

CONTROLLED

PRINT

Process Control Plan
Cust Part No: 09739501
Reference Only**MOLDING**
SST-2317

Run No:

UPDATED: 07/01/2024 REV. NO: A1
TONNAGE: PRESS:SET-UP DIFFICULTY - B
PRINTED: 08/13/2025QTY: ~~4,200~~*All Powder At Press Per*

FINISH DIMENSIONS:

START DATE: 8-14-25

DAYS REQUIRED: 1

DUE BY:

OAL	FL TH	C'BORE 1 - MEAS TO STEP	C'BORE 2	WEIGHT	FL OD	BODY OD	C'BORE 2 DIA	C'BORE 1 DIA	MID
2.136	.810	1.240	.390		2.352	1.245	1.250	.7505	.380
2.156	.830	1.260	.410		2.362	1.255	1.260	.753	.400

MATERIAL: STY-210

DENSITY: 6.7 / 6.8

VOLUME: 66.73

WEIGHT / PC: 447.1 / 453.8

APPROVED VENDOR: NAH

MOLDING DIMENSIONS:

OAL	FL TH	C'BORE 1 - MEAS TO STEP	C'BORE 2	WEIGHT
2.145	.820	1.248	.400	447.1
2.150	.825	1.253	.405	453.8

INSPECTION METHOD:

3 / 1/2 hr	3 / 1/2 hr	3 / 1/2 hr	3 / 1/2 hr	3 / 1/2 hr
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MATERIAL MIX: STY-210

DESC: FC-0208 w/sm3

BLENDING: Blend 998.36 # per M

PRESS SPEED: Target: 0 rpm's

Actual: _____

Set-up by: *Mike P*

Explanation if Actual differs from Target:

TOOL LOCATION: F 4 A

T PUNCH #: 757

DIE #: 607

B PUNCH #: 757

PIN #: 731

TOOLING:

SETUP:

INSTRUCTIONS:

WATCH DIE CAVITY FOR PROPER FILL

OPERATOR TO CHECK ALL MOLDING LENGTHS EVERY
15 MINS AND RECORD FINDINGS AS PRESCRIBED ON
DATASHEET

GREEN PART STORAGE:

PLACE PARTS ON SKIDS W/ CARDBOARD SEPARATORS
& MOVE TO SINTERING AREA*4 Layers High*
Production Steps

1. Mold STY-210
2. Sinter
3. Machining-Sintergy
4. QC Check
5. Packing

