

CONTROLLED
PRINT

Process Control Plan
Cust Part No:
Reference Only

MOLDING
SG-3900

Run No:

UPDATED: 09/22/2022 REV. NO: H
TONNAGE: 750 PRESS: 0

PRINTED: 12/17/2024

QTY: 1,100

FINISH DIMENSIONS:

START DATE: 12-20-24

DAYS REQUIRED: 1

DUE BY:

OAL	WEIGHT	GEAR OD	MOW	ID	LUG HARDNESS	TOOTH HARDNESS	
.305		3.940	4.029	1.1213	Rc 32	Rc 30	
.315		3.955	4.044	1.1285	50	50	

MATERIAL: STY-406

DENSITY: 6.9 / 7.0

VOLUME: 38.04

WEIGHT / PC: 262.5 / 266.3

APPROVED VENDOR: NAH

MOLDING DIMENSIONS:

OAL	WEIGHT	
.308	262.5	
.313	266.3	

INSPECTION METHOD:

3 / 1/2 hr	3 / 1/2 hr	
------------	------------	--

MATERIAL MIX: STY-406

DESC:

BLENDING: Blend 585.86 # per M

PRESS SPEED: Target: 0 rpm's

Actual: _____ Set-up by: _____

Explanation if Actual differs from Target:

TOOL LOCATION: N2D
T PUNCH #: 798

DIE #: 646
B PUNCH #: 798

PIN #: 765

TOOLING:

SETUP:

please add

INSTRUCTIONS:

WATCH DIE CAVITY FOR PROPER FILL
WATCH FOR CHIPPED AND BROKEN GEAR TEETH
OPERATOR TO CHECK ALL MOLDING LENGTHS EVERY
15 MINS AND RECORD FINDINGS AS PRESCRIBED ON
DATASHEET

GREEN PART STORAGE:

PLACE ON SKIDS IN STACKS OF 3 AND MOVE TO
SINTERING AREA

Production Steps

1. Mold STY-406
2. Sinter
3. ANNEALING
4. QC Check
5. Packing

