

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

Dr D.N. Shivappa¹, Mr Rohit², Mr. Abhijit Bhattacharya³

¹ Professor, Mechanical Engineering Department, Sir MV Institute of Technology, Bangalore Karnataka India.

² M Tech Student, Mechanical Engineering Department, Sir MV Institute of Technology, Bangalore India

³ Head Operations, Dakshin Foundry Pvt. Ltd, Bangalore Karnataka India.

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 %

Analysis Of Casting Defects And Identification Of Remedial

RC Schank



Analysis Of Casting Defects And Identification Of Remedial:

The Enigmatic Realm of **Analysis Of Casting Defects And Identification Of Remedial**: Unleashing the Language is Inner Magic

In a fast-paced digital era where connections and knowledge intertwine, the enigmatic realm of language reveals its inherent magic. Its capacity to stir emotions, ignite contemplation, and catalyze profound transformations is nothing short of extraordinary. Within the captivating pages of **Analysis Of Casting Defects And Identification Of Remedial** a literary masterpiece penned by a renowned author, readers attempt a transformative journey, unlocking the secrets and untapped potential embedded within each word. In this evaluation, we shall explore the book's core themes, assess its distinct writing style, and delve into its lasting effect on the hearts and minds of those who partake in its reading experience.

https://matrix.jamesarcher.co/results/book-search/default.aspx/habermas_and_the_unfinished_project_of_modernity_critical_essays_on_the_philosophical_discourse_of_modernity_studies_in_contemporary_german_social_thought.pdf

Table of Contents Analysis Of Casting Defects And Identification Of Remedial

1. Understanding the eBook Analysis Of Casting Defects And Identification Of Remedial
 - The Rise of Digital Reading Analysis Of Casting Defects And Identification Of Remedial
 - Advantages of eBooks Over Traditional Books
2. Identifying Analysis Of Casting Defects And Identification Of Remedial
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Analysis Of Casting Defects And Identification Of Remedial
 - User-Friendly Interface
4. Exploring eBook Recommendations from Analysis Of Casting Defects And Identification Of Remedial
 - Personalized Recommendations

- Analysis Of Casting Defects And Identification Of Remedial User Reviews and Ratings
- Analysis Of Casting Defects And Identification Of Remedial and Bestseller Lists
- 5. Accessing Analysis Of Casting Defects And Identification Of Remedial Free and Paid eBooks
 - Analysis Of Casting Defects And Identification Of Remedial Public Domain eBooks
 - Analysis Of Casting Defects And Identification Of Remedial eBook Subscription Services
 - Analysis Of Casting Defects And Identification Of Remedial Budget-Friendly Options
- 6. Navigating Analysis Of Casting Defects And Identification Of Remedial eBook Formats
 - ePub, PDF, MOBI, and More
 - Analysis Of Casting Defects And Identification Of Remedial Compatibility with Devices
 - Analysis Of Casting Defects And Identification Of Remedial Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Analysis Of Casting Defects And Identification Of Remedial
 - Highlighting and Note-Taking Analysis Of Casting Defects And Identification Of Remedial
 - Interactive Elements Analysis Of Casting Defects And Identification Of Remedial
- 8. Staying Engaged with Analysis Of Casting Defects And Identification Of Remedial
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Analysis Of Casting Defects And Identification Of Remedial
- 9. Balancing eBooks and Physical Books Analysis Of Casting Defects And Identification Of Remedial
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Analysis Of Casting Defects And Identification Of Remedial
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Analysis Of Casting Defects And Identification Of Remedial
 - Setting Reading Goals Analysis Of Casting Defects And Identification Of Remedial
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Analysis Of Casting Defects And Identification Of Remedial
 - Fact-Checking eBook Content of Analysis Of Casting Defects And Identification Of Remedial

- Distinguishing Credible Sources
13. Promoting Lifelong Learning
- Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
14. Embracing eBook Trends
- Integration of Multimedia Elements
 - Interactive and Gamified eBooks

