Process Control Plan MOLDING Run No: Cust Part No: SFC-1700 set up difficulty D Reference Only UPDATED: 10/24/2024 REV. NO: PRINTED: 02/21/2025 TONNAGE: PRESS: QTY: 2,100 START DATE: 2-24-25 **DAYS REQUIRED: 1 DUE BY:** FINISH DIMENSIONS: PUSHOUT 2000# MIN WEIGHT / PC: 160.5 / 162.9 **MATERIAL: STY-204 DENSITY:** 6.7 / 6.8 **VOLUME:** 23.954 APPROVED VENDOR: MOLDING DIMENSIONS: WEIGHT BODY LEN FL TH 1.348 .598 .748 160.5 .753 162.9 1.353 .603 INSPECTION METHOD: 3 / 1/2 hr 3 / 1/2 hr 3 / 1/2 hr 3 / 1/2 hr **MATERIAL MIX: STY-204 DESC:** FC-0205 BLENDING: Blend 358.38 # per M Actual: 10 Set-up by: Mille

PRESS SPEED: Target: 10 rpm's

Explanation if Actual differs from Target:

TOOL LOCATION: 02C

DIE #: 705

PIN #: 825

T PUNCH #: 867

B PUNCH #: 867

TOOLING:

SETUP:

INSTRUCTIONS:

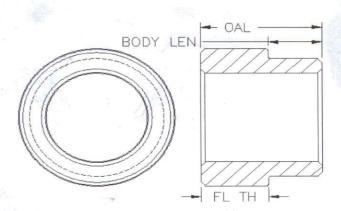
WATCH DIE CAVITY FOR PROPER FILL OPERATOR TO CHECK ALL MOLDING LENGTHS EVERY, 15 MINS & RECORD FINDINGS AS PRESCRIBED ON DATASHEET

GREEN PART STORAGE:

PLACE PARTS ON SKIDS W/ CARDBOARD SEPARATORS & MOVE TO ASSEMBLE AREA

Production Steps

- 1. Mold STY-204
- 2. ASM-SFC1700/SSTC3700
- 3. QC Check
- 4. Packing



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