

REQUEST TO CUSTOMER

MESSAGES ON THE TOUCH PANEL SCREEN LOCATED ON THE OPERATORS PANEL ARE WRITTEN IN ENGLISH.

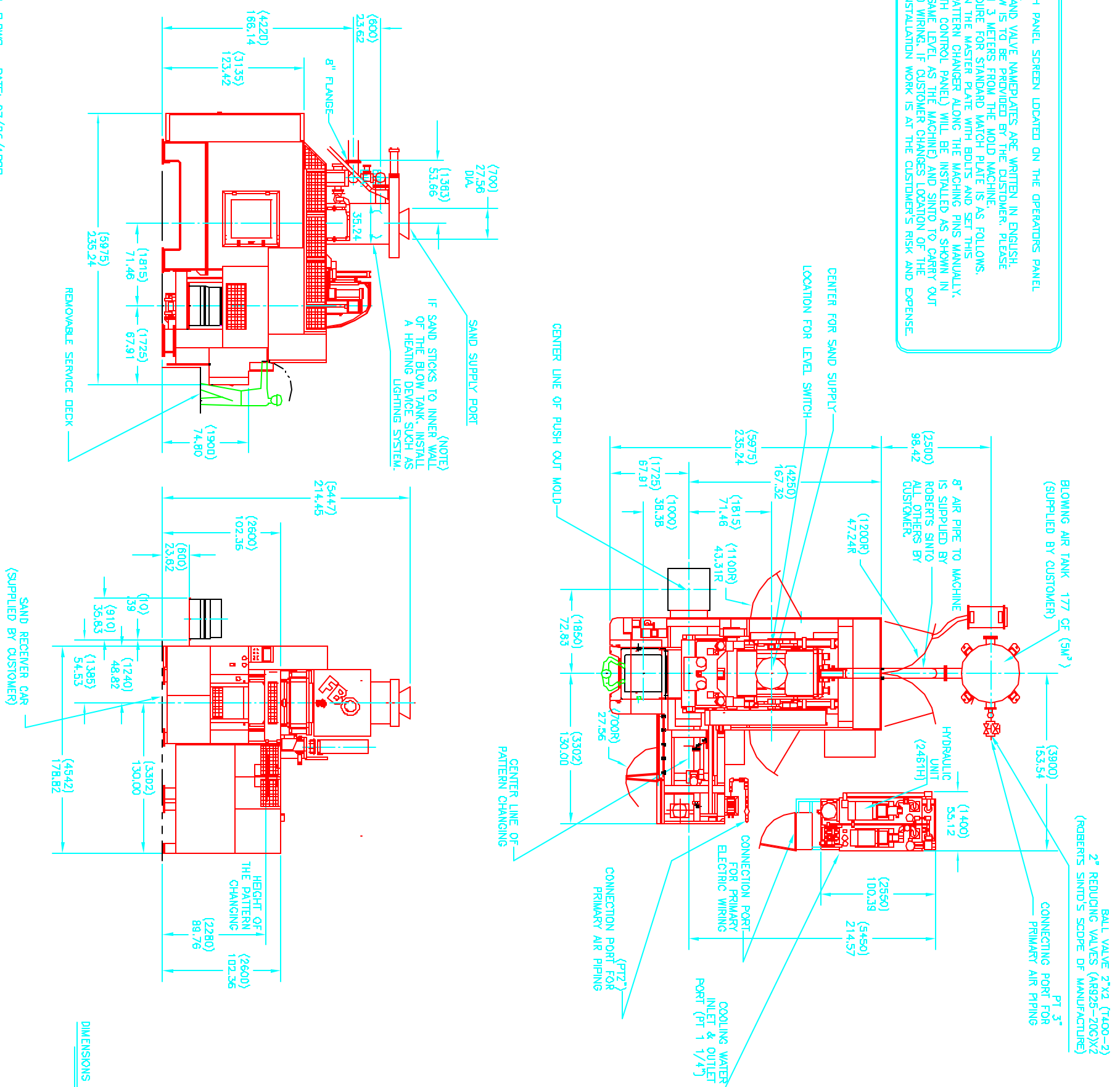
OTHER WARNING PLATES AND VALVE NAMEPLATES ARE WRITTEN IN ENGLISH.

*RECEIVER TANK FOR BLOW IS TO BE PROVIDED BY THE CUSTOMER. PLEASE LOCATE THIS TANK WITHIN 3 METERS FROM THE MOLD MACHINE.

*PATTERN CHANGE PROCEDURE FOR STANDARD MATCH PLATE IS AS FOLLOWS.

*FIX THE MATCH PLATE ON THE MASTER PLATE WITH BOLTS AND SET THIS MASTER PLATE ON THE PATTERN CHANGER ALONG THE MACHING PINS MANUALLY.

*THE HYDRAULIC UNIT (WITH CONTROL PANEL) WILL BE INSTALLED AS SHOWN IN THIS DRAWING (ON THE SAME LEVEL AS THE MACHINE) AND SINTO TO CARRY OUT THE RELATIVE PIPING AND WIRING. IF CUSTOMER CHANGES LOCATION OF THE UNIT THE SUBSEQUENT INSTALLATION WORK IS AT THE CUSTOMER'S RISK AND EXPENSE.



