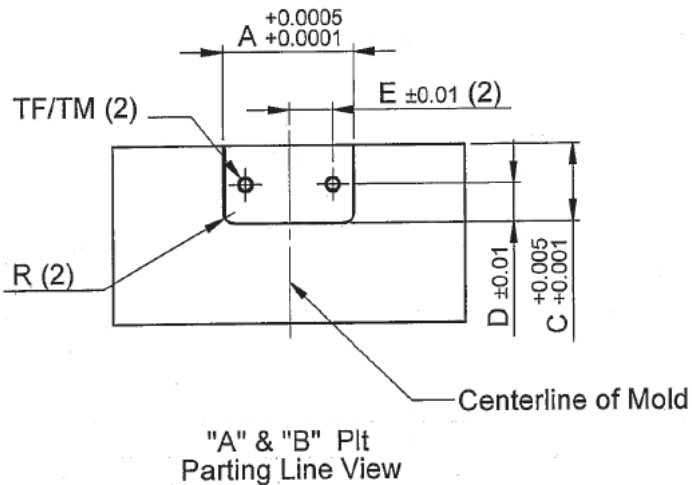
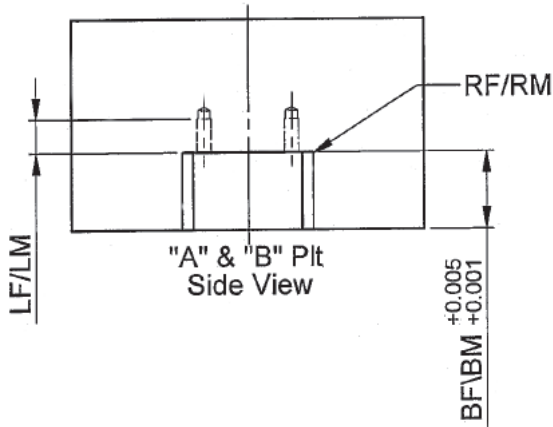
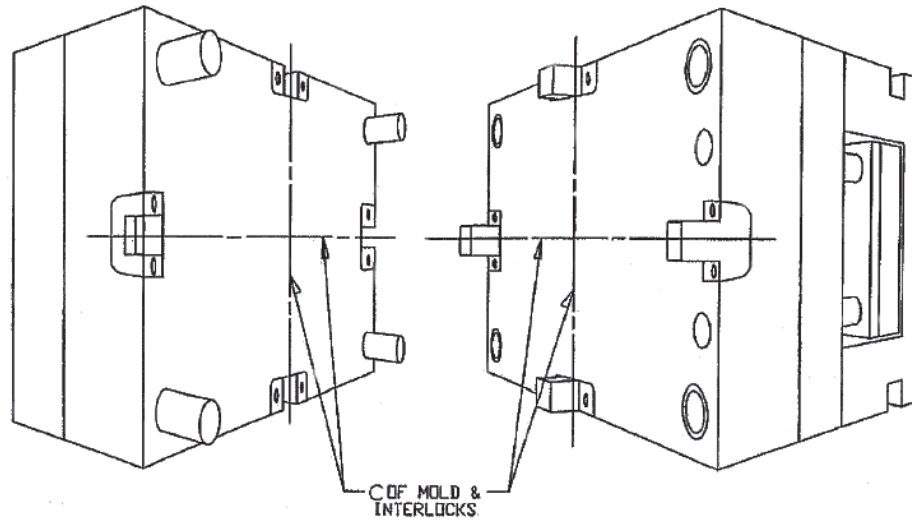




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800-626-6653

Black & Gold Top Interlocks Installation Data

Please read carefully before installing components



Recommended Pocket surface Finish: Ra 63
Dimensions shown in inches unless otherwise
specified. Tolerances are:

Fractions: +/- 0.015
0.00 +/- 0.01
0.000 +/- 0.005



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INSTALLATION INSTRUCTIONS

1. Four DME 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.
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 center line 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 ensure the male interlock does not grow larger than the female interlock if uneven mold temperatures are present.
5. Torque the mounting SHCS to:
 - * 30 in.lbs for #6-32 SHCS
 - * 55 in.lbs for .#8-32 SHCS
 - * 90 in.lbs for #10-32 SHCS
 - * 200 in.lbs for 1/4-20 SHCS
 - * 415 in.lbs for 5/16-18 SHCS
 - * 740 in.lbs for 3/8-16 SHCS
6. After installation, open and close the mold on the bench to insure proper alignment.



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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
BGT1000	BGT1000M	BGT1000F	1.000	.375	.500	.500	.250	.344
BGT1250	BGT1250M	BGT1250F	1.250	.500	.625	.625	.312	.437
BGT12501	BGT12501M	BGT12501F	1.250	.500	.625	.750	.375	.427
BGT1500	BGT1500M	BGT1500F	1.500	.750	.875	.875	.437	.500
BGT15001	BGT15001M	BGT15001F	1.500	.375	.875	1.000	.500	.500
BGT2000	BGT2000M	BGT2000F	2.000	.750	1.125	1.000	.500	.688
BGT20001	BGT20001M	BGT20001F	2.000	.625	.875	1.125	.562	.688
BGT2500	BGT2500M	BGT2500F	2.500	.625	1.375	1.500	.750	.875
BGT3000	BGT3000M	BGT3000F	3.000	.750	1.500	1.125	.562	1.125
BGT3000S	BGT3000SM	BGT3000SF	3.000	.875	1.250	1.750	.875	1.125
BGT3500	BGT3500M	BGT3500F	3.500	.750	1.750	2.000	1.000	1.250

Item # Assembly	Item # Male	Item # Female	"RF/RM" Pocket Radius	"R" Pocket Radius	"TM" Male Screw Size (2)	"TF" Female Screw size (2)	"LM" Male Thread Depth	"LF" Female Thread Depth
BGT1000	BGT1000M	BGT1000F	.016	.187	#6-21 x 1/2	#6-32 x 5/8	.375	.375
BGT1250	BGT1250M	BGT1250F	.016	.250	#6-32 x 5/8	#6-32 x 3/4	.375	.375
BGT12501	BGT12501M	BGT12501F	.016	.250	#8-32 x 5/8	#8-32 x 3/4	.375	.375
BGT1500	BGT1500M	BGT1500F	.016	.250	#8-32 x 7/8	#8-32 x 1"	.375	.375
BGT15001	BGT15001M	BGT15001F	.016	.250	#10-32 x 1/2	#10-32 x 1"	.500	.500
BGT2000	BGT2000M	BGT2000F	.016	.375	#10-32 x 1"	#10-32 x 1-1/4	.625	.500
BGT20001	BGT20001M	BGT20001F	.016	.375	1/4-20 x 3/4	1/4-20 x 1"	.500	.500
BGT2500	BGT2500M	BGT2500F	.016	.375	1/4-20 x 3/4	1/4-20 x 1-1/2	.500	.500
BGT3000	BGT3000M	BGT3000F	.016	.500	1/4-20 x 1-3/4	1/4-20 x 1-3/4	.750	.750
BGT3000S	BGT3000SM	BGT3000SF	.016	.500	5/16-18 x 1-1/8	5/16-18 x 1-5/8	.750	.875
BGT3500	BGT3500M	BGT3500F	.016	.500	3/8-16 x 1"	3/8-16 x 2"	.750	.750