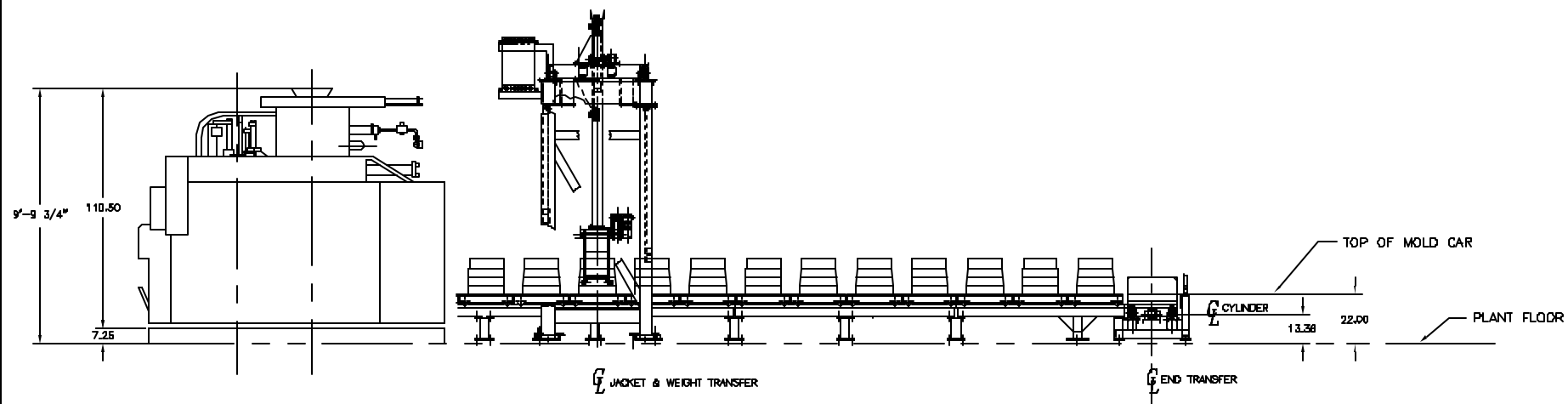


SECTION A-A

NOTE: JACKET CLEANING STATION IS OPTIONAL.



SECTION B-B

SYSTEM DATA:

CYCLE TIME	24 SEC. @ 150 MOLDS/HR. (NOT INCLUDING CORE SETTING)
POURING AREA	B MOLDS
COOLING TIME WITH JACKET @ 150 MOLDS/HR.	MAXIMUM 6.4 MINUTES MINIMUM 3.6 MINUTES
TOTAL COOLING TIME @ 150 MOLDS/HR.	MAXIMUM 22.4 MINUTES MINIMUM 19.8 MINUTES

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NO.	REVISIONS	DATE	BY
 <b>ROBERTS SINTO CORPORATION</b> <small>300 WEST MAIN STREET • P.O. BOX 47740            LANSING, MICHIGAN 48211-1750</small>			
MOLD	3/B=1'-0"	APPROVED BY	CHECKED BY
DATE	12-22-03	DESIGN BY	TGB
<b>FBO-II-R MOLDING SYSTEM</b> <b>GENERAL ARRANGEMENT - 20 MINUTES COOLING @ 150 MPH</b>			
JOB NO.	FBO2R20	DRAWING NUMBER	REV. DATE