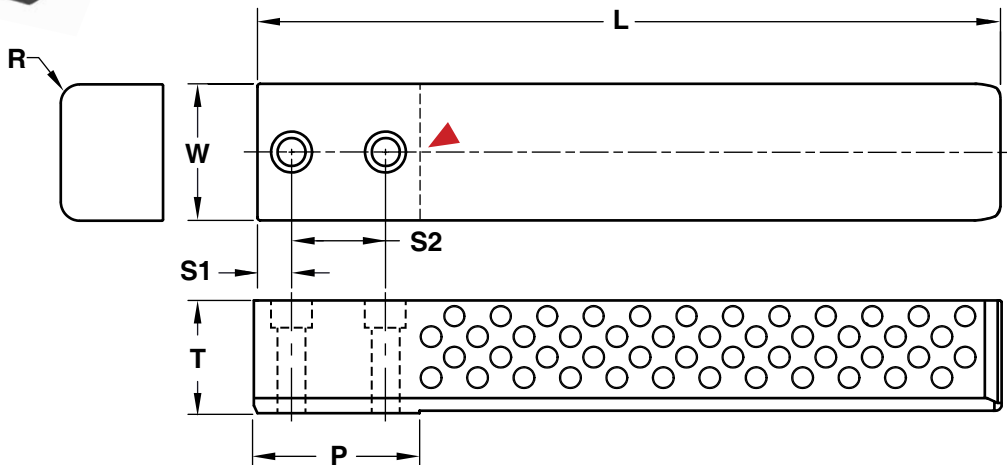


# BAR LOCKS

## BAR-TOP MACHINE STYLE

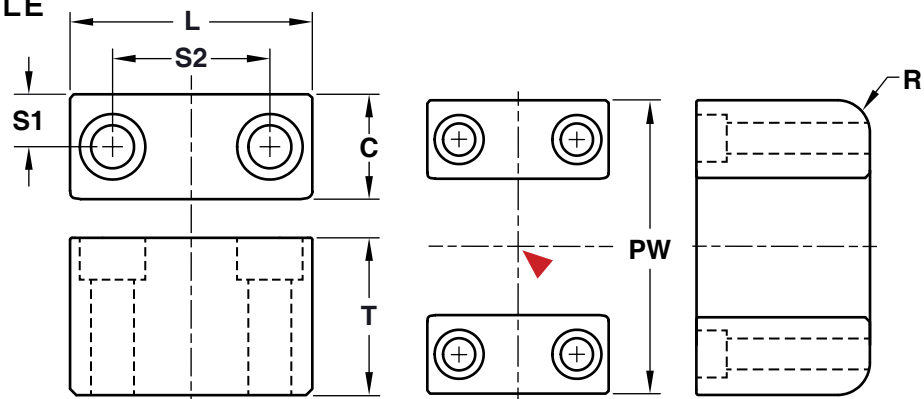
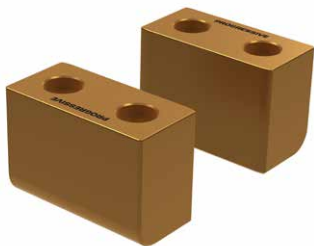


**M** H-13 **H** Core: 42-48 HRC, Surface 70 HRC **S** Black Nitride ▶ CAD insertion point

CATALOG NUMBER	L	T +.000 -.005	W +.0000 -.0005	P MINIMUM POCKET LENGTH	R POCKET RADIUS	S1 ±.01	S2 ±.01	SHCS
<b>BLBT137L6</b>	6.00	1.375	1.625	1.375	.250	.38	.69	5/16-18 x 1-1/2
<b>BLBT162L9</b>	8.88	1.625	2.250	1.875	.312	.50	1.00	3/8-16 x 1-3/4
<b>BLBT200L11</b>	10.88	2.000	3.000	2.375	.375	.63	1.25	1/2-13 x 2-1/4

Bars are sold individually and include 2 screws.