Analysis Of Casting Defects And Identification Of Remedial Introduction

In the digital age, access to information has become easier than ever before. The ability to download Analysis Of Casting Defects And Identification Of Remedial has revolutionized the way we consume written content. Whether you are a student looking for course material, an avid reader searching for your next favorite book, or a professional seeking research papers, the option to download Analysis Of Casting Defects And Identification Of Remedial has opened up a world of possibilities. Downloading Analysis Of Casting Defects And Identification Of Remedial provides numerous advantages over physical copies of books and documents. Firstly, it is incredibly convenient. Gone are the days of carrying around heavy textbooks or bulky folders filled with papers. With the click of a button, you can gain immediate access to valuable resources on any device. This convenience allows for efficient studying, researching, and reading on the go. Moreover, the cost-effective nature of downloading Analysis Of Casting Defects And Identification Of Remedial has democratized knowledge. Traditional books and academic journals can be expensive, making it difficult for individuals with limited financial resources to access information. By offering free PDF downloads, publishers and authors are enabling a wider audience to benefit from their work. This inclusivity promotes equal opportunities for learning and personal growth. There are numerous websites and platforms where individuals can download Analysis Of Casting Defects And Identification Of Remedial. These websites range from academic databases offering research papers and journals to online libraries with an expansive collection of books from various genres. Many authors and publishers also upload their work to specific websites, granting readers access to their content without any charge. These platforms not only provide access to existing literature but also serve as an excellent platform for undiscovered authors to share their work with the world. However, it is essential to be cautious while downloading Analysis Of Casting Defects And Identification Of Remedial. Some websites may offer pirated or illegally obtained copies of copyrighted material. Engaging in such activities not only violates copyright laws but also undermines the efforts of authors, publishers, and researchers. To ensure ethical downloading, it is advisable to utilize reputable websites that prioritize the legal distribution of content. When downloading Analysis Of Casting Defects And Identification Of

Remedial, users should also consider the potential security risks associated with online platforms. Malicious actors may exploit vulnerabilities in unprotected websites to distribute malware or steal personal information. To protect themselves, individuals should ensure their devices have reliable antivirus software installed and validate the legitimacy of the websites they are downloading from. In conclusion, the ability to download Analysis Of Casting Defects And Identification Of Remedial has transformed the way we access information. With the convenience, cost-effectiveness, and accessibility it offers, free PDF downloads have become a popular choice for students, researchers, and book lovers worldwide. However, it is crucial to engage in ethical downloading practices and prioritize personal security when utilizing online platforms. By doing so, individuals can make the most of the vast array of free PDF resources available and embark on a journey of continuous learning and intellectual growth.

FAQs About Analysis Of Casting Defects And Identification Of Remedial Books

How do I know which eBook platform is the best for me? Finding the best eBook platform depends on your reading preferences and device compatibility. Research different platforms, read user reviews, and explore their features before making a choice. Are free eBooks of good quality? Yes, many reputable platforms offer high-quality free eBooks, including classics and public domain works. However, make sure to verify the source to ensure the eBook credibility. Can I read eBooks without an eReader? Absolutely! Most eBook platforms offer web-based readers or mobile apps that allow you to read eBooks on your computer, tablet, or smartphone. How do I avoid digital eye strain while reading eBooks? To prevent digital eye strain, take regular breaks, adjust the font size and background color, and ensure proper lighting while reading eBooks. What the advantage of interactive eBooks? Interactive eBooks incorporate multimedia elements, quizzes, and activities, enhancing the reader engagement and providing a more immersive learning experience. Analysis Of Casting Defects And Identification Of Remedial is one of the best book in our library for free trial. We provide copy of Analysis Of Casting Defects And Identification Of Remedial in digital format, so the resources that you find are reliable. There are also many Ebooks of related with Analysis Of Casting Defects And Identification Of Remedial. Where to download Analysis Of Casting Defects And Identification Of Remedial online for free? Are you looking for Analysis Of Casting Defects And Identification Of Remedial PDF? This is definitely going to save you time and cash in something you should think about.

Find Analysis Of Casting Defects And Identification Of Remedial :

habermas and the unfinished project of modernity critical essays on the philosophical discourse of modernity

studies in contemporary german social thought

handbook of eid security concepts practical experiences technologies

hitachi zaxis zx240 3 zx240lc 3 zx250h 3 zx250lch 3 zx250lc 3 zx250lcn 3 zx250k 3 zx250lck 3 excavator

equipment components parts catalog manual

handbook of nutraceuticals and functional foods second edition

handbook of univariate and multivariate data analysis with ibm spss second edition

holt physics vibrations waves assessment chapter test a

hamworthy combustion engineering ltd

holt science spectrum physical science with earth and space science chapter resource file chapter 9 acids bases and salts

chapter 9 acids bases and salts

holt mcdougal geometry practice workbook answers

handbook of metal forming processes

hill and jones strategic management 10th edition

holt physics chapter 14 refraction test a

holt english workshop third course answer key

handbook of sports and recreational building design vol ume 1 second edition handbook of sports recreational building design

