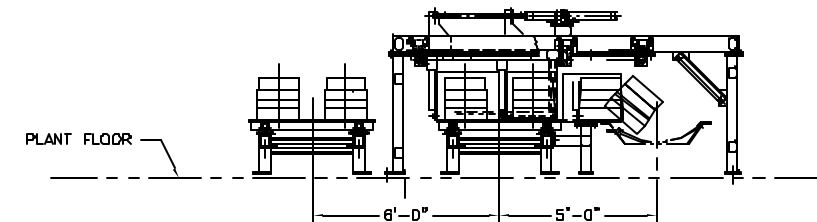
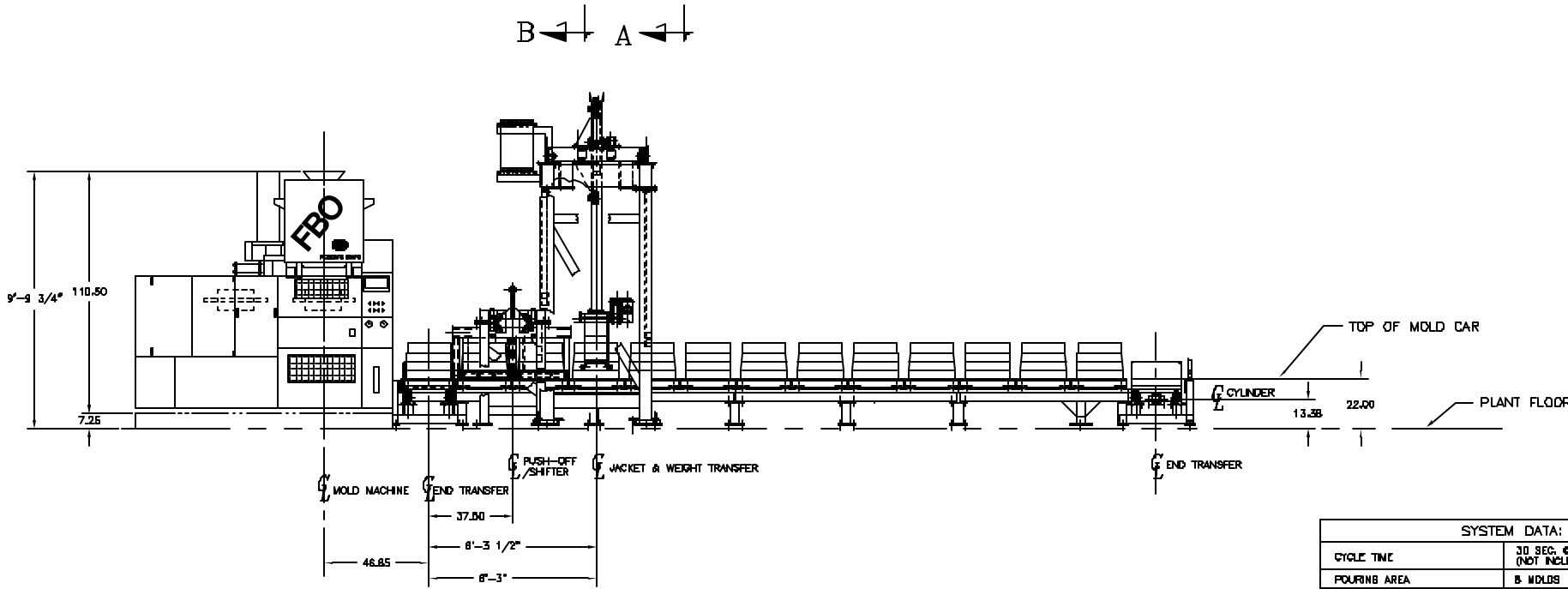


SECTION A-A

NOTE: JACKET CLEANING STATION IS OPTIONAL.



