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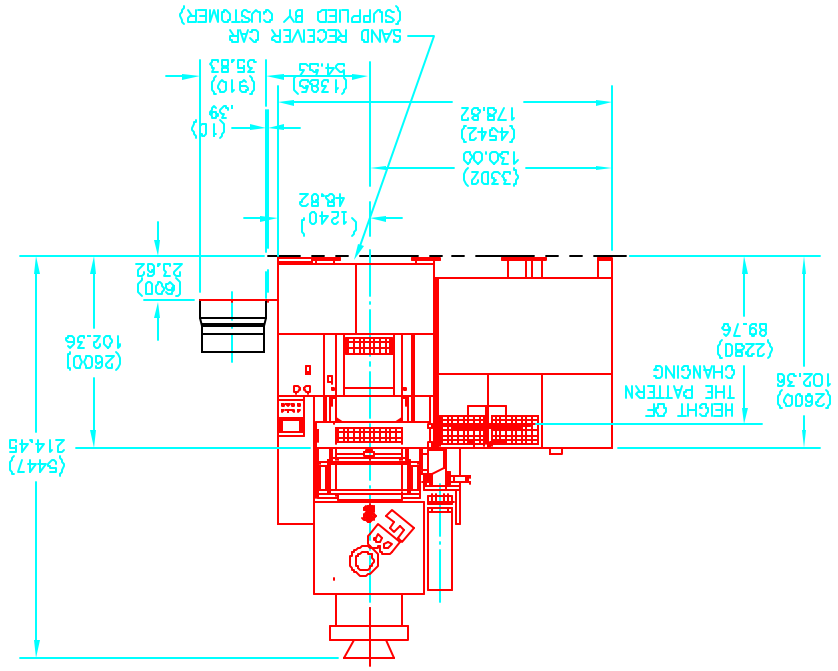
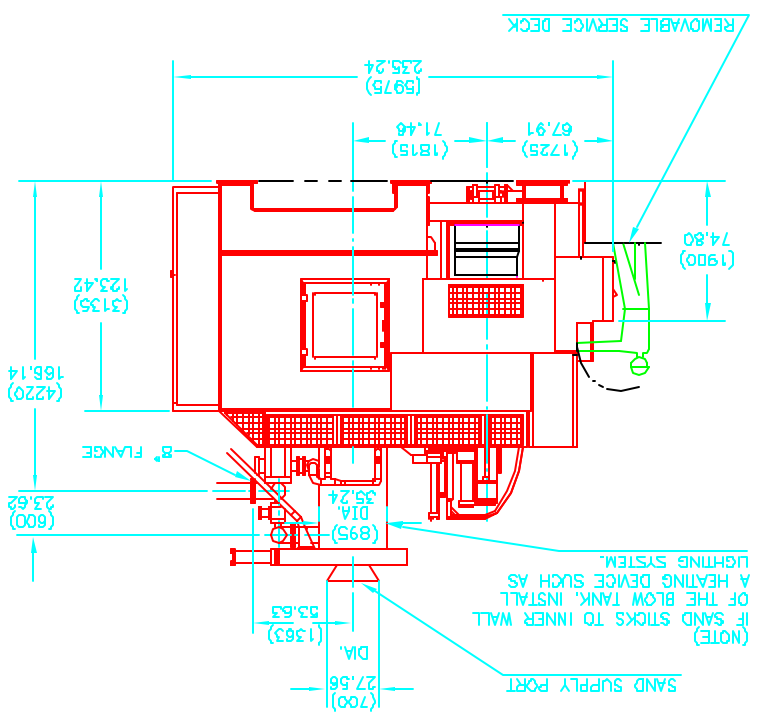




