

BAR LOCKS

Z-SERIES-INCH STANDARD



Progressive's Bar Locks enable mold designers to select off-the-shelf components for alignment of large molds and molds with multiple moving plates.

Long-term precision alignment of plates is achieved through Progressive's Z-Series proprietary treatments, engagement ramp geometry and particle rings on the guiding surfaces.

Non-drying, non-hardening food grade grease is applied to all areas, including the particle rings. For production, install the locks and wipe down the outside of the Bar Locks only; maintain the grease on the mating surfaces and within the rings.

BAR

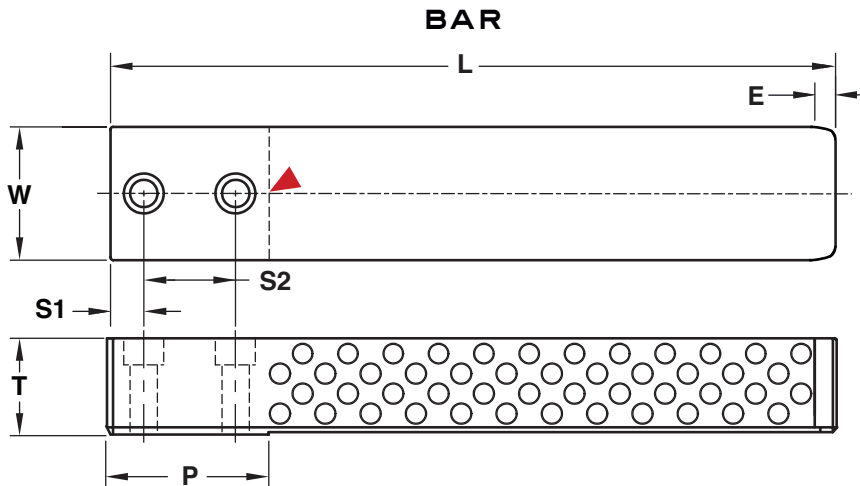
M H-13 **H** Core: 42-48 HRC, Surface: 70 HRC **S** Salt Bath Nitride

CATALOG NUMBER	T +.000 -.005	L ±.005	W +.0000 -.0005	E REF	P	S1 ±.005	S2 ±.005	SHCS
BLB100L6	1.000	6.00	1.000	.22	1.38	.38	.69	5/16-18 x 1.25
BLB125L9	1.250	8.88	1.500	.28	1.88	.50	1.00	3/8 - 16 x 1.50
BLB137L11	1.375	10.88	2.000	.31	2.38	.50	1.38	3/8 - 16 x 1.50
BLB150L16	1.500	15.88	3.000	.31	3.38	.63	2.00	1/2 - 13 x 1.75

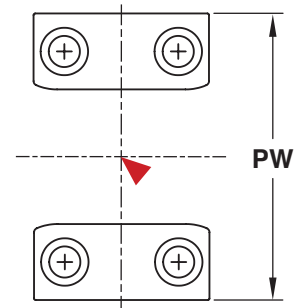
Note: Sold individually. Each catalog number includes (1) Bar Lock and (2) Screws.

► CAD insertion point

For custom Bar Locks, refer to the templates in section X.



