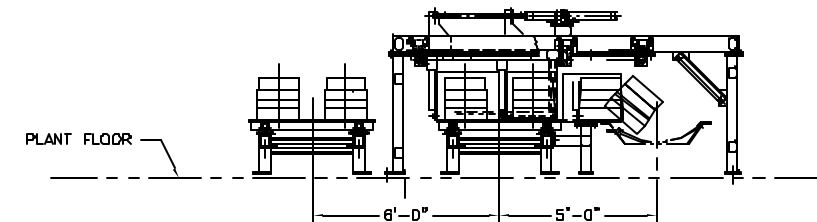
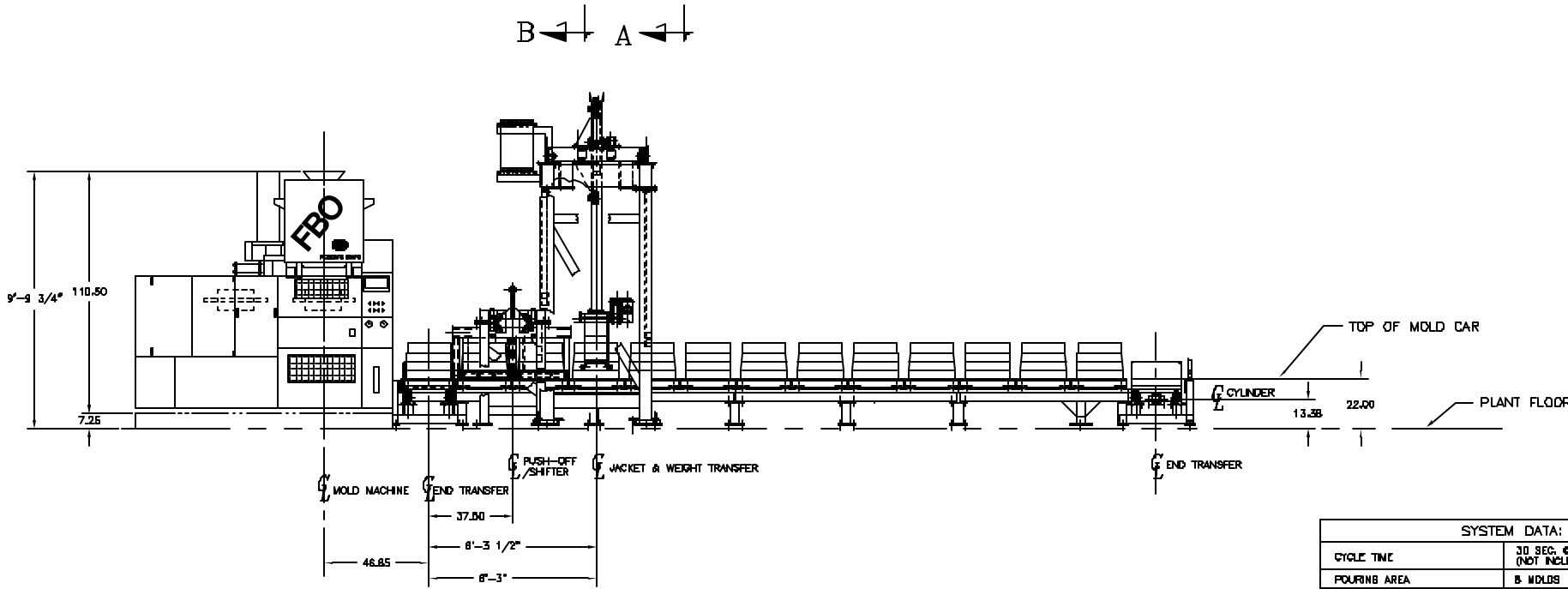


SECTION A-A

NOTE: JACKET CLEANING STATION IS OPTIONAL.



SECTION B-B

SYSTEM DATA:	
CYCLE TIME	30 SEC. @ 120 MOLDS/HR. (NOT INCLUDING CORE SETTING)
POURING AREA	8 MOLDS
COOLING TIME WITH JACKET @ 120 MOLDS/HR.	MAXIMUM 8.0 MINUTES MINIMUM 4.5 MINUTES
TOTAL COOLING TIME @ 120 MOLDS/HR.	MAXIMUM 21.0 MINUTES MINIMUM 17.5 MINUTES

