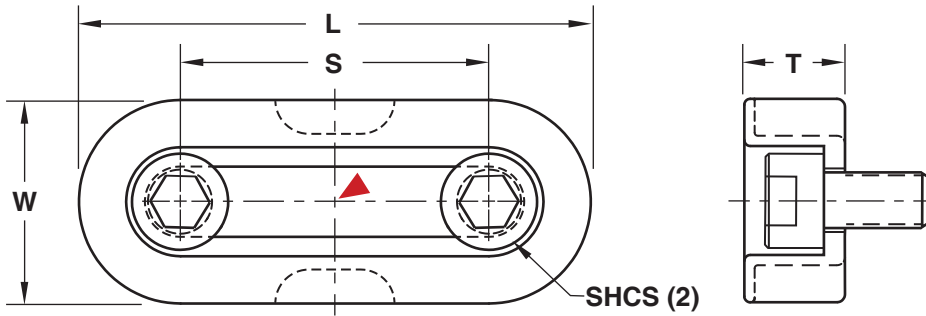


SAFETY STRAPS



APPLICATION GUIDELINES

- Secures mold parting lines for transportation, mold setting, and storage.
- Breakaway feature in center of the Safety Strap is engineered to break slightly before the bolts would shear.
- If unintentionally left on the mold in the press, the Safety Strap will be obvious to the operator that it is broken and can easily be replaced. Other straps shear the bolts, which cannot be removed with the mold in the press, creating an unsafe condition when the mold is later removed from the machine.
- Progressive Safety Straps can replace others' mold straps.
- Strength Ratings have a safety factor of two.
- Powder coated OSHA yellow.



Inch Standard

M 1010 **H** 85 Brinell

▶ CAD insertion point

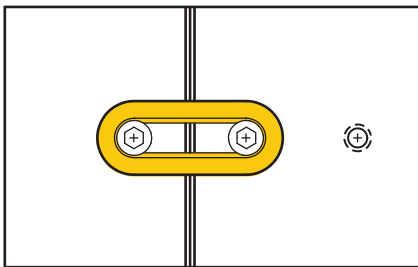
CATALOG NUMBER	L	W	T	S	SHCS	STRENGTH RATING (LBS)
SAFT-88	1.62	.75	.37	.88	1/4-20 x 1/2	1,000
SAFT-150	2.50	1.00	.50	1.50	5/16-18 x 5/8	1,500
SAFT-200	3.37	1.37	.75	2.00	1/2-13 x 1	3,000

Holo-Krome® screws included.

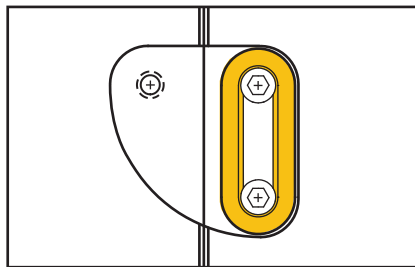
Metric Standard

CATALOG NUMBER	L	W	T	S	SHCS	STRENGTH RATING (KG)
SAFTM-22	42	20	10	22	M6-1.0 x 12	450
SAFTM-38	64	26	14	38	M8-1.25 x 16	680
SAFTM-50	86	35	20	50	M12-1.75 x 25	1360

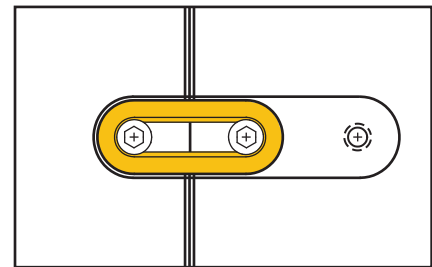
Holo-Krome® screws included.



Surface Mount

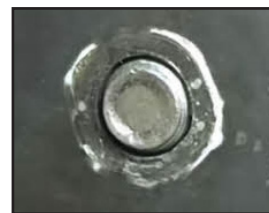


Swing Mount



Sliding Mount

MOLD WEIGHTS	STRAP PART NUMBER
UNDER 1,000 LBS / 450 KG	SAFT-88 / SAFTM-22
UNDER 1,500 LBS / 680 KG	SAFT-150 / SAFTM-38
UNDER 3,000 LBS / 1360 KG	SAFT-200 / SAFTM-50



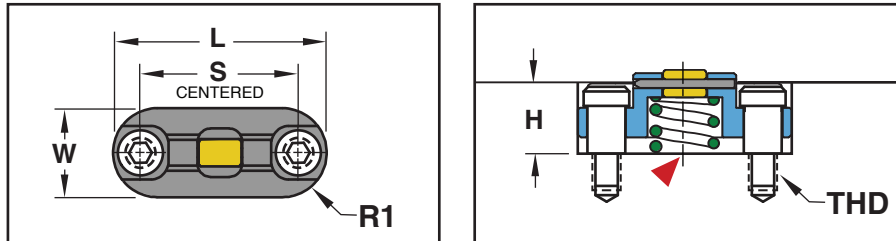
Unlike other mold straps, Progressive's Safety Straps have an engineered break point to avoid bolt shearing when left on the tool in the press.