GUIDES



GUIDES

M D-2 **H** Core: 58-62 HRC, Surface: 80 HRC **S** Titanium Nitride Coated

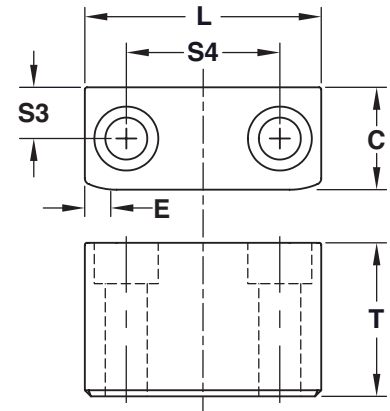
CATALOG NUMBER	T +.000 -.005	L +.000 -.005	C +.0000 -.0003	PW +.0003 +.0006	E REF	S3 ±.005	S4 ±.005	SHCS	USE WITH
BLG100L1.3	1.000	1.310	.500	2.000	.22	.250	.750	#10-32 x 1.25	BLB100L6
BLG100L1.8		1.810					1.125		
BLG125L1.3	1.250	1.310	.625	2.750	.28	.310	.750	1/4-20 x 1.50	BLB125L9
BLG125L2.3		2.310					1.25		
BLG137L1.8	1.375	1.810	.750	3.500	.31	.375	1.125	5/16-18 x 1.50	BLB137L11
BLG137L3.3		3.310					2.250		
BLG150L2.3	1.500	2.310	1.000	5.000	.31	.500	1.500	3/8-16 x 1.75	BLB150L16
BLG150L3.8		3.810					2.500		

Guides are sold in pairs. Each catalog number includes (2) guides and (4) screws.

Note: 500°F max operating temperature.

► CAD insertion point

For custom Guides, refer to the templates in section X.

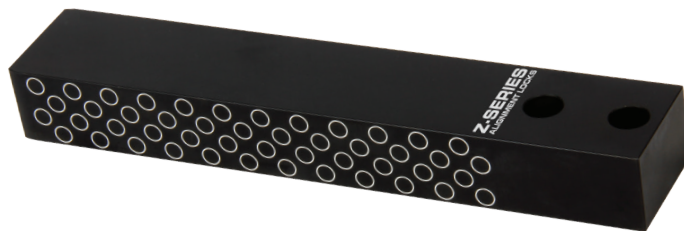


GUIDES



BAR LOCKS

Z-SERIES-METRIC STANDARD



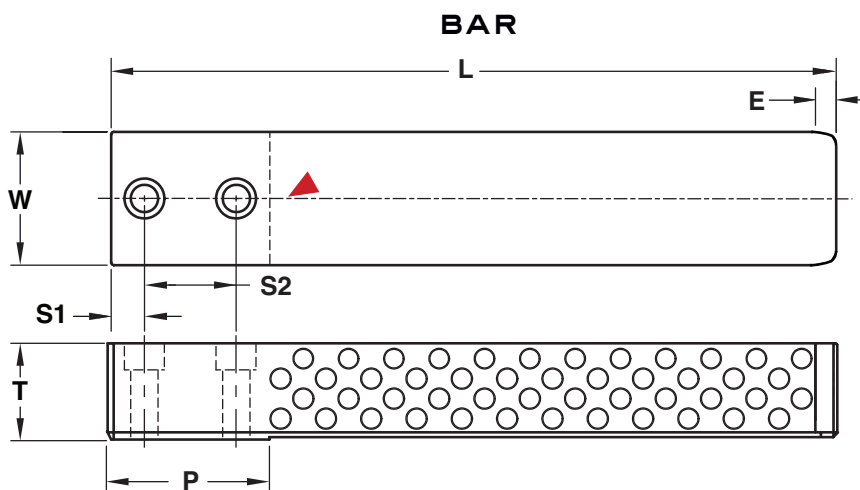
BAR

M H-13 **H** Core: 42-48 HRC, Surface: 70 HRC **S** Salt Bath Nitride

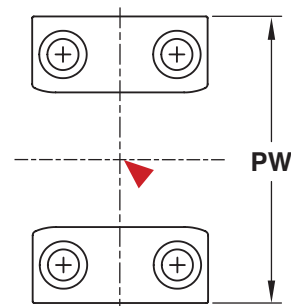
CATALOG NUMBER	T +0 -1	L ±1	W +0.00 -0.01	E REF	P MIN	S1 ±1	S2 ±1	SHCS
BLBM25L125	25	125	25	6	36	10	18	M8-1.25 x 30
BLBM32L160	32	160	38	6	46	12.5	25	M10-1.5 x 35
BLBM38L250	38	250	50	8	56	15	30	M12-1.75 x 45

Note: Sold individually. Each catalog number includes (1) Bar Lock and (2) Screws.