SECTION B-B

SYSTEM DATA:	
CYCLE TIME	30 SEC. @ 120 MOLDS/HR. (NOT INCLUDING CORE SETTING)
POURING AREA	8 MOLDS
COOLING TIME WITH JACKET @ 120 MOLDS/HR.	MAXIMUM 8.0 MINUTES MINIMUM 4.5 MINUTES
TOTAL COOLING TIME @ 120 MOLDS/HR.	MAXIMUM 21.0 MINUTES MINIMUM 17.5 MINUTES

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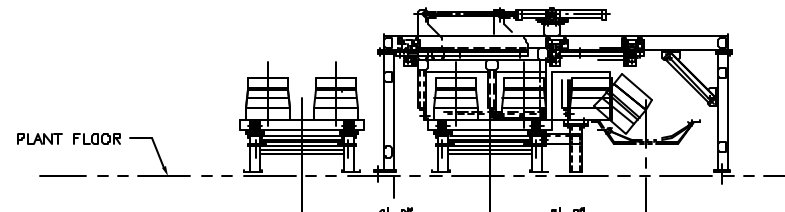
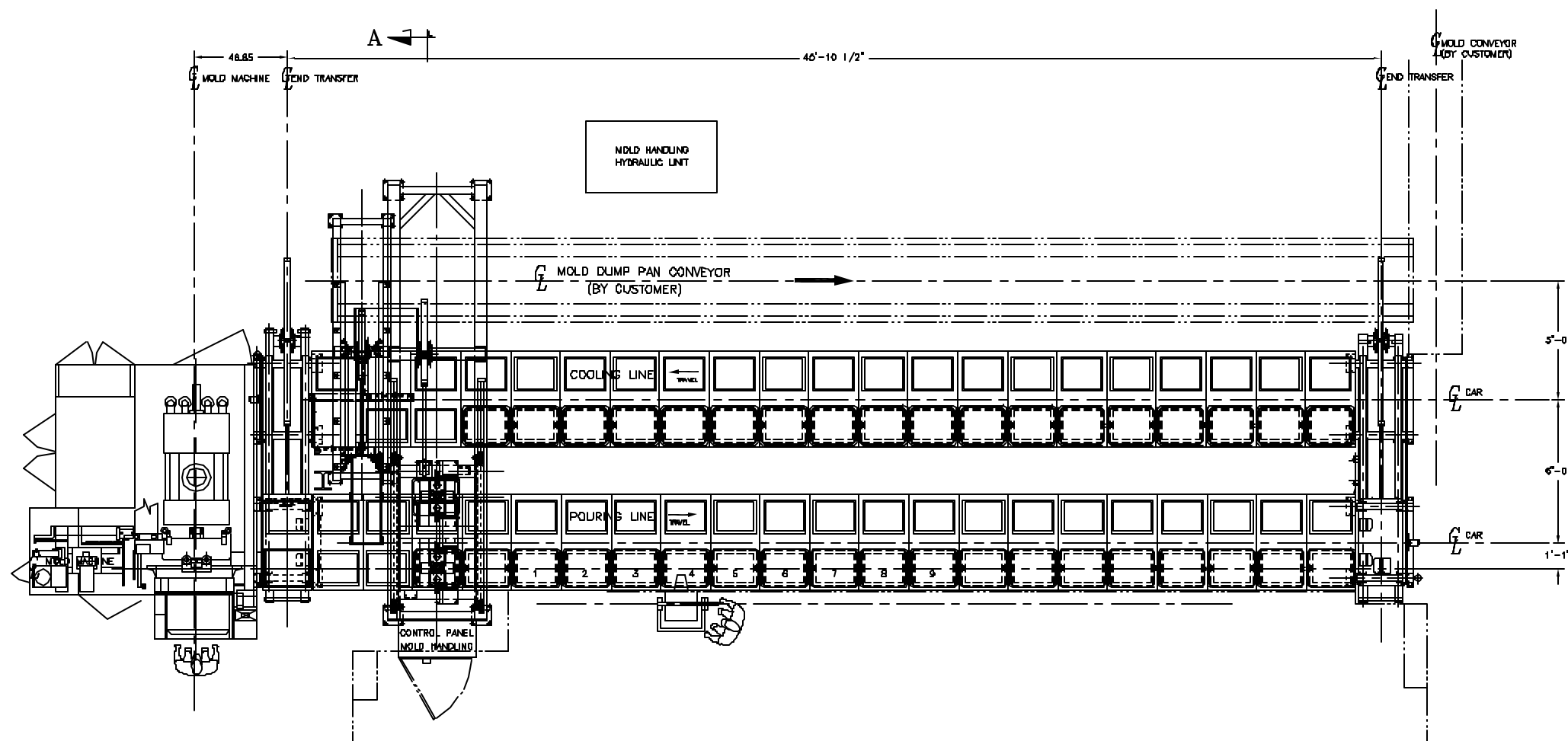
NO.	REVISIONS	DATE	BY

