



Process Control Plan
Cust Part #: MG-DB-100
Reference Only

MOLDING
SST-4404

Run No:

UPDATED: 08/15/2025 REV. NO: D
TONNAGE: PRESS:

SET-UP DIFFICULTY - A
PRINTED: 08/15/2025

QTY:

FINISH DIMENSIONS:

START DATE:

DAYS REQUIRED: 1

DUE BY:

OAL	FL TH	TH ABV	INSERT	HARDNESS	
.325	.195	.095		RB 60	
.335	.205	.105		MIN	

MATERIAL: STY-202

DENSITY: 6.7 / 6.8 REVOLUME:

WEIGHT / PC: 225.5 / 229.5

APPROVED VENDOR: NAH

MOLDING DIMENSIONS:

OAL-1	OAL-2	FL TH	TH ABV	INSERT	WEIGHT	
.328	.328	.198	.098	1.0	225.5	
.333	.333	.203	.103	LBS	229.5	

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-202

DESC: FC-0208

BLENDING: Blend 504.9 # per M

PRESS SPEED: Target: 0 rpm's Actual: _____ Set-up by: _____

Explanation if Actual differs from Target:

TOOL LOCATION: Q 3 A

DIE #: 700

PIN #: 819

T PUNCH #: 861

B PUNCH #: 860

TOOLING:

SETUP:

MUST USE .100 SPACER AND ADJUSTABLE COLLET ON #1 PUNCH.

INSTRUCTIONS:

WATCH DIE CAVITY FOR PROPER FILL

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

CHECK TH ABOVE AT THE OUTER EDGE OF THE PART

GREEN PART STORAGE:

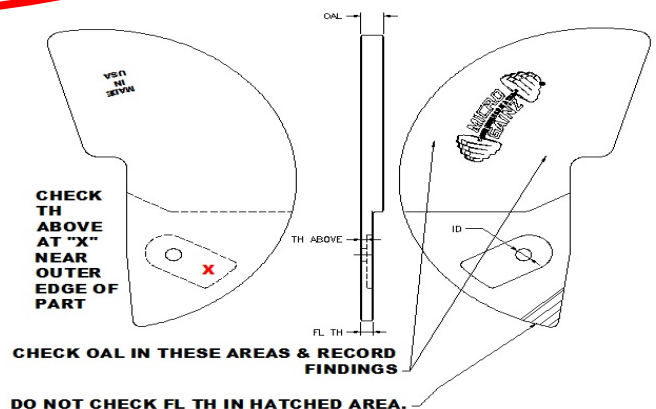
PLACE PARTS ON SKIDS W/ CARDBOARD SEPARATORS -
11 X 15 PER LAYER 8 LAYERS HIGH

Production Steps

1. Mold STY-202
2. Sinter
3. Grt Blast - In House
4. QC Check
5. Packing

UPDATED CHICO

Daryl Almendarez 08/15/2025





MULTI-LEVEL PRESS SET-UP INFORMATION SHEET

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PRESS#

PRE SETUP CHECKLIST

DIE SETTER TO CHECK THE FOLLOWING PRIOR TO SETTING UP PRESS

- ___ CHECK LINKAGE
- ___ MITER GEAR
- ___ ROD ENDS
- ___ VISUAL INSPECTION OF PRESS
- ___ CHECK AND CLEAN SHOE AND DIE PLATE FOR DEBRIS

DIE SETTER SIGN OFF _____

DATE: _____

AIR CLUTCH: _____ P.S.I.		<u>DENSITIES – IF APPLICABLE</u>		<u>TONNAGE</u>	
EJECTION: _____ P.S.I.		WHOLE PART DENSITY: _____		HIGH	HIGH
DELAY 1. ANGLE: _____ Time _____		HUB: _____ OTHER: _____		LOW	GOOD
DELAY 2. ANGLE: _____ Time _____		TOP OR FLANGE: _____			LOW
		BOTTOM OR BODY: _____			GOOD

<u>DIE PLATE</u>		<u>#1 PLATE</u>		<u>#2 PLATE</u>		<u>#3 PLATE</u>	
FLOAT: _____ P.S.I.		FLOAT: _____ P.S.I.		FLOAT: _____ P.S.I.		FLOAT: _____ P.S.I.	
HOLD: _____ P.S.I.		HOLD: _____ P.S.I.		HOLD: _____ P.S.I.		HOLD: _____ P.S.I.	
CAM SETTING: -		CAM SETTING: -		CAM SETTING: -		CAM SETTING: -	
NOTES _____		NOTES _____		NOTES _____		NOTES _____	

<u>FILL POSITIONS</u>		<u>MOLD POSITIONS</u>		<u>UNDERFILL / OVERFILL</u>	
DIE TO #1: _____		DIE TO #1: _____		P.S.I. _____	
DIE TO #2: _____		DIE TO #2: _____		CAM SETTING 1: _____ - _____	
DIE TO #3: _____		DIE TO #3: _____		CAM SETTING 2: _____ - _____	
FILL ABV C'BORE: _____ (PIN)		FILL ABV C'BORE: _____ (PIN)		AMT OF MOVEMENT: _____	
DIE TO FLT. PUNCH: _____ (AIR ON)		DIE TO FLT. PUNCH: _____ (AIR ON)			

<u>FILLER SHOE</u>				POS	VEL.
START: ==	DWELL: _____	SEC. OVER DIE: _____			
RESUME: ==	BUMP ON / OFF: _____	BUMP: _____			
CANCEL: ==	NO. OF SHAKES: _____	SHAKE: _____			
CLEAR: --	CHECK IF HAND PICK: _____	RETRACT: _____			

<u>INNER & OUTER PUNCH</u>					
INNER PUNCH: _____ P.S.I.	AMT. OF MOVEMENT: _____			T.P.H.D. _____	P.S.I. _____
CAM SETTING 1: _____ - _____				CAM SETTINGS: _____	-
CAM SETTING 2: _____ - _____					
OUTER PUNCH: _____ P.S.I.					
HEAD PRESSURE: _____ P.S.I.					



