molding, aiming to remove data silos, place the entire production process under control, and provide customers with digital factory solutions.

Full-process, Multi-level Digital Factory Solutions

What is the need for digital transformation in molding and casting enterprises?

Take one of Yizumi's customers as an example, after years of development, they now own more than 40 machines. The company has strict quality control requirements and strives for production management excellence. Their products are well recognized by international buyers. However, with the continuous growth of its business, bottlenecks in production management start to surface.

The difficulties on scheduling, capacity statistics, efficiency statistics and other analysis requirements have increased significantly. It is challenging for the management to further improve operational productivity. In the words of Jianwen Niu, Director of the Intelligent Interconnection Department of YIZUMI: "enterprises need new management tools and methods that allow to further enable the organization through information technology and data-based measures".

To tackle problems encountered by customers in the development of their organizational effectiveness, YIZUMI's YiMES intelligent manufacturing execution system integrates IoT, Cloud, Big Data, AI, and other new generation ICT technologies to various professional tools, including order management, production management, quality management, process management,

production monitoring, energy consumption management, and mold management that fulfills the needs of small to medium sized enterprises in their digital and intelligent development.

By offering a full range of services, including PO fulfillment, pre-production preparation, output monitoring, defect detection, finished goods warehousing, and other processes, YiMES system helps you to achieve a high level of production control throughout the entire process. It enables you to have standards before production, control during production, and product tracing after production to prevent and remove defect products.

Upon the implementation of the YiMES intelligent manufacturing execution system in 2018, the above mentioned Yizumi customer



achieved 100% product quality tracing and 100% PO progress system management after a short period of time. The efficiency of equipment increased by more than 10%.

YiMES system is developed to meet different needs of users at different levels. For instance, workshop operators can perform easy and simple operations via PC or mobile phones while production directors and supervisors are able to perform real-time monitoring over scheduling and production progress, machine status, establish efficiency statistics and analysis as well as carry out pre-production preparation for the complete value stream. At higher level, the management can manage the work floor through timely, transparent and data-based reports.

"YiMES provides customers with a full-process and multi-level professional solution for digital factory, helping customers to manage their pain points, improve quality, reduce cost, and increase productivity." said Jianwen Niu.

Intelligent Process Management

Unlike traditional MES systems, the YIZUMI YiMES intelligent manufacturing execution system is developed based on the Yi+ platform (YIZUMI Intelligent Equipment Industry Internet Platform). It also support die casting cell integration with standardized communication protocols between die casting machine and peripherals. Cloud management of all devices further reduces customers' costs on implementation, operation and maintenance activities.

Data collection has always been a headache for the injection molding enterprises. With a wide variety of product types and equipment brands, the amount of production parameters available is humongous. This makes data collection and analysis particularly difficult. As a platform specialized in injection- and rubber molding as well as die casting processes, YIZUMI's Yi+ has its unique advantages. Its Yi-CMS system can pick up parameters, overlying pressures, temperature, speed, time, and position of each molding cycle. Besides its benefits in improving injection molding processes, Yi-CMS may be applied to die casting as well as rubber injection molding processes. According to Jianwen Niu, "The data collected is comprehensive. We understand what each parameter represents," and more importantly, how to use these data after collection.

"The relationship between the process parameter of each mold opening/closing and the product yield will be the base for YiMES to optimize the process in the future." As Niu Jianwen said, with the collection of three years worth of data on each mold opening and closing, YiMES can calculate which parameter set will achieve the best yield possible. These parameters will then be recommended to customers. It not only will help the customers to improve their production yield, but also to avoid machine downtime in case there is no machine adjustment specialist available at the site.

Launched in 2018, YIZUMI's YiMES intelligent manufacturing execution system has significantly reduced the cost of digital transformation through its cloud-based services and created great excitement in the market. It has now been used in the fields of electrical equipment, 3C, 5G, automobile, packaging, and home appliances, providing customers with cost-effective digital plant solutions.

"After the pandemic, enterprises' demand for data management will be even greater"

DIE CASTING Magazine: Currently, what is the demand for YiMES system among customers?

Jianwen Niu: The fundamental purpose of the customer is to better operate their business and to make higher quality and increase cost-efficiency. That traditional business management approaches (standardized management, lean management, business processes, PO management, etc.) are quite mature by now. The next step towards a higher level of profitability requires data analysis to find out the capacity constraints to overcome and improve.

The focus is still on QDCP (Quality, Delivery, Cost, and Productivity). So, what does YiMES system have to offer? To improve the profitability, we must first have the data and find out the constraints that limit the operational performance and the causes that lead to low equipment utilization or low production yield. Transparent production and process data aggregated in a meaningful way will allow the management team to correct the shortcomings and enhance the profitability.

It is all about the basic logic. And YiMES system is one of the tools that can help enterprises to achieve the goal.

DIE CASTING Magazine: With many MES system products now available in China, what value advantages does YIZUMI's YiMES system offer that make it stand out?

Jianwen Niu: Our uniqueness is that our system is an ideal choice for small and medium sized enterprises. Previously, it easily costs you tens of millions of yuan to implement a MES system. The system is often complex, requires an IT team, and is available for key professional users only. In comparison, YiMES system offers the advantages such as low investment cost, user friendly features, simple operation, and convenience. It's basically a tool for everyone.

DIE CASTING Magazine: What advice do you have for customers who encounter challenges in the implementation of YiMES system?

