

CONTROLLED
PRINT

Process Control Plan

MOLDING

Run No:

Cust Part No:

Reference Only

SFC-1700

UPDATED: 10/24/2024 REV. NO:

*Please add
set up difficulty D*

TONNAGE:

PRESS:

PRINTED: 02/21/2025

QTY: *2100*

FINISH DIMENSIONS:

START DATE: *2-24-15*

DAYS REQUIRED: 1

DUE BY:

PUSHOUT

2000#
MIN

MATERIAL: STY-204

DENSITY: 6.7 / 6.8

VOLUME: 23.954

WEIGHT / PC: 160.5 / 162.9

APPROVED VENDOR:

MOLDING DIMENSIONS:

OAL	BODY LEN	FL TH	WEIGHT
1.348	.598	.748	160.5
1.353	.603	.753	162.9

INSPECTION METHOD:

3 / 1/2 hr	3 / 1/2 hr	3 / 1/2 hr	3 / 1/2 hr
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MATERIAL MIX: STY-204

DESC: FC-0205

BLENDING: Blend 358.38 # per M

PRESS SPEED: Target: 10 rpm's

Actual: *10*

Set-up by: *M. K. P.*

Explanation if Actual differs from Target:

TOOL LOCATION: Q 2 C
T PUNCH #: 867

DIE #: 705
B PUNCH #: 867

PIN #: 825

TOOLING:

SETUP:

INSTRUCTIONS:

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

GREEN PART STORAGE:

PLACE PARTS ON SKIDS W/ CARDBOARD SEPARATORS
& MOVE TO ASSEMBLE AREA

Production Steps

1. Mold STY-204
2. ASM-SFC1700/SSTC3700
3. QC Check
4. Packing

