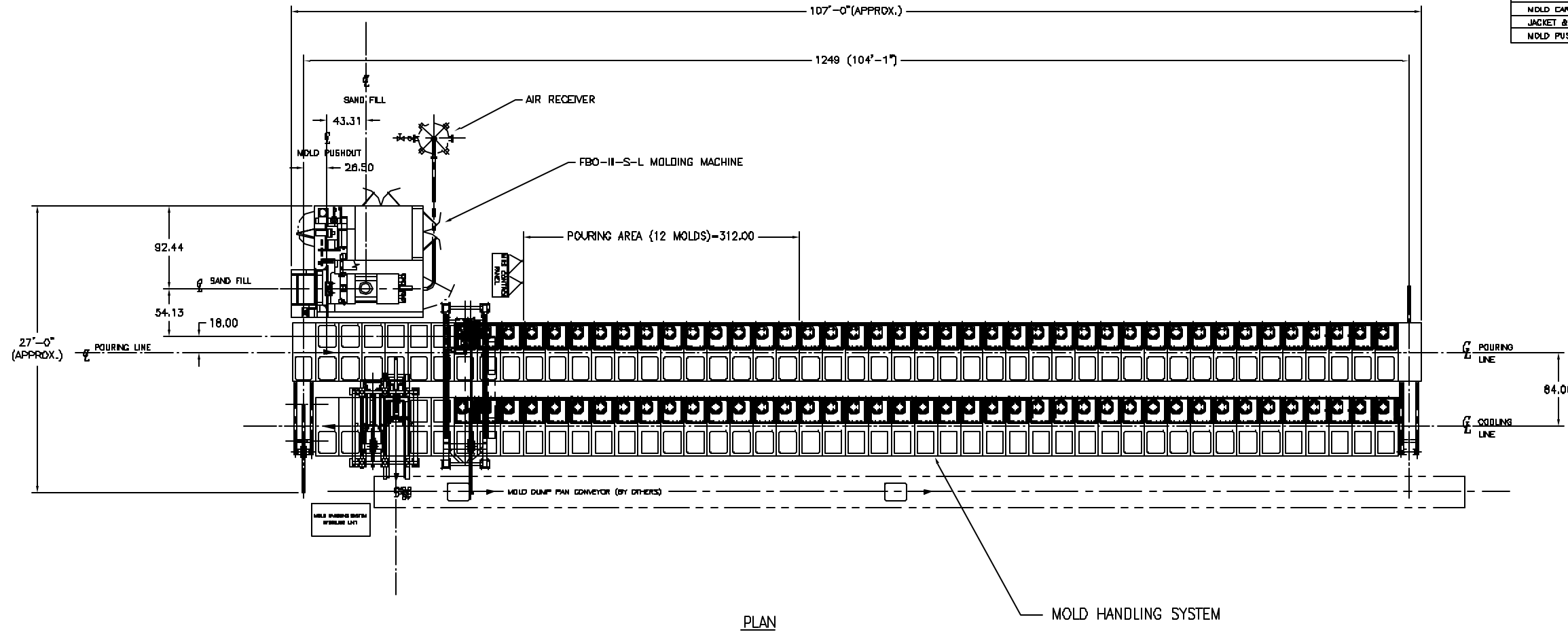



FBO-III-S-L (R.H. Bjork) 2024 FLASKLESS MOLDING DATA

Pouring:		170	120
Molds Per Hour (Max.)		170	120
CYCLE TIME WITHOUT CORE SETTING		21 sec	26 sec
CORE SETTING TIME (Estimated) (W/ Vary)		n/a	8 sec
CYCLE TIME INCLUDING CORE SETTING		21 sec	30 sec
MOLDS IN POURING ZONE		12	12
COOLING TIME w/ JACKET (AVERAGE)	MOLDS	72	25.4 min 38.0 min
COOLING TIME w/o JACKET	MOLDS	88	34.8 min 48.0 min
TOTAL: MOLDS / COOLING TIME (AVERAGE)	MOLDS	170	89.0 min 89.0 min

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

MOLD CARS (26" x 88" FLAT TOP)	80 Req'd + TWO Spares =	82 TOTAL
MOLD JACKETS	82 Req'd + TWO Spares =	84 TOTAL
MOLD WEIGHTS	82 Req'd + TWO Spares =	84 TOTAL
TRACK LENGTH TOTAL		204 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



 ROBERTS SINTO CORPORATION <small>200 WEST MAIN STREET • P.O. BOX 4070 LANSING, MICHIGAN 48201-7800</small>			
SCALE 3/16"=1'-0" DATE 7/15/03	APPROVED BY T. BERGSTRAND	CHECKED BY	DRAWN BY
FBO-III-S-L MOLDING MACHINE W/MOLD HANDLING SYSTEM GENERAL ARRGM. ~ 60 MIN. COOLING (MIN.) @ 170 NPH			REV. PART NO. FBO3SL60
NO.	REVISIONS	DATE	BY