SLIDE RETAINERS

SLIDE LOCK STYLE-METRIC STANDARD

Slide Lock Style slide retention provides smooth, greaseless friction-free performance. Reliably holding 11 to 22 kilograms each, this design features color-coded springs to indicate force rating.



Roller: **M** M-2 **H** 60-62 HRC **S** Titanium Nitride Coated 80 HRC

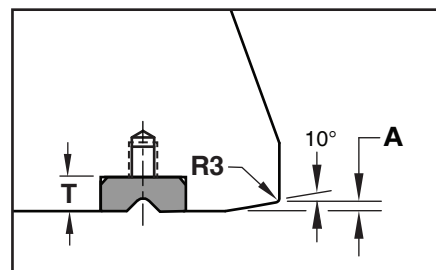
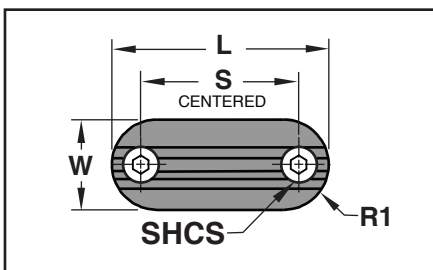
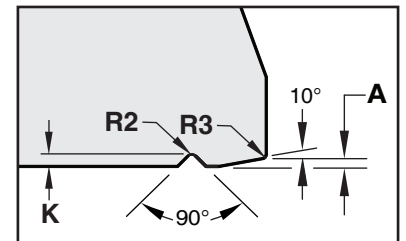
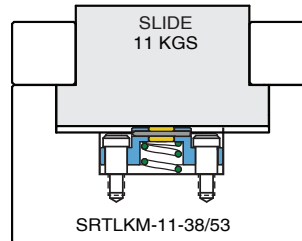
▶ CAD insertion point

SLIDE RETAINER CATALOG NUMBER	MAX WEIGHT PER UNIT (KG)	SPRING COLOR	L +0.10 -0.00	W +0.10 -0.00	H +0.05 -0.00	R1 +0.05 -0.00	THD	S	A	K	R2	R3
SRTLKM-11-38	11	GRN	38	14	12	7	M3-.5	28	2.0	2.5	1	1
SRTLKM-11-53			53	18	14	9	M4-.7	43				
SRTLKM-22-56	22	RED	56	26	24	13	M6-1.0	42	2.5	4.0	2	1.5

Pocket dimensions shown. Screws included.

APPLICATION GUIDELINES

- Select the single Slide Retainer to match the slide weight. Multiple retainers may be used for heavier slides.
- Machine the pockets as shown in the graphics and table.
- For retention on the slide, purchase the Cleats as shown below or machine the groove in the slide as shown at right.



CLEATS



M 4140 **H** 50-54 HRC **S** Black Oxide

CLEAT CATALOG NUMBER	L +0.10 -0.00	W +0.10 -0.00	T +0.05 -0.00	R1 +0.05 -0.00	SHCS	S
SRTLKM-38-C	38	14	5	7	M4-.7 x 8	28
SRTLKM-53-C	53	18		9		43
SRTLKM-56-C	56	26	10	13	M6-1.0 x 12	42

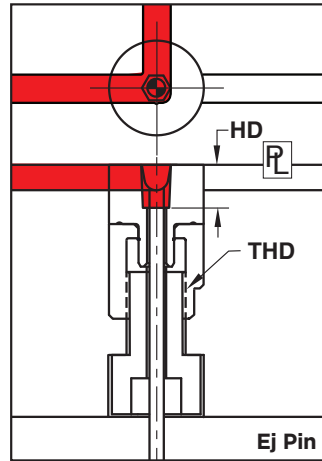
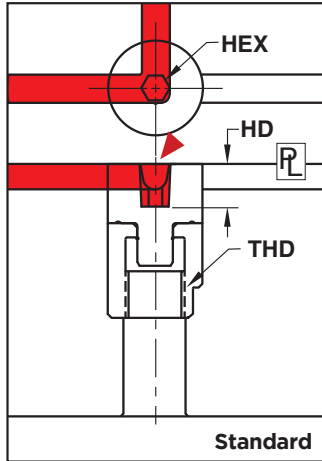
Pocket dimensions shown. Screws included.

