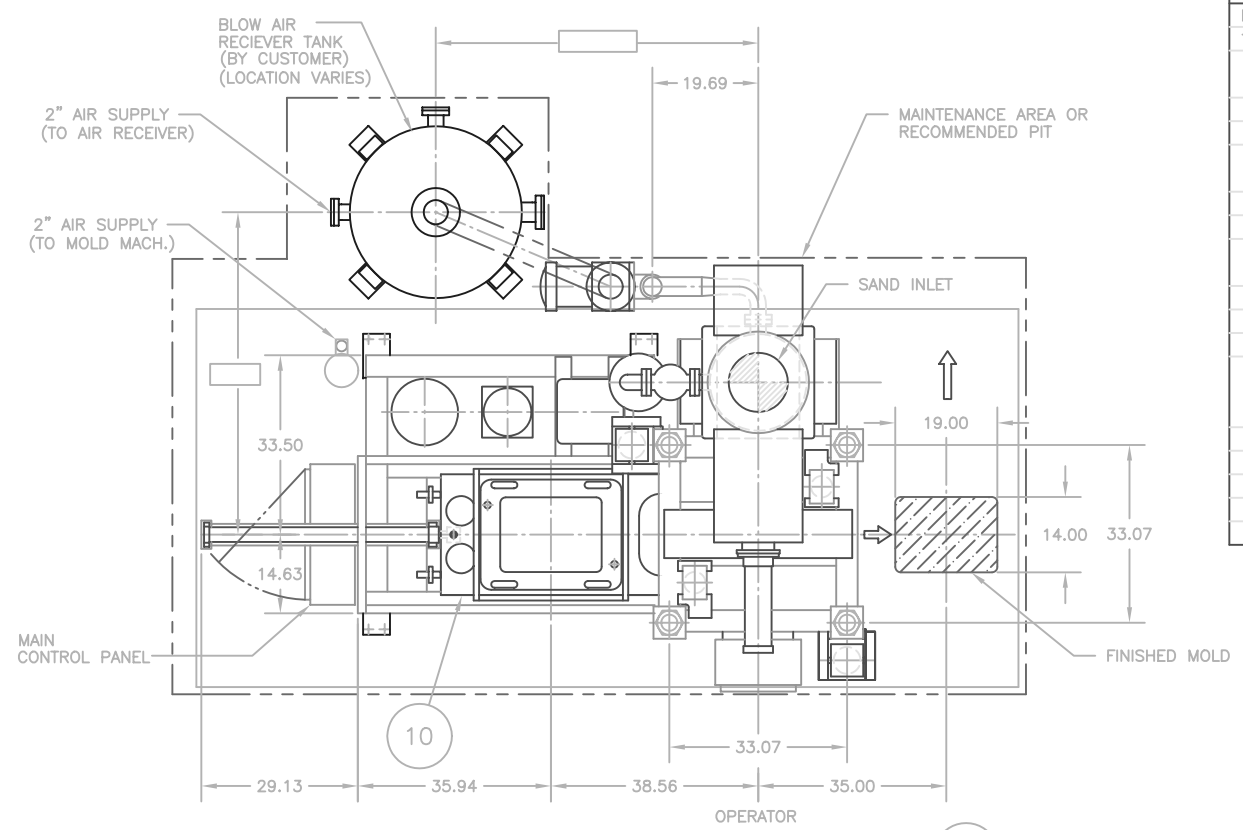
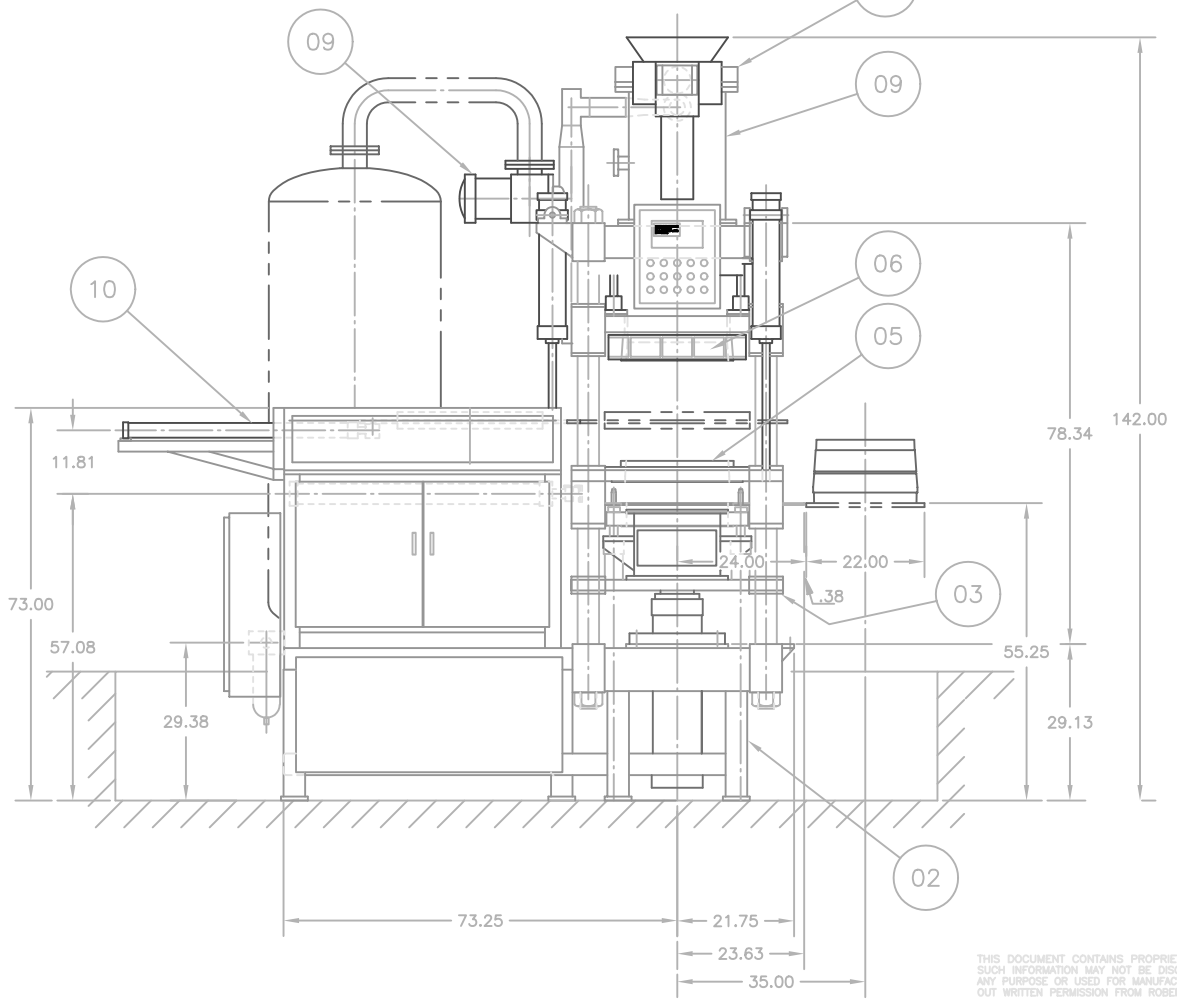


