

**Part Name / No : Apache holder bracket ( B2FP069030)**



**MAP ALLOYS**

# **PROPOSAL to reduce blow holes**

**Part Name : Apache Holder bracket**

**Part No :B2FP069030**

**Part Name / No : Apache holder bracket(B2FP06903O)**

**Improvement for: Defect – Blow holes and shrinkage.**

**Part Name / No : Apache Holder bracket/B2FP06903O**

**Customer : ETL**

**EXISTING Casting**



**PROPOSED CHANGE**



**PROBLEMS :- Contribution of Blow hole rejection 40% approx.(In-house and ETL end)**

**SOLUTION :**

1. Air vents of dia 8.00mm will be provided as per GREEN CIRCLE and marked in both halves(Total 9 Nos) .
2. Calender of die 10 mm will be replace with dia 12.00mm as marked by YELLOW CIRCLE.
3. One ejector pin of 6.00mm will be replaced by 8.00mm.

- Your existing supplier also have round impression mark so it horizontal implementation only at 3 position extra air vents added to reduce blow hole .



3/16/2023



3

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**Thank you**