harcourt math grade 3 teacher s edition

Analysis Of Casting Defects And Identification Of Remedial :

look inside sketching from the imagination characters - Sep 02 2022

web sep 23 2023 this is book 10 from the sketching from the imagination series if you love sketchbooks these are the books to get by the way 3dtotal is offering good

sketching from imagination characters 3dtotal publishing - Jun 30 2022

web apr 16 2019 14k views 3 years ago i flick through 3dtotal publishing s beautiful book sketching from the imagination characters in this video show more show more

sketching from the imagination 3dtotal shop - Oct 03 2022

web sketching from imagination characters 3dtotal publishing art book tutorial flip through

sketching from the imagination characters paperback by - Apr 28 2022

web character design coming soon loish procreate sale sketchbooks sketching from the imaginations

sketching from the imagination character concepts - May 10 2023

web in sketching from the imagination characters fifty talented artists share their sketches inspirations and approaches to creating characters this book is a visually stunning

sketching from the imagination character concepts paperback - Dec 25 2021

sketching from the imagination characters anna s archive - Aug 01 2022

web in sketching from the imagination characters fifty talented artists share their sketches inspirations and approaches to creating characters this book is a visually stunning

sketching from the imagination by 3dtotal publishing - Sep 14 2023

web feb 16 2017 this is the fourth book in the sketching from the imagination series the earlier three were on creative drawing fantasy and sci fi all the good things that i ve

download sketching from imagination characters by 3d total - Feb 24 2022

sketching from the imagination characters paperback - Feb 07 2023

web sketching from the imagination characters 3dtotal publishing amazon sg books

sketching from the imagination character concepts - Dec 05 2022

web 0 00 1 55 look inside sketching from the imagination characters 3dtotal publishing 11 8k subscribers subscribe 842 44k views 6 years ago a flick through the pages of the

sketching from the imagination 3dtotal shop - Jan 26 2022

sketching from the imagination characters 3dtotal shop - Oct 15 2023

web in sketching from the imagination characters fifty exceptional traditional and digital artists have been chosen to share their sketches ranging from the creations of veteran

sketching from the imagination characters google books - Jul 12 2023

web in sketching from the imagination characters fifty talented artists share their sketches inspirations and approaches to creating characters this book is a visually stunning

book review sketching from the imagination character - May 30 2022

web sketching from imagination characters how to draw drawing and sketching objects and environments from your imagination 208 pages 2013 captive imagination letters

book review sketching from the imagination characters parka - Aug 13 2023

web in sketching from the imagination characters fifty talented artists share their sketches inspirations and approaches to creating characters this book is a visually stunning

sketching from the imagination characters paperback amazon - Nov 04 2022

web in sketching from the imagination characters fifty talented artists share their sketches inspirations and approaches to creating characters this book is a visually stunning

sketching from the imagination characters characters - Jun 11 2023

web over 300 pages featuring hundreds of unique character sketches that span a variety of styles and genres 50 chapters by 50 professional artists working in the fields of

sketching from the imagination characters paperback - Mar 08 2023

web jun 6 2023 delve into the world of heroine design as 50 of the world s finest character artists from the fields of animation illustration comics and games share a behind the

sketching from the imagination characters barnes - Jan 06 2023

web in sketching from the imagination 50 talented traditional and digital artists have been chosen to share their sketchbooks whether scribbled in a sketchpad or on a napkin

sketching from the imagination characters youtube - Mar 28 2022

web delve into the world of heroine design as 50 of the world s finest character artists from the fields of animation illustration comics and games share a behind the scenes look at

sketching from the imagination characters goodreads - Apr 09 2023

web mar 10 2017 in sketching from the imagination characters fifty talented artists share their sketches inspirations and approaches to creating characters this book is a

caterpillar c10 c12 engine workshop repair service manual - Aug 15 2023

web complete digital official shop manual contains service maintenance and troubleshooting information for the caterpillar c10 c12 engine diagnostic and repair procedures are covered in great detail to repair maintain rebuild refurbish or restore your c10 c12 engine like a professional mechanic in local service repair workshop

caterpillar cat c12 marine engine service repair manual - Oct 05 2022

web it is an original factory manual for c12 cat caterpillar marine engine service repair manual c1z contains high quality images circuit diagrams and instructions to help you to operate maintenance and service repair your machine

caterpillar c 12 engine service manual repair manual pdf - Jan 28 2022

web this caterpillar c 12 engine machine operation maintenance manual pdf download provides all the details necessary about operating and maintenance procedure i ll order the another service manual again win thu 2020 08 29 great site

