



We Make It Happen

# Process Control Plan

Cust Part #: 09739501

Reference Only

# MOLDING

SST-2317

Run No:

UPDATED: 08/18/2025 REV. NO: A1

TONNAGE:

PRESS:

SET-UP DIFFICULTY - B

PRINTED: 08/18/2025

QTY:

FINISH DIMENSIONS:

START DATE:

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	SM ID
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: \_\_\_\_\_

Explanation if Actual differs from Target:

\_\_\_\_\_

TOOL LOCATION: F 4 A

DIE #: 607

PIN #: 731

T PUNCH #: 757

B PUNCH #: 757

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 4  
LAYERS HIGH & MOVE TO SINTERING AREA

Production Steps

1. Mold STY-210

2. Sinter

3. Machining-Sintergy

4. QC Check

5. Packing

UPDATED CHICO

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