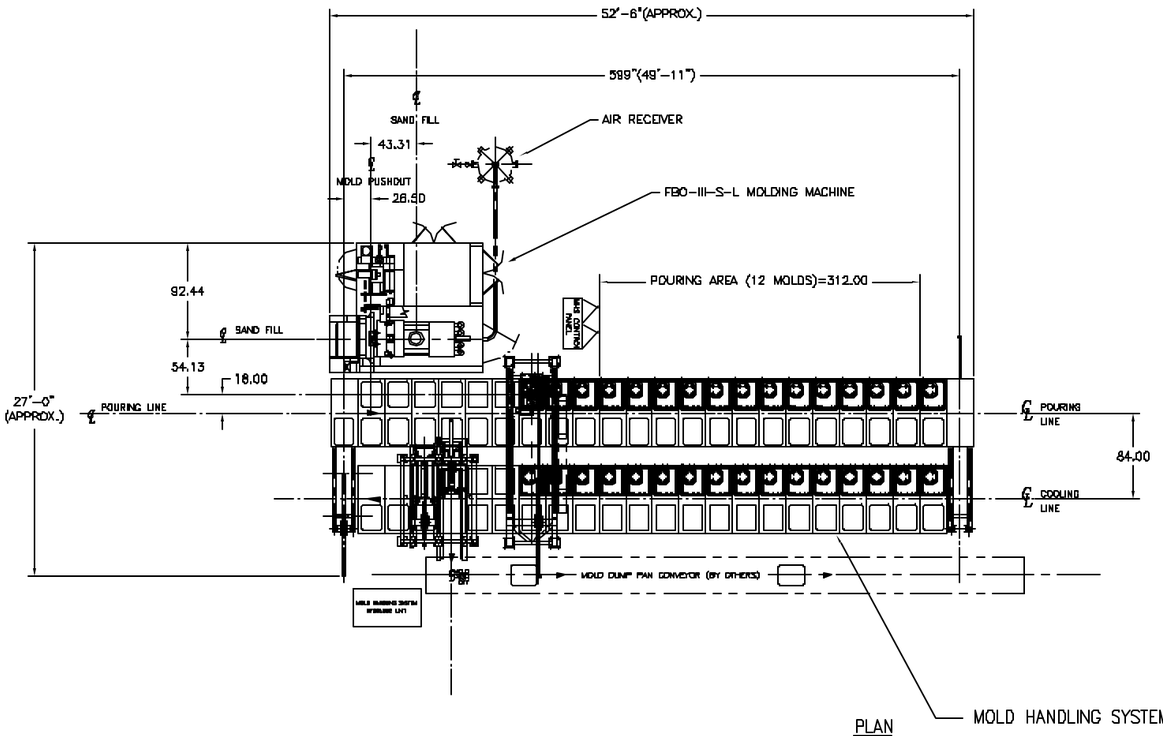
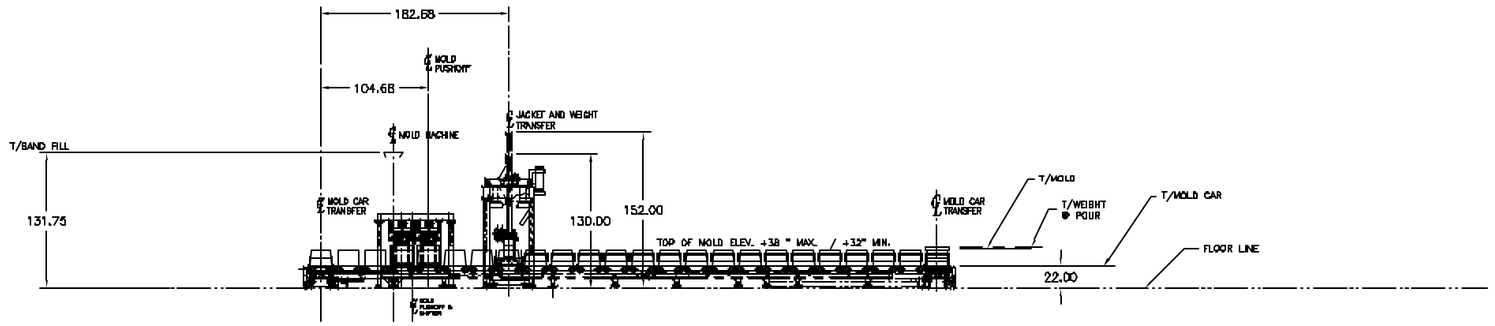


PLAN



ELEVATION

FBO-III-S-L (R.H. Rect) 2026			FLASKLESS MOLDING DATA	
Pouring:				
Molds Per Hour (Max.)			160	120
CYCLE TIME WITHOUT CORE SETTING			22.5 sec	26.0 sec
CORE SETTING TIME (Estimated) (Will Vary)			n/a	3.5 sec
CYCLE TIME INCLUDING CORE SETTING			22.5 sec	30 sec
MOLDS in POURING ZONE)			12	12
COOLING TIME w/ JACKET (MINIMUM)	MOLDS	16	8.0 min	8.0 min
COOLING TIME w/o JACKET	MOLDS	47	17.8 min	23.5 min
TOTALS: MOLDS / COOLING TIME (MINIMUM)	MOLDS	63	23.6 min	31.5 min
MHSS-2 (Two on CAR) MOLD HANDLING SYSTEM EQUIPMENT				
MOLD CARS (28" x 86" FLAT TOP)				
		45 Req'd + TWO Spares =	47	TOTAL
MOLD JACKETS		32 Req'd + TWO Spares =	34	TOTAL
MOLD WEIGHTS		32 Req'd + TWO Spares =	34	TOTAL
TRACK LENGTH: TOTAL			95	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
MOLD CAR RETARDER/CRACK-BACK			(2)	Req'd
JACKET & WEIGHT TRANSFER			(1)	Req'd
MOLD PUSH-OFF & SHIFTER: MOLD CAR to Customer's PAN			(1)	Req'd

CAD FILE: M:\R92720\2720A\04-001.DWG DATE: 10/04/2000

THIS DOCUMENT CONTAINS PROPRIETARY INFORMATION AND SUCH INFORMATION MAY NOT BE DISCLOSED TO OTHERS FOR ANY PURPOSE OR USED FOR MANUFACTURING PURPOSES WITHOUT WRITTEN PERMISSION FROM ROBERTS SINTO CORP.

NO.	REVISIONS	DATE	BY

ROBERTS SINTO CORPORATION

SCALE	APPROVED BY	CHECKED BY	DRAWN BY
3/16"=1'-0"			T. BERGSTRAND
DATE 1/20/04			

FBO-III-S-L MOLDING MACHINE W/MOLD HANDLING SYSTEM
GENERAL ARRGMT. ~ 23 MIN. COOLING (MIN.) @ 160 MPH

T MARKER	DRAWING NO.	BSE PART NO.
	FB03S2026L23	