Jianwen Niu: This is a new management tool. You might feel inconvenient at the beginning. However, the traditional management measures have done many improvements and are now reaching their limit. Informatization is the only way forward. In case that the current management system is not so satisfactory, YiMES system is your chance to build up your organizational system. It is also one of the means that support the globalization of enterprise operations and development.

DIE CASTING Magazine: Under the COVID-19 pandemic, how is customer demand in information and data management?

Jianwen Niu: The demand is greater than ever. After the pandemic, many customers realize the convenience of data management. When a customer has factories located in more than one city, the owner cannot run around all the time. The feedback therefore is either delayed or misinterpreted. An information system can help to solve many of these problems.

In response to the pandemic, many industries have to make changes, such as offering take-away food and allowing work from home. In the future, the equipment maintenance personnel or production management personnel in the injection molding, casting and rubber industries may also solve problems via remote collaboration without the need to be on site. For this purpose we are developing an AR online expert tool that allows our technical experts to guide the customer's field personnel through video chat and walk them through the troubleshooting or adjusting machine parameters, helping customers to solve problems in the shortest possible time, resume production, and reduce the travel costs.



Jianwen Niu
Director of Intelligent Interconnection Department of Yizumi



TAIRISHENG: YIZUMI DM4000HA Die-Casting Production Line for 5G Filter Housings successfully put into operation

TAIRISHENG: Recently, Dongguan TAIRISHENG Technology Co., Ltd. (hereinafter referred to as "TAIRISHENG") successfully put a YIZUMI DM4000HA die-casting production line into operation to manufacture filter housings for ZTE 5G base stations.

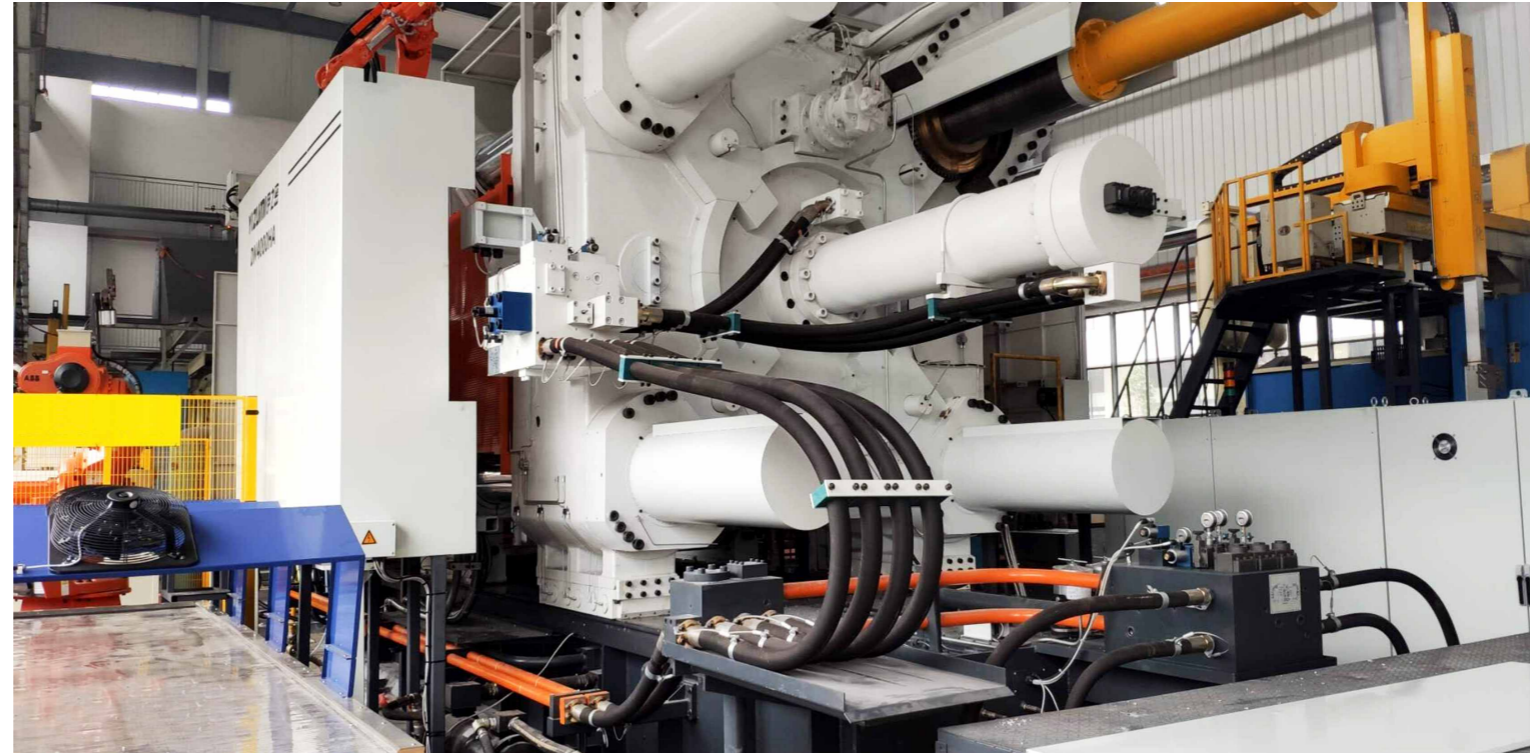
TAIRISHENG is a state-owned enterprise affiliated with CECIS, a subsidiary enterprise of China Electronics Corporation Group (CEC) which specializes in the manufacturing of precise equipment and hardware for communication, electronics, medical, aerospace, automobile, and railway braking systems and other business fields.

