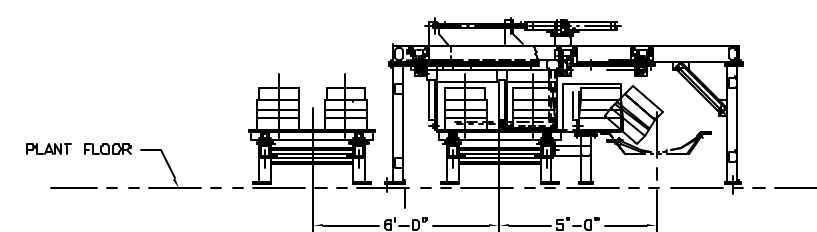
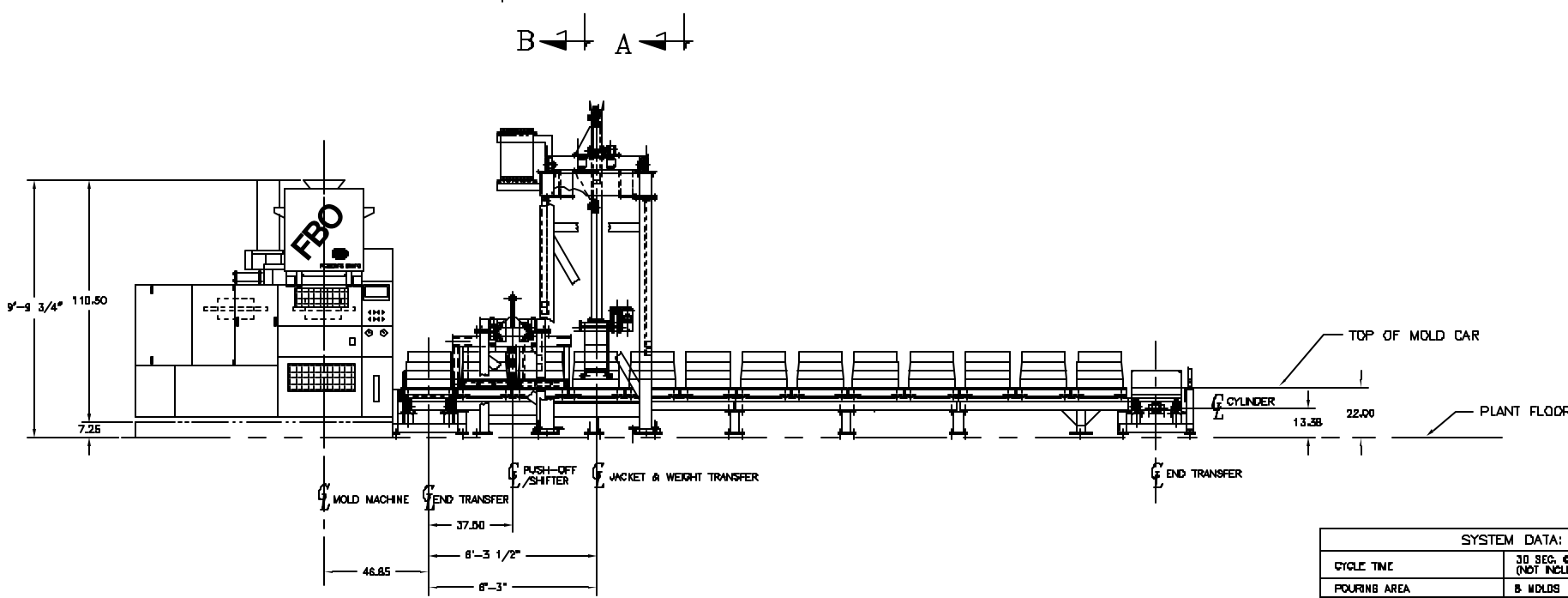


SECTION A-A

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

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 CORPORATION.

NO.	REVISIONS	DATE	BY

**ROBERTS SINTO CORPORATION**  
300 WEST MAIN STREET • P.O. BOX 4070  
LANSING, MICHIGAN 48901-1940

SCALE: 3/8"=1'-0"  
 DATE: 12-01-03

APPROVED BY: \_\_\_\_\_ CHECKED BY: \_\_\_\_\_ DRAWN BY: TGB

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

JOB NO. \_\_\_\_\_ DRAWING NUMBER: FBO2L17@120