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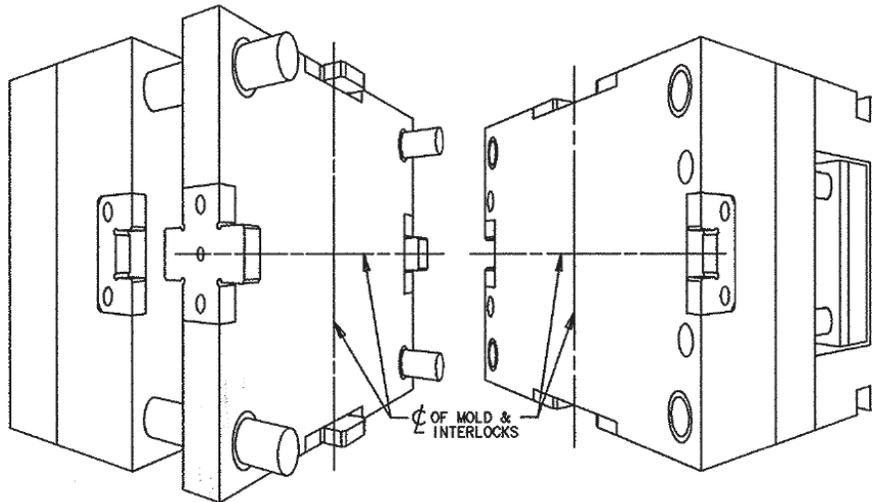
## X-Style Straight Side Interlocks Maching & Installation

(each mates with two female interlocks)

**Please read instructions carefully before installing X-Style and mating female interlocks**

The DME X-Style Straight Side Interlocks are designed for use in molds with floating plates when the two parting lines must be closely aligned with each other. The X-style Straight side Interlocks are designed to be used and mate with two of the equivalent size DME Female Straight Side Interlocks. The X-style Interlocks are typically used on "X" and "AX" series mold bases, as well as other mold bases with floating plates.

Refer to the notes below as well as the charted information for additional installation instructions. Refer to the catalog for interlock dimensions.



### Maching & Installation Instructions

1. Four DME X-Style Interlocks and eight Female Interlocks must be used in each mold application. When in operation, the interlocks contact the edges of the machined pockets to maintain the parting line alignments. The socket head cap screws are only used to retain the interlocks to the mold base. The dowel is used to minimize any movement of the interlock in the open slot thru the stripper plate but the dowel location is only very accurately transferred after the pocket has been closely machined (refer to note #6).
2. To maintain accurate alignment between the parting lines, it is recommended that the mold base assembly be clamped together and machined in assembly.
3. The center of each pocket for the X-Style and Female Interlocks must be located on the centerline of the mold base on each side and each end of the mold. This centerline location is critical to avoid misalignment problems which could result from uneven thermal expansion of the individual mold plates. *It is extremely important to machine the pocket for each interlock accurately with the mold assembled and clamped together.*
4. Individually and uniquely mark each of the components of the mating X-Style and Female Interlocks, as well as their position in the mold. This will insure that the interlocks will remain as sets once they have been installed.
5. The Female Interlocks must be mounted to the plates which are exposed to the highest operating temperature. This procedure is critical to insure that the engaging portions of the X-Style Male Interlocks do not grow larger than the mating Female Interlocks if uneven mold temperatures are present.



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6. After the pockets for the X-Style and Female Interlocks have been accurately machined in the closed mold base assembly, then the locations for the socket head cap screws and dowels must be transferred from the components to the pocket areas on the mold. To accurately locate the holes for the dowels, first transfer, drill, and tap the holes for the socket head cap screws. Then install all of the X-Style and Female Interlocks on the mold with the included socket head cap screws. The holes for the dowels must be very accurately transferred with the X-Style and Female Interlocks installed in the pockets and engaged with the mold assembly closed. Drill and ream or machine as required, and install the dowels.
7. Torque the Socket Head Cop Screws to:
  - 10-ftlbs for 1/4-20 Socket Head Cap Screws
  - 30-ftlbs for 3/8-16 Socket Head Cap Screws
  - 60-ftlbs for 1/2-13 Socket head Caps screws
8. After installation, open and close the mold and move the floating mold plate with the mold on the bench to insure that proper alignment hos been achieved.
9. Always maintain lubrication on the interlocks to extend the life of each component. Lubrication will greatly reduce any wear, as well as minimize any possibility of galling.
10. Refer to the other side of this sheet for basic dimensional information to use in mounting the X-Style Interlocks on a mold. The moldmaker may adjust fit to suit specific application. Installation of other mold components, water-lines, taps for eyebolts, etc. must not interfere with machined pockets or drilled and tapped holes for mounting of X-Style and Female Interlocks.

