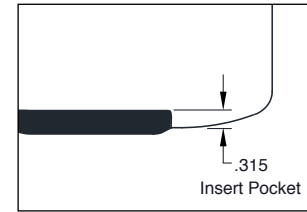
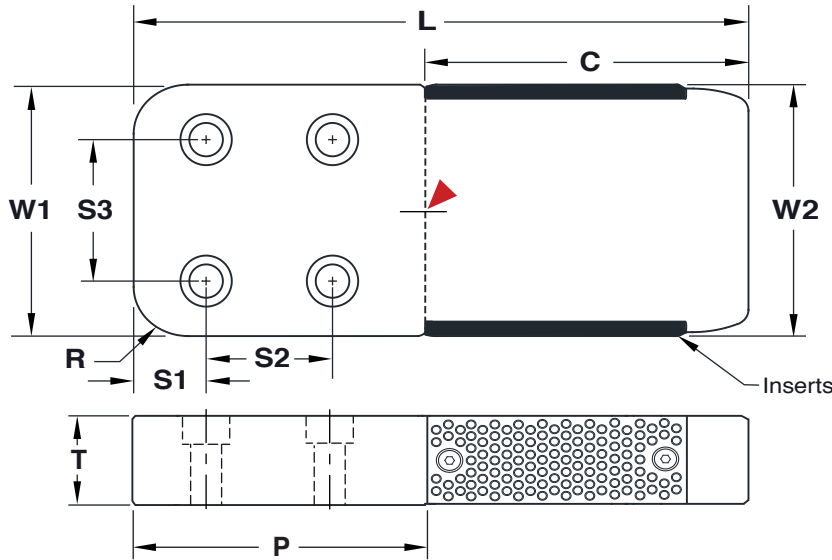
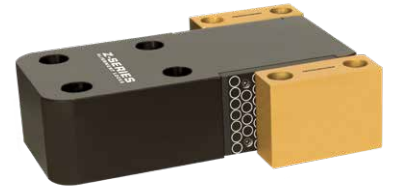




BAR LOCKS INSERTED



MALE BAR LOCK ASSEMBLIES

Bar: **M** 4140 **H** Core: 36-40 HRC, Surface 70 HRC **S** Black Oxide
 Inserts: **M** H-13 **H** Core: 42-48 HRC, Surface 70 HRC **S** Black Nitride

CAD insertion point

| CATALOG NUMBER | T +.000 -.005 | W1 +.0000 -.0005 | W2 | L | C REF | S1 ±.01 | S2 ±.01 | S3 ±.01 | R POCKET RADIUS | P MINIMUM POCKET LENGTH | SHCS |
|------------------|---------------------|------------------------|-------------------------|-------|----------|------------|------------|------------|--------------------|----------------------------|----------------|
| BLN150L8 | 1.500 | 4.000 | 4.000 +.000 -.002 | 7.75 | 3.75 | 1.00 | 2.00 | 2.25 | .75 | 4.00 | 1/2-13 x 1-3/4 |
| BLN250L10 | 2.500 | 5.000 | 5.000 +.000 -.002 | 10.38 | 5.00 | 1.25 | 3.25 | 3.25 | 1.00 | 5.38 | 5/8-11 x 2-3/4 |
| BLN350L13 | 3.500 | 6.000 | 6.000 +.000 -.003 | 12.88 | 6.00 | 1.50 | 4.00 | 3.50 | 1.00 | 6.88 | 3/4-10 x 3-3/4 |

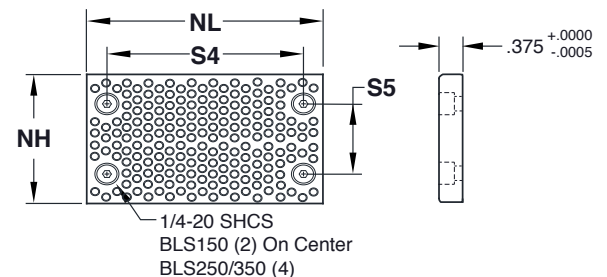
Each catalog number includes (1) Bar and (2) Inserts with screws. Guides are sold separately on page C-5.

INSERTS

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

| CATALOG NUMBER | NH +.000 -.005 | NL +.000 -.002 | S4 ±.01 | S5 ±.01 |
|----------------|----------------------|----------------------|------------|------------|
| BLS150 | 1.440 | 2.999 | 1.75 | --- |
| BLS250 | 2.440 | 3.999 | 2.25 | 1.50 |
| BLS350 | 3.375 | 4.999 | 3.00 | 2.50 |

Inserts sold individually and include screws.