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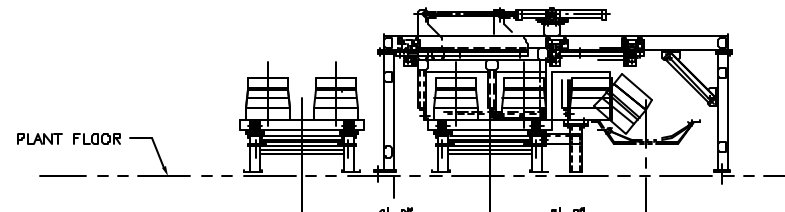
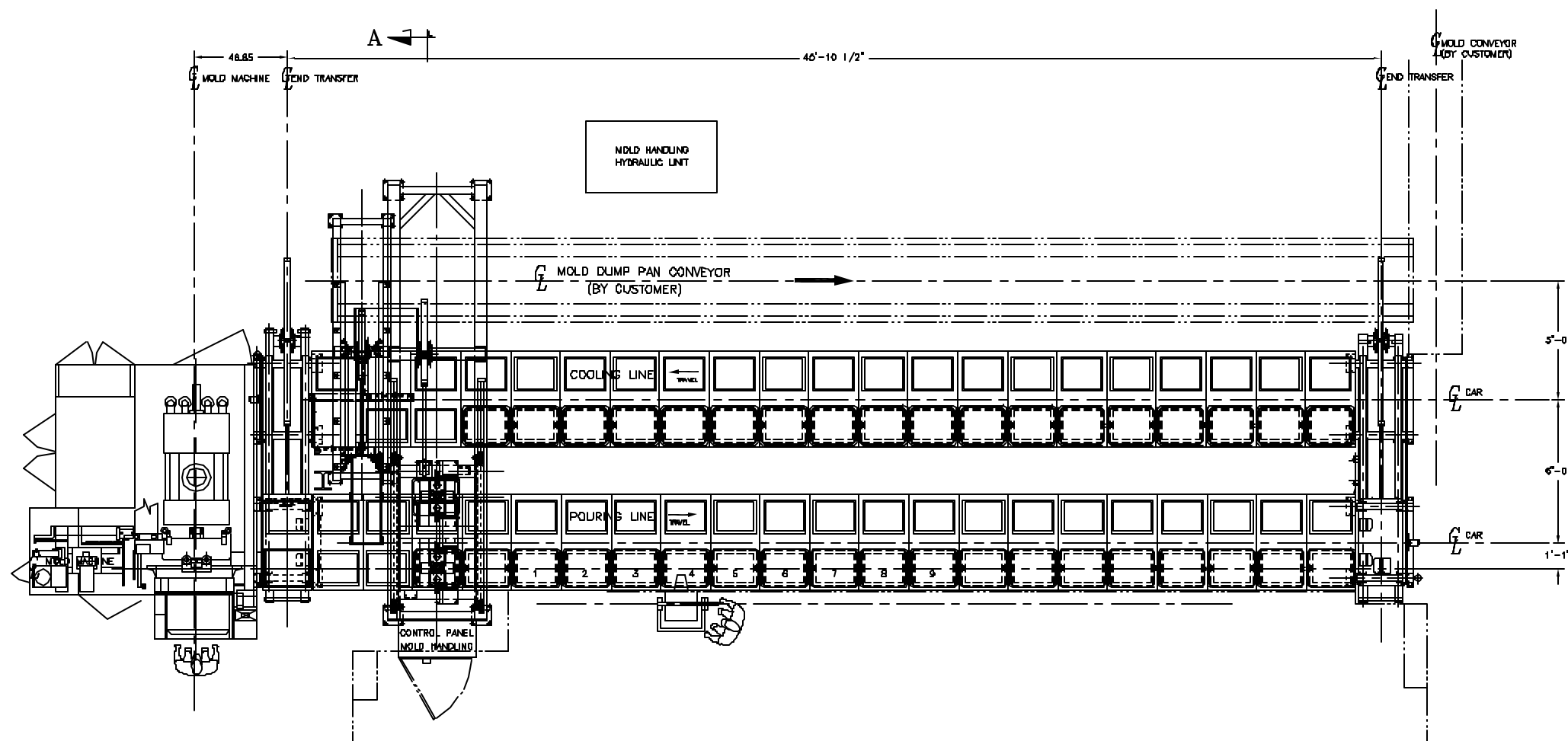
NO.	REVISIONS	DATE	BY

**ROBERTS SINTO CORPORATION**  
sinto 3501 WEST MAIN STREET • P.O. BOX 4070  
LANSING, MICHIGAN 48911-7940

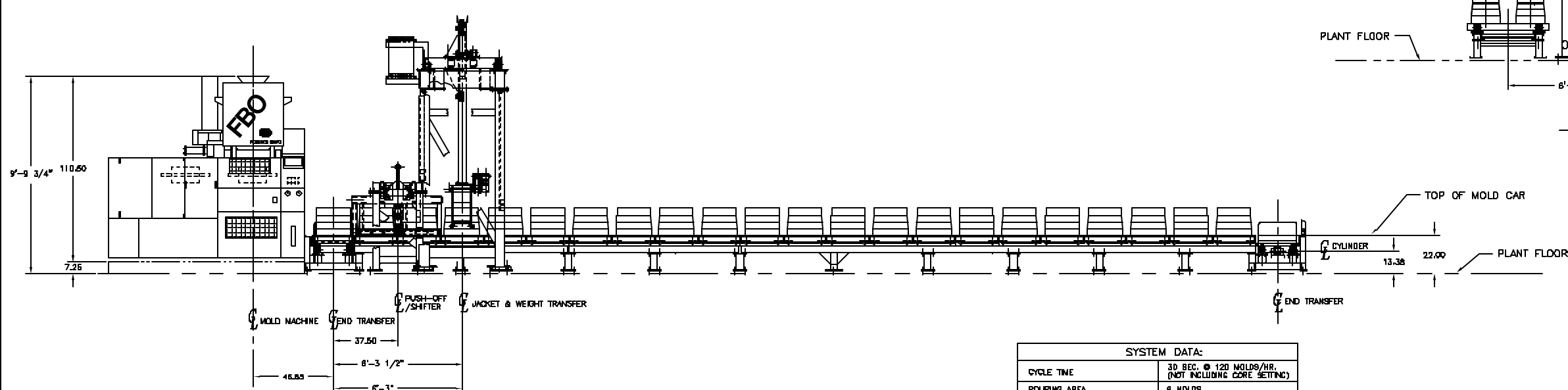
SCALE 3/8"=1'-0"	APPROVED BY	CHECKED BY	DRAWN BY TGB
DATE 12-01-03			

