

CONTROLLED

PRINT

Process Control Plan

MOLDING

Run No:

Cust Part No:

Reference Only

SSK-2100

please add

UPDATED: 12/07/2023 REV. NO: A

TONNAGE: 200 DS

PRESS: 45

31u Difficulty - C
PRINTED: 11/19/2024

QTY: 2,200

FINISH DIMENSIONS:

START DATE: 11-26-24 DAYS REQUIRED: 1

DUE BY:

OAL	FL TH	FL OD	BODY OD	ID	HARDNESS
.678	.221	2.161	1.190	.501	RB 60
.698	.231	2.171	1.210	.504	MIN

MATERIAL: STY-202

DENSITY: 6.7 / 6.8

VOLUME: 15.63

WEIGHT / PC: 104.7 / 106.3

APPROVED VENDOR: NAH

MOLDING DIMENSIONS:

OAL	FL TH	WEIGHT	BODY & FLANGE
.685	.223	104.7	
.690	.228	106.3	

INSPECTION METHOD:

3 / 1/2 hr	3 / 1/2 hr	3 / 1/2 hr	3 / 1/2 hr
MICROMETER	MICROMETER	SCALE	FOR CRACK @

MATERIAL MIX: STY-202

DESC: FC-0208

BLENDING: Blend 233.86 # per M

PRESS SPEED: Target: 10 rpm's

Actual: 9/10

Set-up by: Jv

Explanation if Actual differs from Target:

TOOL LOCATION: J1B

DIE #: 499

PIN #: 613

T PUNCH #: 624

B PUNCH #: 624

TOOLING:**SETUP:****INSTRUCTIONS:**

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

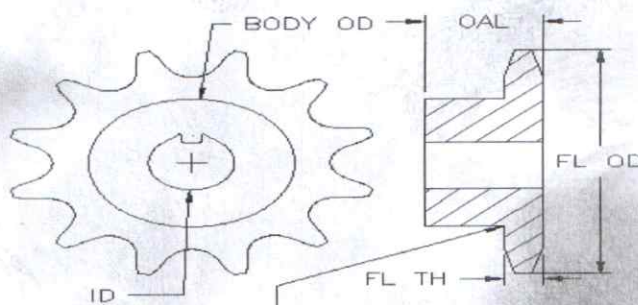
OPERATOR TO WATCH FOR CRACKING AT BODY AND
FLANGE AS SHOWN IN PICTURE

GREEN PART STORAGE:

PLACE PARTS ON SKIDS 5 LAYERS HIGH AND MOVE TO
SINTERING AREA

Production Steps

1. Mold STY-202
2. Sinter
3. QC Check
4. HEAT TREAT-AHT
5. QC Check
6. Packing



WATCH FOR
CRACKING AT FLANGE
AND BODY