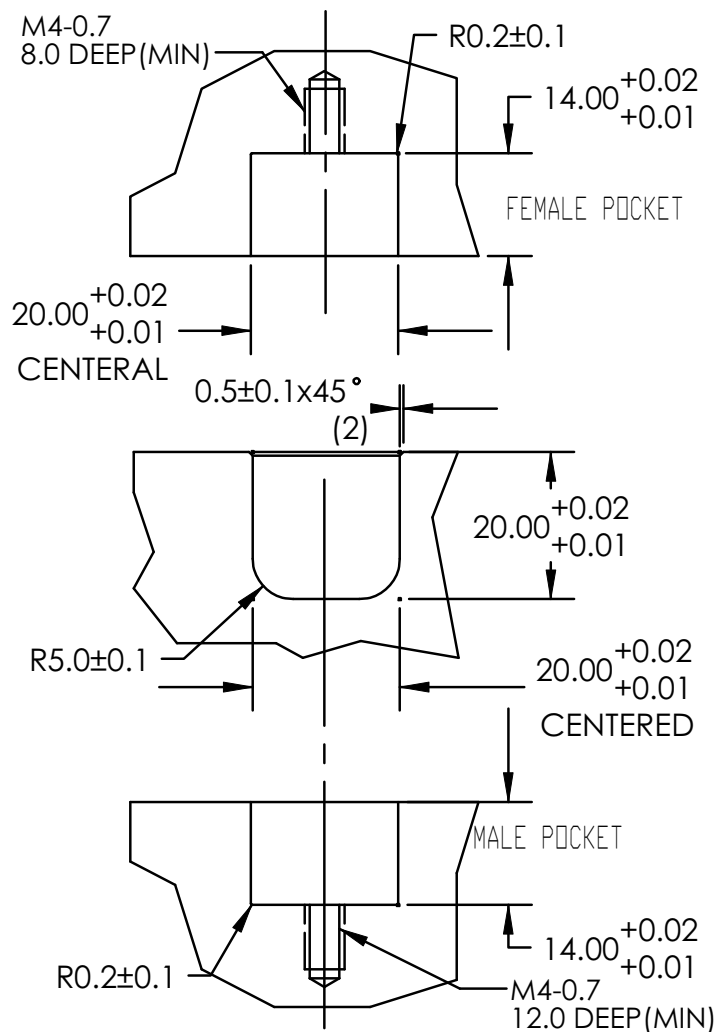
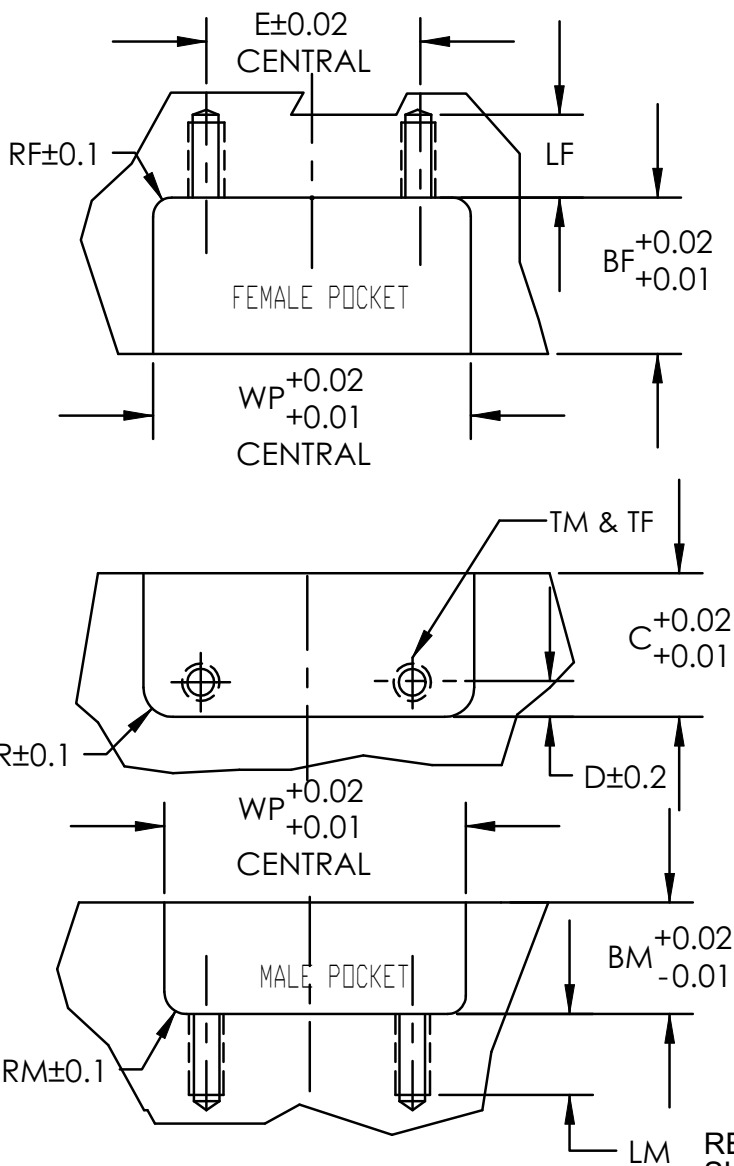
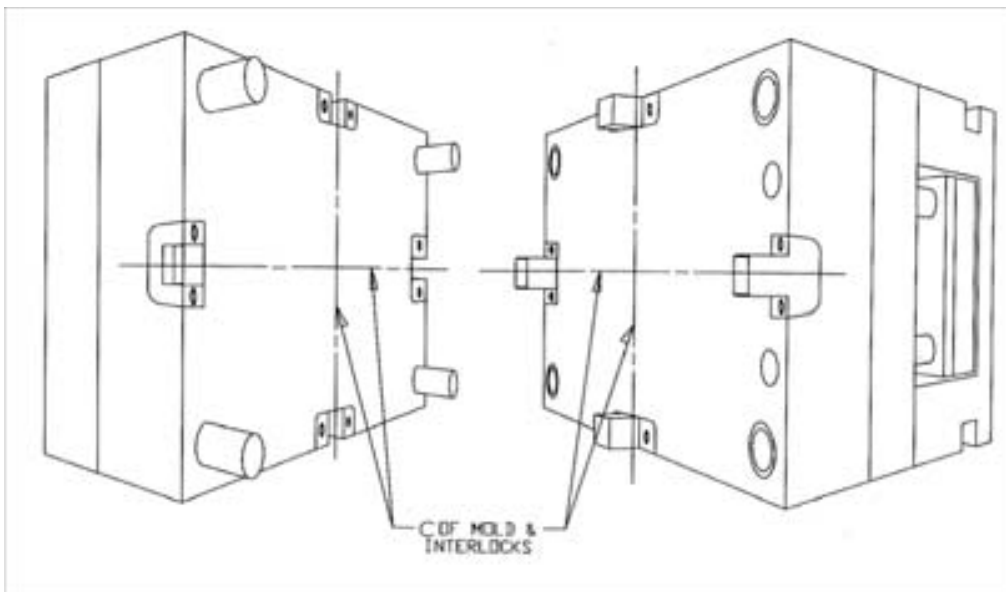