**FBO-II-L MOLDING SYSTEM**  
GENERAL ARRANGEMENT - 17 MINUTES COOLING @ 120 MPH

JOB NO.	DRAWING NUMBER	IMP PART NO.
	FBO2L17@120	




SECTION A-A



SYSTEM DATA:	
CYCLE TIME	30 SEC. @ 120 MOLDS/HR. (NOT INCLUDING CORE SETTING)
POURING AREA	8 MOLDS
COOLING TIME WITH JACKET @ 120 MOLDS/HR.	MINIMUM 13.0 MINUTES MAXIMUM 17.0 MINUTES
TOTAL COOLING TIME @ 120 MOLDS/HR.	MINIMUM 30.0 MINUTES MAXIMUM 39.0 MINUTES

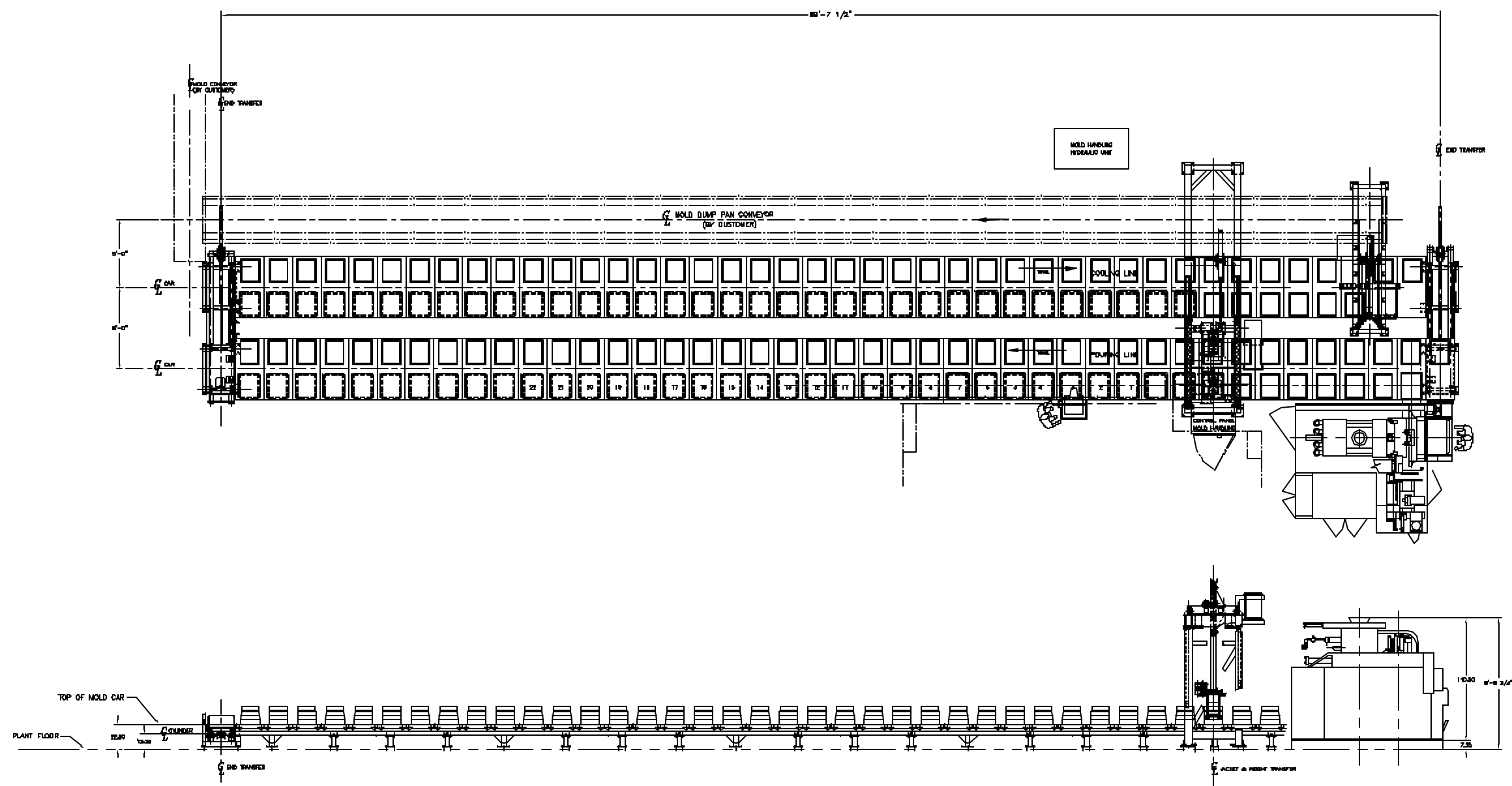
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NO.	REVISIONS	DATE	BY

