Process Control Plan
Cust Part No: 289619

Reference Only
UPDATED: 01/17/2025 REV. NO: 000

SINTERING SST-2606

PRINTED: 01/27/2025

START DATE:

DAYS REQUIRED: 1

DUE BY:

Run No:

OTY:

MATERIAL: B-133L

90-10 BRASS

HARDNESS: Rh 72

SINTERING SPECIFICATIONS

OVEN	BELT SPEED	PRE HEAT	MAIN HEAT	DEW PT	
NUMBER		± 50°	± 20°	± 4°	
3	3	1300	1650	45 / 55	
67	6"	1200/1200/1200	1650	45 / 55	
68	5.5	1200/1200	1650	45 / 55	
107	6	1200/1200/1200	1650	45 / 55	
126	6	1200/1200/1200	1650	45 / 55	
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Use The Gray Area Above For Changes To Sintering Spec. Approve & Initial

SINTERING DIMENSIONS

DITTERNITO BITTERNITO								
WEIGHT	O.D.	CRUSH	DENSITY	HARDNESS				
		@ SETUP	SIZE 1ST					
	2.622	3000#	7.8	Rh 72				
	2.630	MIN	7.9	min				
INSPECTION METHOD								
,_	1 / 2 hrs.	1 / 2 hrs.	1 / 2hrs.	1 / 2 hrs				
VE STEPAS	l							
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INSTRUCTIONS:

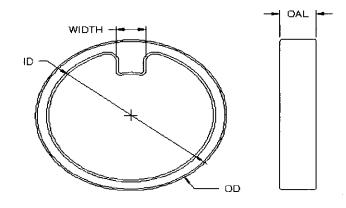
SINTERING LOADING:

SPRINKLE SMALL AMOUNT OF ZINC POWDER ON 8 - 10 CERAMIC PLATES BEFORE RUNNING PRODUCTION

Load parts tight as possible on belt.

MUST Hand Load Parts on Belt.

Handle with Care



SINTERING UNLOADING:

INSURE PART IS FULLY SINTERED

Parts can Fall into Drums

Use 1 Sized Part for Weight, Density, & Crush Tests.

Record Readings on Data Form & Also Write Readings on Part.

Date Part and Place in Box.-

NEXT PROCESS:

Move parts to molding area.

Form: SinterM.rv