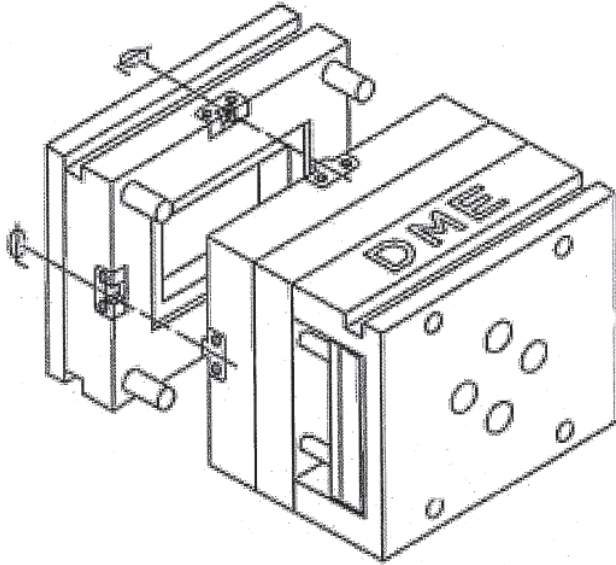




29111 Stephenson Hwy.
Madison Heights, MI 48071 USA
800-626-6653

Black & Gold Side interlocks Installation Data

Please read carefully before installing components.



Dimensions shown in inches unless otherwise specified.

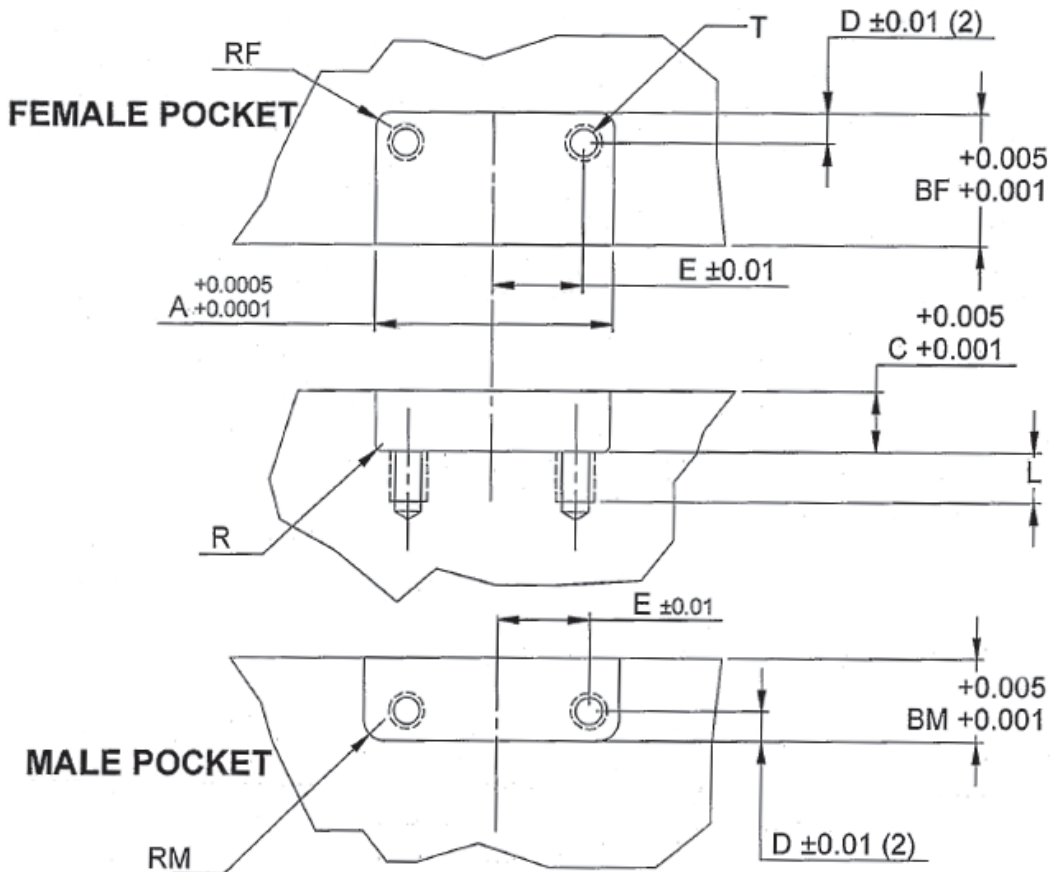
Tolerances are:

Fractions: +/- 0.015

0.00 +/- 0.01

0.000 +/- 0.005

Recommended pocket surface finish is 63 Ra.





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1. Four DME 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 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 which will have the highest operating temperature. Normally, this will be the "A" side of the mold. This procedure is critical to insure 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.

Item # Assembly	Item # Male	Item # Female	"A" Pocket Length	"BM" Male Pocket Width	"BF" Female Pocket Width	"C" Pocket Depth	"D" Screw Location	"E" Screw Location	"RF/RM" Pocket radius	"R" Pocket Bottom Radius	"T" Screw size	"L" Thread Depth
BGS1000	BGS1000M	BGS1000F	1.000	.875	1.125	.375	.250	.250	.125	.016	#10-32x1/2	.375
BGS1250	BGS1250M	BGS1250F	1.250	.875	1.125	.500	.250	.375	.125	.016	#8-32x5/8	.375
BGS1500	BGS1500M	BGS1500F	1.500	.875	.875	.500	.250	.500	.125	.016	#8-32x5/8	.375
BGS2000	BGS2000M	BGS2000F	2.000	.875	1.375	.500	.312	.688	.125	.016	#10-32x5/8	.438
BGS3000	BGS3000M	BGS3000F	3.000	.875	1.875	.750	.375	1.125	.187	.016	1.4-20x7/8	.500
BGS4000	BGS4000M	BGS4000F	4.000	1.375	2.375	1.000	.500	1.500	.375	.016	3/8-16x1"	.500
BGS5000	BGS5000M	BGS5000F	5.000	1.375	2.875	1.250	.625	1.875	.375	.016	1/2-13x1-1/4"	.813
BGS6000	BGS6000M	BGS6000F	6.000	1.375	2.875	1.500	.625	2.375	.375	.016	1/2-13x1-3/4	.875