

CONTROLLED
PRINT

Process Control Plan MOLDING
Cust Part No: S-3007
Reference Only

Run No:

UPDATED: 10/21/2024 REV. NO: Orig.
TONNAGE: PRESS: 0

PRINTED: 01/16/2025

QTY: 3,100

FINISH DIMENSIONS: START DATE: 1-23-25 DAYS REQUIRED: 1 DUE BY:

OAL	OD	ID	HARDNESS
.4973	2.995	1.010	RB 60
.5073	3.005	1.016	MIN

MATERIAL: STY-102

DENSITY: 6.6 / 6.7

VOLUME:

WEIGHT / PC: 342 / 348

APPROVED VENDOR: REMILL

MOLDING DIMENSIONS:

OAL	WEIGHT
.500	342
.505	348

INSPECTION METHOD:

3 / 1/2 hr	3 / 1/2 hr
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MATERIAL MIX: STY-102

DESC: F-0008

BLENDING: Blend 765.6 # per M

PRESS SPEED: Target: 0 rpm's

Actual:

Set-up by:

Explanation if Actual differs from Target:

TOOL LOCATION: P2C

T PUNCH #: 871

DIE #: 691

B PUNCH #: 851

PIN #: 810

TOOLING:

SETUP:

INSTRUCTIONS:

WATCH DIE CAVITY FOR PROPER FILL

WATCH FOR BROKEN & CHIPPED EDGES

GREEN PART STORAGE:

PLACE PARTS ON SKIDS & MOVE TO SINTERING AREA

Production Steps

1. Mold STY-102
2. Sinter
3. Grt Blast - In House
4. QC Check
5. Packing