  
 380 WEST MAIN STREET • P.O. BOX 49740  
 LANSING, MICHIGAN 48211-7500

SCALE	3/8"=1'-0"	APPROVED BY	CHECKED BY	DRAWN BY
DATE	12-22-03			TGB

FBO-II-L MOLDING SYSTEM  
 GENERAL ARRANGEMENT - 35 MINUTES COOLING @ 120 MPH  
 ENGINE NUMBER: FBO2L35@120



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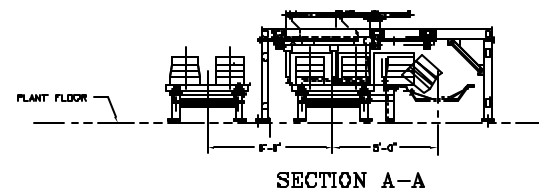
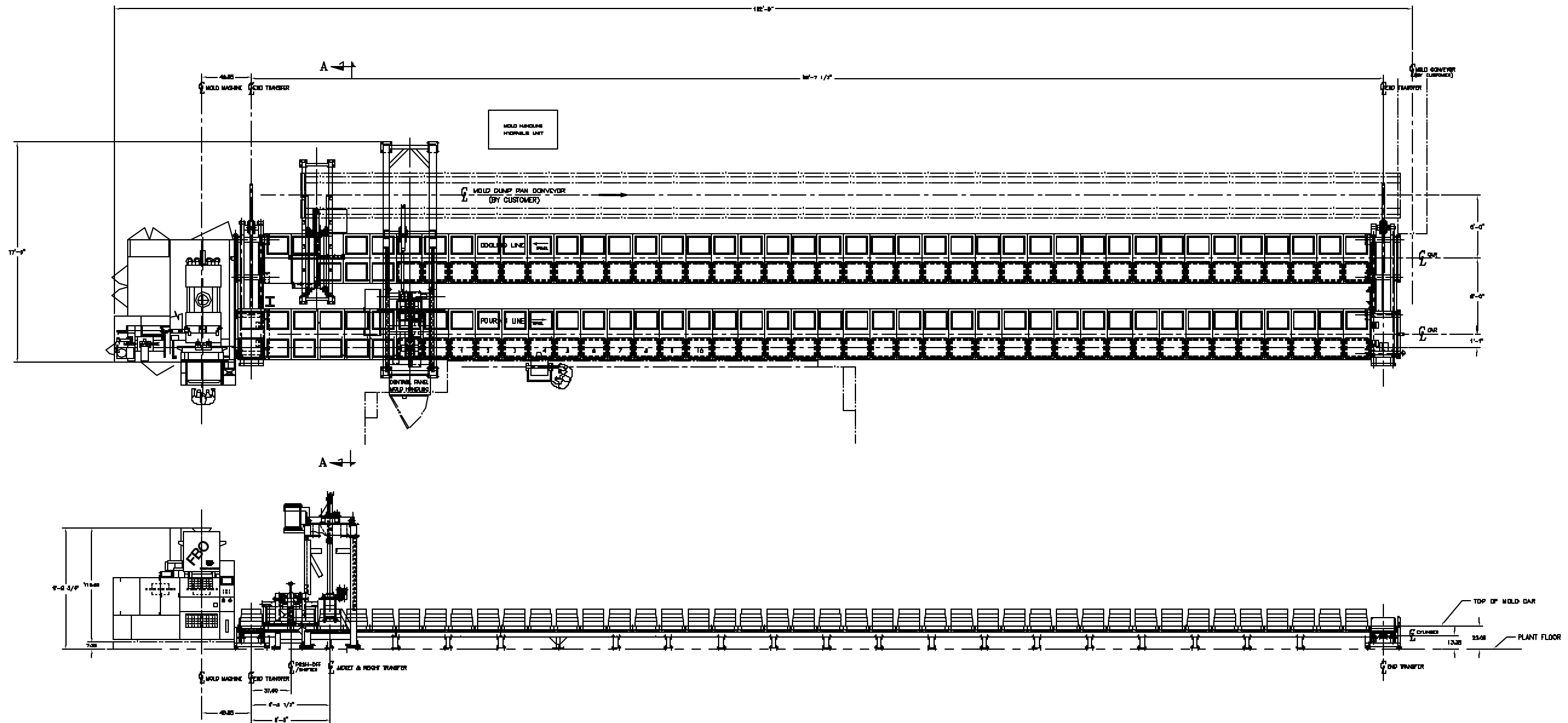


3341 WEST MAIN STREET • P.O. BOX 40760  
LANSING, MICHIGAN 48211-7760

SYSTEM DATA:	
CYCLE TIME	24 SEC. @ 150 MOLDS/HR. (NOT INCLUDING CORE SETTING)
POURING AREA	8 TO 22 MOLDS
COOLING TIME WITH JACKET @ 150 MOLDS/HR.	MAXIMUM 28.0 MINUTES MINIMUM 17.0 MINUTES
TOTAL COOLING TIME @ 150 MOLDS/HR.	MAXIMUM 62.0 MINUTES MINIMUM 53.8 MINUTES


NO.	REVISIONS	DATE	BY

SCALE	1/4"=1'-0"	APPROVED BY	CHECKED BY	DRAWN BY
DATE	9-14-04			TGB
FBO-II-L MOLDING SYSTEM				
GENERAL ARRANGEMENT - 60 MINUTES COOLING @ 150 MPH				
DESIGN NO.	FBO2L60	ISSUE NUMBER		ISSUE DATE



SYSTEM DATA:	
CYCLE TIME	30 SEC. @ 120 MOLDS/HR. (NOT INCLUDING CORE SETTING)
POURING AREA	10 MOLDS
COOLING TIME WITH JACKET @ 120 MOLDS/HR.	MINIMUM 30.0 MINUTES MAXIMUM 35.0 MINUTES
TOTAL COOLING TIME @ 120 MOLDS/HR.	MINIMUM 74.0 MINUTES MAXIMUM 78.0 MINUTES