Believing in YIZUMI's strong industry reputation and considering the high-quality requirements of the structural parts used in 5G base station, TAIRISHENG entrusted YIZUMI with its order for a 4000T die casting cell in 2019. In January 2020, YIZUMI's HA series 4000T die-casting machine was installed at TAIRISHENG and realized regular production in March. The yield rate of this 5G base station filter housing production has exceeded 97%, and its productivity has reached Company's goal. In its newest version, these 5G base station housings feature larger dimensions with a more complex geometry and unavoidable uneven wall thicknesses. Quality requirements for these components include highest part integrity with high density and no shrinkage porosity to facilitate good thermal

conductivity. Due to after-casting-operations of machining, very restrictive tolerances are applied regarding porosity across the part. Besides a high-quality die design, it is crucial that the injection process avoids any air entrapment in the metal.

The chosen YIZUMI DM4000HA die casting machine, equipped with the 5th generation real-time closed loop shot control system, is well suited to ensure highest injection precision and repeatability needed for such large structural die casting components:

- Optimized and smooth plunger movement in the pre-filling phase with constant acceleration which effectively reduces air entrapment in the metal.
- YIZUMI's ARC real time closed loop shot control ensures a highly precise and repeatable injection process resulting in highest process consistency.
- The improved acceleration of the filling speed and the shortened pressure build-up time ensure a precise cavity filling and highest compensation of metal shrinkage during solidification.
- The ARC system allows breaking of the injection speed shortly before the end of the cavity filling to protect the die from unnecessary metal pressure impact and reduces flash build up.



Applying vacuum, integrated in the YIZUMI DM4000HA die-casting cell, air in the cavity is efficiently evacuated further minimizing gas porosity and allowing to heat treat the castings after casting.

With the advantages mentioned above, YIZUMI's DM4000HA die-casting machine realizes highest consistency and stability for the injection process. The machine's outstanding performance is well recognized by TAIRISHENG. According to the relevant person in charge, YIZUMI DM4000HA die-

casting machine is the largest tonnage die-casting equipment currently in operation at TAIRISHENG. The machine demonstrates excellent performance in process stability and is easy to operate. This results in very few production interruptions which, combined with the low reject rate leads to an attractive OEE for TAIRISHENG. This reliable casting production allows TAIRISHENG to guarantee "on-time" delivery even with a very tight order schedule.



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4000T

RUNXINGTAI: A Bright Future: DM4000H Die Cast Cell + Rheocasting Technology Combination

Production of heat-sinks for 5G base station with a weight of 25kg, cooling fin height of 130mm, fin top thickness of 1.0mm, and a draft angle of 1.0°

Since its commercialization, 5G technology has been growing strongly. The 5G technology advantages have been given a full play during the pandemic. Applications such as 5G infrared temperature detection devices, 5G robots, 5G video networking, etc. are widely used in pandemic prevention and control efforts as well as the resumption of production.

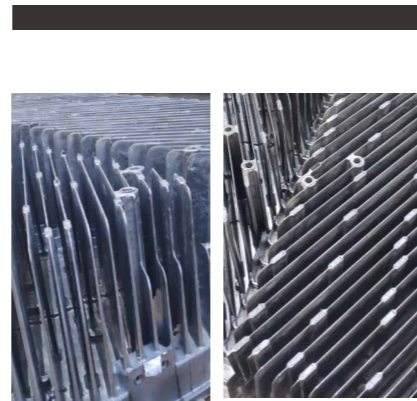
As one of the major suppliers of communication base stations in China, Zhuhai Runxingtai Electrical Equipment Co., Ltd ("RUNXINGTAI") has also joined the 5G race. With a full order book for structural parts of base stations, the factory is running around the clock. The DM4000H fully automatic die casting cell recently purchased from YIZUMI was successfully put into operation for continuous production reaching an output of 638 pieces/shift.

Production of heat-sinks for 5G Base Station using Rheocasting Technology

In the field of die-casting, RUNXINGTAI is specialized in Rheocasting technology. Since 2014, the company dedicated research & development resources with the aim of applying Rheocasting casting technology to their 4G wireless base station production. These efforts which included suppliers, universities as well as other research institutions and of course its customers, have paid off. RUNXINGTAI has become a domestic leader in the application of Rheocasting to the die casting process and now owns relevant key technology and intellectual property rights.

Rheocasting technology providing the alloy with thixotropic behavior is well suited to cast large, thin-walled lightweight castings with complex structures and offers great advantages in dimensional accuracy, short processing times and thus is also very energy efficient. The net shape casting capability also allows a material saving overall process. Today, RUNXINGTAI owns 15 Rheocasting production lines with an annual output of 3.5 million pieces, ranked first in the industry.

Driven by the strong growth of 5G technology, RUNXINGTAI engaged in a strategic cooperation with ZTE and successfully developed the manufacturing process for large, thin-walled aluminum alloy housings for 5G base stations. Last year, the company introduced a YIZUMI DM 4000 H fully automated die-casting cell and started to produce the 5G base station structural parts using Rheocasting technology. The technical specifications of this wireless base station heat-sink are impressive: Weight 25kg, Cooling fin height of 130mm, fin thickness at the top of 1.0mm all with a single side draft angle of only 1.0°.



■ 5G base station heat-sink with cooling fin height of 130mm



YIZUMI DM4000H Automated Die-Casting Cell - Production yield over 96%

In order to increase heat dissipation, the height of cooling fins on 5G base station housing continue to increase while the casting wall thicknesses become ever thinner. This improves the functionality of the component, but it makes the overall structure of the housings more complex. Combined with a development of increasingly larger part designs, the level of casting difficulty continuously rises.