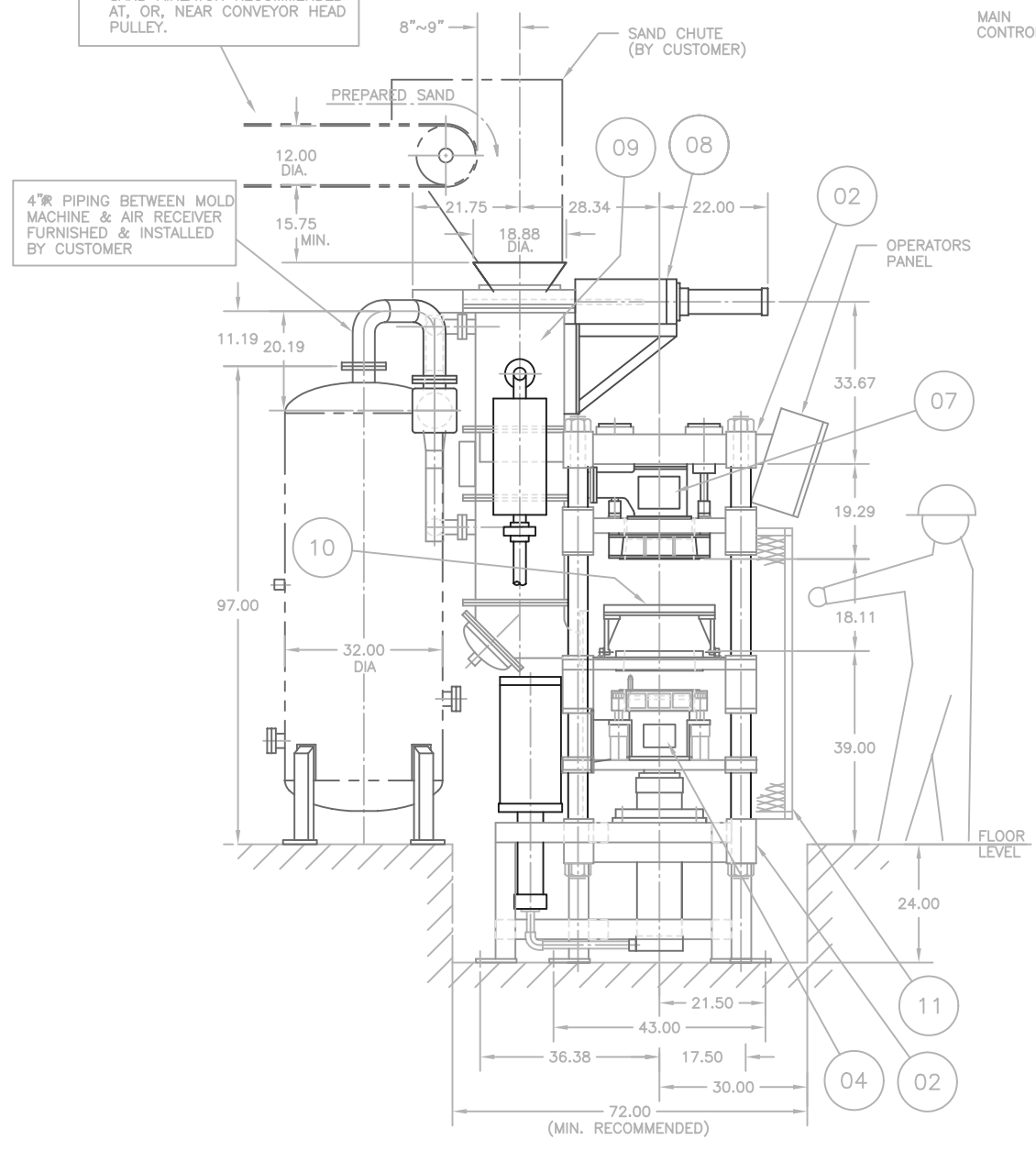
SPECIFICATIONS	
NAME	HORIZONTALLY SPLIT FLASKLESS TYPE MOLDING MACHINE
TYPE	FBM-1L (R.H. EJECT)
MOLD SIZE	L X W HT. 14" X 19" (COPE) 4.8",6.0" (DRAG) 4.8",6.0"
MOLDING METHOD	TOP & BOTTOM BLOW & SQUEEZE
MOLDING SPEED MAX.	30 SEC./MOLD (NOT INCLUDING CORE SETTING)
SQUEEZED AREA PRESSURE	100 PSI (3 STEP CHANGEOVER)
DRIVE METHOD	AIR & AIR/OIL
AIR CONSUMPTION	113 SCFM (MOLD MACH. ONLY) 17.5 CFM @ 80 PSIG.
WORKING AIR PRESSURE	5.6±0.4 KG/CM = 80 ±6 PSIG.
CONTROL METHOD	SLC 500
POWER SUPPLY	120V AC, 60Hz 60 AMP SERVICE
MOLD WEIGHT (MAX.)	172 LBS./MOLD (10 TON/HR. MAX.)
MACHINE WEIGHT (INCL. BODY & HYDR. FLUID)	7000 KG. (15500 LBS.)
ACCESSORIES	STANDARD SPRUE CUP & POST OPTIONAL: PATTERN PLATE HEATER OPTIONAL: AIR RECIEVER TANK (35 CF. CAP.)