NO.	REVISIONS	DATE	BY

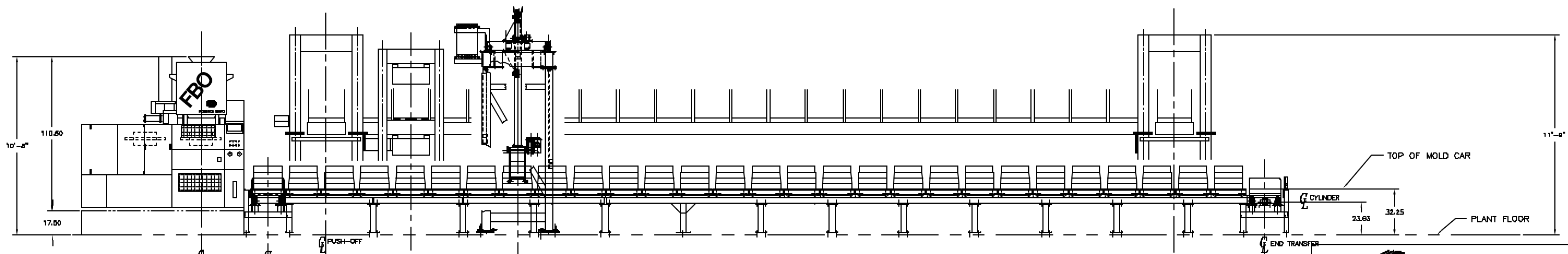
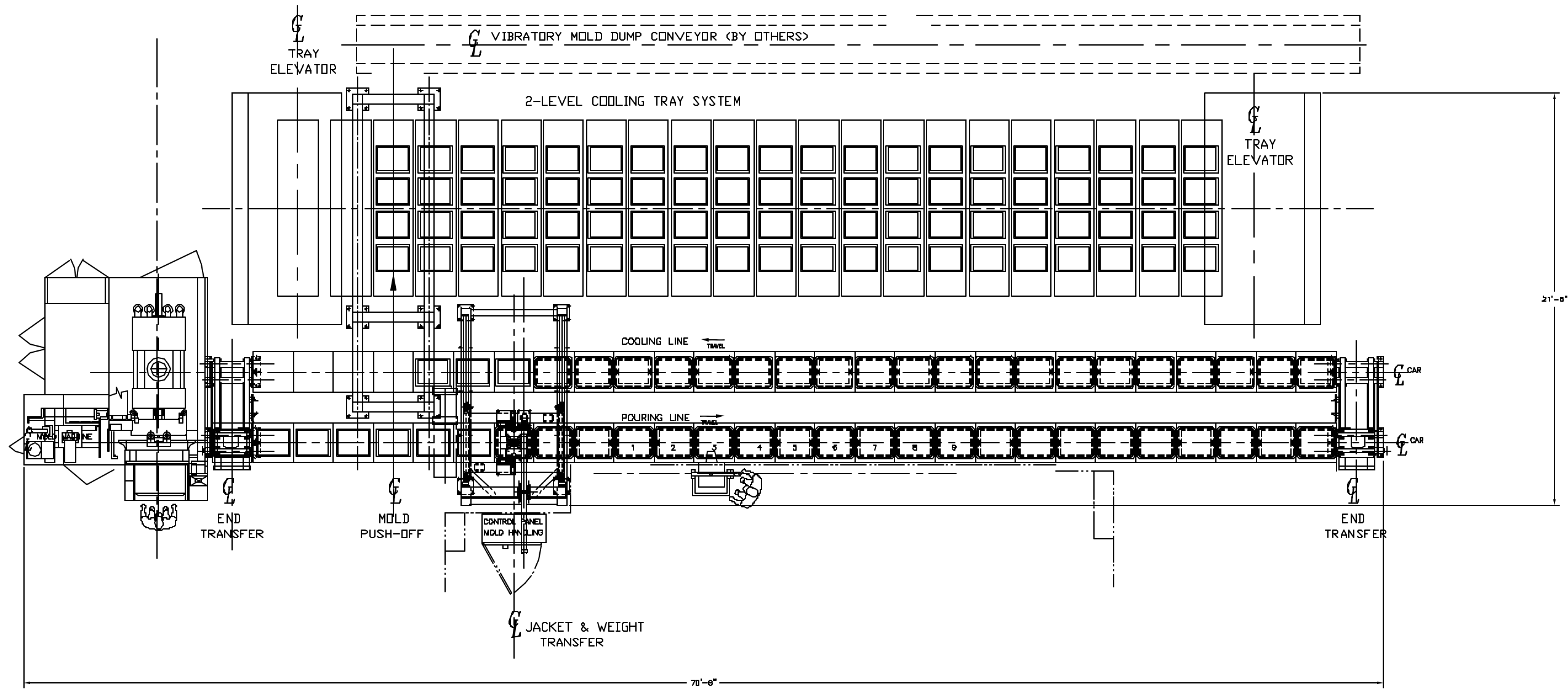

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SCALE 1/4"=1'-0"	APPROVED BY	CHECKED BY	DRAWN BY TGB
DATE 12-22-03			

**FBO-II-L MOLDING SYSTEM**  
**GENERAL ARRANGEMENT - 75 MINUTES COOLING @ 120 MPH**

JOB NO.	DRAWING NUMBER FB02L75@120	IND. PART NO.
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SYSTEM DATA:	
CYCLE TIME	30 SEC. @ 120 MOLDS/HR (NOT INCLUDING CORE SETTING)
POURING AREA	9 MOLDS
COOLING TIME WITH JACKET @ 120 MOLDS/HR	MAXIMUM 18.6 MINUTES MINIMUM 14.5 MINUTES
TOTAL COOLING TIME @ 120 MOLDS/HR	MAXIMUM 88.0 MINUTES MINIMUM 94.0 MINUTES

