

**ABC Company**  
**Part Name**  
**PART NUMBER**  
**1 Cavity Mold**



**February 09, 2001**  
**Revision Level: 01**

## Operator Procedure Sheet

ABC Company

Part Name

PART NUMBER

Mold #: 5555

Gauges: Pin Gauges & Calipers



Picture 1



**SPECIAL INSTRUCTION: Each insert has to be checked for length with the Go/No Go gage prior to loading in the mold (see picture 1).**

Picture 2



1. When the mold opens, remove the part and the runner (see picture 2). On the bottom of the Brass Insert, #INSERT BCRANK, there is a hole. Place 1 insert with the hole on the pins in the front of the mold (see picture 3). Close the door.

Picture 3



2. Inspect the part; see the **PRODUCT QUALITY STANDARD SHEET**.

**Operator Procedure Sheet**  
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3. Break or clip the runner from the part (see picture 4).  
Trim the gate area smooth.

Picture 4



4. Trim flash (excess plastic) if present (see picture 5).

Picture 5



5. Cool 10 parts on the table at all times (see picture 6).

Picture 6



**NOTE: Place all rejected part in a box or container. At the end of the order, these parts are taken to maintenance to remove the inserts. You will need to be on a REWORK labor ticket with the part number and shop order. To remove the inserts, place the end of the part with the insert in the vise. Tighten the vice until the material around the insert cracks. You may have to do this several times. Do not deform the hole in the insert. Keep all inserts in the box. Give the inserts to your material handler for disposition.**

**Packaging Procedure Sheet**  
**ABC Company**  
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1. Date stamp a (Produced by) #PR-002 slip (see picture 7) and place in each TOTE.

Picture 7



2. Neatly bulk package parts in a returnable RCB (12x15x5) TOTE (see picture 8). 40 total parts per tote.

Picture 8



3. Place a ½ date stamped label on each tote (see picture 9).

Picture 9



4. Place TOTES on an orange skid, 12 totes per layer, 8 layers high. 96 total totes per skid.

**ALTERNATE PACK:**

1. Neatly bulk package parts in a ¼ Keg box. 60 total parts per box.
2. Place a date stamped label in the LOWER right hand corner of each box.
3. Place full boxes on a skid, 12 boxes per layer, 5 layers high. 60 total boxes per skid.

## Product Quality Standard Sheet

ABC Company

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### Quality Assurance Information

#### Shared Responsibilities:

1. Gate trim must be flush to .020" high.
2. Maximum allowable flash (excess plastic) = .010" thick and .020" high. Any flash (excess plastic) that exceeds this must be trimmed.
3. Color is to be black.
4. This part has a molded brass insert. One end of the insert has a hole in it, this end of the insert must be on the side of the part with the part number on it. Any excess material that may cover the holes of either side of the brass insert is acceptable. NOTE: Unfilled areas on the side of the brass insert is acceptable as long as it does not exceed .355" in length and .155" in width.
5. Splay and/or burns are not acceptable.

#### Quality Assurance Responsibilities:

1. Check the following dimensions at start-up and twice per shift:

<u>Area</u>	<u>Dimension</u>	<u>Gauge(s)</u>	<u>Picture (if available)</u>
Inside Diameter of the hole (large hole in the middle of the part) check on both sides of part.	Minimum: .499" Maximum: .503"	Gauge Pins	
Thickness (over large hole)	Minimum: .389" Maximum: .709"	Calipers	
Small hole inside diameter	Minimum: .256" Maximum: .295"	Pin Gauge	

**Run History**  
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This section is to include photos and descriptions of what is and is not acceptable to our customers. The purpose is to transfer the knowledge and lessons that ABC Company has learned with respect to our customers' requirements and expectations.

**Work Station Layout (press 26)**

**ABC Company**

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