INSTALLATION DATA
FOR BLACK&GOLD METRIC TOP INTERCHANGEABLE
INTERLOCKS

Please read carefully before installing components.



BGT02020F/BGT020020M

RECOMMENDED POCKET
SURFACE FINISH IS $1.6 \mu m$ [63 μin] Ra

ME-06-0005-0012(B) 05-25 Catalog # BGMTIP
 INSTALLATION DATA
 FOR BLACK & GOLD METRIC TOP INTERCHANGEABLE
 INTERLOCKS
 Please read carefully before installing components.



Installation Instructions:

- Four D-M-E Top 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.
- To maintain alignment, it is recommended that the mold base assembly be clamped together and machined in assembly to insure proper parting line alignment.
- 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.
- 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. Place the female interlocks so the relief slot are at the bottom of the pocket for easy interlock removal. Place the male interlock with the release side facing the pocket bottom.
- Place both male and female interlocks into the pockets while the mold is clamped together then thread in and tighten screws.
- Torque the mounting SHCS to:
 - 7.8 N x m [5.7 FT x LBS] for M4-0.7 SHCS
 - 16 N x m [11.7 FT x LBS] for M5-0.8 SHCS
 - 27 N x m [19.8 FT x LBS] for M6-1 SHCS
 - 65 N x m [47.7 FT x LBS] for M8-1.25 SHCS
 - 130 N x m [95.5 FT x LBS] for M10-1.5 SHCS
- After installation, open and close the mold on the bench to insure proper alignment.
- For "shuttle" molds repeat steps 2 to 7 for each interchangeable "B" side.

CATALOG #	WP	BM	BF	C	RF / RM	R	D	E	TM	TF	LM	LF	
		MALE	FEMALE		POCKET	POCKET			MALE	FEMALE	MALE	MALE	
		POCKET	POCKET	POCKET	RADIUS	RADIUS	SCREWS LOCATIONS		SHCS SIZE	SHCS SIZE	THREAD LENGTH	THREAD LENGTH	
		POCKET WIDTH	POCKET WIDTH	DEPTH							MIN	MIN	
		+0.02 +0.01	+0.02 +0.01	+0.02 +0.01		+/-0.1	+/-0.1	+/-0.2	+/-0.2				
BGT02020F	BGT02020M	SEE POCKETS DIMENSIONS SHOWN ON DRAWING FOR BGT02020F/BGT02020M.											
BGT03526F	BGT03526M	35.00	15.00	25.00	26.00	8.00	0.2	13.0	23.0	M5 x 20 LG	M5 x 30 LG	12.0	13.0
BGT04530F	BGT04530M	45.00	15.00	25.00	30.00	8.00	0.3	15.0	30.0	M6 x 18 LG	M6 x 30 LG	11.0	13.0
BGT05536F	BGT05536M	55.00	20.00	30.00	36.00	8.00	0.7	18.0	37.5	M8 x 25 LG	M8 x 35 LG	15.0	15.0
BGT07536F	BGT07536M	75.00	20.00	35.00	36.00	8.00	0.7	18.0	52.0	M10 x 25 LG	M10 x 40 LG	17.0	17.0
BGT10045F	BGT10045M	100.00	20.00	60.00	45.00	8.00	1.0	22.5	70.0	M10 x 25 LG	M10 x 65 LG	17.0	17.0

NOTE: Dimensions are in mm.



29111 STEPHENSON HIGHWAY
 MADISON HEIGHTS
 MICHIGAN 48071 USA
 US 800-656-6656
 CANADA 800-387-6600
 www.dme.net