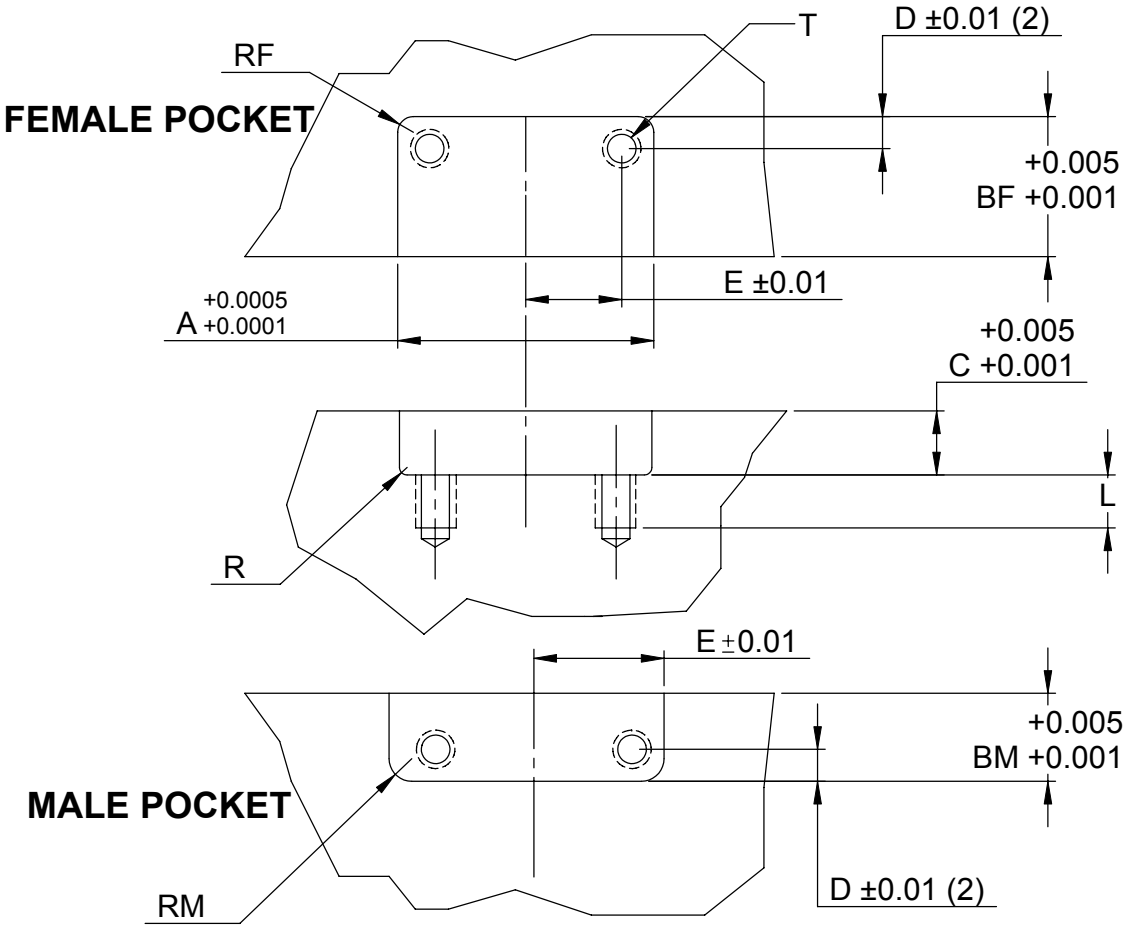
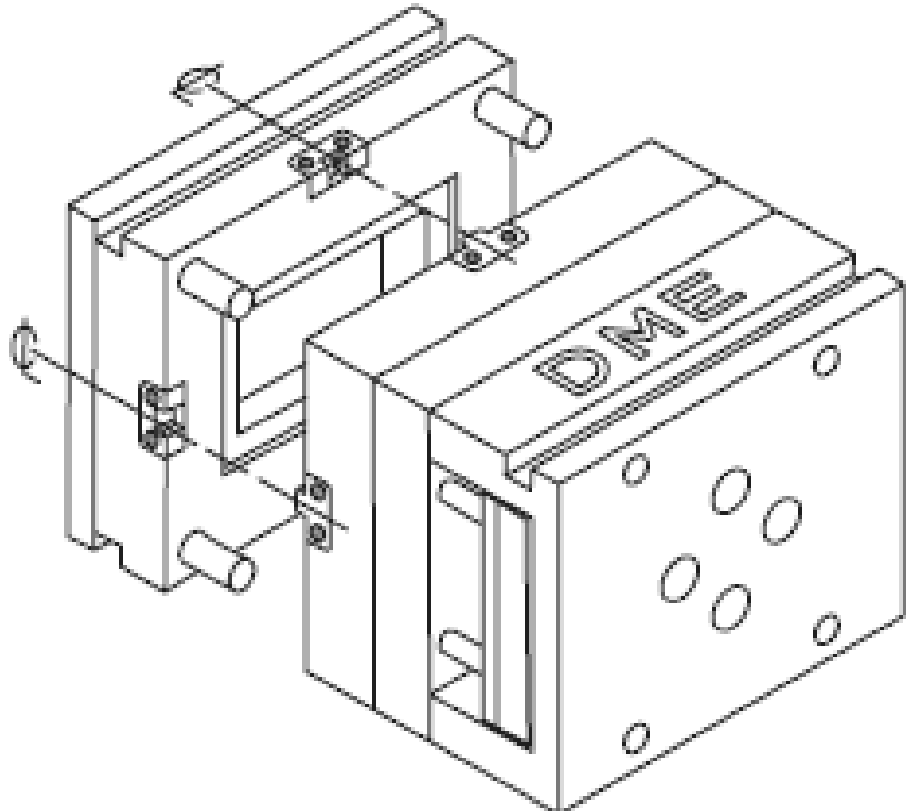


