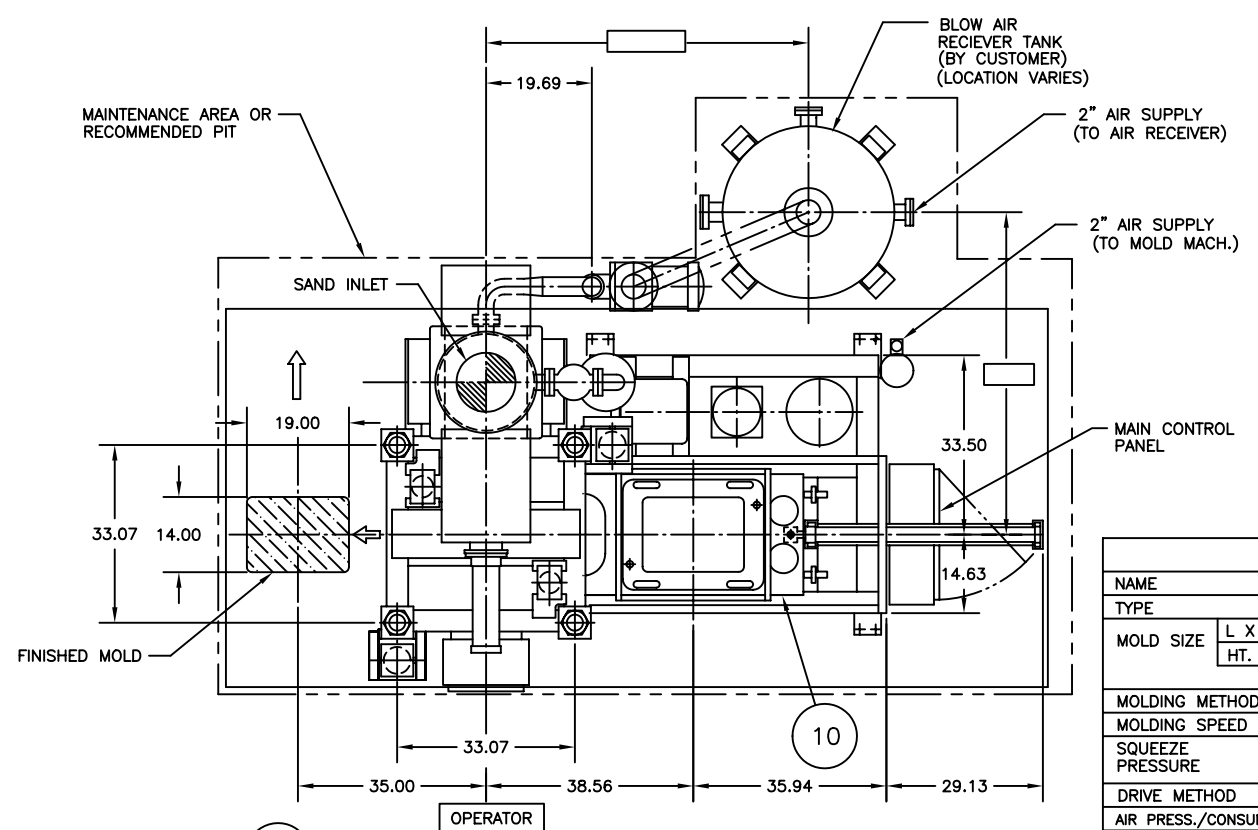
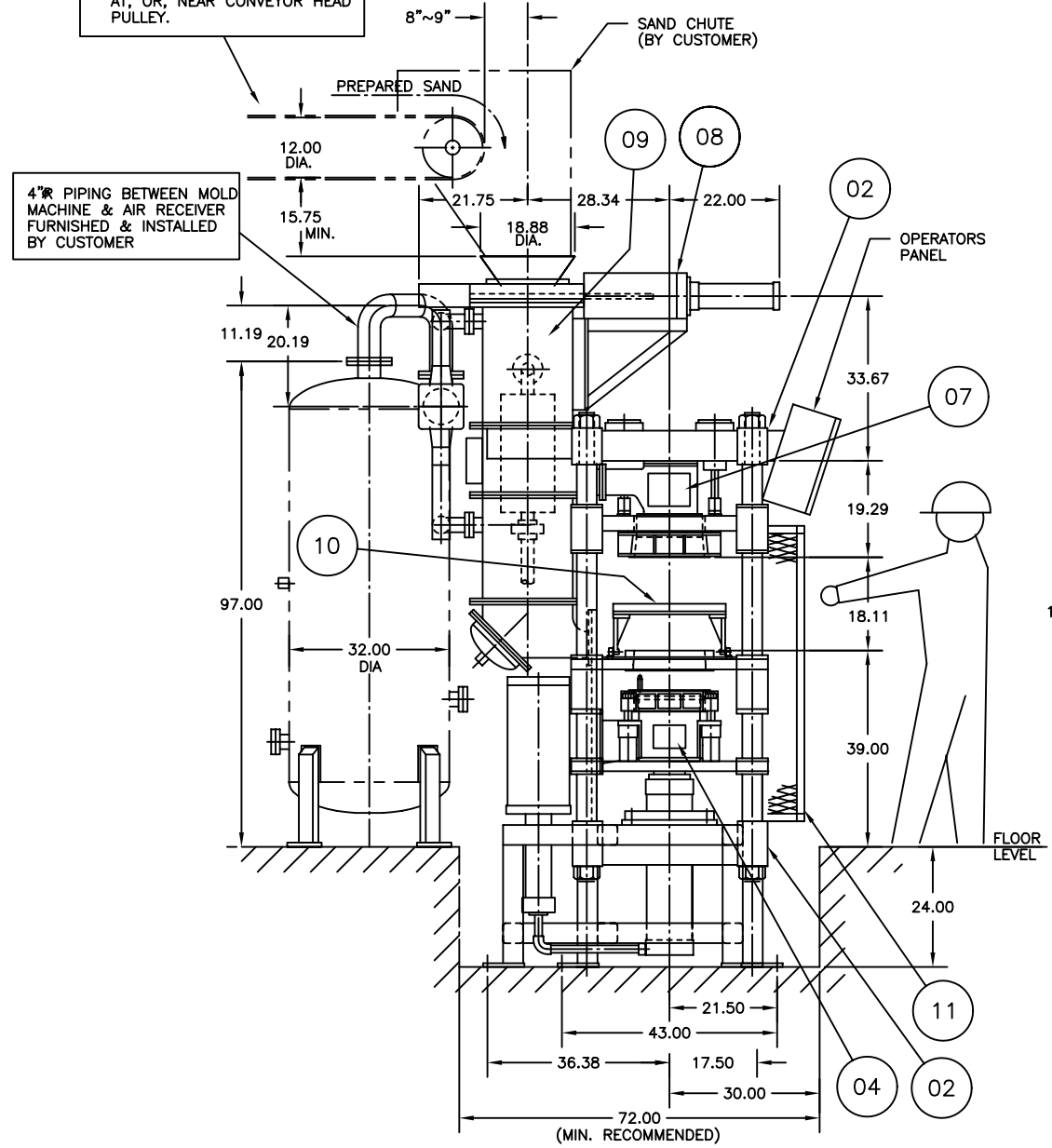
