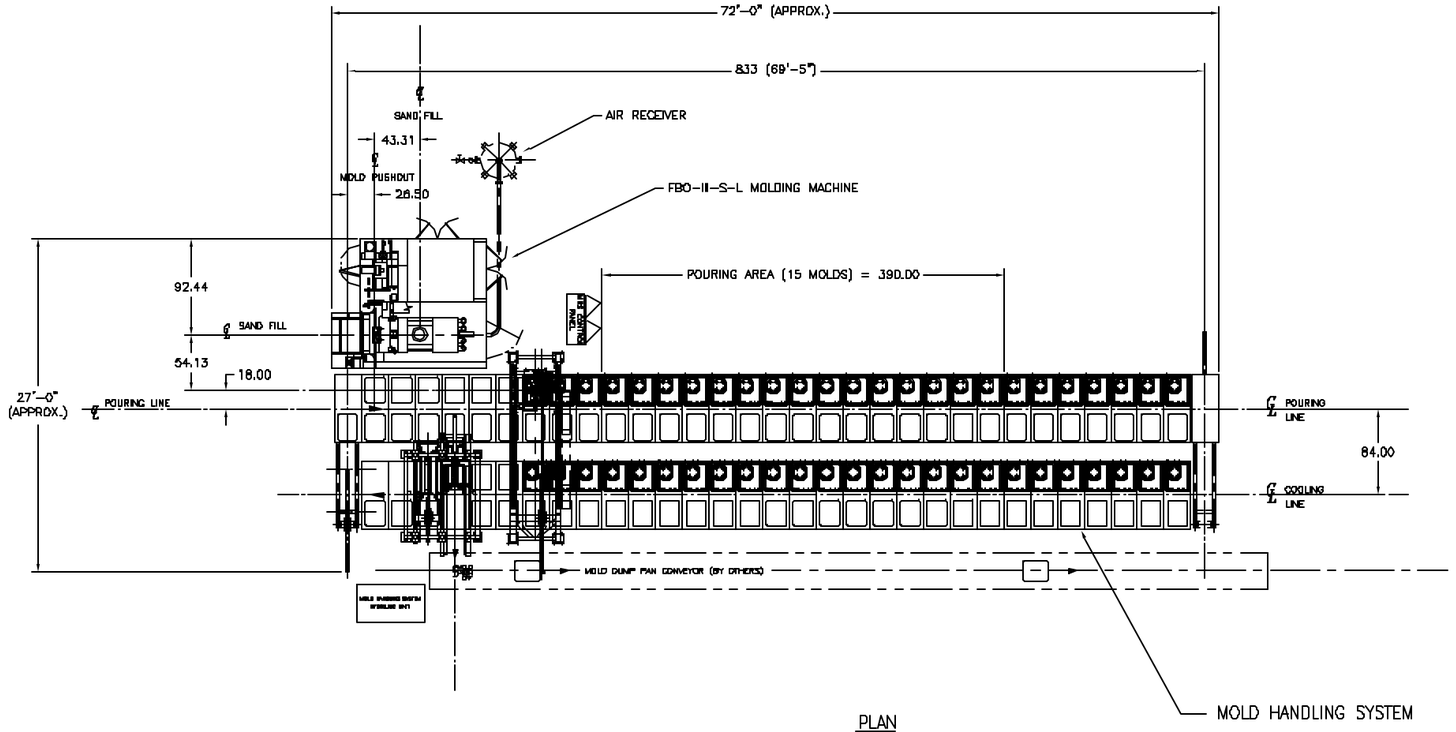

PLAN

FBO-III-S-L (R.H. Eject) 2026			FLASKLESS MOLDING DATA	
Pouring:				
Molds Per Hour (Max.)			160	114
CYCLE TIME WITHOUT CORE SETTING			22.5 sec	26.5 sec
CORE SETTING TIME (Estimated) (Will Vary)			n/a	5 sec
CYCLE TIME INCLUDING CORE SETTING			22.5 sec	31.5 sec
MOLDS in POURING ZONE			15	15
COOLING TIME w/ JACKET (AVERAGE)	MOLDS	38	14.3 min	20.0 min
COOLING TIME w/o JACKET	MOLDS	65	24.7 min	34.7 min
TOTALS: MOLDS / COOLING TIME (AVERAGE)	MOLDS	104	39.0 min	54.7 min

MHSS-2 (Two on CAR) MOLD HANDLING SYSTEM EQUIPMENT

MOLD CARS (28" x 88" FLAT TOP)		
	63 Req'd + TWO Spares =	65 TOTAL
MOLD JACKETS	50 Req'd + TWO Spares =	52 TOTAL
MOLD WEIGHTS	50 Req'd + TWO Spares =	52 TOTAL
TRACK LENGTH: TOTAL		134 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

CAD FILE: M:\RS2720\2720A\DA-001.DWG DATE: 10/04/2000

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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. ~ 39 MIN. COOLING (MIN.) @ 160 MPH

J NUMBER	DRAWING NO.	ESI PART NO.
	FBO3S2026L39	