Aiming at achieving a highly efficient casting production line, the technical teams from RUNXINGTAI and YIZUMI cooperated closely to set up a fully automatic die casting cell around a DM4000H YIZUMI die casting machine in September 2019. This modern automatic die-casting cell is equipped with robot extraction, automatic die spray, part air cooling installation, traceability marking, trimming operation as well as other equipment providing RUNXINGTAI with an easy to use die casting solution offering great equipment availability.

YIZUMI's DM4000H die-casting machine offers an actual injection speed up to 8.5m/s which, coupled with its high PQ injection capacity, is the perfect equipment for the casting of large, thin walled components such as heat sinks with tall cooling fins. The comprehensive process monitoring system also includes precise real-time clamping force monitoring able to detect any clamping force deviation immediately. The use of a 6-

axis robot spraying system ensures effective cleaning of the intricate cavity geometry before applying release agent with highest consistency.

Starting in late October of last year, the DM4000H automated die-casting cell has been running 24/7. It had almost no interruption even during the Spring Festival and the outbreak of the pandemic and so helped to avoid any supply chain interruptions during these challenging times. With renewed confidence in the market now, more orders pour in and the machine is kept running. The production capacity reached up to 638 pieces / 20 hours with a yield of over 96%.

RUANXINGTAI acknowledged the great performance of the YIZUMI team and the equipment delivered in their thank-you letter on 20th June. In this letter, RUANXINGTAI expressed: "Facing the difficulties of a tight delivery schedule requiring a short equipment delivery time, YIZUMI assigned specialists to support and guarantee the commissioning and startup of the DM 4000 H die casting cell. The team successfully fulfilled the manufacturing tasks at hand resulting in casting the number of parts as planned in the required target quality. Your technicians and service staff sacrificed their spare time and supported production overtime in our company, making great contributions to our production performance. In a short time the production efficiency was increased by 51.9% from 420pcs/20H to 638pcs/20h, which facilitated delivery on time."



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FAST: Expansion of 5G Mobile Phone Mid-frame capacity

Spanning across from magnesium alloy to aluminum alloy mid-frame, FAST continues to work hand in hand with YIZUMI.

Since its inception in 2014, Dongguan Fast Precision Hardware Co., Ltd. is the research, development and production center of Fast Precision Technology Co., Ltd. Covering a total of land area of 50,000 square meters, it is primarily engaged in the research, development and production of precision die-casting structural parts made of aluminum alloy, magnesium alloy, zinc alloy and other materials. These products are used in smart phones, laptops, smart homes and more.

After several years of rapid growth, FAST has built comprehensive technical capabilities that comprise of die design, die-casting manufacturing as well as after casting processes such as surface treatment, quality testing and so on. In the investment of die-casting equipment, FAST has always been maintaining a close cooperation with YIZUMI, aligning itself with the use of nearly 50 YIZUMI die casting solutions such as hot chamber magnesium die-casting machines and cold chamber die-casting machines (300-ton and 400-ton) for the production of 4G and 5G mobile phone mid-frames.

Accelerating the progress of 5G mobile phone mid-frame

Thanks to a detailed in-depth understanding of the latest development trends in the market, the precision die-casting structural parts produced by FAST have reached overseas markets as far as the U.S., Europe, South East Asia and other countries and regions. Its clientele includes Foxconn, Huawei, Lenovo, Xiaomi, BYD and other

internationally renowned enterprises, as well as the world's largest IOT company, Amazon, the world's largest POS manufacturer, Verifone and other Fortune Global 500 companies.

In recent years, FAST has been following the development trends of 5G mobile phones closely and continuously expands its research and development of die-casting molding solutions for new products. As a result, the orders have been gradually on an upward trend.

Sun Lianhe, General Manager of Fast Precision Hardware Co., Ltd., said that the 5G mobile phones are increasingly trending towards a larger display screen. It is now more appropriate to use a 400-ton die-casting machine for mobile phone mid-frame. FAST plans to invest more in this type of equipment in its next steps.



Mobile Phone Mid-frame



Special inspection service of YIZUMI's mobile phone mid-frame industry

Apart from larger dimensions, 5G mobile phones have increasingly high demands for internal quality, compactness, and mechanical performance. YIZUMI has been constantly upgrading its die-casting machines, improving the injection performance, mold clamping force, injection speed and other critical features. Not only do repeatability, efficiency, and dimensional precision meet the client's requirements for production, the mobile phone mid-frames have also won compliments from many clients by leveraging on the test items like the customer's three-point bending flexural test (modulus of rupture), average thickness tolerance, porosity and so on.

In addition, to meet the needs of the rapid development of 5G products, YIZUMI provides a special preventive inspection

service for its clients in the mobile phone mid-frame industry. Our service engineering team is inspecting the clients' machines once per month. Checks include key machine functions, system pressure configuration, toggle lubrication piping, distribution and frequency, energy storage systems, and much more. These preventive after-sales-services checks, help the clients to best utilize the equipment, achieve highest performance and prolong the service life of the equipment.

In view of such value-added services, Sun Lianhe expressed his acknowledgement. "The after-sales services of YIZUMI has always been excellent. It would always immediately respond to any issues. Various value-added services have further supported us in critical maintenance issues caused by different equipment operators ensuring the equipment always remains in its best conditions."

