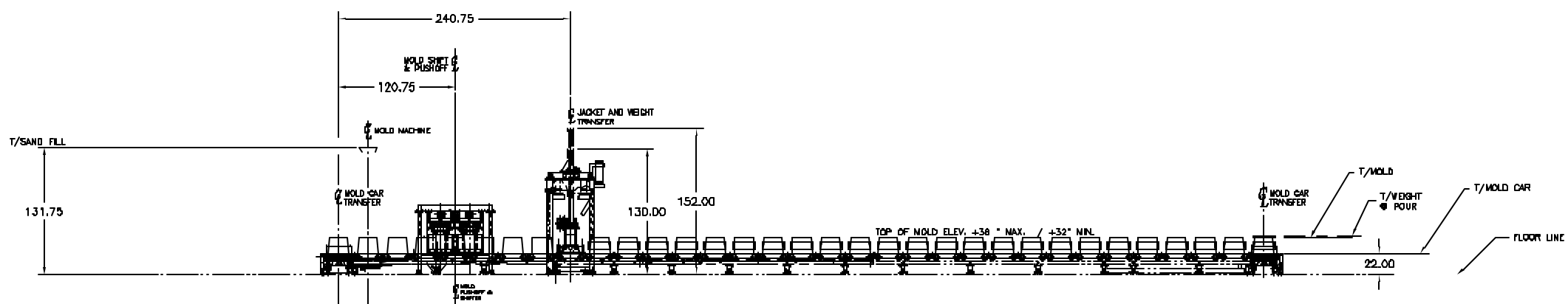


PLAN



ELEVATION

FBO-III-S-L (R.H. Eject) 2024		FLASKLESS MOLDING DATA	
<b>Pouring:</b>			
Molds Per Hour (Max.)	170	120	
CYCLE TIME WITHOUT CORE SETTING	21 sec	25 sec	
CORE SETTING TIME ( Estimated )	n/a	0 sec	
CYCLE TIME INCLUDING CORE SETTING	21 sec	30 sec	
MOLDS IN POURING ZONE	12	12	
COOLING TIME w/ JACKET (MINIMUM)	MOLDS	30	10.6 min 15.0 min
COOLING TIME w/o JACKET	MOLDS	67	23.6 min 33.6 min
TOTALS MOLDS / COOLING TIME (MINIMUM)	MOLDS	87	34.2 min 48.6 min
<b>MESB-2 (Two on CAR) MOLD HANDLING SYSTEM EQUIPMENT:</b>			
MOLD CARS (Std. = 30" x 82" FLAT TOP)	63 Req'd + TWO Spares =	65	TOTAL
MOLD JACKETS	48 Req'd + TWO Spares =	50	TOTAL
MOLD WEIGHTS	48 Req'd + TWO Spares =	50	TOTAL
TRACK LENGTH TOTAL		155	Feet
MOLD CAR END TRANSFER R.H.		( 2 )	Req'd
MOLD CAR RETARDER/CRACK-BACK		( 2 )	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

NO.	REVISIONS	DATE	BY

**ROBERTS SINTO CORPORATION**  
 shto  
 300 WEST MAIN STREET • P.O. BOX 6070  
 LANSING, MICHIGAN 48201-7960

SCALE: 3/16"=1'-0"  
 DATE: 10/8/03

APPROVED BY: T. BERGSTRAND  
 CHECKED BY:  
 DRAWN BY:

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

DRAWING NO. FBO3SL30  
 JOB PART NO.