ROBERTS SINTO CORPORATION
sinto 3501 WEST MAIN STREET • P.O. BOX 4070
LANSING, MICHIGAN 48914-1940

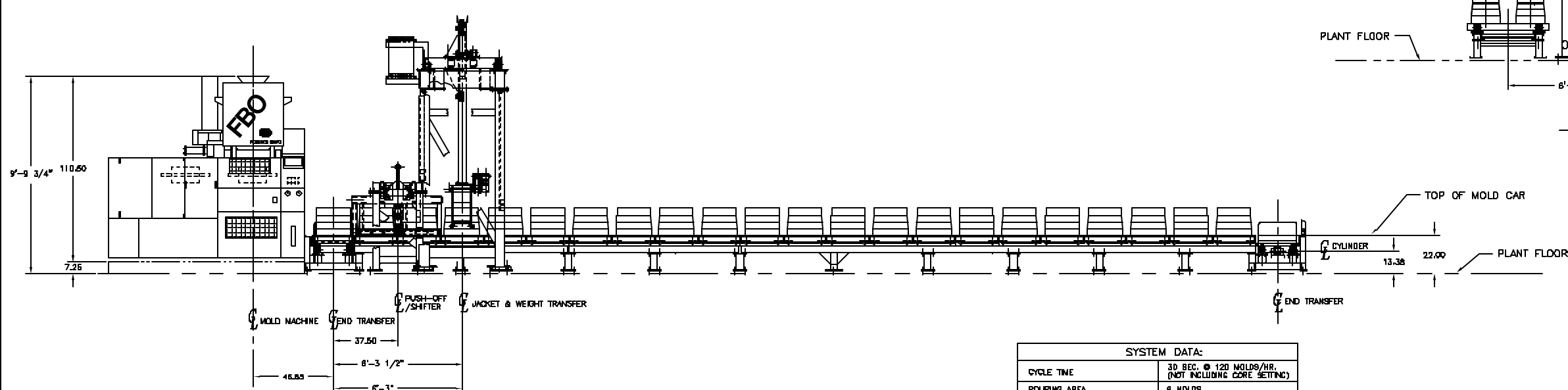
SCALE 3/8"=1'-0"	APPROVED BY	CHECKED BY	DRAWN BY TGB
DATE 12-01-03			

FBO-II-L MOLDING SYSTEM
GENERAL ARRANGEMENT - 17 MINUTES COOLING @ 120 MPH

JOB NO.	DRAWING NUMBER	NOTIFY FAX
	FBO2L17@120	




SECTION A-A



SYSTEM DATA:	
CYCLE TIME	30 SEC. @ 120 MOLDS/HR. (NOT INCLUDING CORE SETTING)
POURING AREA	8 MOLDS
COOLING TIME WITH JACKET @ 120 MOLDS/HR.	MINIMUM 13.0 MINUTES MAXIMUM 17.0 MINUTES
TOTAL COOLING TIME @ 120 MOLDS/HR.	MINIMUM 30.0 MINUTES MAXIMUM 39.0 MINUTES