NO.	REVISIONS	DATE	BY

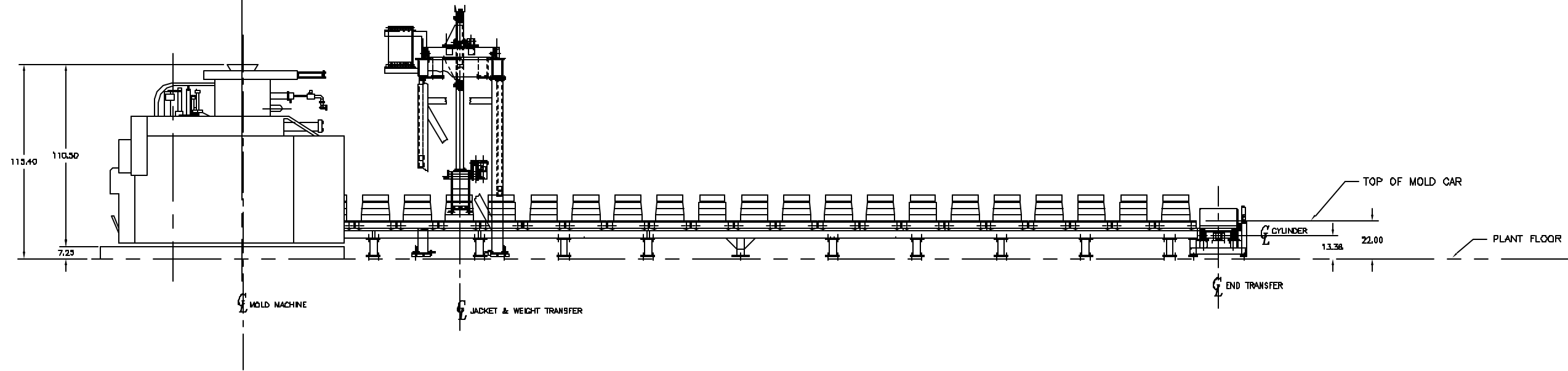
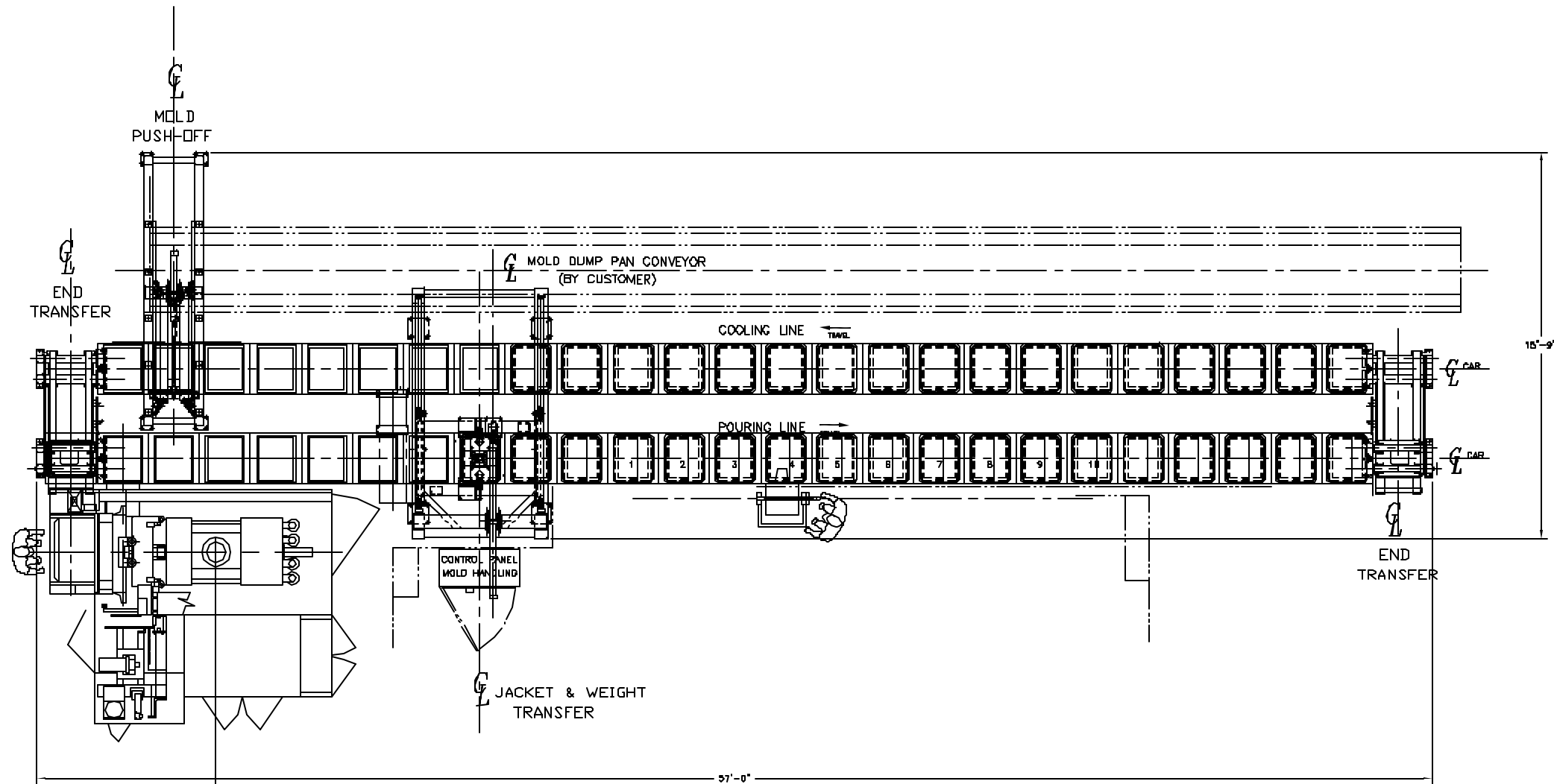
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LANSING, MICHIGAN 48211-7580

