



# Process Control Plan

**MOLDING**

Run No:

Cust Part No:  
Reference Only

**SST-1710**

UPDATED: 05/06/2020	REV. NO: E	SET-UP DIFFICULTY - D
TONNAGE: 60	PRESS: 1	PRINTED: 02/19/2025

QTY:

START DATE:

DAYS REQUIRED: 1

DUE BY:

RETURN WITH TOOLS



SET-UP INFORMATION  
SINTERGY PART # **SST-1710** PRESS # **60 OR 100 TON**

**PRE SETUP CHECKLIST**  
**DIE SETTER TO CHECK THE FOLLOWING PRIOR TO SETTING UP PRESS**

- ☐ CHECK LINKAGE
- ☐ MITER GEAR
- ☐ ROD ENDS
- ☐ VISUAL INSPECTION OF PRESS

DIE SETTER SIGN OFF \_\_\_\_\_ DATE: \_\_\_\_\_

**PRESS SETTINGS:**

AIR CLUTCH: MIN

TYPE OF CORE ROD: AIR AMOUNT OF MOVEMENT Eject with Part.

HOLDER: FLOATING AMOUNT OF MOVEMENT NA

PLATE FLOAT .400

BOTTOM PUNCH SETTING 1.160 (AIR ON ) .760 NO AIR

**OTHER SETTINGS: SHOE TIMINGS, CAM SETTINGS, ETC**

Air on Core Rod Down Before Full Eject.

Part should Slide off Die Plate with Shoe (DO NOT LET PARTS BUMP INTO EACH OTHER)  
Use Accumulator Table.

**SET-UP INFORMATION:**

Test for Hardness RB 45-65

Check ID using Gage #0877 (Drawer 3- slot 8)

Run at 16 RPM in Press #41

Use Special Backer Block-Punch Must Not Be Able to turn- See Layout.

**MAKE SURE BOTTOM PUNCH HAS NO NUMBERS OR LETTERS.**

**MAKE SURE NUMBER ON PART MATCHES NUMBER ON PRINT.**

•Be sure kick off is set properly so as not to chip parts.

•Run while Testing for size control and density distribution.

•Make sure top punch has the following detail .023V / 087130 ( .6 mm )