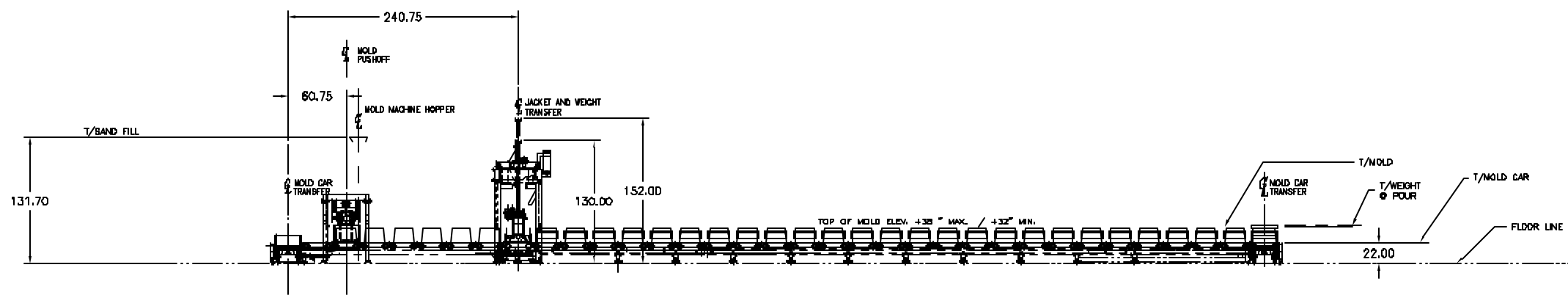



PLAN



ELEVATION

FBO-III-S-L (R.H. Bjork) 2024		FLASKLESS MOLDING DATA	
Pouring:			
Molds Per Hour (Max.)	170	100	
Cycle Time Without Core Setting	21 sec	25 sec	
Core Setting Time (Estimated) (with Optional Auto. Core Saker)	n/a	3 sec	
Cycle Time Including Core Setting	n/a	28 sec	
Molds in Pouring Zone	12	12	
Cooling Time w/ Jacket (Minimum)	MOLDS	36	12.7 min 18.7 min
Cooling Time w/o Jacket	MOLDS	6	2.1 min 2.8 min
TOTALS MOLDS / COOLING TIME (MINIMUM)	MOLDS	42	14.8 min 19.5 min
(Data on CAR) MOLD HANDLING SYSTEM EQUIPMENT:			
MOLD CARS (Std. = 30" x 30" FLAT TOP)	87 Req'd + TWO Spares =	89	TOTAL
MOLD JACKETS	52 Req'd + TWO Spares =	54	TOTAL
MOLD WEIGHTS	52 Req'd + TWO Spares =	54	TOTAL
TRACK LENGTH: TOTAL		185	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 RETAINER/CRACK-BACK		(2)	Req'd
JACKET & WEIGHT TRANSFER		(1)	Req'd
MOLD PUSH-OFF:	MOLD CAR to Customer's PAN	(1)	Req'd

NO.	REVISIONS	DATE	BY



ROBERTS SINTO CORPORATION
sinto
300 WEST MAIN STREET • P.O. BOX 4070
LANSING, MICHIGAN 48211-7980

SCALE 3/16"=1'-0"	APPROVED BY	CHECKED BY	DRAWN BY
DATE 10/29/02			T. BERGSTRAND
FBO-III-S-L MOLDING MACHINE W/MOLD HANDLING SYSTEM GENERAL ARR'G'MT ~ 15 MINS. COOLING TIME @ 170 MPH			
NO. DRAWN	DATE	BY	REV. PART NO.
			FBO3SL15