Client Profile

Name: Dongguan Fast Precision Hardware Co., Ltd.
Products: Mobile phone mid-frames, tablet support brackets
Area Occupied: 50,000 square meters
Production Equipment: YIZUMI's hot chamber magnesium alloy die-casting machines, cold chamber die-casting machines (300-ton, 400-ton)



A Rising Star in the Structural Parts of New Energy Automobiles

QIXIN MOLD: More than 4,800 sets of molds produced over 16 years

Founded in 2004, Foshan Qixin Mold Co., Ltd. (hereinafter referred to as "QIXIN MOLD") is mainly specializing in the research, development, and production of die-casting molds for the automobile industry. In the past 16 years more than 4,800 sets of molds have been manufactured. Its products include a wide array of molds ranging from power train components to heat sinks and electronic communication base stations. To date, QIXIN MOULD is one of the top 20 die-casting mold manufacturers in China.

Recently, QIXIN MOLD has begun to invest in die-casting applications for new energy automobiles, delivering a full suite of services ranging from mold design, production, product die-casting, processing, and assembly. In fact, its performance has almost doubled every year.

Mr. Chen Liangjin, Managing Director of QIXIN MOLD, cited: "The trend is of paramount importance. If you want to succeed in the future industry, you need to prepare in advance. The investment in the die-casting parts for new energy automobiles is an example. We have planted the seeds earlier and now is the harvesting period."

Exponential growth in die-casting parts for new energy automobiles every year

What is exactly the trend for new energy automobiles?

In 2019, the total sales for Chinese automobiles was 25.769 million units. Among them, 1.206 million units were new energy automobiles. Chen Liangjin, Managing Director, added: "The base unit for new energy automobiles is still relatively low now. Therefore, the potential growth can be very significant."

However, in the die-casting field, you must be very fast in the new energy sector. The

relevant specifications are still not here yet. While there is a wide range of different components, the production volumes are still small. For many manufacturers involved in traditional automobile parts, the "cake is too small" to interest them.

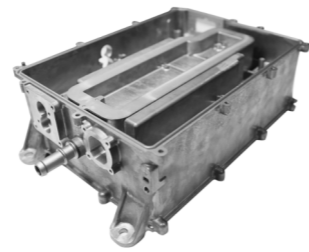
"We do not see this as a problem but as a chance to differentiate ourselves from the competition." Chen Liangjin, Managing Director, expressed that the trend towards electric vehicles is an opportunity for QIXIN MOLD. Moreover, the strong background in mold technology is a further bonus for the firm. "From 2004 to the present, we have



already produced over 4,800 sets of die-casting molds, accumulating over 10 years of invaluable experience. "We are able to offer significant support to our clients in successfully implementing casting projects in this new product spectrum" Chen Liangjin further explains.

Being bullish on the emerging trend of new energy automobiles, QIXIN MOLD has started to invest in these types of die-casting parts since 2016. According to Mr. Chen Liangjin, QIXIN MOLD has acquired more than 110 new energy automobile parts projects in mainland China. Its clientele includes BAIC, JAC, GWM, CHANGAN, GEELY, DFM, BYD and other automotive OEM's and key industry players. With the new emerging trends in electro mobility and autonomous driving, its performance has growth exponentially every year, from 5 million CNY in 2017 to over 30

million CNY in 2018. Even reaching a record high of more than 60 million CNY in 2019. Despite the significant impact from the coronavirus pandemic in early 2020, QIXIN MOLD has gone against the tide, steaming ahead with a full order book.



■ Electronic control housing for new energy automobiles



■ 70kW motor housing for new energy automobiles

Crafting highly air-tight structural parts

At present, the core technology in electric vehicle drives include battery, motor and electronic control. Some even compare it with the notion that "the battery is the heart; the electronic control is the brain; the motor is the pair of legs." With the solid background in mold technology, QIXIN MOLD mainly focuses on the housings for motor and electronic control.

Take the 70kW motor housing as an example. As an important component of the motor drive system in new energy automobiles, the die-casting part has several requirements like highly precise dimensions (up to 8 μ) and no air or water leakage which requires minimum porosity. Uneven wall thicknesses (thickest at 30mm, thinnest at 4mm) further complicate the requirements.

Q&A

DIE CASTING Magazine: In comparison with traditional automobile die-casting parts, what do you think are the challenges of die-casting parts for new energy automobiles?

Chen Liangjin: The die-casting parts for new energy automobiles have higher requirements for surface and internal quality as compared to traditional automobile parts. Moreover, the time schedule is always very tight, and the response speed must be very fast. Nowadays, the development cycle of new energy automobile components is often only 35 days with a small batch of supply (50 units). From mold design, mold production and mold testing, it is very difficult to deliver 50 products in 35 days. Many enterprises could not believe these short delivery times to be possible. Of course, the die design, manufacturing and sample casting processes need to be planned and executed with highest quality standards allowing no delays.

DIE CASTING Magazine: How do you evaluate the products and services of YIZUMI?

Chen Liangjin: Many of our peers and mold clients make use of YIZUMI's equipment.

"It is a huge challenge for the molds and die-casting process," Mr. Chen Liangjin said. Uneven wall thicknesses easily result in unacceptable shrinkage porosity. A smart die design in combination with a high-quality die casting machine providing sufficient intensification force is essential to reach expected component quality.

As of now, the motor housings are in smooth production using YIZUMI's 1650-ton die-casting machine. The passing rate is more than 95%. Chen Liangjin, Managing Director, acknowledged: "I couldn't believe it can be done so well. But it is a fact. The castings are produced without shrinkage- or gas porosity".