ME-06-0005-0007(B) Catalog # BGSIP
 INSTALLATION DATA
 FOR BLACK & GOLD SIDE INTERCHANGEABLE INTERLOCKS
 Please read carefully before installing components.



Dimensions Shown in inches
 Unless otherwise specified,
 Tolerances are:
 Fractions +/- 0.015
 0.00 +/- 0.01
 0.000 +/- 0.005
 RECOMMENDED POCKET
 SURFACE FINISH IS 63 Ra

Installation Instructions:

1. Four D-M-E Side Interlocks must be used in each mold application. When in operation, the interlocks contact the edges of the machined pocket to maintain parting line alignment. The cap screws are only utilized to retain the interlocks to the mold base.
2. To maintain alignment, it is recommended that the mold base assembly be clamped together and machined in assembly to insure proper parting line alignment.
3. Machine the interlock pockets accurately in assembly. Locate each interlock pocket on the centerline of the mold. The location is critical to avoid misalignment problems which could result from uneven thermal expansion of the separate mold halves.
4. Mount the female interlock on the half of which will have the highest operating temperature. Normally, this will be the "A" side of the mold. This procedure is critical to insure that the male interlock does not grow larger than the female interlock if uneven mold temperatures are present.
5. Torque the mounting SHCS to:
 - 55 in.lbs for #8-32 SHCS
 - 90 in.lbs for #10-32 SHCS
 - 200 in.lbs for 1/4-20 SHCS
 - 740 in.lbs for 3/8-16 SHCS
 - 1,800 in.lbs for 1/2-13 SHCS
6. After installation, open and close the mold on the bench to insure proper alignment.

CAT #	CAT #	A	BM	BF	C	D	E	RF/RM	R	T	L
MALE	FEMALE	POCKET	MALE	FEMALE	POCKET				POCKET	SCREW	THREAD
		LENGTH	POCKET	POCKET	POCKET	SCREWS	POCKET	POCKET	BOTTOM	SIZE	LENGTH
			WIDTH	WIDTH	DEPTH	LOCATIONS	RADIUS	RADIUS			
BGS1600M	BGS1600F	1.500	0.875	0.875	0.500	0.250	0.500	0.125	0.016	#8-32x5/8"	0.375
BGS2000M	BGS2000F	2.000	0.875	1.375	0.500	0.312	0.688	0.125	0.016	#10-32x5/8"	0.438
BGS3000M	BGS3000F	3.000	0.875	1.875	0.750	0.375	1.125	0.187	0.016	1/4-20x7/8"	0.500
BGS4000M	BGS4000F	4.000	1.375	2.375	1.000	0.500	1.500	0.375	0.016	3/8-16x1"	0.500
BGS5000M	BGS5000F	5.000	1.375	2.875	1.250	0.625	1.875	0.375	0.016	1/2-13x1.14"	0.813

Dimensions Shown in inches
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 Fractions +/- 0.015
 0.00 +/- 0.01
 0.000 +/- 0.005