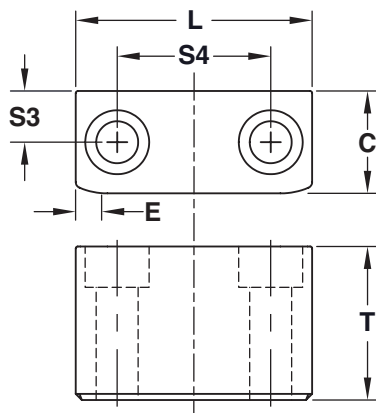
► CAD insertion point



GUIDES



GUIDES



GUIDES

M D-2 **H** Core: 58-62 HRC, Surface: 80 HRC **S** Titanium Nitride Coated

CATALOG NUMBER	T +0 -1	L +0 -1	C +0.00 -0.005	PW +0.007 +0.015	E REF	S3 ±1	S4 ±1	SHCS	USE WITH
BLGM25L27	25	27	12	49	6	6	14	M4-0.7 x 25	BLBM25L125
BLGM25L36		36					20		
BLGM32L36	32	36	16	70		8	20	M6-1.0 x 35	BLBM32L160
BLGM32L46		46					30		
BLGM38L46	38	46	22	94		11	24	M10-1.5 x 40	BLBM38L250
BLGM38L76		76					54		

Guides are sold in pairs. Each catalog number includes (2) guides and (4) screws.

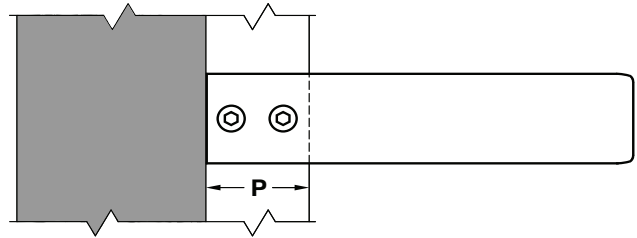
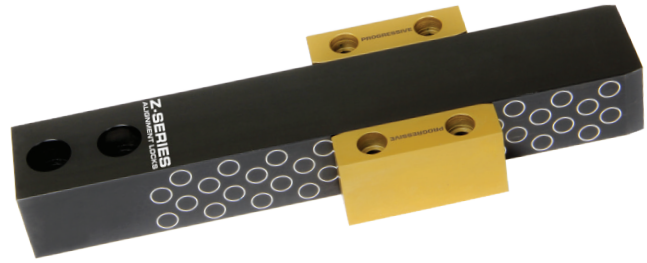
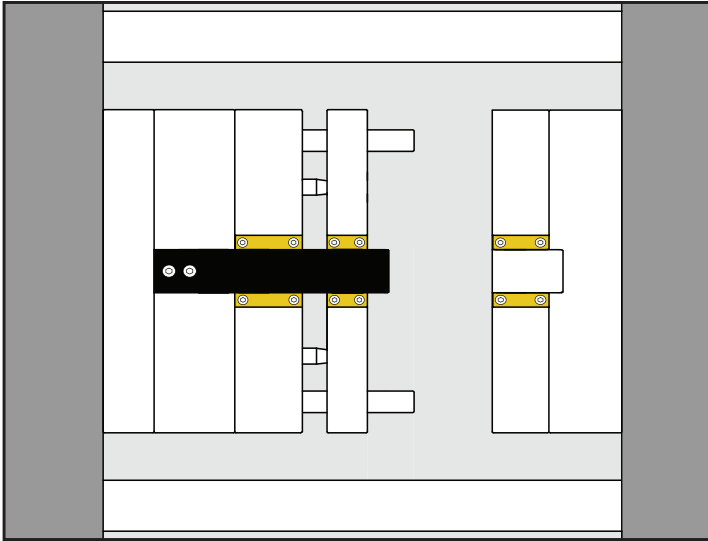
Note: 500°F max operating temperature.

 For custom Guides, refer to the templates in section X.

