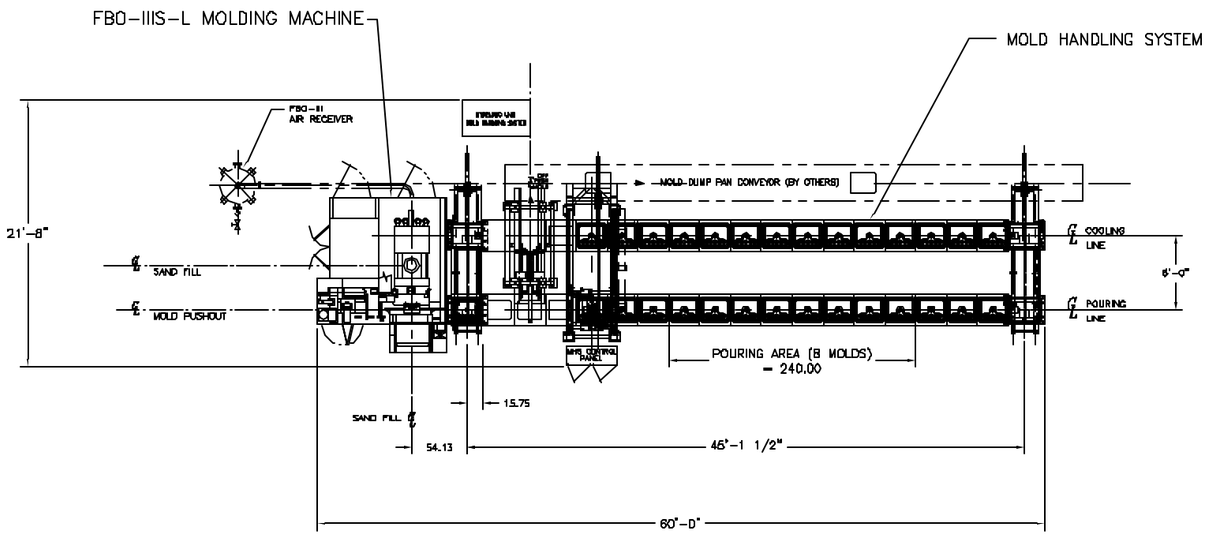
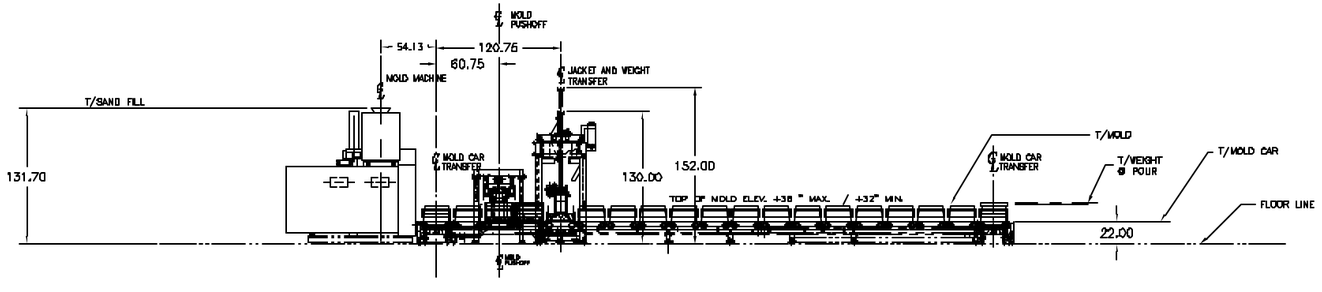


PLAN



ELEVATION

FBO-III-S-L (R.H. Eject) 2024				FLASKLESS MOLDING DATA
Pouring:				
Molds Per Hour (Max.)				100
CYCLE TIME WITHOUT CORE SETTING				25 sec
CORE SETTING TIME (Estimated)				11 sec
CYCLE TIME INCLUDING CORE SETTING				36 sec
MOLDS in POURING ZONE				8
COOLING TIME w/ JACKET (MINIMUM)	MOLDS	16		9.8 min
COOLING TIME w/o JACKET	MOLDS	2		1.2 min
TOTALS: MOLDS / COOLING TIME (MINIMUM)	MOLDS	18		10.5 min

(One on CAR) MOLD HANDLING SYSTEM EQUIPMENT

MOLD CARS (Std. = 30" x 30" FLAT TOP)			
	35 Req'd + TWO Spares =	37	TOTAL
MOLD JACKETS	28 Req'd + TWO Spares =	30	TOTAL
MOLD WEIGHTS	28 Req'd + TWO Spares =	30	TOTAL
TRACK LENGTH: TOTAL		85	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
JACKET & WEIGHT TRANSFER		(1)	Req'd
MOLD PUSH-OFF: MOLD CAR to Customer's PAN		(1)	Req'd

CAD FILE: M:\RS2720\2720A\DA-001.DWG DATE: 10/04/2000

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NO.	REVISIONS	DATE	BY

ROBERTS SINTO CORPORATION

SCALE	APPROVED BY	CHECKED BY	DRAWN BY
3/16"=1'-0"			T. BERGSTRAND
DATE 4/30/02			

FBO-IIIS-L MOLDING MACHINE W/MOLD HANDLING SYSTEM
GENERAL ARR'G'M'T ~ 10 MINS. COOLING TIME @ 100 MPH

J NUMBER	DRAWING NO.	RSE PART NO.
	FB03L10	