## GUIDES-TOP MACHINE STYLE



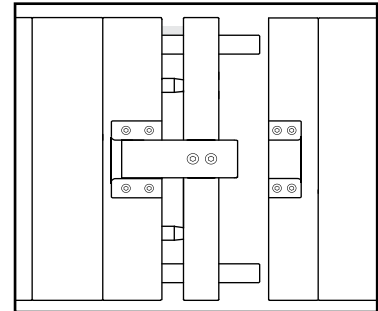
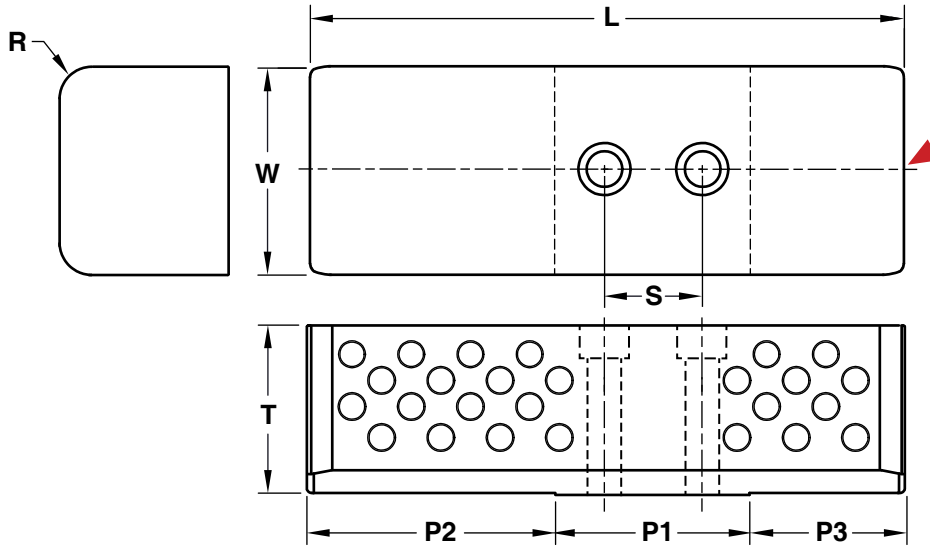
**M** D-2 **H** Core: 58-62 HRC, Surface 80 HRC **S** Titanium Nitride Coated ▶ CAD insertion point

CATALOG NUMBER	T +.000 -.005	L +.000 -.005	C +.0000 -.0003	R POCKET RADIUS	S1 ±.01	S2 ±.01	PW +.0003 +.0006	SHCS	USE WITH
<b>BLGT137L1.3</b>	1.375	1.310	1.000	.250	.50	.75	3.625	#10-32 x 1-1/2	BLBT137L6
<b>BLGT137L1.8</b>		1.810				1.12			
<b>BLGT162L1.3</b>	1.625	1.310	1.125	.312	.56	.75	4.500	1/4-20 x 1-3/4	BLBT162L9
<b>BLGT162L2.3</b>		2.310				1.25			
<b>BLGT200L1.8</b>	2.000	1.810	1.375	.375	.69	1.12	5.750	5/16-18 x 2-1/4	BLBT200L11
<b>BLGT200L2.8</b>		2.810				1.62			

Guides are sold in pairs. Each set includes 2 Guides and 4 Screws.