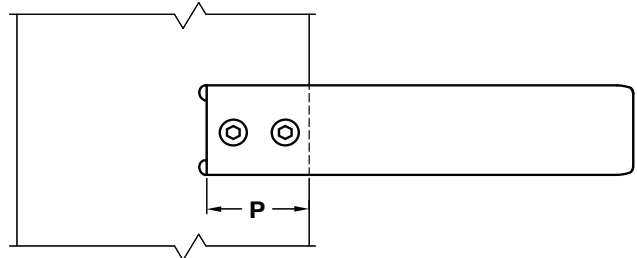
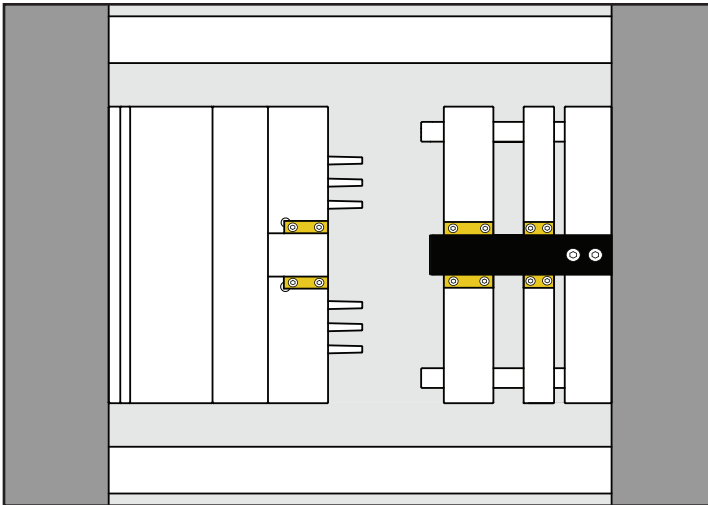
BAR LOCKS

APPLICATIONS

Stripper Plate Application

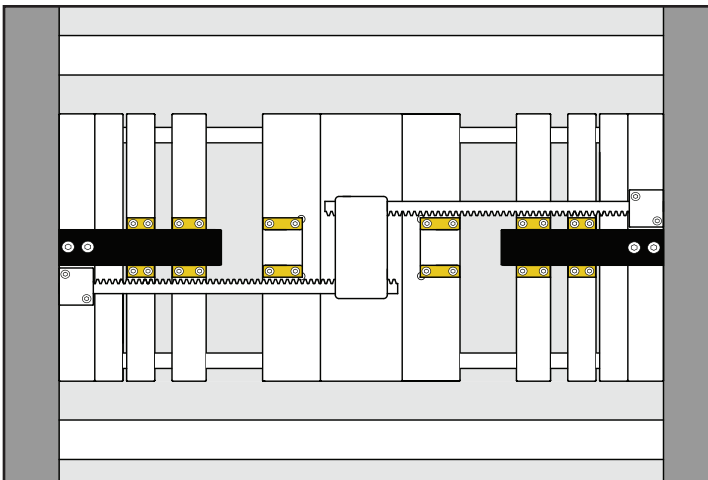


Three Plate Application

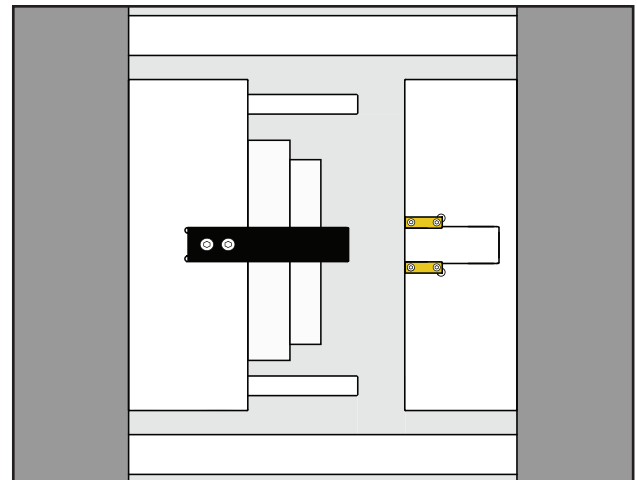


MINIMUM POCKET LENGTH = P

Stack Mold Application



Large Mold Application





SIDE/TOP/GUIDE LOCK SELECTION GUIDE

Refer to the chart below to match the correct alignment lock for the corresponding mold size and weight of B-Side and press platen, using four locks per mold. Clean and lubricate lock every 100,000 cycles, and prevent corrosion during mold storage.

