

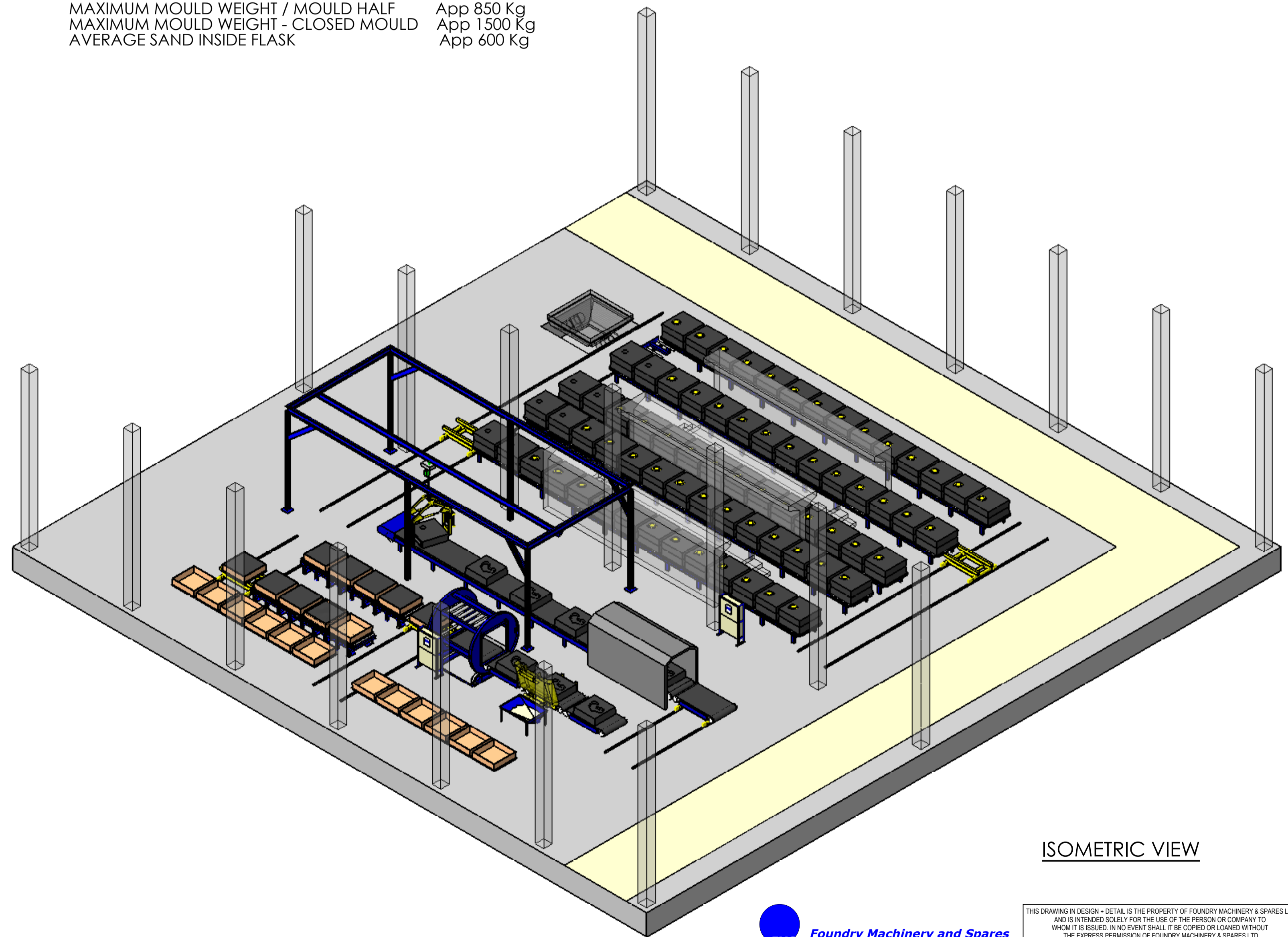
**OPERATION DATA:**

PLANT LOCATION:  
 PRODUCTION DATA: 5 DAYS / WK, 2 SHIFTS / DAY, 7.5 HRS / SHIFT

