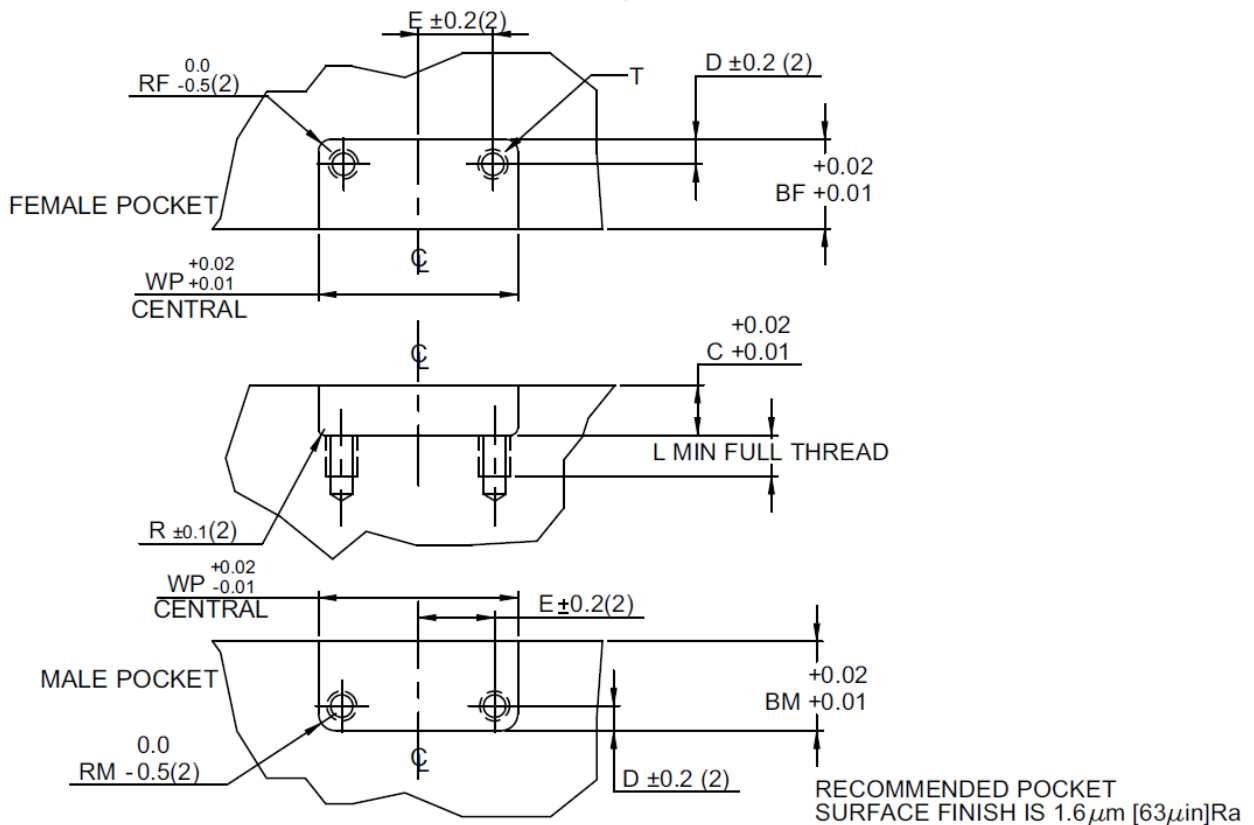
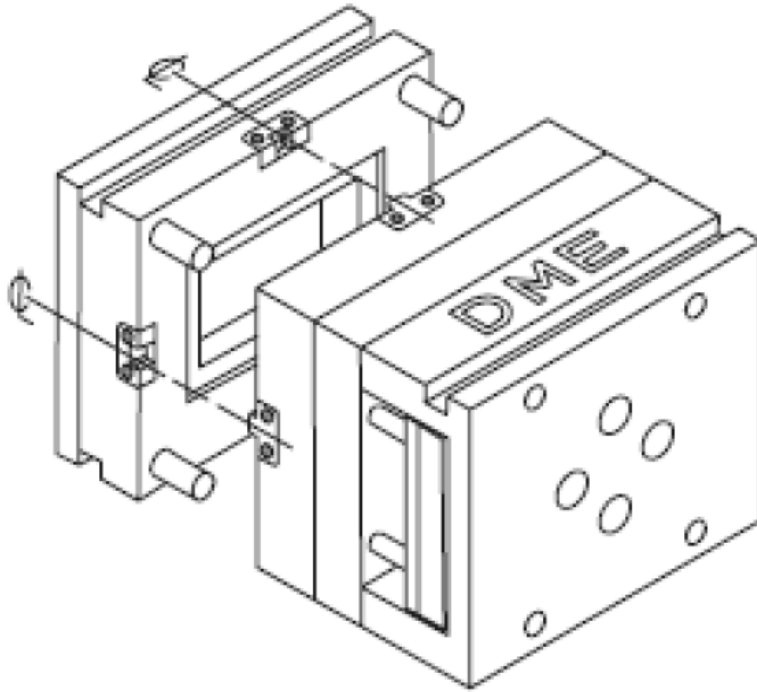




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Black & Gold Metric Side Interchangeable Interlocks Installation Data

Please read carefully before installing components





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INSTALLATION INSTRUCTIONS

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 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. Place both male and female interlocks into the pockets while the mold is clamped together then thread in and tighten screws.
6. Torque the mounting SHCS to:
27 N x m [19.8 FT x LBS] for M6-1.0 SHCS
130 N x m [95.5 FT x LBS]for M10-1.5 SHCS
7. After installation, open and close the mold on the bench to insure proper alignment.
8. For "shuttle" molds repeat steps 2 to 7 for each interchangeable "B" side.

ITEM #	ITEM #	WP	BM	BF	C	D	E	RF/RM	R	T	L
MALE	FEMALE		MALE	FEMALE				POCKET	POCKET		THREAD
		POCKET	POCKET	POCKET	POCKET	SCREWS		RADIUS	RADIUS	SCREW	LENGTH
		LENGTH	WIDTH	WIDTH	DEPTH	LOCATIONS				SIZE	MIN
		+0.02 +0.01	+0.02 +0.01	+0.02 +0.01	+0.02 +0.01	+/-0.2		+0 -0.5	+/-0.1		
BGS05016M	BGS05016F	50.00	21.50	21.50	16.00	11.00	17.00	5.0	0.2	M6 X 20 LG	12.0
BGS07519M	BGS07519F	75.00	36.00	36.00	19.00	18.00	25.00	5.0	0.5	M10 X 25 LG	18.0
BGS10019M	BGS10019F	100.00	45.00	45.00	19.00	22.00	35.00	5.0	0.5	M10 X 25 LG	18.0
BGS12525M	BGS12525F	125.00	45.00	45.00	25.00	22.00	42.00	5.0	1.0	M10 X 30 LG	17..0

NOTE: Dimensions are in mm.