

CONTROLLED

PRINT

Process Control Plan MOLDING

Run No:

Cust Part No:
Reference Only**S-3006**

UPDATED: 10/21/2024 REV. NO: B

TONNAGE: PRESS: 0

PRINTED: 01/16/2025

QTY: 4,500

FINISH DIMENSIONS:

START DATE: -22-25

DAYS REQUIRED: 1

DUE BY:

OAL	OD	ID	HARDNESS
.3298	2.995	1.010	RB 60
.3398	3.005	1.016	MIN

MATERIAL: STY-102

DENSITY: 6.6 / 6.7 VOLUME:

WEIGHT / PC: 226 / 232

APPROVED VENDOR: REMILL

MOLDING DIMENSIONS:

OAL	WEIGHT
.332	226
.337	232

INSPECTION METHOD:	
3 / 1/2 hr	3 / 1/2 hr

MATERIAL MIX: STY-102

DESC: F-0008

BLENDING: Blend 510.4 # per M

PRESS SPEED: Target: 0 rpm's

Actual: S

Set-up by: Jason

Explanation if Actual differs from Target:

TOOL LOCATION: P2C

T PUNCH #: 870

DIE #: 691

B PUNCH #: 851

PIN #: 810

TOOLING:

SETUP:

INSTRUCTIONS:

WATCH DIE CAVITY FOR PROPER FILL

WATCH FOR BROKEN & CHIPPED EDGES

GREEN PART STORAGE:

PLACE PARTS ON SKIDS & MOVE TO SINTERING AREA

Production Steps

1. Mold STY-102
2. Sinter
3. Grt Blast - In House
4. QC Check
5. Packing