3/8"=1'-0"  
DATE: 12-22-03

APPROVED BY: [Signature] CHECKED BY: [Signature] DRAWN BY: TGB


FBO-II-L MOLDING SYSTEM  
GENERAL ARRANGEMENT - 90 MINUTES COOLING @ 120 MPH

NO. 12 ENGINE NUMBER: FBO2L90@120



SYSTEM DATA:	
CYCLE TIME	24 SEC. @ 150 MGLDS/HR. (NOT INCLUDING CORE SETTING)
POURING AREA	10 MGLDS
COOLING TIME WITH JACKET @ 150 MGLDS/HR.	MAXIMUM 12.4 MINUTES MINIMUM 8.8 MINUTES
TOTAL COOLING TIME @ 150 MGLDS/HR.	MAXIMUM 14.8 MINUTES MINIMUM 11.2 MINUTES

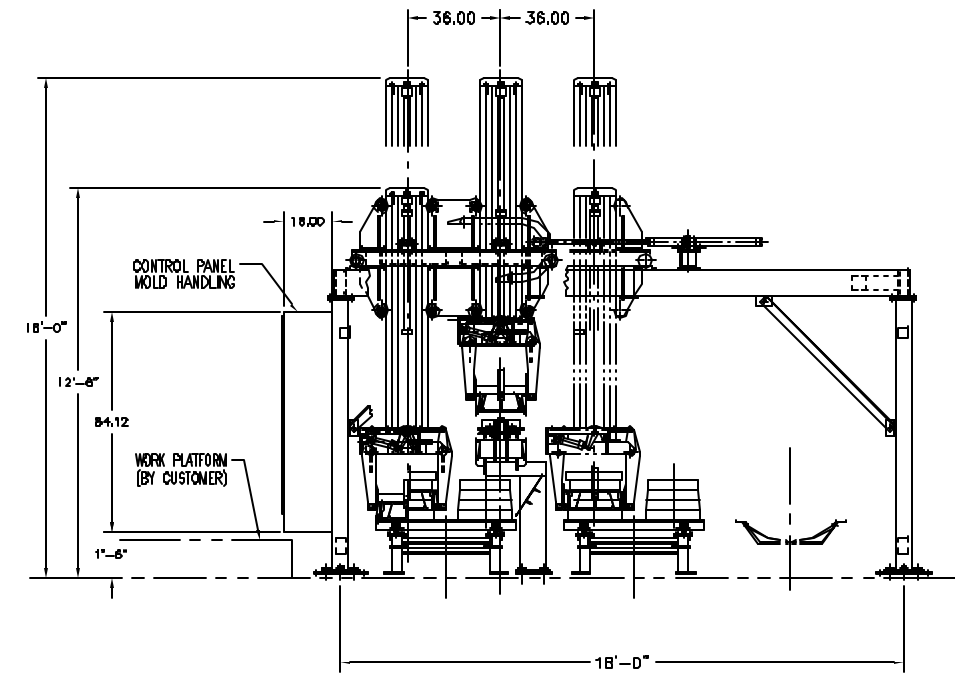
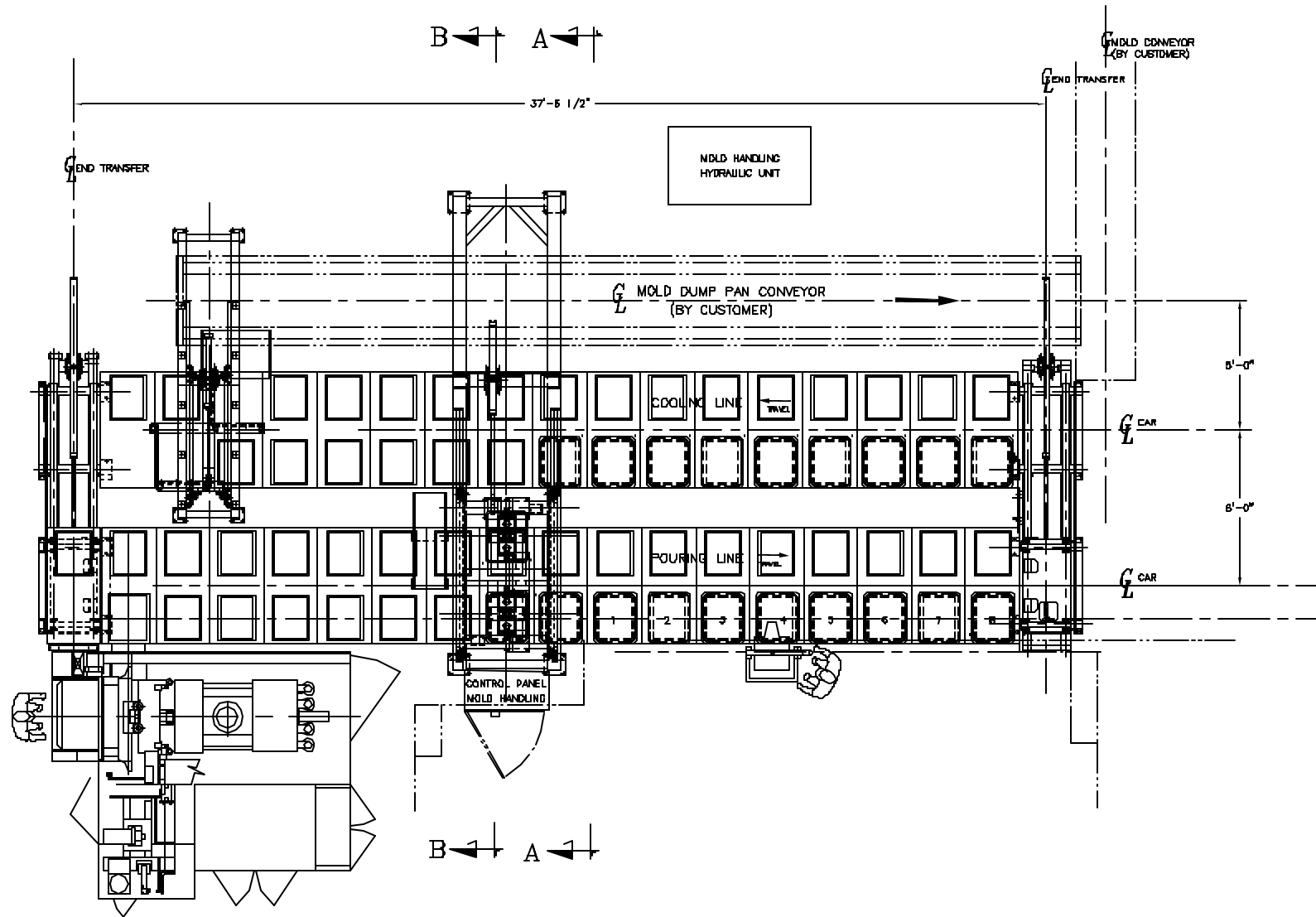
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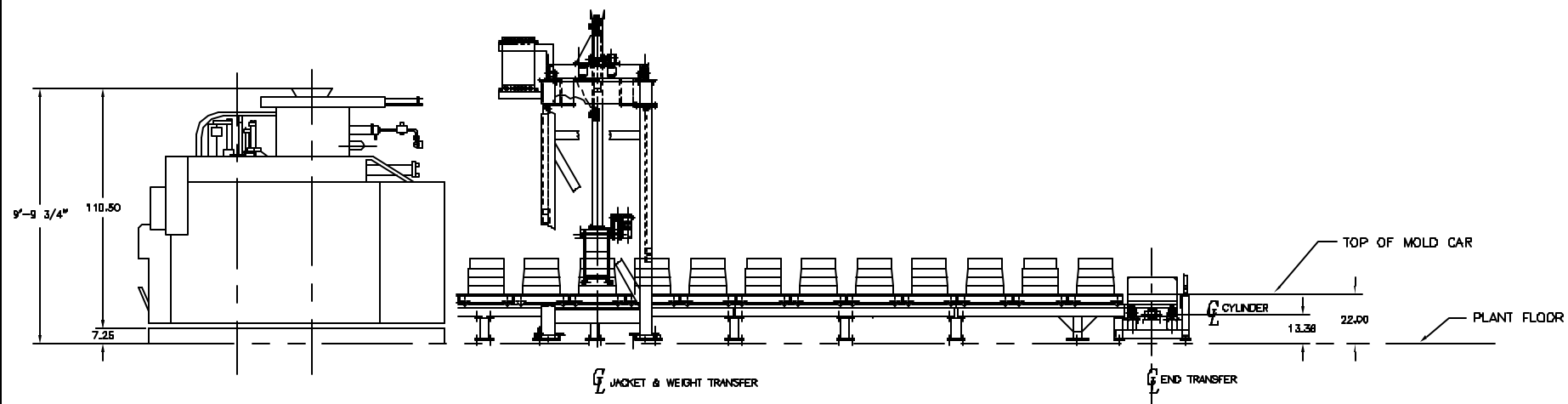
SCALE 3/8"=1'-0"	APPROVED BY	CHECKED BY	DRAWN BY TGB
DATE 12-01-03			
FBO-II-R MOLDING SYSTEM GENERAL ARRANGEMENT - 10 MINUTES COOLING @ 150 MPH			
