



SYSTEM DATA:	
CYCLE TIME	30 SEC. @ 120 MOLDS/HR (NOT INCLUDING CORE SETTING)
POURING AREA	9 MOLDS
COOLING TIME WITH JACKET @ 120 MOLDS/HR	MAXIMUM 18.6 MINUTES MINIMUM 14.5 MINUTES
TOTAL COOLING TIME @ 120 MOLDS/HR	MAXIMUM 88.0 MINUTES MINIMUM 94.0 MINUTES

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NO.	REVISIONS	DATE	BY

ROBERTS SINTO CORPORATION
 3801 WEST MAIN STREET • P.O. BOX 40740
 LAWRENCE, MISSOURI 64601-1780

3/8"=1'-0"
 DATE: 12-22-03

APPROVED BY: [Signature] CHECKED BY: [Signature] DRAWN BY: TGB

FBO-II-L MOLDING SYSTEM
 GENERAL ARRANGEMENT - 90 MINUTES COOLING @ 120 MPH

NO. FBO2L90@120