In addition, the electronic control housings have very high requirements for air-tightness, as well as on casting surface quality. They have entered production with YIZUMI's

1250T, 900T die-casting machines. The passing rate is over 98%.

Q&A (Q: YIZUMI's client magazine "DIE CASTING", A: Chen Liangjin, Managing Director of Foshan Qixin Mold Co., Ltd.)



■ Chen Liangjin, Managing Director of Foshan Qixin Mold Co., Ltd.

Client Profile

Name: Foshan Qixin Mold Co., Ltd.
 Product: Die-casting molds for automobiles and communication equipment; die-casting parts for new energy automobiles
 Equipment: YIZUMI's 300-ton/ 400-ton/ H900-ton/ 1250-ton and 1650 ton die casting machines

Changchun LIJIA: Casting of Gearbox Housing for Heavy - Duty Truck with YIZUMI DM4500H Fully Automated Die Casting Cell

Since Changchun LIJIA acquired YIZUMI DM4500H fully automated Robotic die-casting cell in year 2019, YIZUMI has successfully completed the delivery and debugging of this heavy duty die casting machine complete with Automation cell. Machine assigned for casting of gearbox housing for heavy-duty trucks & successfully commissioned in March this year. This is the biggest tonnage die casting machine cell in LIJIA.



The entire system could complete the full production process automatically including spraying for die release, product extraction, integrity inspection, overflow removal, cooling, deburring & stacking.

This System has overcome many technical difficulties with challenges as below:

Challenge No. 1: Multifunctional demands of removal robot

1. The gearbox housing of heavy-duty trucks is large & heavy. Result with great challenge for the gripper with stability during extraction. Any negligence during extraction by grabbing the sprue may result falling of the product. It may cause deformation or damage to the sprue and product. This also result with interruption to continue the subsequent

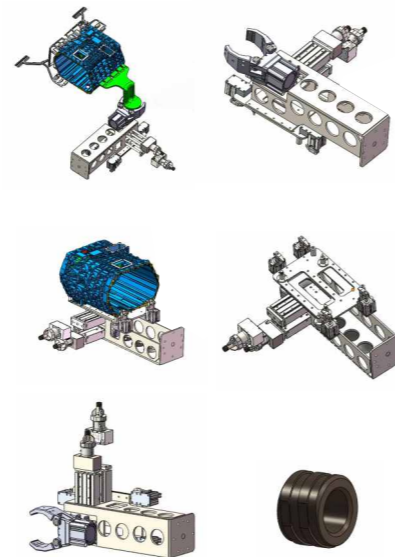
process such as marking and sprue removal.

2. Insert with two small rings to be placed on both movable & fixed platen. The insertion position for each fixed point are different. This may result with low production yield if not inserted in place.

3. After the gate removal, the product will have to undergo deburring and stacking. Thereafter, the robot needs to extract the product once again after the gate removal.

To integrate the extracting, inserting and product arm into one machine with limited space & avoid any interference with each other's, this plays a vital role in the subsequent work.

Engineering team of YIZUMI made great effort on the design of the arm which integrate with three functionable gripper to meet complex process requirement. A cylinder-driven clamping structure is adopted to grip the cylindrical gate with a diameter range of 130 ~ 200 mm. It provides a maximum clamping force up to 600KN. With a structural self-locking function, which meets the needs of holding the heavy-weight casting part. The inserting gripper uses a three-claw cylinder to grab the inner circle. With a built-in ejection mechanism, it could grab two inserts at the same time to set in the movable platen and the fixed platen, providing a highly efficient solution for the completion of insertion. By first providing positioning support to the product after removing the runner and the gate, the product is secured with a four-claw cylinders for gripping and handling easily.



Challenge No. 2: Special-shaped mold with effective spraying demands

Special-shaped molds with complex structure & deep die cavity. The ordinary spray head with low spray pressure could not accomplish the task. To achieve an even and improve efficiency of spaying function while reducing unnecessary movement is a tough problem.

Special spray arm with combined structure is specially designed by YIZUMI for product housing which reduces the unnecessary movement in the coating operation and allows appropriate amount of expansion with multiple spray heads, to achieve an effective spray distance of more than 500 mm. The connection of control valve and spray arm ensures the flow of atomized gas and air blow. Through fast response, it improves the spray frequency and quality effectively, optimizes the atomization effect, and allows an even surface coverage of the mold release agent, resulting in lower failure rate.



Challenge No. 3: Complicated deburring demand

1. During the die-casting process, burrs are inevitable. In this specific case, a large casting, making it difficult to design a proper moving path for the robot. The product is characterized by more burrs, more deep cavity positions and special shapes of inner

holes, it takes special long reach tools to complete the deburring task. Multiple tools are required at some specific positions.

2. Multiple floating tools applicable in the process, for safety and environmental protection, handing the grinding dust shall also be considered.

To tackle the complex deburring process of this product while reducing the overall cycle time, YIZUMI applied deburring robot system which owns high-power rigid electric spindle with aluminum alloy professional milling tool to remove the residuals around the sprue, achieving rapid cutting and preventing breakage of floating tools during grinding operation. The optional belt sander is efficient in removing burrs of large area and unevenness between the sand belt contact surface and the grinding surface of the workpiece while compatible with deviation in the previous die casting process. It also has a dust collection port reserved to collect grinding dust by the dust collector, allowing a safer working environment.