JOB NO.	DRAWING NUMBER FBO2R10	DATE	BY

NO.	REVISIONS	DATE	BY



SECTION A-A

NOTE: JACKET CLEANING STATION IS OPTIONAL.



SECTION B-B

SYSTEM DATA:		
CYCLE TIME	24 SEC. @ 150 MOLDS/HR. (NOT INCLUDING CORE SETTING)	
POURING AREA	B MOLDS	
COOLING TIME WITH JACKET @ 150 MOLDS/HR.	MAXIMUM	6.4 MINUTES
	MINIMUM	3.6 MINUTES
TOTAL COOLING TIME @ 150 MOLDS/HR.	MAXIMUM	22.4 MINUTES
	MINIMUM	19.8 MINUTES

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 <b>ROBERTS SINTO CORPORATION</b> <small>300 WEST MAIN STREET • P.O. BOX 47740            LANSING, MICHIGAN 48211-1750</small>			
MOLD	3/B=1'-0"	APPROVED BY	DRAWN BY
DATE	12-22-03	CHECKED BY	TGB
<b>FBO-II-R MOLDING SYSTEM</b> <b>GENERAL ARRANGEMENT - 20 MINUTES COOLING @ 150 MPH</b>			
JOB NO.	FBO2R20	ENGINE NUMBER	REV. FILE NO.