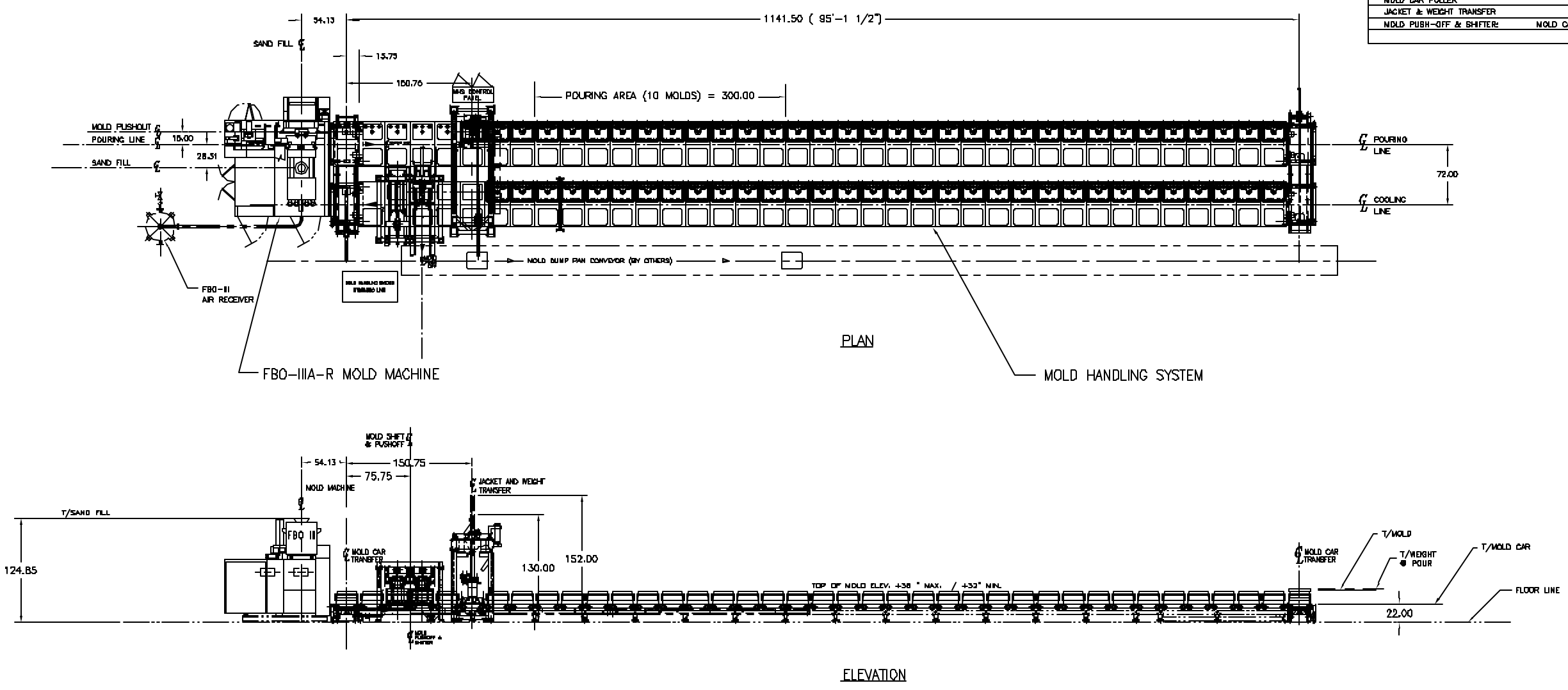


FBO-III-R (L.H. Eject) 2024		FLASKLESS MOLDING DATA	
Pouring:			
Molds Per Hour (Max.)	133	62	
CYCLE TIME WITHOUT CORE SETTING	27 sec	31 sec	
CORE SETTING TIME (Estimated)	n/a	8 sec	
CYCLE TIME INCLUDING CORE SETTING	27 sec	39 sec	
MOLDS IN POURING ZONE:	10	10	
COOLING TIME w/ JACKET (MINIMUM)	MOLDS	52	23.4 min 33.8 min
COOLING TIME w/o JACKET	MOLDS	77	34.8 min 50.0 min
TOTAL: MOLDS / COOLING TIME (MINIMUM)	MOLDS	129	58.0 min 83.8 min
MEIBB-2 (Two on CAR) MOLD HANDLING SYSTEM EQUIPMENT:			
MOLD CARS (Std. = 30" x 54" FLAT TOP)			
	70 Req'd + TWO Spares =	77	TOTAL
MOLD JACKETS	68 Req'd + TWO Spares =	68	TOTAL
MOLD WEIGHTS	68 Req'd + TWO Spares =	68	TOTAL
TRACK LENGTH: TOTAL		185	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 & SHIFTER	MOLD CAR to Customer's PAN	(1)	Req'd



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

THIS DOCUMENT CONTAINS PROPRIETARY INFORMATION AND SUCH INFORMATION MAY NOT BE DISCLOSED TO OTHERS FOR ANY PURPOSE OR USED FOR MANUFACTURING PURPOSES WITHOUT WRITTEN PERMISSION FROM ROBERTS SINTO CORP.

NO.	REVISIONS	DATE	BY

ROBERTS SINTO CORPORATION
sinto
200 WEST MAIN STREET • P.O. BOX 4070
LANSING, MICHIGAN 48201-7880

SCALE 3/16"=1'-0" DATE 6/25/02	APPROVED BY T. BERGSTRAND	CHECKED BY	DRAWN BY T. BERGSTRAND
FBO-III-R MOLDING MACHINE W/MOLD HANDLING SYSTEM GENERAL ARRANGEMENT ~ 60 MINUTES COOLING TIME			
T. NUMBER	DRAWING NO. FBO3R60	JOB PART NO.	