# BAR LOCKS X-STYLE



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

CAD insertion point

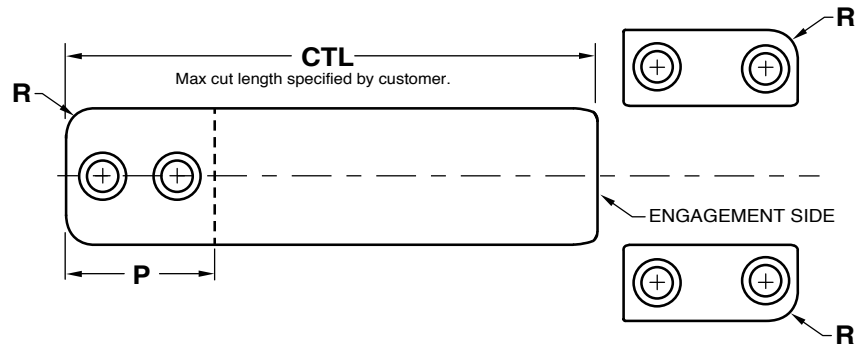
CATALOG NUMBER	L	T +.000 -.005	W +.0000 -.0005	P1 MINIMUM POCKET LENGTH	P2 MIN. PLATE THICKNESS	P3 MIN. PLATE THICKNESS	R POCKET RADIUS	S ±.01	SHCS
<b>BLBX137L5</b>	4.63	1.375	1.625	1.375	1.88	1.38	.250	.69	5/16-18 x 1-1/2
<b>BLBX162L6</b>	5.63	1.625	2.250	1.875	2.38	1.38	.312	1.00	3/8-16 x 1-3/4
<b>BLBX200L7</b>	7.13	2.000	3.000	2.375	2.88	1.88	.375	1.25	1/2-13 x 2-1/4

Bars are sold individually and include 2 screws. Top machine style Guides are sold on page C-6.

## MOLD-READY SPECIALS

### To Order:

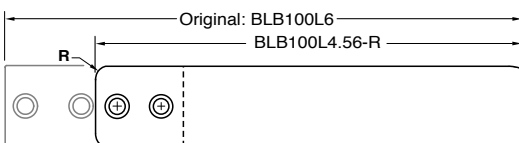
- For cut-to-length Side Machine Bars (pg C-4) or Top Machine Bars (pg C-6), specify the prefix of the Bar and the finished length. Ex. BLB100L4.56. (See max CTL length in the chart below.)
- For Side Machine Bars cut to length with pocket radii with sizes shown in the chart, specify the size, length and add "-R" suffix. Ex. BLB100L4.56-R.
- For Side Machine Bars with pocket radii in standard lengths, add "-R" to the end of the catalog number. Ex. BLB100L6-R.
- For Side Machine Guides with corner radii on both parts, add "-R" to the end of the catalog number. Ex. BLG150L2.8-R.



Note: Mold-Ready Specials must have a minimum quantity of (2) Bars or (2) sets of Guides per order.

### APPLICATION GUIDELINES

- For Guides, the pocket radii are machined on opposing sides as shown above.
- Bar lengths are modified from standards and radii (for Side Machine Bars) are machined on the pocket side to maintain the integrity of the material and treatment on the engagement side.