BAR LOCKS

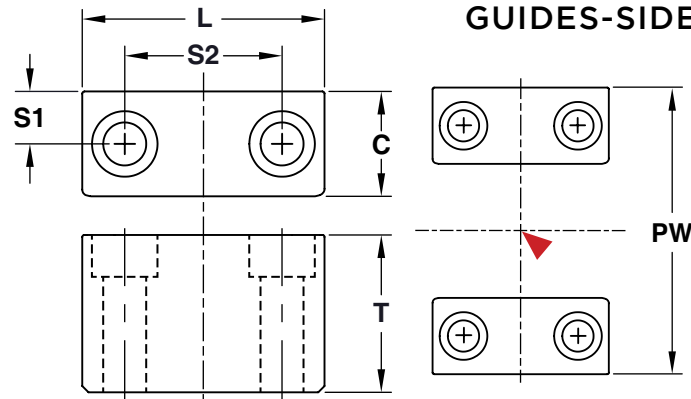
GUIDES-SIDE MACHINE STYLE

PW Tolerances:

Standard Bars:
+.0003/+0.0006
(+.007/+0.015mm)

Inserted Bars:
+.0010/+0.0015
(+.025/+0.038mm)

▶ CAD insertion point



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

Inch Standard

| CATALOG NUMBER | T +.000 -.005 | L +.000 -.005 | C +.0000 -.0003 | S1 ±.01 | S2 ±.01 | PW | SHCS | USE WITH |
|-------------------|---------------------|---------------------|-----------------------|------------|------------|-----------------------------|-----------------|---------------------------------|
| BLG100L1.3 | 1.000 | 1.310 | .500 | .25 | .75 | 2.000 | #10-32 x 1-1/4 | BLB100L4 & BLB100L6 |
| BLG100L1.8 | | 1.810 | | | 1.12 | | | |
| BLG100L2.3 | | 2.310 | | | 1.25 | | | |
| BLG100L2.8 | | 2.810 | | | 1.625 | | | |
| BLG125L1.3 | 1.250 | 1.310 | .625 | .31 | .75 | 2.750 | 1/4-20 x 1-1/2 | BLB125L5 & BLB125L9 |
| BLG125L1.8 | | 1.810 | | | 1.12 | | | |
| BLG125L2.3 | | 2.310 | | | 1.25 | | | |
| BLG125L2.8 | | 2.810 | | | 1.62 | | | |
| BLG137L1.8 | 1.375 | 1.810 | .750 | .37 | 1.12 | 3.500 | 5/16-18 x 1-1/2 | BLB137L6 & BLB137L11 |
| BLG137L2.3 | | 2.310 | | | 1.25 | | | |
| BLG137L2.8 | | 2.810 | | | 1.62 | | | |
| BLG137L3.3 | | 3.310 | | | 2.25 | | | |
| BLG137L3.8 | | 3.810 | | | 2.50 | | | |
| BLG150L1.8 | 1.500 | 1.810 | 1.000 | .50 | 1.00 | 5.000 (6.000 for BLN150) | 3/8-16 x 1-3/4 | BLN150L8, BLB150L8, & BLB150L16 |
| BLG150L2.3 | | 2.310 | | | 1.50 | | | |
| BLG150L2.8 | | 2.810 | | | 1.62 | | | |
| BLG150L3.3 | | 3.310 | | | 2.25 | | | |
| BLG150L3.8 | | 3.810 | | | 2.50 | | | |
| BLG250L4.3 | 2.500 | 4.310 | 1.250 | .62 | 3.00 | 7.500 | 1/2-13 x 2-3/4 | BLN250L10 |
| BLG350L4.8 | 3.500 | 4.810 | 1.750 | .87 | 3.25 | 9.500 | 5/8-11 x 3-3/4 | BLN350L13 |