SPECIFICATIONS

NAME	HORIZONTAL TYPE FLASKLESS MOLDING MACHINE
MODEL	FBO-V (R)
SIZE	Lx Bx H: 32" X 32" X 81.2" (812.8 X 812.8 X 2063.2)
MOLD	H: 11" ~ 14" (CORE) 11" ~ 14" (BRGK) CAN BE PRESET AT 3 STAGES
MOLDING METHOD	TOP BLOW + SQUEEZE
MOLDING SPEED (MAX)	4/5 SEC./MOLD (CORE SETTING IS NOT INCLUDED) (NOTE 1)
SQUEEZE PRESSURE (MAX)	14.2 PSI (10.0 KGF/CM ²)
OPERATION METHOD	AIR & HYDRAULIC PRESSURE (52KWX4P W/WATER COOLING)
AIR CONSUMPTION	1.41 CFM/MOLD (4.0 NM ³ /MOLD)
OPERATION AIR PRESSURE	7.4 ~ 8.6 PSI (5.2 ~ 6.0 KGF/CM ²)
CONTROL METHOD	SEQUENCER
POWER SOURCE	SOURCE: AC 480V, 60HZ (OPERATION: AC 100V)
MOLD WEIGHT (MAX)	1,528 LBS. (693KG)
COLOR OF PAINT	MACHINE: SI-1002
ACCESSORIES	CONTROL AND OPERATION PANELS: SI-1002 (NOTE 2) MASTER PLATE (FOR STANDARD MATCH PLATE) 1 SET SPRUE CUP, SPRUE STICK 1.38" (35) DIA. 1 SET STANDARD TOOLS 1 SET MACHINE FOUNDATION BOLT 1 SET SQUEEZE BOARD HEATER (200V X 1000W) 2 SETS PARTING AGENT TANK 5.3 GAL (20L) 1 SET

(NOTE 1) THIS MAX. MOLDING SPEED (4.5 SEC./MOLD) IS ACHIEVED WHEN THE MOLD HEIGHTS ARE 1.4" / 1.4". IF CORES MUST BE SET, ADD 6 SECONDS FOR DRAG MOLD SLIDING + CORE SETTING TO CYCLE TIME.

(NOTE 2) COLOR OF PAINT CONFORMS TO THE NUMBER OF JAPAN PAINT ASSOCIATION.

OTHER EQUIPMENT EXCEPT FOR THE ESTIMATED SPECIFICATIONS (SUPPLIED BY CUSTOMER)

1. AIR TANK FOR BLOWING	177 CF (5M ³)	1 SET
2. HYDRAULIC WORKING OIL	(WEAR RESISTANT HYDRAULIC OIL ISO VG46 240 GAL/900L)	
3. WATER COOLED HYDRAULIC UNIT	COOLING WATER 90°F (32°C) OR BELOW	
4. MATCH PLATE	STEEL PLATE 1.38" ~ 1.57" (35 ~ 40) THICK [MATCH PLATE ATTACHED ON THE MATCH PLATE WITH BOLT]	1 SET
5. PRIMARY AIR PIPING	3" DIA. & 2" DIA.	1 SET
6. PRIMARY ELECTRIC AND EARTH WIRES	AC 480V, 60HZ, 50KW	1 SET
7. WIRING BETWEEN CONTROL PANEL AND OPERATION PANEL	WIRING WORKS SHOWN IN THIS DRAWING WILL BE BY SINTO. WHILE OTHERS BY CUSTOMER.	1 SET
8. MIXED SAND SUPPLY UNIT		1 SET
9. WORKING DECK FOR CORE SETTING AND PATTERN CHANGE		1 SET
10. MOLDING MACHINE SUPPORT FOUNDATION FRAME AND SAND RECEIVER CAR		1 SET
11. MEASURES AGAINST FREEZE		1 SET
12. HOST FOR REPLACING MATCH PLATE	FOR APPROX. 1,784 LB (800KG)	1 SET
13. UTILITY		
14. COMPRESSED AIR	7.4 ~ 8.6 PSI (5.2 ~ 6.0 KGF/CM ²) SECONDARY INLET	
15. ELECTRIC POWER	PRESSURE AC 480V 60HZ	
16. SUPPLIED WATER	1.4 ~ 2.9 PSI (1 ~ 2 KGF/CM ²) 66 GPM (250 L/MIN) WATER TEMPERATURE 50°F (10°C) OR BELOW	

OPTIONAL SPECIFICATIONS

* PATTERN HEATER (100V X 2 SET) WITH VOLUME CONTROLLER.

* AIR BLOWING DEVICE FOR DRAG MOLD CLEANING WITH BALL VALVE (3/4")

* SIMULTANEOUS OPERATION WITH DRAG FLASK SLIDE.

IF IT IS NOT USED CLOSE THE RETAINER VALVE.

DIMENSIONS IN () BRACKETS ARE IN MM

SINTO# L2-103973

FBO-V (R) HORIZONTAL FLASKLESS MOLD MACHINE

REVISIONS

NO.	DATE	BY

1/12/99

ROBERTS SINTO CORPORATION

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