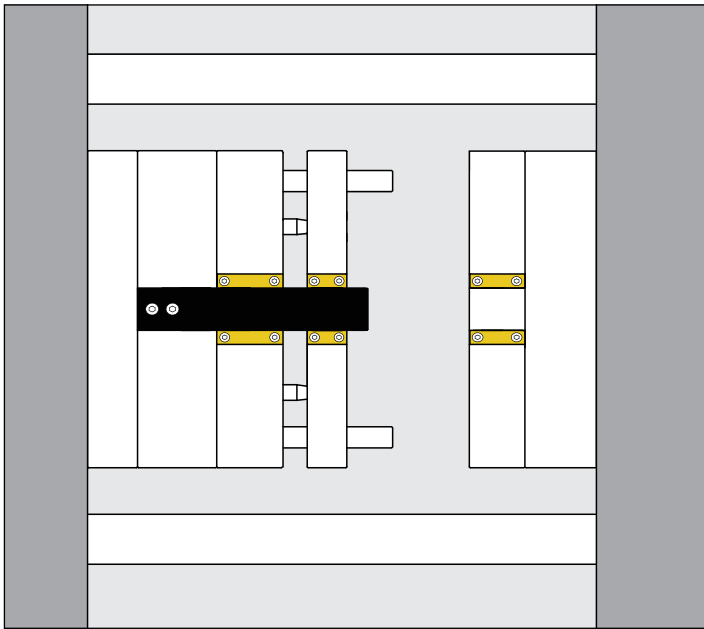


BAR CATALOG PREFIX	CTL MAX	R POCKET RADIUS
<b>BLB100</b>	4.62	.25
<b>BLB125</b>	7.00	.31
<b>BLB137</b>	8.50	.37
<b>BLBT137</b>	4.62	N/A
<b>BLB150</b>	12.50	.50
<b>BLBT162</b>	7.00	N/A
<b>BLBT200</b>	8.50	N/A
<b>BLBM25</b>	89mm	6 mm
<b>BLBM32</b>	114mm	8 mm
<b>BLBM38</b>	194mm	10 mm

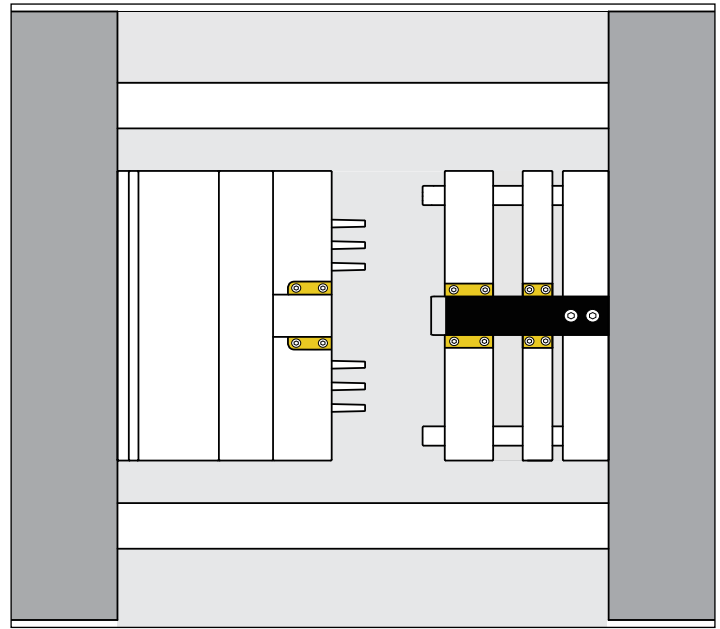
GUIDE CATALOG PREFIX	R POCKET RADIUS
<b>BLG100</b>	.18
<b>BLG125</b>	.25
<b>BLG137</b>	.31
<b>BLG150</b>	.37
<b>BLG250</b>	.37
<b>BLG350</b>	.50
<b>BLGM25</b>	5mm
<b>BLGM32</b>	6mm
<b>BLGM38</b>	7mm