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

Metric Standard

| CATALOG NUMBER | T +0 -1 | L +0 -1 | C +.000 -.007 | S1 ±.25 | S2 ±.25 | PW | SHCS | USE WITH |
|------------------|---------------|---------------|---------------------|------------|------------|----|--------------|------------|
| BLGM25L27 | 25 | 27 | 12 | 6 | 14 | 49 | M4-0.7 x 25 | BLBM25L125 |
| BLGM25L36 | | 36 | | | 20 | | | |
| BLGM32L36 | 32 | 36 | 16 | 8 | 20 | 70 | M6-1.0 x 35 | BLBM32L160 |
| BLGM32L46 | | 46 | | | 30 | | | |
| BLGM38L46 | 38 | 46 | 22 | 11 | 24 | 94 | M10-1.5 x 40 | BLBM38L250 |
| BLGM38L76 | | 76 | | | 54 | | | |

ALTERNATIVE CONFIGURATIONS AVAILABLE

- Side Machine Bars are sold separately on page C-4. Inserted Bar Locks are sold on page C-9.
- Guides can have 2 or 4 radii machined. Refer to page C-7 for details.
- Made-to-order Guides can be quoted using the templates at procomps.com.

APPLICATION GUIDELINES

- Guides are sold in pairs. Each set includes 2 Guides and 4 Screws.
- Refer to page C-8 for application guidelines.



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 the B-Side and press platen, using four locks per mold. Clean and lubricate lock every 100,000 cycles, and prevent corrosion during mold storage.

| RECOMMEND-ED 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, SLPM16X20 SLPM16X40, SLPM20X25 SLPM20X50, SLMS13X38 SLMS16X50 | GL100X150 GLM25X45 | TL75X75, TLM20X20 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, SLPM25X63 SLPM32X40, SLPM32X80 SLPM40X50, SLPM40X100 SLMS19X100 | GL100X150 GL150X250 GLM25X45 | TL62X125, TL75X125 TL100X100, TLM25X25 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 SLRM32X63 SLRM40X100 | GL150X250 GLM40X65 | TL75X125, TL87X150 TL137X137, TLM32X32 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

| MALE BAR CATALOG NUMBER | GUIDE CATALOG NUMBER | BAR LOCK ENGAGEMENT | TOTAL MAX WEIGHT SUPPORTED (LBS/KG) |
|-------------------------|--|---------------------|-------------------------------------|
| BLB100L4 | BLG100L1.3, BLG100L1.8 BLG100L2.3, BLG100L2.8 | 2.50 | 10,000 / 4,500 |
| BLBX137L5 | BLGT137L1.3, BLGT137L1.8 | 3.00 | |
| BLB100L6 | BLG100L1.3, BLG100L1.8 BLG100L2.3, BLG100L2.8 | 4.50 | |
| BLBT137L6 | BLGT137L1.3, BLGT137L1.8 | | |
| BLBM25L125 | BLGM25L27, BLGM25L36 | 89mm | 15,000 / 6,800 |
| BLB125L5 | BLG125L1.3, BLG125L1.8 BLG125L2.3, BLG125L2.8 | 3.00 | |
| BLBX162L6 | BLGT162L1.3, BLGT162L2.3 | 3.50 | |
| BLB125L9 | BLG125L1.3, BLG125L1.8 BLG125L2.3, BLG125L2.8 | 7.00 | |
| BLBT162L9 | BLGT162L1.3, BLGT162L2.3 | | |
| BLBM32L160 | BLGM32L36, BLGM32L46 | 114mm | |
| BLB137L6 | BLG137L1.8, BLG137L2.3 BLG137L2.8, BLG137L3.3, BLG137L3.8 | 3.50 | 20,000 / 9,000 |
| BLBX200L7 | BLGT200L1.8 & BLGT200L2.8 | 4.50 | |
| BLB137L11 | BLG137L1.8, BLG137L2.3 BLG137L2.8, BLG137L3.3, BLG137L3.8 | 8.50 | |
| BLBT200L11 | BLGT200L1.8 & BLGT200L2.8 | | 26,000 / 11,800 |
| BLBM38L250 | BLGM38L46, BLGM38L76 | 194 mm | |
| BLB150L8 | BLG150L1.8, BLG150L2.3 | 4.50 | |
| BLB150L16 | BLG150L2.8, BLG150L3.3, BLG150L3.8 | 12.50 | |
| BLN150L8 | BLG150L1.8, BLG150L2.3 BLG150L2.8, BLG150L3.3, BLG150L3.8 | 3.75 | |
| BLN250L10 | BLG250L4.3 | 5.00 | 50,000 / 22,500 |
| BLN350L13 | BLG350L4.8 | 6.00 | 75,000 / 34,000 |