For burrs on the parting surfaces and in deep cavity, an electrical spindle or optional pneumatic spindle is available with a flexible free-floating range of 360°

± 15 mm to remove sharp burrs in special shaped holes, round holes, and other less accessible areas. It can also polish off the gate residuals for a better smooth surface and higher production yield.



Challenge No. 4:

In vast majority of die-casting workshops, it is common to handle such die-cast clutch housing manually, which is time-consuming

and labor intensive. When the casting weight is too heavy, manual handling becomes impossible. As a result, the application of fully automated equipment is imminence.

The custom-made cylinder stacking automated workstation designed by YIZUMI is equipped with integrated grip-sucking claws which is able to determine the state of workpiece extraction and add divider during the stacking. The double-layer stacking processes are simplified into one single grip. Depending on the products and the types of stacking, the system has an open stacking process package that allows you to build circled or array stack modeling to save manpower.



In addition to the process with machining for gate removal, grinding, deburring, and in-cell stacking, the system is also equipped with the inserts feed device, preheating, the 2-in-1 pneumatic hammer and hydraulic shear gate removal device, pneumatic marking, and other automated peripheral devices to be delivered by YIZUMI as a packaged with total solution for customer's convenience.

New Integrated Machine Design

YIZUMI launched the H Series DCM Gen II (1800–9000 kN)

In 2017, YIZUMI launched the H series heavy-duty die casting machine, which won many global customers' acceptance with highest quality standards and stable, highly repeatable casting performance. In addition, die casting solutions with machines sizes of 3500T, 4000T, 4500T helped some industry leaders such as CNHTC, LIJIA, RUNXINGTAI, Wuxi LANGSHION, Wenzhou RUIMING, Dongguan JIANSHEG realize mass production of large castings, which include gearbox housings for trucks, 5G base stations, battery housings for new energy vehicle as well as structural castings incl. shock towers, instrument panels etc.

Based on the rich, practical experience we accumulated with our H series DCM at customer' site, the YIZUMI R&D team, in collaboration with our European experts, have introduced innovations with a clear focus on improved injection capability and performance. The result is an upgrade package providing significantly increased shot control precision and a high injection repeatability. These technological improvements strongly facilitate our customer's high performance manufacturing capability allowing them to successfully compete.

High precision & repeatable switch-over to fast filling phase

Precisely triggering the fast filling phase is critical for many die casting applications. The Gen-II provides a high standard of precision to switch-over to the cavity filling phase. A repeatability of max +/-2mm satisfies the highest requirements.

Top Injection Capability

With its optimized hydraulic system, the Gen-II system offers a high injection acceleration of $\geq 50G$. In combination with its high capacity P/Q performance, the Gen-II die casting machine is built to provide high casting quality with even the most difficult of parts.

Fast Pressure Build-up time for critical components

Further improved pressure build-up time reduction by more than 30%. The Gen-II pressure build-up time offers great performance to any casting process

Technology Data Management & Calculation

Based on technology data entry the YIZUMI DM Gen-II control system calculates critical casting process data to support process engineers.

The PQ2 diagram with actual operating-point is displayed on the HMI screen to support the process engineer with great transparency.

YI-MES Intelligent Manufacturing Execution System (optional)

YI-MES is a professional MES system designed for the die casting industry. YI-MES is designed to allow easy implementation which also makes it a preferred choice for smaller and medium sized companies. With its comprehensive selection of modules, the YI-MES system offers great efficiency gains in all aspects of managing the die casting

operation. YI-MES facilitates the digitalization of production planning and monitoring as well as quality management on all organizational levels.