PLAN VIEW



- NOTES:
1. POSITION OF SAND FEED BELT TO ALLOW FOR REMOVAL OF SAND CHAMBER SCREENS.
 2. PROVIDE SAND SHUT-OFF AT PULLEY TO PREVENT SAND DRIBBLE ONTO SLIDE GATE.
 3. SAND AIREATOR RECOMMENDED AT, OR, NEAR CONVEYOR HEAD PULLEY.



UNIT NUMBER LISTING	
UNIT NO.	DESCRIPTION
01	GENERAL ARRANGEMENT
02	MACHINE BASE
03	SQUEEZE TABLE ASSEMBLY
04	DRAG BLOW HEAD ASSEMBLY
05	DRAG FLASK ASSEMBLY
06	COPE FLASK ASSEMBLY
07	COPE BLOW HEAD ASSEMBLY
08	SAND GATE ASSEMBLY
09	SAND TANKS & BLOW VALVE
10	PATTERN SHUTTLE & MOLD PUSH OFF
11	GUARDING

NO.	REVISIONS	DATE	BY
SCALE	3/4"=1'-0"	DATE	11-8-94
GENERAL ARRANGEMENT & SPECIFICATIONS			DRAWING NUMBER FBM-1L MOLD MACHINE (R.H. EJECT) RS -01-001

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