DIMENSIONS IN BRACKETS ARE IN MM

SINTO# L2-103973

			DATE 1/12/99	CL
SCALE	UNLESS OTHERWISE SPECIFIED	DRAWING NO.		DRAWN BY

ROBERTS SINTO CORPORATION
3301 WEST MAIN STREET • P.O. BOX 4070
LANSING, MICHIGAN 48904-1960

NO.	REVISIONS	DATE	BY

FBO-V-00-DO1-L

SPECIFICATIONS

NAME		HORIZONTAL TYPE FLASKLESS MOLDING MACHINE
MODEL		FBO-V (R)
MOLD	L x B	32" X 32" (812.8 X 812.8)
	H	11" ~ 14" (CDPE) 11" ~ 14" (DRAG) CAN BE PRESET AT 3 STAGES
MOLDING METHOD		TOP BLOW + SQUEEZE
MOLDING SPEED (MAX)		45 SEC/MOLD (CORE SETTING IS NOT INCLUDED) (NOTE 1)
SQUEEZE PRESSURE (MAX)		142 PSI (10.0 KGF/CM²)
OPERATION METHOD		AIR & HYDRAULIC PRESSURE (52KW/4P W/WATER COOLING)
AIR CONSUMPTION		141 CFEA/MOLD (4. 0 NM³/MOLD)
OPERATION AIR PRESSURE		74 ~ 86 PSI (5.2 ~ 6.0 KGF/CM²)
CONTROL METHOD		SEQUENCER
POWER SOURCE		SOURCE: AC 480V, 60HZ (OPERATION: AC 100V)
MOLD WEIGHT (MAX)		1,528 LBS. (693KG)
COLOR OF PAINT		MACHINE: S1-1002
		CONTROL AND OPERATION PANELS :S1-1002 (NOTE 2)
ACCESSORIES		MASTER PLATE (FOR STANDARD MATCH PLATE) 1 SET
		SPRUE CUP, SPRUE STICK 1.38" (35) DIA. 1 SET
		STANDARD TOOLS 1 SET
		MACHINE FOUNDATION BOLT 1 SET
		SQUEEZE BOARD HEATER (200V X 1000W) 2 SETS
		PARTING AGENT TANK 5.3 GAL. (20L) 1 SET

(NOTE 1) THIS MAX. MOLDING SPEED (45 SEC. /MOLDS) IS ACHIEVED WHEN THE MOLD HIGH'S ARE 14"/14". IF CORES MUST BE SET, ADD 8 SECONDS FOR DRAG MOLD SLDING + CORE SETTING TO CYCLE TIME.

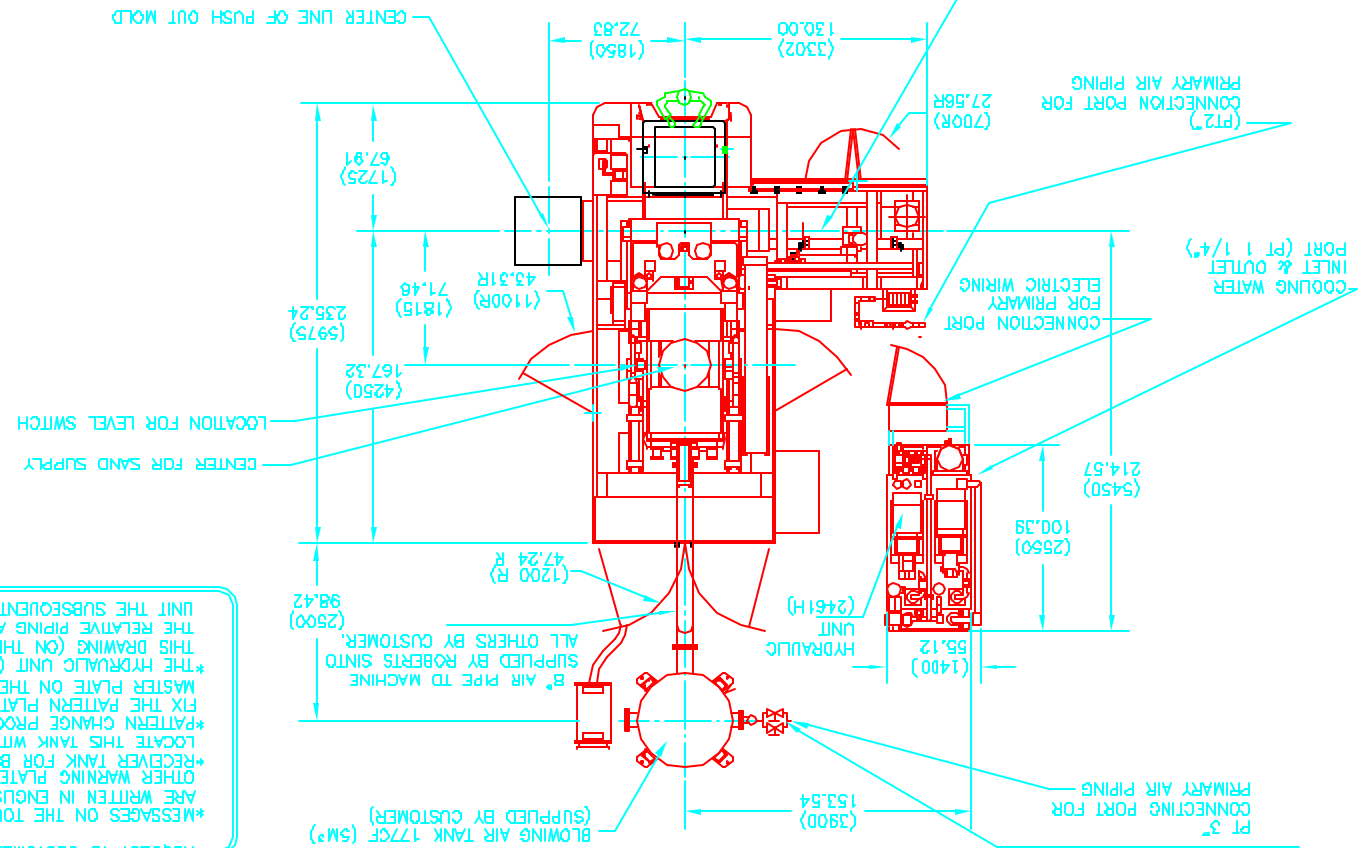
(NOTE 2) COLOR OF PAINT CONFERS TO THE NUMBER OF JAPAN PAINT ASSOCIATION.

