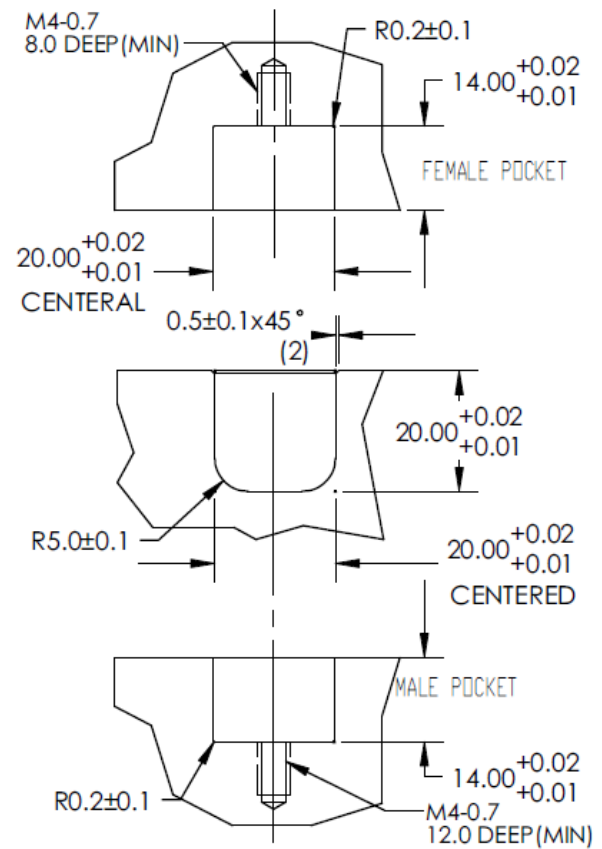
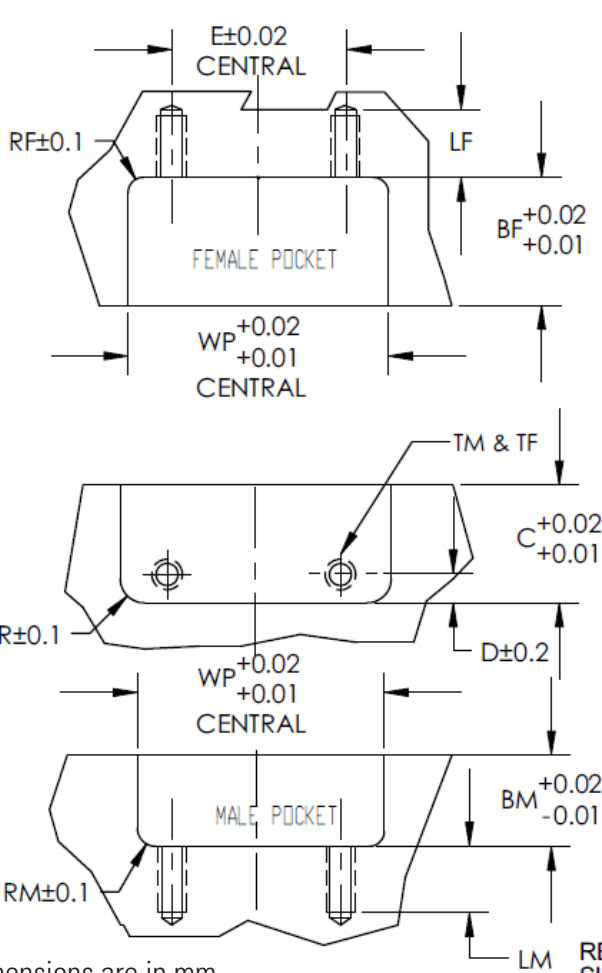
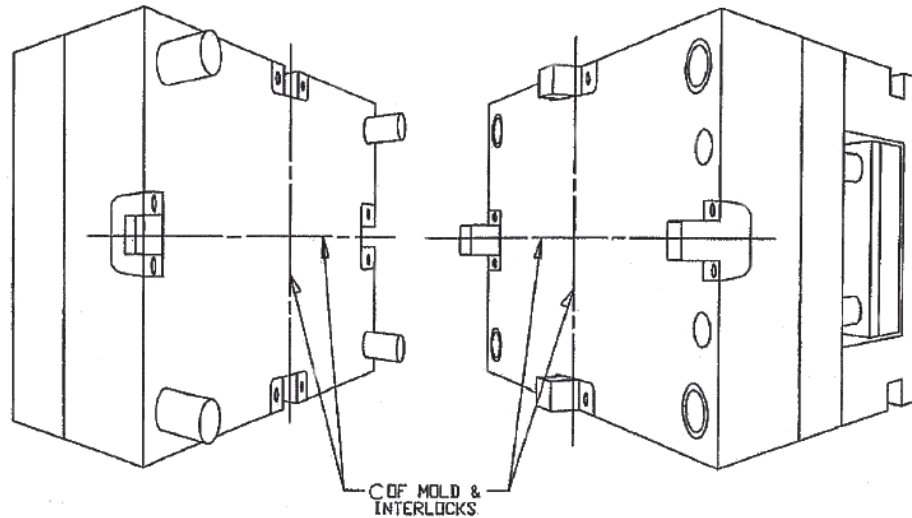




