



We Make It Happen

Process Control Plan

Cust Part #: 103-9506

Reference Only

MOLDING

SST-1800

Run No:

UPDATED: 08/07/2025

REV. NO: D

SET-UP DIFFICULTY - C

TONNAGE: 100

PRESS: 50 OR 41

PRINTED: 08/07/2025

QTY:

FINISH DIMENSIONS:

START DATE:

DAYS REQUIRED: 2

DUE BY:

OAL MUST HOLD	C.C	HUB LEN (2X)	I.D.	O.D.	HUB O.D. (2X)	RUNOUT	HARDNESS	PLATING	
1.166	.004	.040	1.200	1.865	1.730	.005	RB 60	Yellow	
1.176	TIR	.080	1.210	1.885	1.770	TIR	MIN		

MATERIAL: STY-200 REMILL

DENSITY: 6.7 / 6.8

VOLUME: 30.45

WEIGHT / PC: 204 / 207

APPROVED VENDOR: AMP-4

MOLDING DIMENSIONS:

OAL MUST HOLD	C.C ID TO OD	WEIGHT	
1.169	.004	204	
1.174	TIR	207	

UPDATED CHICO

INSPECTION METHOD:

3 / 1/2 hr	3 / 1/2 hr	3 / 1/2 hr	
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Daryl Almendarez 08/07/2025

MATERIAL MIX: STY-200 REMILL DESC: FC-0208 REMILL

BLENDING: Blend 455.4 # per M

PRESS SPEED: Target: 12 rpm's

Actual: Set-up by:

Explanation if Actual differs from Target:

TOOL LOCATION: A-8-K

DIE #: 48 (A-8-K)

PIN #: 47 (A-8-K)

T PUNCH #: 52 (A-8-K)

B PUNCH #: 52 (A-8-K)

TOOLING:

SETUP:

SEE "SETUP SHEET"

61 TON'S ACTUAL 6-08

INSTRUCTIONS:

Watch die cavity for proper fill.

Operator to check all molding lengths every 15 mins. and record findings as prescribed on data sheet.

C.C. .004 I.D.TO O.D.

GREEN PART STORAGE:

Place parts on skids and move to Sintering Area. Approx 585 pcs. per Layer..

7 layers max.

Production Steps

1. Mold STY-200 REMILL

2. Sinter

3. QC Check

4. LS & Plate-BFG

5. QC Check

6. Packing

Form: MoldM.rv

RETURN WITH TOOLS