OTHER EQUIPMENT EXCEPT FOR THE ESTIMATED SPECIFICATIONS (SUPPLIED BY CUSTOMER)

1. AIR TANK FOR BLOWING	177 CF (5M³)	1 SET
2. HYDRAULIC WORKING OIL	(NEAR RESISTANT HYDRAULIC OIL) ISO VG46 240 GAL(90DL)	
WATER COOLED HYDRAULIC UNIT	COOLING WATER 90°F (32°C) OR BELOW	
3. MATCH PLATE	STEEL PLATE 1.38" ~ 1.57" (35~40) THICK (MATCH PLATE ATTACHED ON THE MATCH PLATE WITH BOLT)	1 SET
4. PRIMARY AIR PIPING	3" DIA. & 2" DIA.	1 SET
5. PRIMARY ELECTRIC AND EARTH WIRES	AC 480V, 60HZ, 55KW	1 SET
	WIRING WORKS SHOWN IN THIS DRAWING WILL BE	
PANEL AND OPERATION PANEL	BY SINTO, WHILE OTHERS BY CUSTOMER.	1 SET
6. MIXED SAND SUPPLY UNIT		1 SET
7. WORKING DECK FOR CORE SETTING AND PATTERN CHANGE		1 SET
8. MOLDING MACHINE SUPPORT FOUNDATION FRAME AND SAND RECEIVER CAR		1 SET
9. MEASURES AGAINST FREEZE		1 SET
10. HOIST FOR REPLACING MATCH PLATE	FOR APPROX. 1,764 LB (800KG)	1 SET
11. UTILITY		
*COMPRESSED AIR	74 ~ 86 PSI (5.2 ~ 6.0 KGF/CM²) SECONDARY INLET PRESSURE	
*ELECTRIC POWER	AC 480V 60HZ	
*SUPPLIED WATER	14 ~ 29 PSI (1 ~ 2 KGF/CM²) 66 GPM (250 L/MIN) WATER TEMPERATURE 90°F (32°C) OR BELOW	

OPTIONAL SPECIFICATIONS

* PATTERN HEATER (100V X 650W X 2 SET) WITH VOLUME CONTROLLER.
* AIR BLOWING DEVICE FOR DRAG MOLD CLEANING, WITH BALL VALVE (3/4")
SIMULTANEOUS OPERATION WITH DRAG FLASK SLIDE.
IF IT IS NOT USED CLOSE THE RETAINER VALVE.



REQUEST TO CUSTOMER

*MESSAGES ON THE TOUCH PANEL SCREEN LOCATED ON THE OPERATORS PANEL ARE WRITTEN IN ENGLISH.
OTHER WARNING PLATES AND VALVE NAMEPLATES ARE WRITTEN IN ENGLISH.
*RECEIVER TANK FOR BLOW IS TO BE PROVIDED BY THE CUSTOMER. PLEASE LOCATE THIS TANK WITHIN 3 METERS FROM THE MOLD MACHINE.
*PATTERN CHANGE PROCEDURE FOR STANDARD PATTERN PLATE IS AS FOLLOWS.
FIX THE PATTERN PLATE ON THE MASTER PLATE WITH BOLTS AND SET THIS MASTER PLATE ON THE PATTERN CHANGER ALONG THE MACHING PINS MANUALLY.
*THE HYDRAULIC UNIT (WITH CONTROL PANEL) WILL BE INSTALLED AS SHOWN IN THIS DRAWING (ON THE SAME LEVEL AS THE MACHINE) AND SINTO TO CARRY OUT THE RELATIVE PIPING AND WIRING. IF CUSTOMER CHANGES LOCATION OF THE UNIT THE SUBSEQUENT INSTALLATION WORK IS AT THE CUSTOMER'S RISK AND EXPENSE.