



FBO SERIES

Horizontal Parting Flaskless Molding Machine

**Aeration
Sand Filling
Technology**

FEATURES

For the first time in single station machine, automatic drag shuttle mechanism is adopted for safe and easy core setting in a comfortable posture.

Touch screen panel is adopted for simple control of the machine. Legible display provides reliable and stable molding operation.

Top blow system of FBO does not require severe control of molding sand. The machine accepts tough property of sand with a high CB value.

Changing of matchplate is as simple as one touch by setting the plate to the pins on shuttle frame.

Easy core setting & Easy operation

Molding Rate (MAX) : **150** molds/hr

*Excluding core setting time FBO-II-FBO-IIN

Drag Mold Slides Out

GREEN SAND MOLDING LINEUP OF MOLDING MACHINES



FCMX SERIES
Horizontal Parting Flaskless Molding Machine



FBOX SERIES
Horizontal Parting Flaskless Molding Machine



FDNX SERIES
Horizontal Parting Flaskless Molding Machine

ACE SERIES Tight Flask Molding Machine



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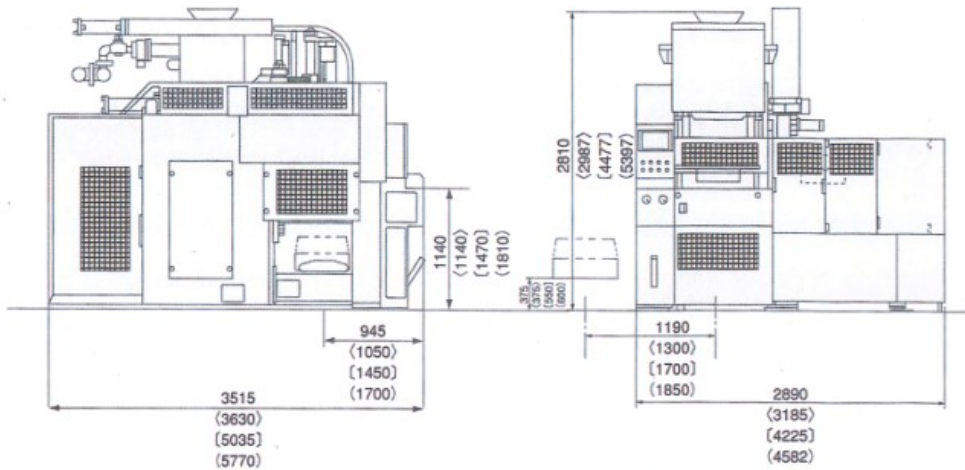
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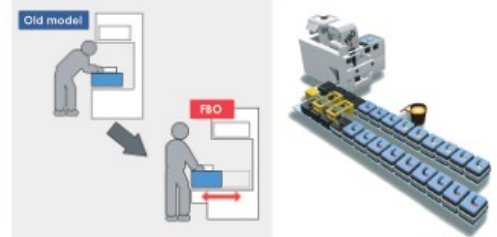
DIMENSION



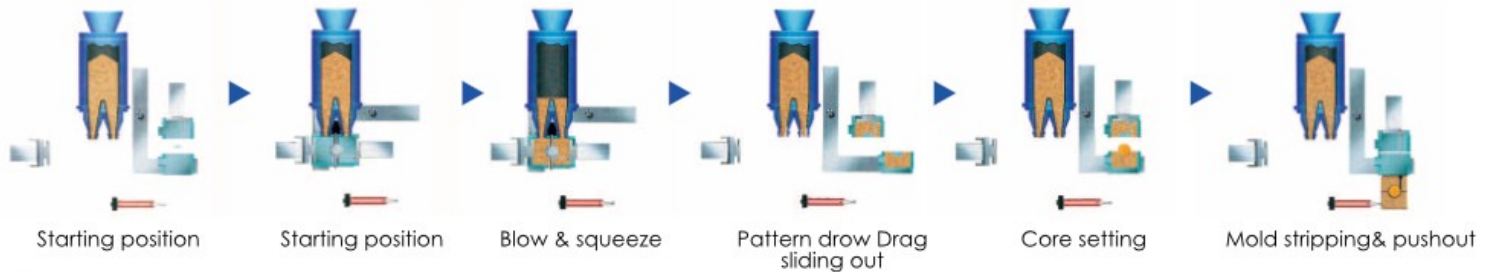
*The machine shown above is FBO-II, and the dimensions in < > are for fbo () for FBO-IV and () for FBO-V.



Actual installation example



Molding Process



SPECIFICATION

FBO SERIES SPECIFICATION

Model		FBO-II	FBO-III	FBO-IV	FBO-V
Mold size	Length(L)x Breadth(B)mm	400x300 500x400 430x310 500x406 (20"x16")	600x500 609.6x508 (24"x20")	700x600 671.2x508 (28"x20")	762x609.6 812.8x762 (30"x24") (32"x30")
	Height(H)mm	450x350 520x420 483x356 550x450 (19"x14")	660.4x508 26"x20"	711.2x660.4 28"x24"	812.8x812.8 32"x32"
		[Cope] 130-200/[Drag] 130-200 3-steps optional presetting *400x300, 430x310 [Cope] 100-150/[Drag] 100-150 3-steps optional presetting		[Cope] 180-250/[Drag] 180-250 3-steps optional presetting	
Molding method		Top blow + Squeeze (Option:Aeration Sand Filling)			
Molding speed (Max)		24sec/mold (Without core setting)*1	27sec/mold (Without core setting)*1	36sec/mold (Without core setting)*2	40sec/mold (Without core setting)*3
Squeeze pressure on mold face (Max)		~1.0 Mpa (~10.0kgf/cm ²) 3-steps changeable			
Actuating Power source		Air & hydraulic (15kW...water-cooled)		Air & hydraulic (30kW...water-cooled)	Air & hydraulic (52kW...water-cooled)
Air consumption		1.0m ³ (Normal)/mold	1.2m ³ (Normal)/mold	2.5m ³ (Normal)/mold	3.5m ³ (Normal)/mold
Actuating air pressure		0.5~0.55MPa (5~5.5 kgf/cm ²)			
Electricity		Drive circuit AC460V (50Hz) Control circuit AC100V (50Hz)			
Weight of Mold(max)		36 kg~148 kg	117 kg~201 kg	195 kg~352 kg	320 kg~567 kg
Colour code		Machine & panels : DE80 Wire netting : Black			

Molding speed given here stands for fastest case with maximum setting of mold thickness and without core. If cores are set, the cycle time is prolonged for 4 sec. for drag shuttling + core setting time. Molding speed given here stands for fastest case with maximum setting of mold thickness and without core. If cores are set, the cycle time is prolonged for 5 sec. for drag shuttling + core setting time. Molding speed given here stands for fastest case with maximum setting of mold thickness and without core. If cores are set, the cycle time is prolonged for 6 sec. for drag shuttling + core setting time. The above specification may be changed for improvement without notice.

Standard accessories

Regular sprue cup former and gate stick 1set. Tool set. Squeeze board heater (200V) - 2sets. Anchor bolts 1set. Parting agent tank 1set. (15L for FBO-II, 20 & for FBO-IV, V.)