ordered the wrong one bought the correct one they issued refund for my mistake dale bruns 2021 09 14

caterpillar c10 c12 mbj mbl diesel engine service manual set - Feb 09 2023

web this downloadable 4 volume pdf service manual set contains specifications service and rebuild procedures operating and testing adjusting information for the caterpillar c10 c12 mbj mbl diesel engines over 200 pages of the detailed oem information for the engine are included in this download

caterpillar c12 engine guide cat 12 specs performance - Feb 26 2022

web mar 11 2023 looking at the basic specs the caterpillar c12 is a 12 0l inline 6 turbodiesel the engine features two valves per cylinder for a total of 12 its operating range is 1 200 to 2 100 rpm cat c12 diesel engines weigh in at 2 070 lbs so uses are mostly limited to larger trucks buses and machinery

caterpillar c10 c12 engine workshop service repair manual - Nov 06 2022

web aug 29 2023 it is complete original factory for caterpillar c10 c12 engine covers all the service and repair information about caterpillar c10 c12 engine the information in this manual covers everything you need to know when you want to service and repair caterpillar c10 c12 engine

caterpillar c10 c12 truck engine service manual set - Mar 10 2023

web factory service information for the cat c10 and c12 engines with serial prefixes cpd 3cs and 2ks 14 manuals are included in the set which covers specifications operation and maintenance overhaul testing and adjusting wiring troubleshooting and much more for the engine and supporting systems this high quality manual set is written

caterpillar engine truck c12 manuals operator manual service - Mar 30 2022

web the caterpillar c12 engine has a power output ranging from 340 to 490 horsepower the exact power output of a specific c12 engine model depends on various factors such as its configuration and application the c12 engine is known for its reliable power and efficiency making it a popular choice for heavy duty truck and equipment applications

c12 cat caterpillar marine engine service repair manual - Dec 27 2021

web c12 cat caterpillar marine engine service repair manual c1z service repair manual contents disassembly and assembly general service information schematic specifications system operation testing and adjusting torque specifications troubleshooting file format pdf

c12 propulsion engine marine cat - Jul 02 2022

web cat c12 diesel marine propulsion engines with ratings of 340 490 bhp 254 366 bkw at 1800 2300 rpm meet imo ii extended service coverage esc optional engine protection coverage for up to 60 months from date of delivery may be purchased through your manual sump pump transmission oil cooler mounting system vibration isolators

c12 cat caterpillar marine engine service repair manual - Apr 30 2022

web c12 cat caterpillar marine engine service repair manual nfl it is an original factory manual for c12 cat caterpillar marine engine service repair manual nfl contains high quality images circuit diagrams and instructions to help you to operate maintenance

[caterpillar c10 c12 truck engine service troubleshooting manual set](#) - Jan 08 2023

web this downloadable 14 volume pdf service and troubleshooting manual set contains specifications service and overhaul procedures operating testing adjusting and troubleshooting information for caterpillar c10 and c12 truck diesel engines with cpd 2ks or 3cs prefix over 1 600 pages of detailed workshop information for the diesel

cat c10 c12 mbj mbl diesel engine service manual - May 12 2023

web cat c10 c12 mbj mbl diesel engine service manual pdf engines diesel engine i01796722 when the pump is viewed from the drive end the smcs code 1261 1263 3 tighten the bolt to the following torque 28 7 n m 21 5 lb ft 1

c12 - Jun 01 2022

web feb 9 2021 service tool and customer wiring connector center sump oil pan c12 acert engine dimensions weight 1 length to flywheel housing 1573 9 mm 61 96 in 2 width 968 6 mm 38 13 in 3 height 1008 7 mm 39 71 in caterpillar diesel engine oil 10w30 or 15w40 3 12

caterpillar c12 engines factory service shop manual - Jul 14 2023

web caterpillar c12 engines factory service shop manual instant download add to cart complete workshop service manual with electrical wiring diagrams for caterpillar c 12 engines it s the same service manual used by dealers that guaranteed to be fully functional and intact without any missing page

caterpillar cat c12 marine engine service repair the repair manual - Sep 04 2022

web this service manual is a guide to servicing and repairing of the caterpillar c12 marine engine the instructions are grouped by systems to serve the convenience of your ready reference long productive life of your engine depends to

caterpillar c12 engines factory service shop manual - Aug 03 2022

web caterpillar c12 engines service repair manual including maintenance overhaul disassembling assembling adjustment tune up operation inspecting diagnostic troubleshooting is divided into different sections each section covers a specific component or system with detailed illustrations