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HYDRAULIC VELOCITIES			AIR CORE ROD SETTING		
FILL:	MOLD:	EJECT:	FROM:	TO:	PSI:

HYDRAULIC PRESSURES		
UP:	COUNTER:	DOWN:

COMMAND DOWN HYDRAULIC CORE ROD CAM SETTING					
UP TO FILL	F		FILL TEST	F	T
DOWN FOR MOLD	F		RETRACT TEST	F	T
DOWN FOR EJECT	F		EJECT TEST	F	T
MOLD BLOCKS	F	T	MOLD TEST	F	T

FLOAT MODE HYDRAULIC CORE ROD					
UP TO FILL	F		FILL TEST	F	T
DOWN FOR EJECT	F		RETRACT TEST	F	T
FLOAT FOR MOLD	F	T	EJECT TEST	F	T
FLOAT FOR EJECT	F	T	MOLD TEST	F	T
BLOCKS	F	T			

COMMAND DOWN WITH RAM HYDRAULIC CORE ROD CAM SETTING					
UP TO FILL	F		FILL TEST	F	T
TRIGGER	F		RETRACT TEST	F	T
DOWN FOR EJECT	F		EJECT TEST	F	T
BLOCKS	F	T	MOLD TEST	F	T



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SPECIAL INSTRUCTIONS OR COMMENTS:

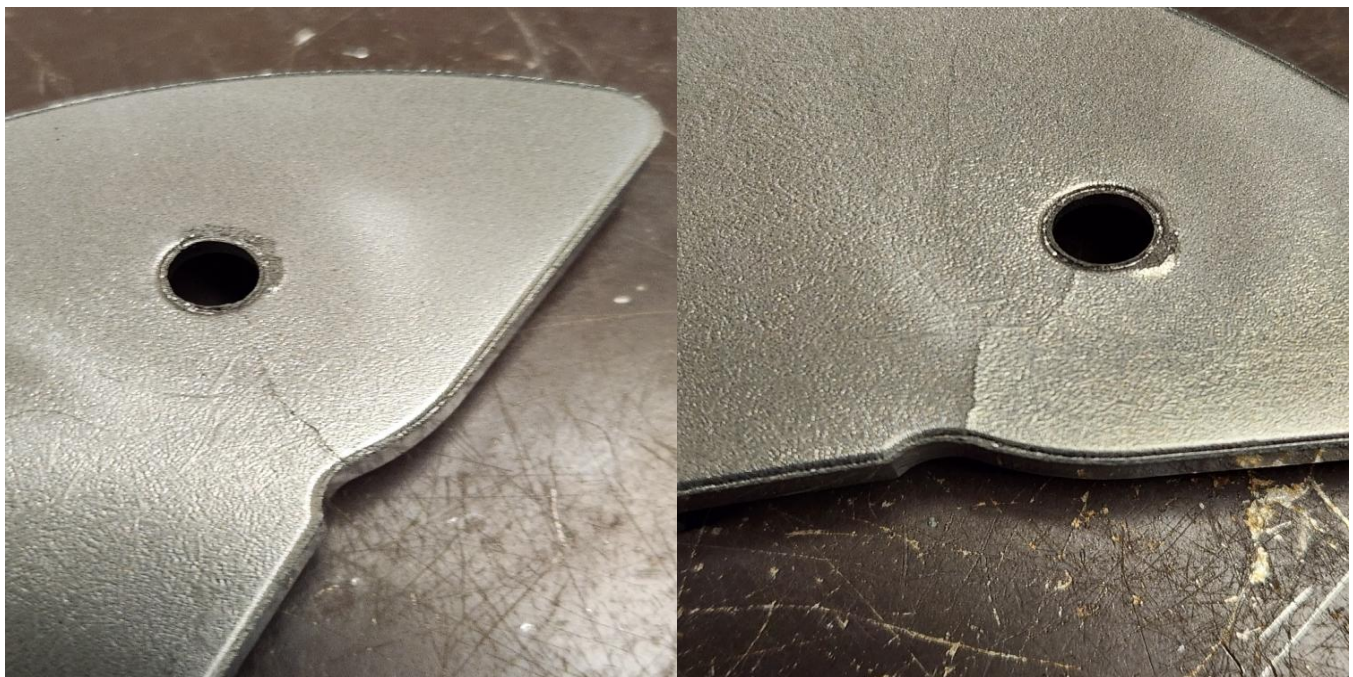
USE .100 SPACER UNDER #1 PUNCH (KEEP WITH TOOLS)

USE ADJUSTABLE COLLET ON #1 PUNCH ALSO

USE SPACER BEHIND TOP PUNCH SO INSERT CAN'T PUSH BACK

PART OR TOOLING PROBLEMS:

**IF PARTS ARE FOUND WITH CRACKS DURING MOLDING.
STOP AND PLACE PARTS ON HOLD TILL DETERMINATION
CAN BE MADE BY C.A.S.T MEMBERS.**



**WATCH FOR CRACKING FACE OF PART AS IT COMES OUT OF THE
PRESS
THERE HAVE BEEN CUSTOMER COMPLAINTS**



**MULTI-LEVEL PRESS SET-UP INFORMATION SHEET
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WATCH FOR CRACKING ON FLANGE OF PART



WATCH FOR CRACKING IN C'BORE & ACROSS FACE OF PART



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VERIFY CORRECT

INSERT

1.0 LBS

DO NOT MIX WITH

SIMILAR PARTS