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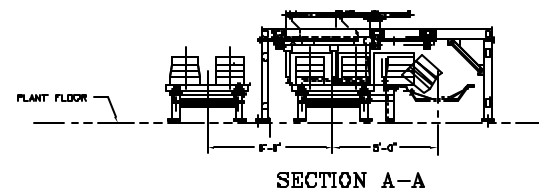
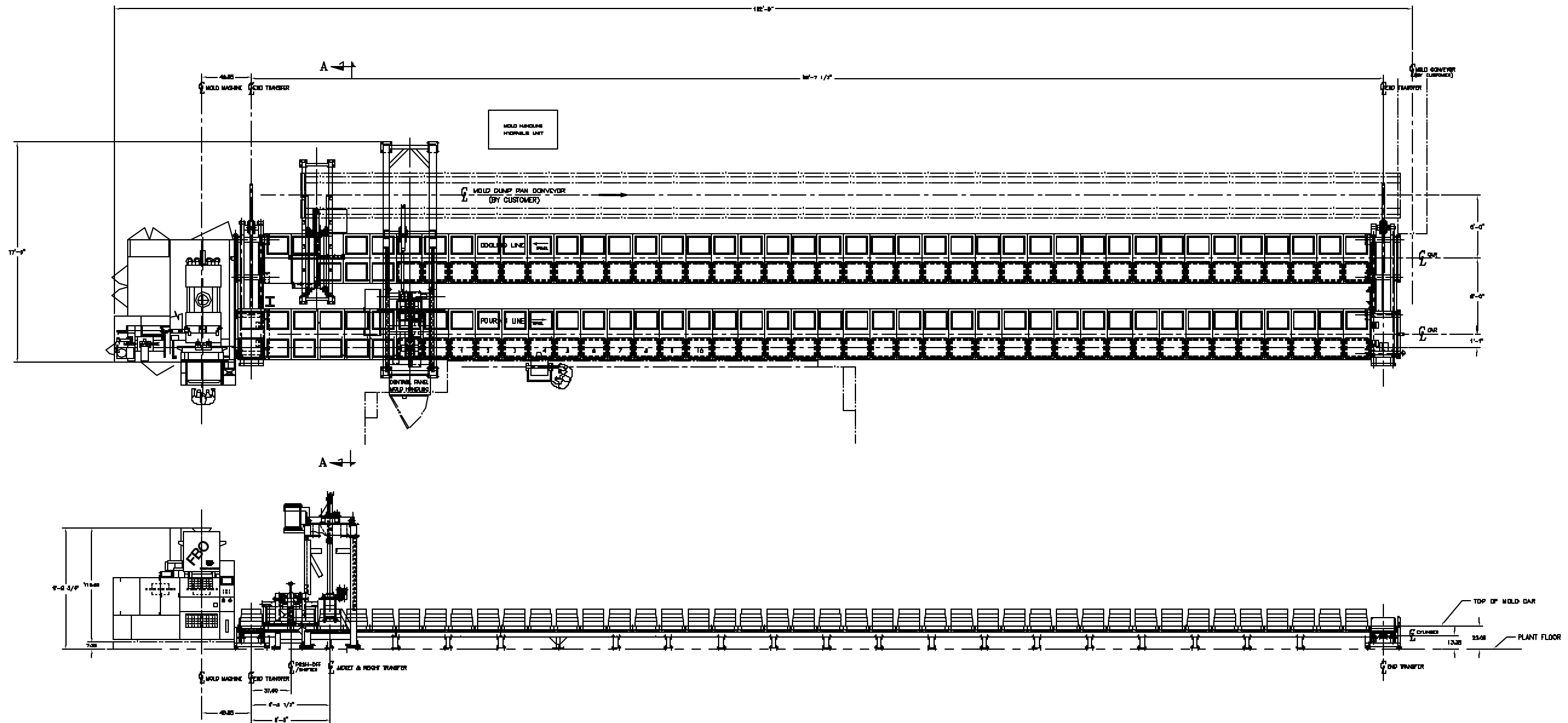
NO.	REVISIONS	DATE	BY


 380 WEST MAIN STREET • P.O. BOX 87760
 LANSING, MICHIGAN 48211-7760

SCALE	APPROVED BY	CHECKED BY	DESIGN BY
3/8"=1'-0"			TGB


FBO-II-L MOLDING SYSTEM
 GENERAL ARRANGEMENT - 35 MINUTES COOLING @ 120 MPH

DATE	ENGINE NUMBER	REV. FOR NO.
12-22-03	FBO2L35@120	



SYSTEM DATA:	
CYCLE TIME	30 SEC. @ 120 MOLDS/HR. (NOT INCLUDING CORE SETTING)
POURING AREA	10 MOLDS
COOLING TIME WITH JACKET @ 120 MOLDS/HR.	MINIMUM 30.0 MINUTES MAXIMUM 35.0 MINUTES
TOTAL COOLING TIME @ 120 MOLDS/HR.	MINIMUM 74.0 MINUTES MAXIMUM 78.0 MINUTES

NO.	REVISIONS	DATE	BY


ROBERTS SINTO CORPORATION
3301 WEST MAIN STREET • P.O. BOX 87760
 LITTLE ROCK, AR 72211-7760

SCALE 1/4"=1'-0"	APPROVED BY	CHECKED BY	DRAWN BY TGB
DATE 12-22-03			

FBO-II-L MOLDING SYSTEM
GENERAL ARRANGEMENT - 75 MINUTES COOLING @ 120 MPH

JOB NO.	DRAWING NUMBER FBO2L75@120	IND. PART NO.
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