

Process Control Plan MOLDING

Cust Part #: 09739501 Reference Only

SST-2317

Run No:

We Make It Happen

UPDATED: 08/18/2025 REV. NO: A1 TONNAGE: PRESS:

SET-UP DIFFICULTY - B PRINTED: 08/18/2025

OTY:

FINISH DIMENSIONS: START DATE: DAYS REQUIRED: 1 DUE BY:

OAL	FL TH	C'BORE 1 -	C'BORE 2	WEIGHT	FL OD	BODY OD	C'BORE 2 DIA	C'BORE 1 DIA	SM ID
2.136	.810	1.240	.390		2.352	1.245	1.250	.7505	.380
2.156	.830	1.260	.410		2.362	1.255	1.260	.753	.400

MATERIAL: STY-210 DENSITY: 6.7 / 6.8 VOLUME: 66.73 WEIGHT / PC: 447.1 / 453.8

APPROVED VENDOR: NAH **MOLDING DIMENSIONS:**

TITOEDETIC		0 - 110 1						
OAL	FL TH	C'BORE 1 -	C'BORE 2	WEIGHT				
		TMS4EP						
2.145	.820	1.248	.400	447.1				
2.150	.825	1.253	.405	453.8				
INSPECTION METHOD:								
3 / 1/2 hr	3 / 1/2 hr	3 / 1/2 hr	3 / 1/2 hr	3 / 1/2 hr				

MATERIAL MIX: STY-210 DESC: FC-0208 w/sm3

BLENDING: Blend 998.36 # per M

PRESS SPEED: Target: 0 rpm's Actual: Set-up by:

Explanation if Actual differs from Target:

TOOL LOCATION: F 4 A DIE #: 607 PIN #: 731

T PUNCH #: 757 B PUNCH #: 757

TOOLING:

SETUP:

INSTRUCTIONS:

WATCH DIE CAVITY FOR PROPER FILL OPERATOR TO CHECK ALL MOLDING LENGTHS EVERY 15 MINS AND RECORD FINDINGS AS PRESCRIBED ON DATASHEET

GREEN PART STORAGE:

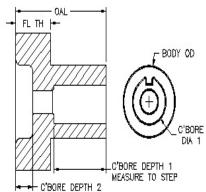
PLACE PARTS ON SKIDS W/ CARDBOARD SEPARATORS 4 LAYERS HIGH & MOVE TO SINTERING AREA

Production Steps

- 1. Mold STY-210
- 2. Sinter
- 3. Machining-Sintergy
- 4. QC Check
- 5. Packing

C'BORE SM ID

- FL OD



UPDATED CHICO

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