



SYSTEM DATA:	
CYCLE TIME	24 SEC. @ 150 MGLDS/HR. (NOT INCLUDING CORE SETTING)
POURING AREA	10 MGLDS
COOLING TIME WITH JACKET @ 150 MGLDS/HR.	MAXIMUM 12.4 MINUTES MINIMUM 8.8 MINUTES
TOTAL COOLING TIME @ 150 MGLDS/HR.	MAXIMUM 14.8 MINUTES MINIMUM 11.2 MINUTES

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ROBERTS SINTO CORPORATION
3001 WEST MAIN STREET • P.O. BOX 4070
 LANSING, MICHIGAN 48901-7000

SCALE 3/8"=1'-0"	APPROVED BY	CHECKED BY	DRAWN BY
DATE 12-01-03			TGB
FBO-II-R MOLDING SYSTEM GENERAL ARRANGEMENT - 10 MINUTES COOLING @ 150 MPH			
NO.	REVISIONS	DATE	BY
			DRAWING NUMBER FBO2R10