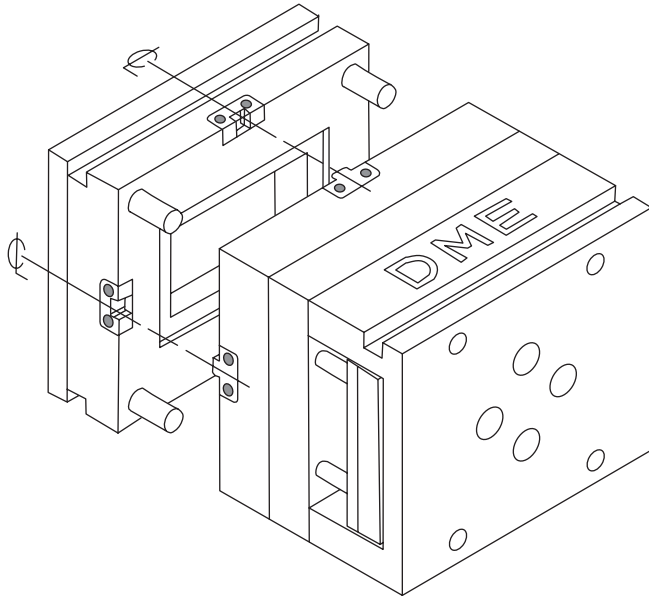
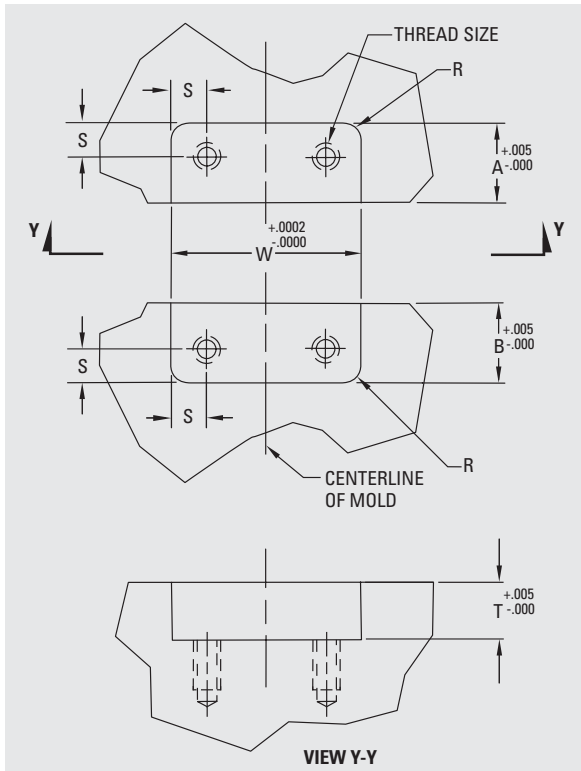


Please carefully read instructions before installing interlocks.



- Four (4) D-M-E IN2 INnovative INterlocks must be used on each mold. When in operation, the interlocks contact the edges of the machined pocket to maintain parting line alignment. The socket head cap screws are only used to retain the interlocks to the mold base.
- It is recommended that the mold base assembly be clamped together and machined as an 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 centerline location is critical to avoid misalignment problems which could result from uneven thermal expansion of the separate mold halves.
- Mark the mating interlocks to insure that the interlocks remain as sets.
- Mount the IN2 female interlock on the half of the mold which will have the highest operating temperature. Normally, this will be the "A" side of the mold. This is important to insure that the male interlock does not grow larger than the female interlock if uneven mold temperatures occur.
- Torque the socket head cap screws to:
4.5 ft.lbs for #8-32 socket head cap screws
7.5 ft.lbs for #10-32 socket head cap screws
16.5 ft.lbs for 1/4-20 socket head cap screws
- After installation, open and close the mold on the bench and check to insure proper alignment has been achieved.
- Always maintain lubrication on the interlocks to prevent galling.
- Please carefully read instructions on other side regarding installation of the inserts for IN2 INnovative INterlocks.