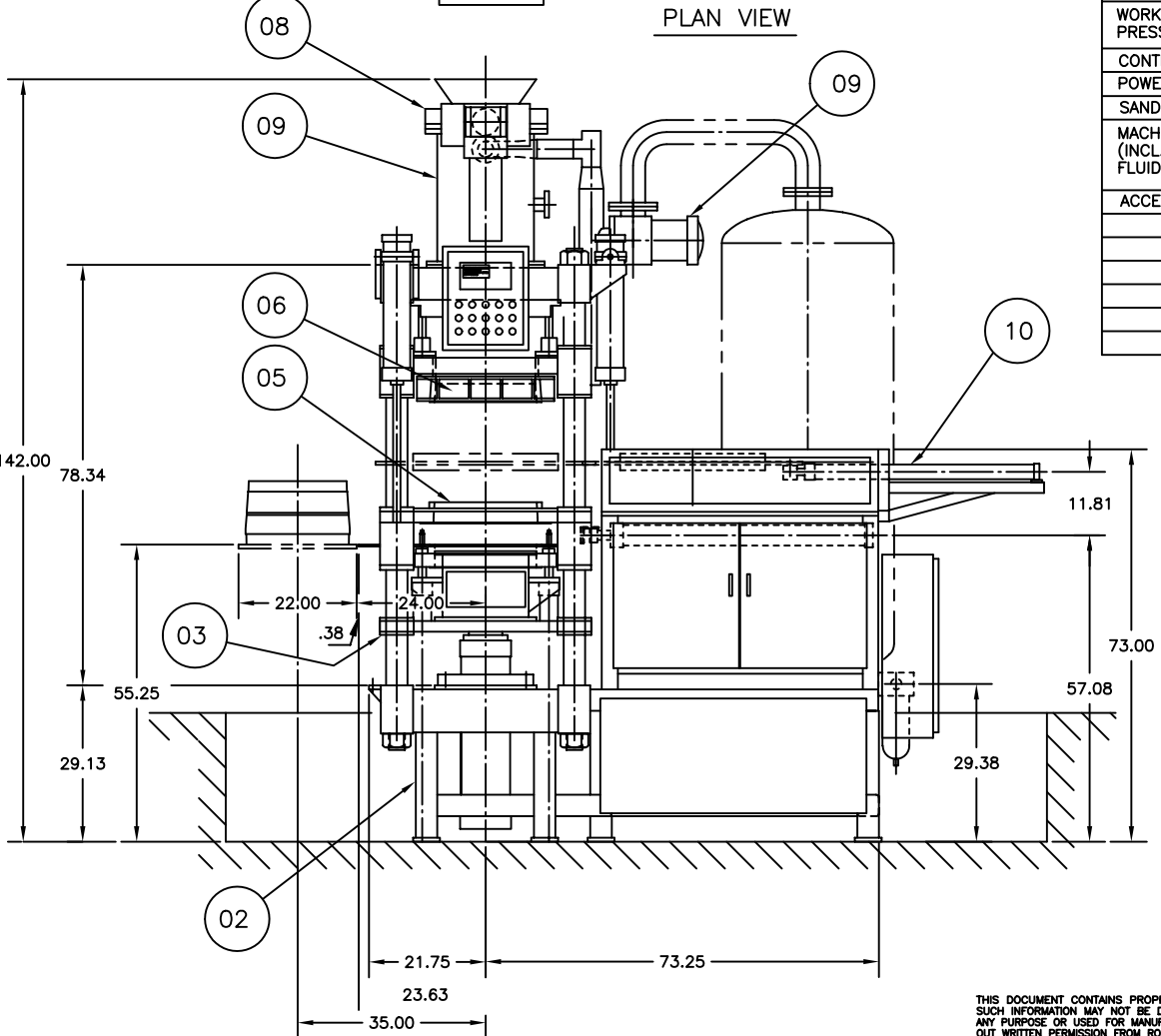