RECOMMENDED MAX MOLD SIZE (LXWXH)	SIDE LOCKS	METRIC SIDE LOCKS	GUIDE LOCKS	TOP LOCKS	TOTAL MAX WEIGHT B SIDE + PRESS PLATEN (LBS/KG)
RTI AND MOLDS 8 X 8 X 8 AND SMALLER	SL37X100, SL50X125 SL50X150, SL50X200 SLS62X150, SLS62X200 SLR50X125, SLR50X150	SLM16X50, SLP16X20 SLPM16X40, SLP20X25 SLPM20X50, SLMS13X38 SLMS16X50	GL100X150 GLM25X45	TL50X100, TL62X125 TL75X125, TLM26X35 TLR87X150	2,000 / 900
11 X 16 X 10	SL50X125, SL50X150 SL50X200, SLS62X150 SLS62X200, SLS75X300 SLS75X400, SLR50X150 SLR50X200	SLM16X50, SLMS19X75 SLPM25X32, SLP25X63 SLPM32X40, SLP32X80 SLPM40X50 SLPM40X100 SLMS19X100	GL100X150 GL150X250 GLM25X45	TL62X125, TL75X125 TLM26X35 TLR87X150 TLR112X200	5,000 / 2,300
16 X 24 X 16	SL50X150, SL50X200 SL75X300, SLS112X500 SLS75X300, SLS75X400 SLR75X300, SLR100X400	SLM19X75, SLM19X100 SLMS25X125 SLPM50X56 SLPM50X112	GL150X250 GLM40X65	TL75X125, TL87X150 TLM26X35, TLM30X45 TLR112X200 TLR150X250	7,000 / 3,200
28 X 34 X 24	SL75X300, SLS112X500	SLM19X75, SLM19X100	GL200X350 GL150X250 GLM40X65	TL100X150, TL100X200 TL112X200, TL112X300 TLM26X35, TLM30X45	10,000 / 4,500
32 X 40 X 28	SL100X400	SLM25X125	GL200X350 GLM40X65	TL112X200, TL112X300 TLM36X55, TLM36X75	15,000 / 6,800
42 X 48 X 34	SL125X500		GL250X450 GLM50X90	TL150X250, TL175X300 TLM36X55, TLM36X75	20,000 / 9,000
48 X 52 X 38	SL150X600		GL250X450	TL175X300, TL200X350 TLM45X100	26,000 / 11,800

BAR LOCK SELECTION GUIDE

BAR CATALOG NUMBER	GUIDE CATALOG NUMBER	BAR LOCK ENGAGEMENT	TOTAL MAX WEIGHT SUPPORTED (LBS/KG)
BLB100L6	BLG100L1.3, BLG100L1.8	4.50	15,000 / 6,800
BLBM25L125	BLGM25L27, BLGM25L36	89	15,000 / 6,800
BLB125L9	BLG125L1.3, BLG125L2.3	7.00	20,000 / 9,000
BLBM32L160	BLGM32L36, BLGM32L46	114	20,000 / 9,000
BLB137L11	BLG137L1.8, BLG137L3.3	8.50	23,000 / 10,400
BLBM38L250	BLGM38L46, BLGM38L76	194	26,000 / 11,500
BLB150L16	BLG150L2.3, BLG150L3.8	12.50	26,000 / 11,800
BLN150L8	BLG150L2.3, BLG150L3.8	3.75	25,000 / 11,250
BLN250L10	BLG250L4.3	5.00	50,000 / 22,500
BLN350L13	BLG350L4.8	6.00	75,000 / 34,000

