



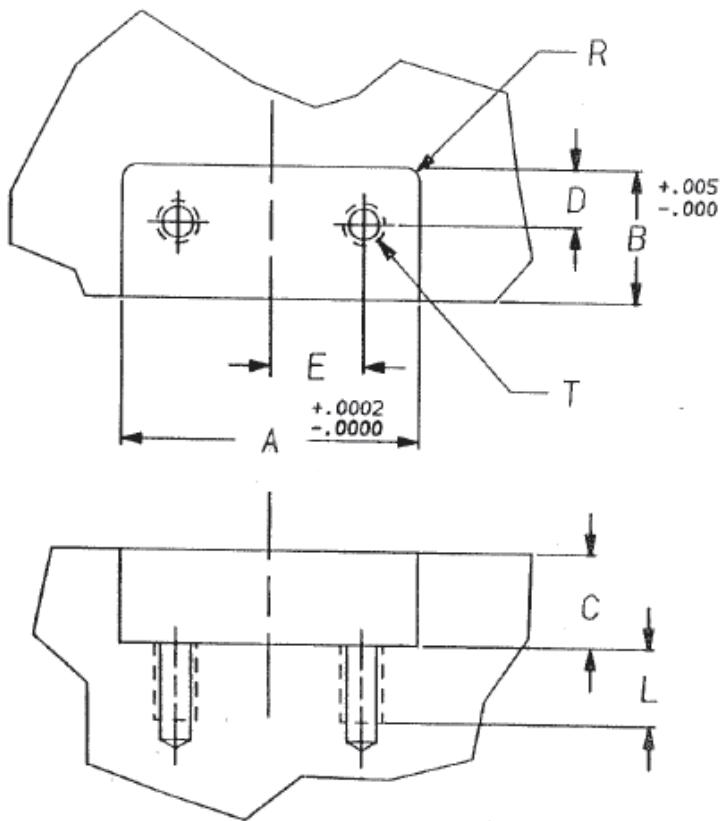
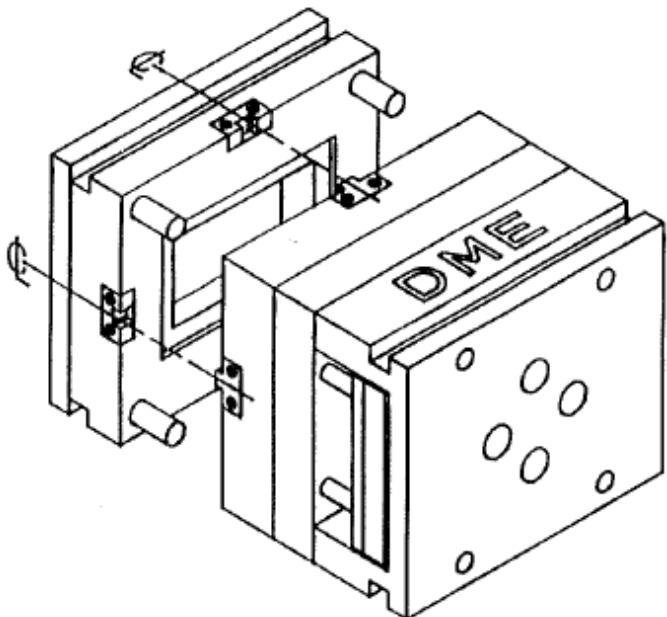
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**ME-0509-PS-040-A**  
**PLM9999**

# **Straight Side Interlocks**

## **Machining & Installation Instructions**

Please carefully read instructions on 2nd page before installing interlocks



Catalog #	A	B	C	D		E	T	L	R
				MALE	FEMALE				
PLM-0001	1.5000	.875	.625	.437	.281	.469	1/4-20 UNC	.50	.12
PLF-0001									
PLM-0002	2.000	.875	.625	.437	.375	.625	1/4-20 UNC	.50	.12
PLF-0002									
PLM-0003	3.000	1.375	.750	.688	.688	1.125	3/8-16 UNC	.62	.12
PLF-00003									
PLM-0004	4.000	1.375	.750	.875	.875	1.375	3/8-16 UNC	.62	.25
PLF-0004									
PLM-0005	5.000	1.875	1.125	.875	.875	1.750	1/2-13 UNC	.75	.25
PLF-0005									



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## Straight Side Interlocks Installation Instructions

Four DME Straight 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.

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 straight 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.

Mark the mating interlocks to insure that the interlocks will remain as sets.

Mount the 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 procedure is critical to insure that the male interlock does not grow larger than the female interlock if uneven mold temperatures are used.

Torque the allen head cap screws to:  
10 ftlbs for 1/4-20 cap screws  
30 ftlbs for 3/8-16 cap screws  
60 ftlbs for 1/2-13 cap screws

After installation, open and close the mold on the bench to insure proper alignment.

Always maintain lubrication on the interlocks to prevent galling.