caterpillar c10 c12 truck engine service manual s n - Apr 11 2023

web caterpillar c10 c12 truck engine service manual s n cpd 2ks 3cs 129 95 84 95 buy now or add to cart covers caterpillar c10 c12 truck engines with serial number prefixes cpd 2ks 3cs pages 2 152 format pdf file size 84mb compatibility windows mac tablet notes bookmarked searchable printable instant

parts service manuals cat caterpillar - Jun 13 2023

web cat service parts and operation and maintenance manuals we have everything you need to keep your cat equipment performing whether you need genuine cat parts service and parts manuals or if you would like to contact your local cat dealer for support we make it easy to keep your cat equipment running

[caterpillar c 12 marine engine workshop repair service manual](#) - Dec 07 2022

web this caterpillar c 12 marine engine workshop repair service manual provides complete information for repairing and maintenance it includes testing and adjusting troubleshooting specifications disassembly and assembly instructions it is compatible with all windows and mac versions and comes with unlimited print copies

[61 best xxx indian girl nangi photo desi chut gaand pics](#) - Mar 09 2023

web may 8 2021 by goddess aphrodite desi sexy nude girls ki gulabi chut tight gaand aur juicy boobs ke images dekhkar lund hilaye lijiye maza is latest xxx indian girl nangi photo

[ladkiyon ki nangi photo nude collection xxx hd](#) - Feb 08 2023

web ladkiyon ki nangi photo xxx nude collection in hd is just too good i got many emails daily to share indian aunty s nude photos so in this post i shared many indian ladki nude

50 nude indian girls ke hot pics desi porn gallery - Nov 24 2021

web apr 11 2017 kuch der me uska boyfriend is ladki ko bhi nanga kar dega wo uski wait me he aur uske sath aur bhi bahut sab pics he niche is ladki ke kisi me ladki apni chut se

nangi ladki ful nangi photo pictures p 1 of 1 blingee com - Jan 27 2022

web nangi ladki ful nangi photo top rated most relevant most recent these animated pictures were created using the blingee free online photo editor create great digital art

[nangi ladki xhamster](#) - Sep 03 2022

web categories related to nangi ladki lick boobs japanese beautiful japanese massage chie aoi rina japanese hd japanese oil hot japanese teen 18

[nangi ladkiyon ki photo xxx nude collection hd](#) - Jul 13 2023

web nangi ladkiyon ki photo xxx new hd collection you are looking for it s here in this post i shared many indian ladkiyon ki nangi photos all indian ladki got a very hot figure with

nangi nangi ladkiyon ko chodte hue dikhayen porn indian - Feb 25 2022

web is that even possible yes it is and all the action packed nangi nangi ladkiyon ko chodte hue dikhayen sex scenes are here to satisfy your every need and moment you spend

[nangi sexy ladki ke hot fuck ki choda chodi sex video indian](#) - Mar 29 2022

web dono hindi mai gandi gandi baat karte hue jordaar pussy fuck masti karte hain ladki first time choda chodi karti hai aur

nude babes ki chanchal chut lund ki pyasi hai aur aapko

dus saal ki ladki ki nangi photo xxxww mobi - Jul 01 2022

web dus saal ki ladki ki nangi photo 00 00 00 00 21007 10 01 dus saal ki ladki ki xvideo dus saal ki ladki ki sexy video hd dus saal ki bachi ki triple dus saal ki ladki ka bp video

nangi ladki photo pictures p 1 of 1 blingee com - Aug 02 2022

web slideshow movie maker nangi ladki photo top rated most relevant most recent featured badges likes achievement best anime blingee these animated pictures were

indian college ladki ki nangi chut aur gand chudai photos - May 11 2023

web jawan desi aur gori ladkiyo ke hot college sex photos dekhe young ladkiyo ko lund chuste hue aur apni chut aur gaand ke andar lund lete hue nashik ki sexy college girl ko nangi

56 sexy indian nangi girls pics chut gaand boobs photos - Sep 22 2021

web may 13 2021 indian nangi girls ke sexy boobs gaand chut ke xxx pics may 13 2021 by goddess aphrodite desi hot babes ki tight chut gaand aur rasile boobs ke photos

kuwari ladki ki nangi photos porn sex images xxx pics - Jan 07 2023

web aug 27 2022 here you can see that kunwari indian ladkiyo ki chudai photos how the young girls enjoying the first sex with their boyfriends you can see these leaked photos