



INJECTION MOLDED PART STANDARDS

HIBIKI's base is constructed with polycarbonate, a soft material that will scratch and scuff over time. Scratches and marks may be more noticeable, given the clear-polish finish.

We've spent months pre-tooling this part to ensure we have accurate final product samples.

The construction process starts with a variable thickness injection mould (3.00-11.00mm) and post-machining removal of tooling markings (sprues, ejector pins) before finishing with another polish.

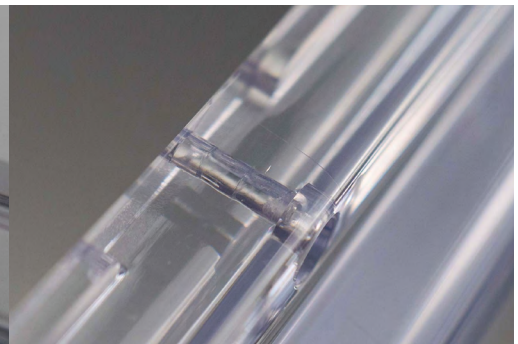
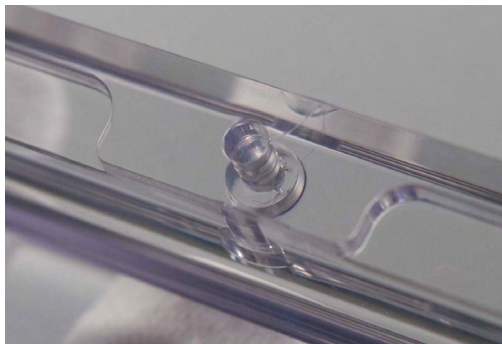
We've worked hard to ensure a stunning result. However, like HIBIKI's base, we wanted to be transparent about what to expect with this manufacturing process. Below are some images of our finished polycarbonate bases!



WELD LINES

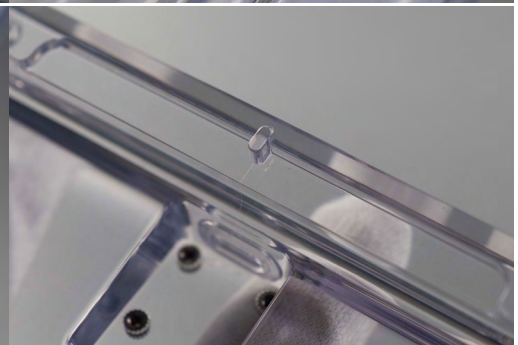
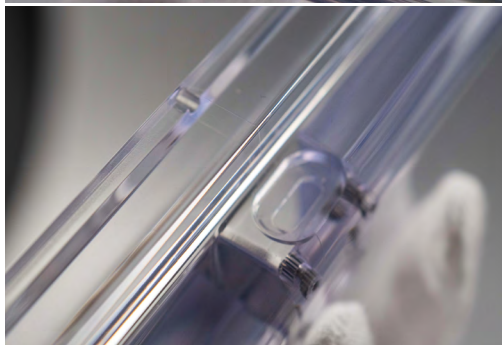
Also known as knit lines - a weld line occurs when the plastic flow hits an obstacle (e.g. a rib or hole) before rejoining. The result - kind of looks like a seam!

These are only seen around the screw holes and are not noticeable when the keyboard is assembled.



PART LINE

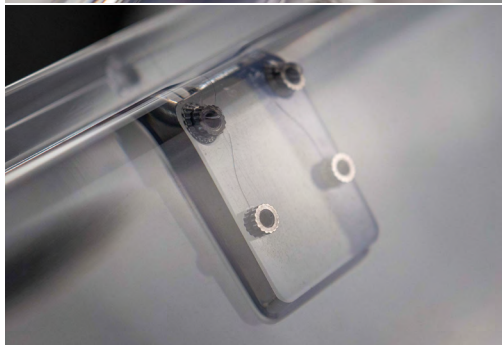
This is where two parts of the tool meet and shut off. The result is a hairline that's only visible on the base's inner top and bottom mating wall.



FLOW MARKS

Flow marks occur when plastic flows through sections with varying wall thickness.

These hairlines can be seen only in the USB-C mounting area between the threaded inserts.



SPRUE AREA

Although completely flat and polished, under super harsh light, you can still see where our giant chonky sprue mark once was.

Thankfully, this has no distortion or colour effect on the clear window base once the keyboard is assembled.