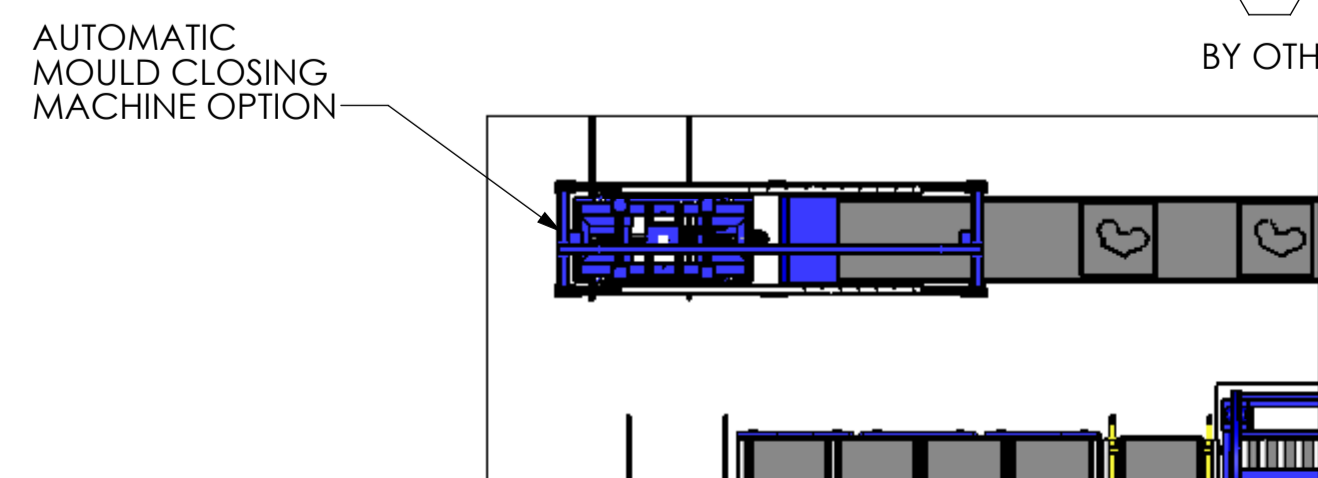
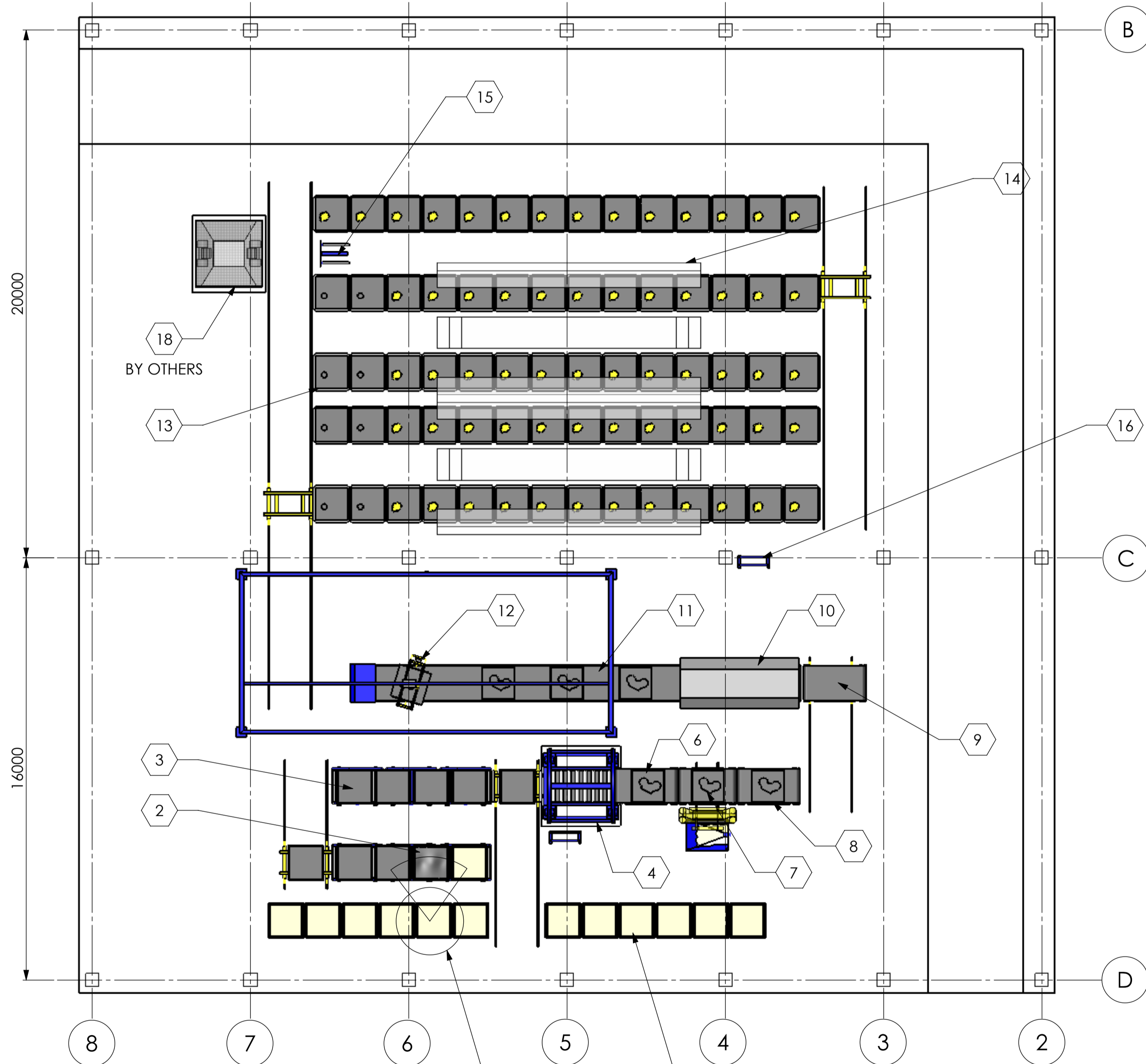
MOULD SIZES: MINIMUM 500 x 500 x 200 / 150  
 MAXIMUM 1200 x 1200 x 300 / 400