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Madison Heights, MI 48071 USA  
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## Black & Gold Metric Top Interchangeable Interlocks Installation Data

Please read carefully before installing components



**BGT02020F/BGT020020M**

NOTE: Dimensions are in mm.

RECOMMENDED POCKET  
SURFACE FINISH IS  $1.6\mu\text{m}$  [63 $\mu\text{in}$ ]Ra



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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 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. Place the female interlocks so the relief slot are at the bottom of the pocket for easy interlock removal. Place the male interlock with the release side facing the pocket bottom.
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:
  - 7.8 N x m [ 5.7 FT x LBS] for M4-0.7 SHCS
  - 16 N x m [ 11.7 FT x LBS] for M5-0.8 SHCS
  - 27 N x m [ 19.8 FT x LBS] for M6-1 SHCS
  - 65 N x m [ 47.7 FT x LBS] for M8-1.25 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 #	WP	BM	BF	C	RF/RM	R	D	E	TM	TF	LM	LF	
		MALE	FEMALE		POCKET	POCKET			MALE	FEMALE	MALE	MALE	
	POCKET	POCKET	POCKET	POCKET	RADIUS	RADIUS	SCREW LOCATIONS		SHCS	SHCS	THREAD	THREAD	
	WIDE	WIDTH	DEPTH	DEPTH					SIZE	SIZE	LENGTH	LENGTH	
	+0.02 +0.01	+0.02 +0.01	+0.02 +0.01	+0.02 +0.01	+/-0.01	+/-0.01	+/-0.02	+/-0.02			MIN	MIN	
BGT02020F	BGT02020M	SEE POCKET DIMENSIONS SHOWN ON DRAWING FOR BGT02020F/BGT02020M											
BGT03526F	BGT03526M	35.00	15.00	25.00	26.00	8.00	0.2	13.0	23.0	M5X20 LG	M5X20 LG	12.0	13.0
BGT04530F	BGT04530M	45.00	15.00	25.00	30.00	8.00	0.3	15.0	30.0	M6X18LG	M6X30LG	11.0	13.0
BGT05536F	BGT05536M	55.00	20.00	30.00	36.00	8.00	0.7	18.0	37.5	M8X25LG	M8X35LG	15.0	15.0
BGT07536F	BGT07536M	75.00	20.00	35.00	36.00	8.00	0.7	18.0	52.0	M10X25LG	M10X40LG	17.0	17.0
BGT10045F	BGT10045M	100.00	20.00	60.00	45.00	8.00	1.0	22.5	70.0	M10X65LG	M10X65LG	17.0	17.0