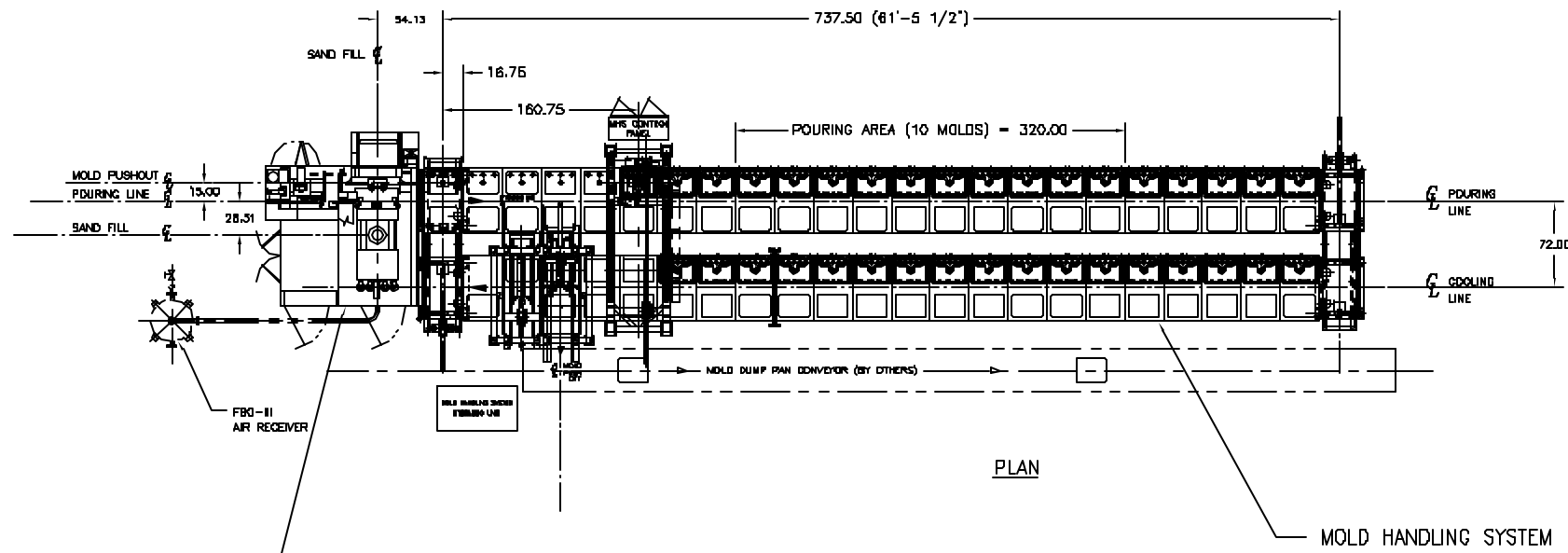


FBO-III-R (L.H. Eject) 2026 FLASKLESS MOLDING DATA

Pouring:		133	100
Molds Per Hour (Max.)			
CYCLE TIME WITHOUT CORE SETTING	27 sec	31 sec	
CORE SETTING TIME (Estimated)	n/a	0 sec	
CYCLE TIME INCLUDING CORE SETTING	27 sec	36 sec	
MOLDS IN POURING ZONE:	10	10	
COOLING TIME w/ JACKET (MINIMUM)		MOLDS	22
			9.9 min
			13.2 min
COOLING TIME w/o JACKET		MOLDS	47
			21.2 min
			28.2 min
TOTALS: MOLDS / COOLING TIME (MINIMUM)		MOLDS	69
			31.1 min
			41.4 min

MEISS-2 (Two on CAR) MOLD HANDLING SYSTEM EQUIPMENT:

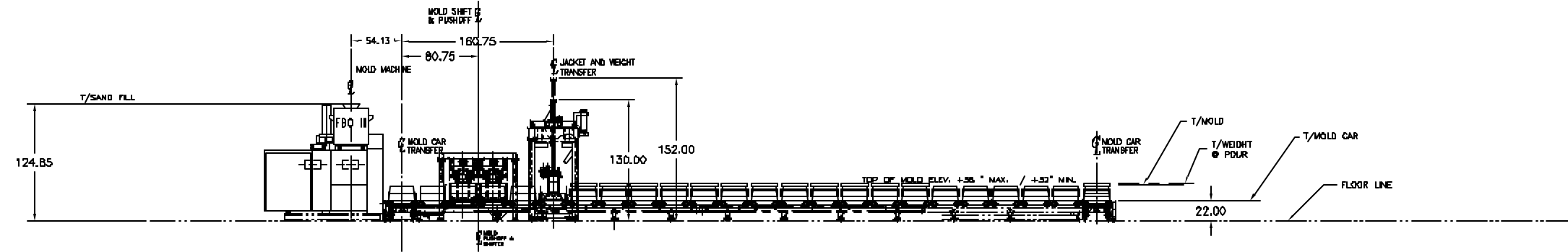
MOLD CARS (Std. = 32" x 54" FLAT TOP)		47 TOTAL
	40 Req'd + TWO Spares =	47 TOTAL
MOLD JACKETS	38 Req'd + TWO Spares =	38 TOTAL
MOLD WEIGHTS	38 Req'd + TWO Spares =	38 TOTAL
TRACK LENGTH: TOTAL		117 Feet
MOLD CAR END TRANSFER R.H.		(1) Req'd
MOLD CAR END TRANSFER L.H.		(1) Req'd
MOLD CAR PULLER		(2) Req'd
JACKET & WEIGHT TRANSFER		(1) Req'd
MOLD PUSH-OFF & SHIFTER: MOLD CAR to Customer's PAN		(1) Req'd



PLAN

MOLD HANDLING SYSTEM

FBO-III-R MOLD MACHINE



ELEVATION

NO.	REVISIONS	DATE	BY

ROBERTS SINTO CORPORATION
200 WEST MAIN STREET • P.O. BOX 4070
 LANSING, MICHIGAN 48201-7820

SCALE: 3/16"=1'-0"
 DATE: 12/5/01

APPROVED BY: [Signature]
 CHECKED BY: [Signature]
 DRAWN BY: T. BERGSTRAND

FBO-III-R MOLDING MACHINE W/MOLD HANDLING SYSTEM
 GENERAL ARRANGEMENT ~ 30 MINUTES COOLING TIME

DRAWING NO: FBO32026R30