10 MOULDS / HOUR  
 FURANE BONDED SAND PROCESS  
 FLASKLESS MOULDS USING SILICA SAND

MAXIMUM MOULD WEIGHT / MOULD HALF App 850 Kg  
 MAXIMUM MOULD WEIGHT - CLOSED MOULD App 1500 Kg  
 AVERAGE SAND INSIDE FLASK App 600 Kg



ISOMETRIC VIEW



**Foundry Machinery and Spares**  
 Unit H, Fryers Close, Walsall, West Midlands, WS3 2XQ  
 Tel: 01922 713729

TOLERANCES UNLESS OTHERWISE STATED		
DIMENSIONS IN MM	MACHINED	UNMACHINED
UP TO 20	±0.10	±0.5
ABOVE 20 TO 50	±0.15	±0.75
ABOVE 50 TO 200	±0.20	±1.0
ABOVE 200 TO 500	±0.40	±1.25
ABOVE 500 TO 1000	±1.00	±1.5
1000 AND ABOVE	±0.80	±2.0

DRAWN: A.P.E. DATE: NOV 08

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TITLE: PROPOSED FOUNDRY LAYOUT

PROJECT:	SCALE: 1:125	REVISION
SHEET SIZE: A1		
DRAWING No.		
FMS-0133-01		