

Analysis of Casting Defects and Identification of Remedial Measures – A Diagnostic Study

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Abstract—Paper presents analysis of casting defects and identification of remedial measures carried out at Dakshin Foundry Ltd, Bangalore, India. Diagnostic study carried out on Transition Support Bracket (TSB) Castings revealed that the contribution of the four prominent defects in casting rejections are sand drop, blow hole, mismatch, and oversize. It was noticed that these defects are frequently occurring at particular locations. Systematic analyses were carried out to understand the reasons for defects occurrence and suitable remedial measures were identified. Outcome of the validation trials showed substantial reduction in rejection of castings. Company has accepted the remedial measures and incorporated them in the standard operating procedure.

I. INTRODUCTION

Dakshin Foundry is facing casting rejections due to some chronic defects, after observing six months' data of the company the most frequently rejected castings identified were TSB, Converter Housing, and Gear Housing. Out of these three castings TSB casting was identified as most severely affected casting, hence it was considered for detail investigation. The work on Quality Improvement of castings was carried out in following steps.

- Identification of defects in the TSB casting and analysis.
- Selection of most chronic defects which frequently occurred and carried out the analysis.
- Identification of root causes and finding the remedial measures.
- Production trials in the company with the remedial measures and validation.

II. IDENTIFICATION OF CASTING DEFECTS AND ANALYSIS

The frequently rejected castings identified at Dakshin Foundry are Transition Support Bracket (TSB), Converter Housing, Gear Housing etc. TSB casting comprises 15-20 percent of total production of the company. The number of castings produced in the month of June 2010 and their weight, quantity and cost per kg are given in Table I. As the production of TSB is maximum and its cost of rejection is highest this casting was considered for detail study. TSB casting is having defects such as sand drop, blow hole, shrinkage, mismatch, sand fusion, core shift, parting line leak, oversize, flash, mould not filled, cold shut etc. The data observation of defects in TSB for six months period from June 2010 to Dec 2010 is plotted as Pareto Chart shown in Figure 1. It may be noticed that the most occurring casting defects are Sand drop, Blow holes, Mismatch, and Oversize hence they were picked up for diagnostic study. To understand the reason for causes of these four defects a detail study was carried out in foundry.

III. PRODUCTION PROCESS OF TSB CASTING

Photograph of the TSB casting is shown in Figure 2. Details of sand systems used for mould and core making are explained hereunder [1], [2].

Sand System used for Mould making:

Sand: Silica sand 98.5 %

Binder: Urea Furan Resin 1% of sand

Catalyst: 0.5% of resin

Silica sand comprises 85% reclaimed sand and 15% new sand with AFS number 4.5 to 5.5, clay content 0.27% (max), and moisture 0.5% (max). Mixing of sand and binder along with catalyst is done in 20 tonne mixer for 3 to 4 minutes.

Sand System used for Core making:

Four cores are used in TSB casting, these are central core, breaker core, U cut core, flat core.

Sand system used for central core, U cut core, breaker core are:

Sand: Silica sand 98.5 %

Binder: Urea Furan Resin 1% of sand

Catalyst: 0.5% of resin

Sand system used for flat core are:

Sand: Silica sand 96.5 %

Binder: Sodium silicate 3.5 %

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