


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
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 LANSING, MICHIGAN 48211-7760

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 FB02L75@120	FIG. PART NO.
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