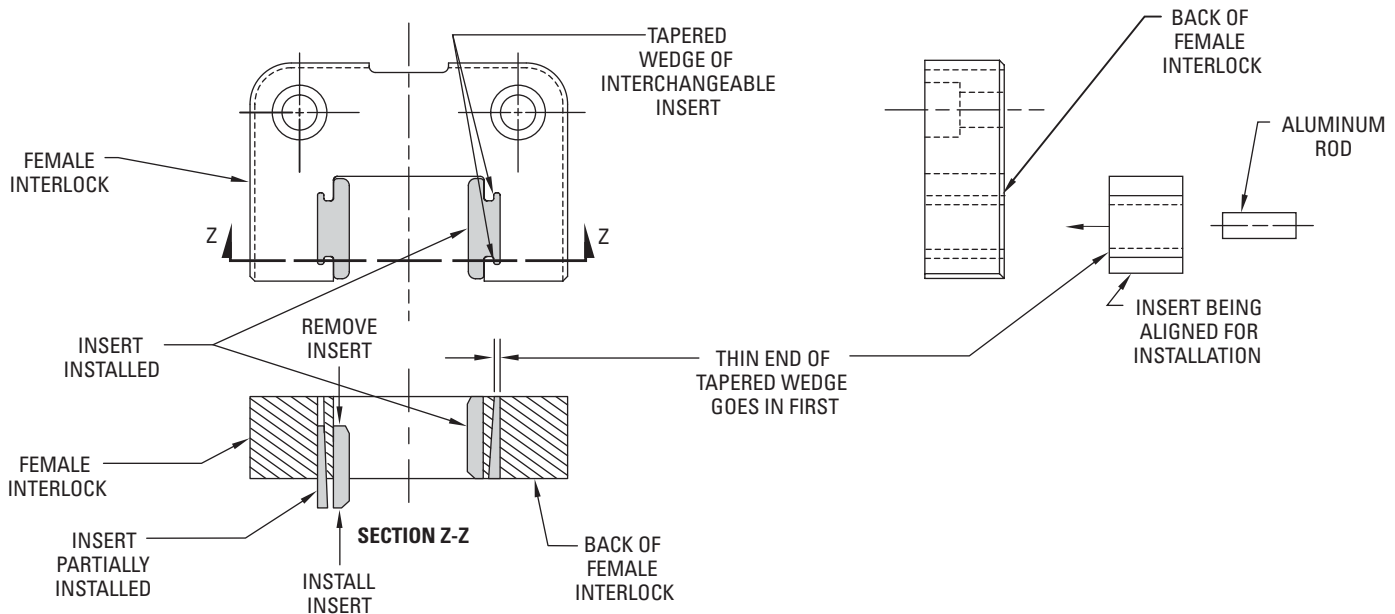
IN2 INnovative INterlock Dimensions

INTERLOCK SET* ITEM NO.	W WIDTH	A HEIGHT FEMALE	B HEIGHT MALE	T DEPTH	R RADII	S SCREW LOCATIONS	THREAD SIZE	REPLACEMENT INTERCHANGEABLE INSERTS** ITEM NO.
SIS150023	1.500	.875	.875	.500	.25	.250	#8-32 x .38 Deep	SI115003
SIS200023	2.000	1.375	.875	.500	.25	.312	#10-32 x .44 Deep	SI120003
SIS300023	3.000	1.875	.875	.750	.375	.375	1/4-20 x .50 Deep	SI130003

*Sets include one (1) male, one (1) female, two (2) inserts, four (4) SHCS.

**Replacement Interchangeable Inserts are sold in pairs.

Please carefully read instructions before installing inserts.



INSERT INSTALLATION

D-M-E Interchangeable Inserts can only be installed from the back of the female IN2 INnovative INterlock. The back of the female interlock mounts against the mold (and is the side opposite the counterbores for the socket head cap screws). When the Interchangeable Inserts are properly inserted into the female interlock they will be retained by the tapered wedge of the Interchangeable Insert and the retaining taper of the female interlock. Once installed in a mold, the mold will insure that Interchangeable Inserts will be securely retained.

1. First, place the female interlock face down on a flat surface with the back facing up.
2. Next, select a pair of IN2 INterchangeable INserts for the appropriate size interlock for insertion into the female interlock. Interchangeable Inserts of the same size are truly interchangeable; any Interchangeable Insert of the proper size can be inserted into the female interlock.
3. Inspect the tapered wedge on the Interchangeable Insert to determine which end of the Interchangeable Insert is the thin end of tapered wedge. The thin end of the tapered wedge will be inserted into the female interlock first (refer to above drawings for clarification).
4. Insert the thin end of the tapered wedge into the female interlock from the back and slide the Interchangeable Insert firmly into the female interlock. The Interchangeable Insert should seat most of the way into the female interlock by hand. The tapered wedge of the Interchangeable Insert provides a slight interference fit with the retaining wedge of the female interlock.

5. Now, place an aluminum rod against the Interchangeable Insert and use a hammer to tap on the aluminum rod to move the Interchangeable Insert until it is flush with the back of the female interlock. Properly seated Interchangeable Inserts will be .000 to .005 below the back surface of the female interlock. Use an aluminum rod whose diameter is small enough to make contact with only the Interchangeable Insert and does NOT contact the small retaining wedges on the female interlock.
6. Repeat this procedure for each insert.
7. The D-M-E IN2 INnovative INterlock is now ready for installation on your mold. Please carefully read instructions on other side regarding installation of IN2 INnovative INterlocks on your mold.

INSERT REMOVAL

To remove an Interchangeable Insert from an IN2 INnovative INterlock, the female interlock must be removed from the mold.

1. Place the female interlock on two aluminum blocks with the front facing up. (The front face of the female interlock is the side with the counterbores.) Position the two aluminum blocks under the outer edges of the female interlock but not under the Interchangeable Insert being removed.
2. Place an aluminum rod on the Interchangeable Insert and use a hammer to tap on the aluminum rod. The Interchangeable Insert has a tapered wedge which will release from the retaining taper of the female interlock as the insert moves down, allowing the Interchangeable Insert to drop free from the female interlock. As previously indicated, use an aluminum rod whose diameter is small enough to make contact with only the Interchangeable Insert and does NOT contact the small retaining wedges on the female interlock.
3. Repeat this procedure for each insert.