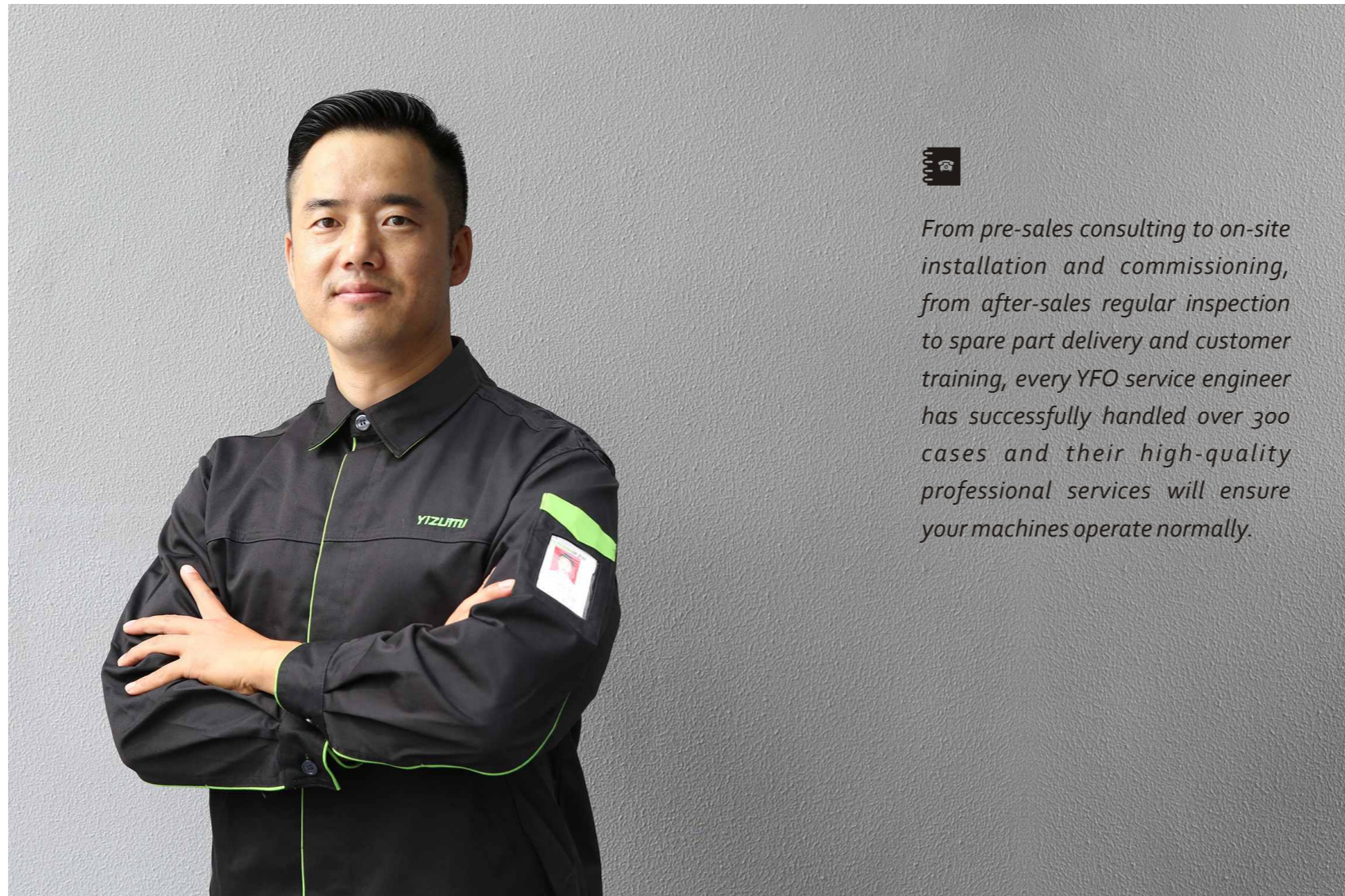


DM500H II

YFO-based Instant Prime Service

Timely, Professional, Customer First

YFO (Yizumi Factory Outlet) model ensures high response speed and controllability of the service and it is also Yizumi's new global service strategy for the future. As regards the service concept, we not only ensure the safety of customer's production activity, but also endeavor to fulfill the ultimate goal of reducing the risk of downtime through every detail and improving customer's productivity.



From pre-sales consulting to on-site installation and commissioning, from after-sales regular inspection to spare part delivery and customer training, every YFO service engineer has successfully handled over 300 cases and their high-quality professional services will ensure your machines operate normally.

The worldwide part supply network ensures smooth, prompt and accurate part distribution

- China** A total of 35 spare part centers and maintenance part warehouses
- Abroad** Spare part warehouses in 15 overseas countries



YFO one-stop spare part service solution Save your time, worry and money

- Shorter waiting time**
Unified service channel, hour-level spare part delivery service available
- Cost-effective**
Key spare parts are purchased from manufacturers, ensuring the price transparency and economy.
- Some spare parts imported**
More durable and applicable.



365/24	72	8,000 +	10+	5,000+m²
24-hour hotline available for 365 days, nearly 200 maintenance experts ready to respond to your needs.	YFO service network in 35 Chinese cities and 37 overseas countries provide better access to service.	So far the service team has provided YFO service support for over 8,000 machines to ensure they function normally.	Over half of YFO service engineers have over 10 years of professional experience.	Powerful spare part warehouse system covers warehouses in 35 Chinese cities and 15 overseas spare part centers, total warehousing area up to 5,000m ² .

Eight YFO Commitments

Focus on machines; greater focus on customer experiences

8 specialized services allowing you to have a better customer experience



Presales Consultancy & Technical Support

Delivering exhaustive die casting machines and auxiliary equipment selection solutions, professional configuration and optimization solutions of its manufacturing technologies.



Professional Technical Training

Exquisitely designed, nationwide standardized courseware menu selection system, the national instructing team will personally visit the sites to customize the trainings.



Professional Parts Supply

5 warehouse agencies and 2 service centers with warehouse inventories overseas, spanning across Asia, America and Europe, achieving a 24-hour turnaround of common parts delivery.



PLC Remote Service Mode

Remote process support within the whole world. It can rapidly resolve the customized requirements for the customer processes.



GPS Vehicle Monitoring System

Over 50 service vehicles with real-time online monitoring control nationwide. Timely nearby dispatch services ensuring its response speed.



e-service 24-hr Online Services

One button to report any repairs with the mobile apps. Swiftly search for malfunctions, building the mobile after-sales experiences for the customers.



Technology Service Center

The service center, which is directly under the management of Yizumi's headquarters, the service engineers deliver timely and effective services. Meanwhile, there are 2 technology service centers in India and Vietnam.



Permanent Engineers' Services

In view of the key markets already developed, Yizumi will dispatch the Chinese engineers to reside at the markets permanently, providing timely and highly efficient services to the customers.

YIZUMI e-service

Delivering a real-time service system for its clients

Through YIZUMI e-service, you can have a full-day, online support, mobile and rapid remote repair and maintenance as well. Regardless of where you are, it can deliver a rapid, convenient, online after-sales service, ensuring the equipment to be maintained in the best condition for the long term.

- Rapid
- Reliable
- Effective
- Visual
- Recordable
- Can be evaluated
- Cost effective

YIZUMI e-service can deliver the followings to you



Mobile Operation: Smart Phone/Tablet/PC Multiplatform available.

Download the APP, enter equipment serial number /scan equipment QR code and the registration is completed.



IOS

Android