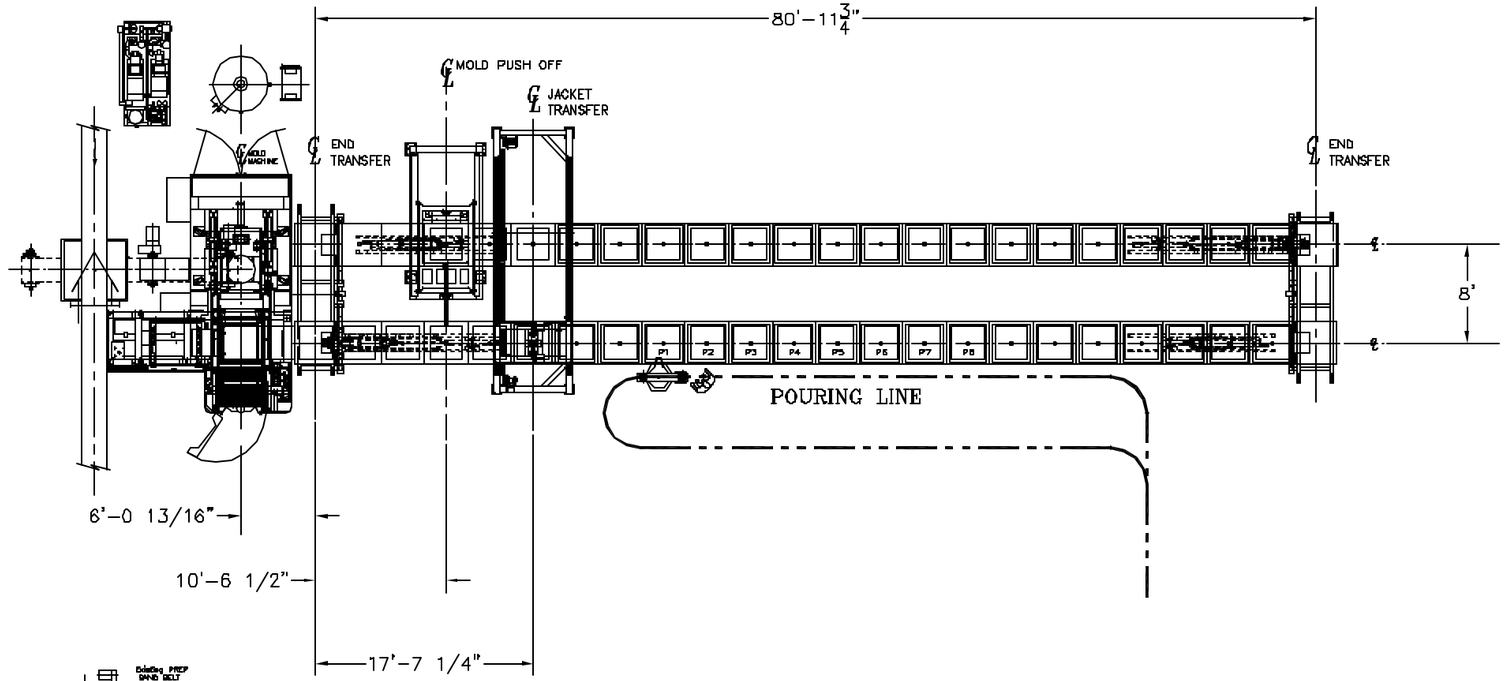

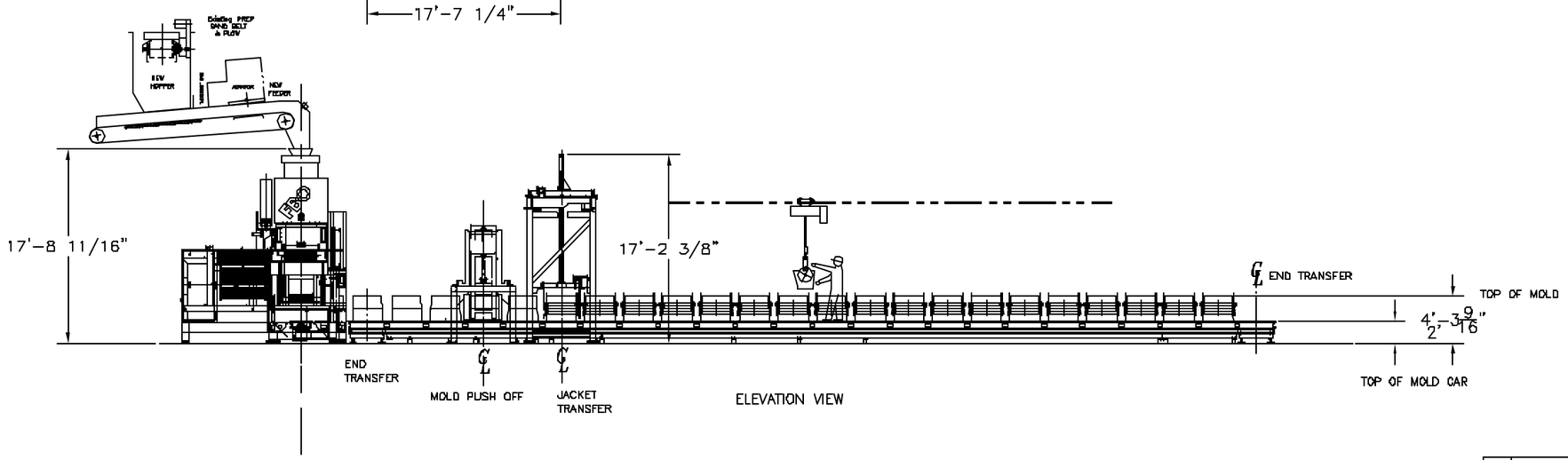

EQUIPMENT	
MOLD CAR END TRANSFER R.H.	(1) REQ'D.
MOLD CAR END TRANSFER L.H.	(1) REQ'D.
MOLD CAR PULLER	(4) REQ'D.
CRACK BACK	(2) REQ'D.
JACKET & WEIGHT TRANSFER	(1) REQ'D.
MOLD PUSH-OFF	(1) REQ'D.
MOLD CARS	(46) REQ'D.
MOLD JACKETS	(34) REQ'D.
MOLD WEIGHTS	(34) REQ'D.
TRACK LENGTH	106 FT.

SYSTEM DATA:	
CYCLE TIME	46 SEC. @ 60 MOLDS/HR. (NOT INCLUDING CORE SETTING)
POURING AREA	8 MOLDS
AVG. COOLING TIME WITH JACKET	18 – 24 MINUTES @ 60 MOLDS/HR.
AVG. TOTAL COOLING TIME	18 –28 MINUTES @ 60 MOLDS/HR.

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NO.	REVISIONS	DATE	BY

ROBERTS SINTO CORPORATION
2801 WEST MAIN STREET • P.O. BOX 49760
LANSING, MICHIGAN 48909-7960

SCALE	APPROVED BY:	CHECKED BY:	DRAWN BY:
DATE 7/3/01			TGM

GENERAL ARRANGEMENT – FBO–V MOLDING SYSTEM
(32 x 32) (1 MOLD/CAR) 20 MINUTES COOLING TIME

CUSTOMER

DRAWING NUMBER FBO5L20

CAD FILE: F:\EST\BERGSTRA\FLASKLES\9051.DWG DATE: 08/05/1999