# BAR LOCKS APPLICATIONS

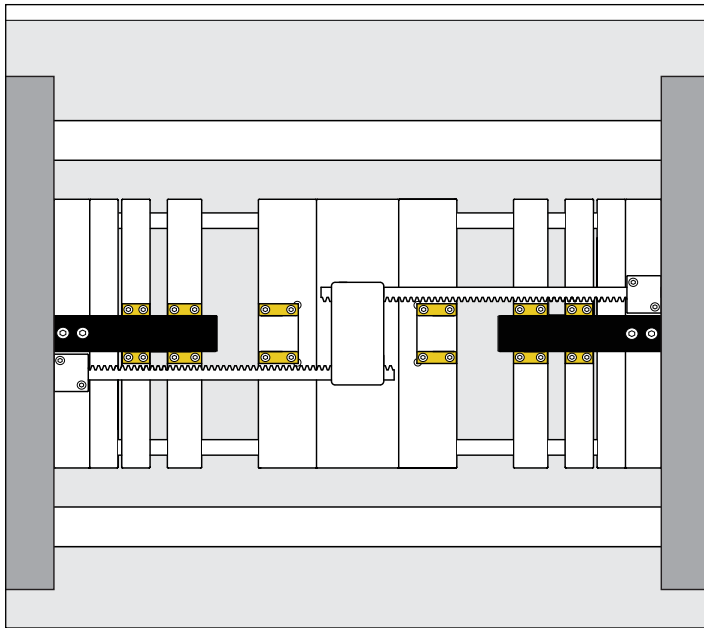
Stripper Plate Application



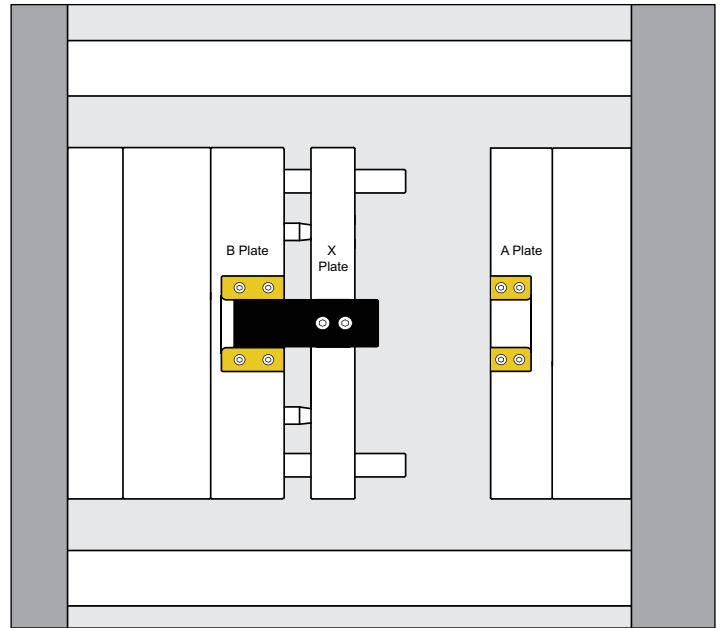
Three Plate Application



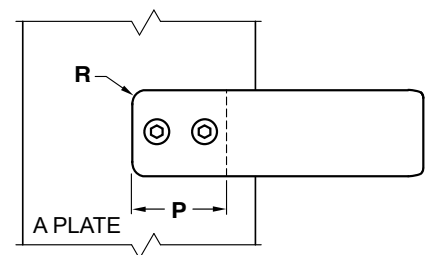
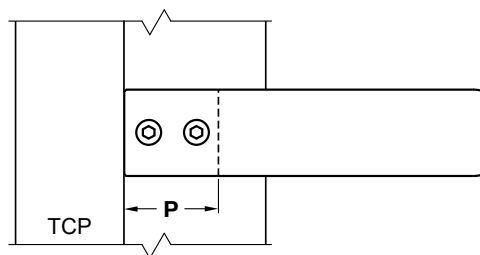
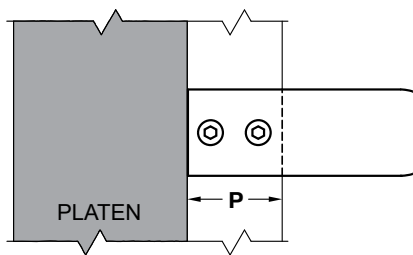
Stack Mold Application



Floating Plate Application



The minimum pocket length (P) is shown below in different applications.





## 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)
<b>RTI AND MOLDS 8 X 8 X 8 AND SMALLER</b>	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
<b>11 X 16 X 10</b>	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
<b>16 X 24 X 16</b>	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
<b>28 X 34 X 24</b>	SL75X300, SLS112X500	SLM19X75, SLM19X100	GL200X350 GL150X250 GLM40X65	TL100X150, TL100X200 TL112X200, TL112X300 TLM26X35, TLM30X45	10,000 / 4,500
<b>32 X 40 X 28</b>	SL100X400	SLM25X125	GL200X350 GLM40X65	TL112X200, TL112X300 TLM36X55, TLM36X75	15,000 / 6,800
<b>42 X 48 X 34</b>	SL125X500		GL250X450 GLM50X90	TL150X250, TL175X300 TLM36X55, TLM36X75	20,000 / 9,000
<b>48 X 52 X 38</b>	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	
BLN350L13	BLG350L4.8	6.00	75,000 / 34,000