

AVAYA

\$114,000 Lifetime Savings
38% Standard Deviation Improvement

Case Study Overview

AVAYA, a supplier of telecommunication products, historically built low-cavitation molds to avoid part quality problems commonly associated with higher cavitations. Unhappy with their high operation and equipment costs, and the inherent variation they were experiencing by running the same part in multiple molds and machines, Process Engineer Jay VanRoy sought a more efficient production method. As part of his cost-savings initiative, VanRoy tested the effectiveness of MeltFlipper® in one-half of a new, higher cavitation 16-cavity production mold.

Project Description

- Telecommunication Connector (Figure 1)
- Goal: Optimize Cavitation vs. Quality/Cost

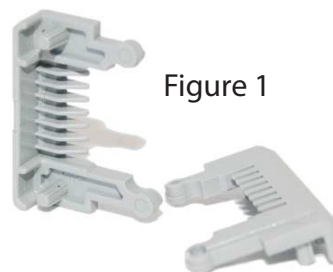


Figure 1

Problems

- Low Cavitation
 - Increased production and equipment costs
 - Multiple molds requiring multiple machines
- High Cavitation
 - Large imbalance
 - Short shots in thin features, high scrap rates

Solutions

- MeltFlipper® Technology
 Installed in higher cavitation 16-cavity mold

Benefits and Cost Savings

- \$133,646 annual savings on press time only
- 33% to 4% reduction in shear imbalance
- 38% standard deviation improvement (see Table 1)
- Lower pressures in mold (see Figures 2-3)
- Lower operating costs with higher cavitation mold with fewer machines required

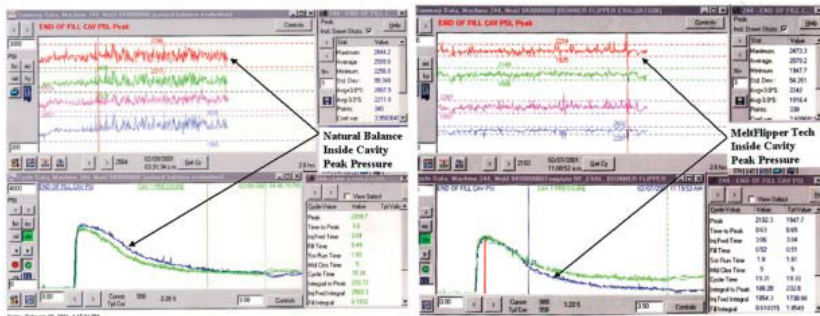


Figure 2: Pressure trace without MeltFlipper®

Figure 3: Pressure trace with MeltFlipper®

16 Cavity Tool Avaya Inc., RJG Inc.	Peak Pressure/Std Dev	
	Inside Cavity	Outside Cavity
Natural Balance	2509.8/99.348	2321.6/84.795
Meltflipper	2079.2/54.261	2150.6/57.848

Table 1: Summary of peak pressures and standard deviations

“MeltFlipper® technology provided AVAYA a cost reduction, a larger processing window, and quality improvements.” -Jay VanRoy, Process Engineer, AVAYA