



Process Control Plan
Cust Part No: 289619
Reference Only

SINTERING
SST-2606

Run No:

UPDATED: 01/17/2025 REV. NO: 000

PRINTED: 01/27/2025

START DATE:

DAYS REQUIRED: 1

DUE BY:

QTY:

MATERIAL: B-133L

90-10 BRASS

HARDNESS: Rh 72

SINTERING SPECIFICATIONS

OVEN NUMBER	BELT SPEED	PRE HEAT ± 50°	MAIN HEAT ± 20°	DEW PT ± 4°		
3	3	1300	1650	45 / 55		
67	6"	1200/1200/1200	1650	45 / 55		
68	5.5	1200/1200	1650	45 / 55		
107	6	1200/1200/1200	1650	45 / 55		
126	6	1200/1200/1200	1650	45 / 55		

Use The Gray Area Above For Changes To Sintering Spec. Approve & Initial

SINTERING DIMENSIONS

WEIGHT	O.D.	CRUSH @ SETUP	DENSITY SIZE 1ST	HARDNESS	
	2.622	3000#	7.8	Rh 72	
	2.630	MIN	7.9	min	

INSPECTION METHOD

	1 / 2 hrs.	1 / 2 hrs.	1 / 2hrs.	1 / 2 hrs	
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INSTRUCTIONS:

SINTERING LOADING:

**SPRINKLE SMALL AMOUNT OF ZINC POWDER ON 8 - 10
CERAMIC PLATES BEFORE RUNNING PRODUCTION**

Load parts tight as possible on belt.

MUST Hand Load Parts on Belt.

Handle with Care

SINTERING UNLOADING:

INSURE PART IS FULLY SINTERED

Parts can Fall into Drums

Use 1 Sized Part for Weight, Density, & Crush Tests.

Record Readings on Data Form & Also Write Readings on Part.

Date Part and Place in Box.

NEXT PROCESS:

Move parts to molding area.

