


MINIMUM TOTAL COOLING TIME
 @ 120 MOLDS/HOUR
 = 12.5 MINUTES

SYSTEM DATA:	
CYCLE TIME	30 SEC. @ 120 MOLDS/HR. (NOT INCLUDING CORE SETTING)
POURING AREA	10 MOLDS
COOLING TIME WITH JACKET @ 120 MOLDS/HR.	MAXIMUM 15.5 MINUTES MINIMUM 11.0 MINUTES
TOTAL COOLING TIME @ 120 MOLDS/HR.	MAXIMUM 17.0 MINUTES MINIMUM 12.5 MINUTES

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300 WEST MAIN STREET • P.O. BOX 8070
 LANSING, MICHIGAN 48911-7900

NO. 3/B"=1'-0"	APPROVED BY	CHECKED BY	DRAWN BY TGB
DATE 12-01-03			
FBO-II-L MOLDING SYSTEM GENERAL ARRANGEMENT - 12 MINUTES COOLING @ 120 MPH			
NO.	REVISIONS	DATE	BY
			PROJECT NO. FBO2L12@120