- NOTES:
1. POSITION OF SAND FEED BELT TO ALLOW FOR REMOVAL OF SAND CHAMBER SCREENS.
  2. PROVIDE SAND SHUT-OFF AT PULLEY TO PREVENT SAND DRIBBLE ONTO SLIDE GATE.
  3. SAND AIREATOR RECOMMENDED AT, OR, NEAR CONVEYOR HEAD PULLEY.



PLAN VIEW



SPECIFICATIONS	
NAME	HORIZONTALLY PARTED FLASKLESS TYPE MOLDING MACHINE
TYPE	FBM-1R (L.H. EJECT)
MOLD SIZE	L X W 14" X 19"
	HT. (COPE) 4 3/4" TO 6" (DRAG) 4 3/4" TO 6" (INDEPENDENTLY ADJUSTABLE FROM OPERATORS PANEL)
MOLDING METHOD	TOP & BOTTOM BLOW & SQUEEZE
MOLDING SPEED MAX.	30 SEC./MOLD (NOT INCLUDING CORE SETTING) 120 MOLDS/HR
SQUEEZE PRESSURE	MAX. 30,300 LBS. SAND SURFACE PRESSURE -114 PSI
DRIVE METHOD	AIR & AIR/OIL
AIR PRESS./CONSUMPTION	74 PSI/56.5 CFFA/MOLD
WORKING AIR PRESSURE	5.6±0.4 KG/CM = 80 ±6 PSIG.
CONTROL METHOD	SLC 500
POWER SUPPLY	110V AC, 60Hz -CONTROLS 30 AMP SERVICE
SAND QUANTITY	200 LBS./MOLD MAX. (10 TON/HR. MAX.)
MACHINE WEIGHT (INCL. BODY & HYDR. FLUID)	7000 KG. (15500 LBS.)
ACCESSORIES	CONTROL PANEL STANDARD SPRUE CUP & DOWN SPRUE (1)SET 1" DIA. MASTER PLATE
	OPTIONAL: PATTERN HEATER WITH TEMPERATURE CONTROLLER OPTIONAL: AIR RECIEVER TANK (35 CF. CAP.)

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"	APPROVED BY:	DATE
DATE	11-10-94	CHECKED BY:	RTG
<b>GENERAL ARRANGEMENT &amp; SPECIFICATIONS</b> <b>FBM-1R MOLD MACHINE (L.H. EJECT)</b>			
J-	RS-	FBM-1030-00	01-001R
			SHEET 1 OF 6

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