RUNNER TURN OFF



APPLICATION GUIDELINES

- Runner Turn Off inserts provide a reliable position of material flow.
- Hex with 2° taper provided for rotating insert.
- Runner Turn Offs utilize detents positioned in 45° increments.
- Machining is straightforward with two flats provided on top and bottom rings to hold in place without risk of spinning.
- Press fit flat (PF) is provided for orientation during installation.
- Recommended runner guidelines are provided on the following page.
- The Ejector Pin versions are supplied with screws. Modify the length to suit.
- For removal, a spare bolt must be used to strike from back in order to overcome the press fit.



▶ CAD insertion point

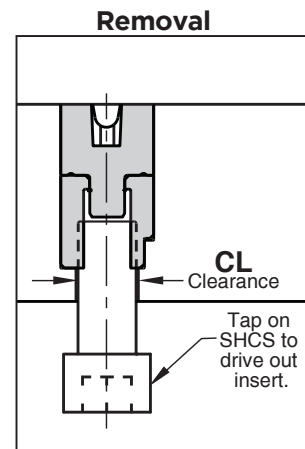
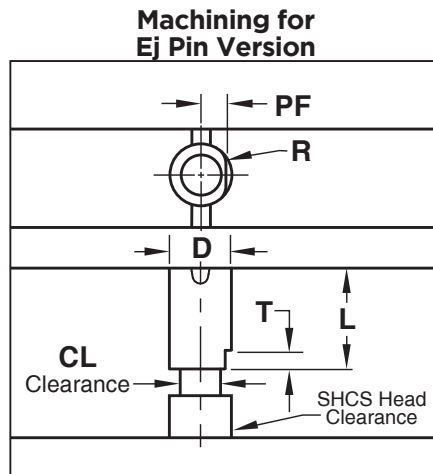
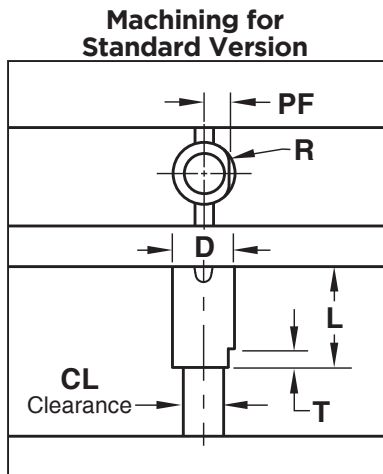
Inch Standard

M 420 Stainless **H** 30-34 HRC

CATALOG NUMBER	EJ PIN SIZE	D	L	T	R	PF	CL	HEX	HD HEX DEPTH	THD
RT62	—	.625	1.125	.300	.125	.250	.40	5/32	.25	3/8-16
RT62-EP	1/8									
RT100	—	1.000	1.625	.300	.312	.400	.65	1/4	.45	5/8-11
RT100-EP	3/16									

Metric Standard

CATALOG NUMBER	EJ PIN SIZE	D	L	T	R	PF	CL	HEX	HD HEX DEPTH	THD
RTM16	—	16	28	8	4	6.5	10.8	4	7	M10 x 1.5
RTM16-EP	3.0									
RTM24	—	24	40	8	8	9.5	16.8	6	12	M16 x 2.0
RTM24-EP	4.5									

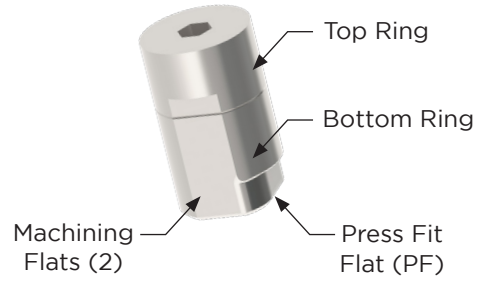




RUNNER TURN OFF

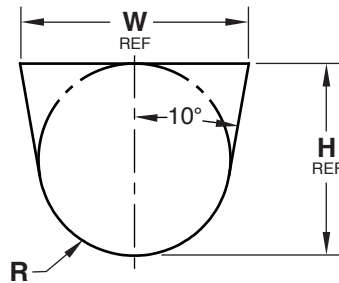
RUNNER MACHINING GUIDELINES

- Runner Turn Offs have two machining flats to prevent spinning when holding the assembly in a vise.
- Refer to the table below for recommended runner geometry for the inch standard runners.
- Maximum machining depth (H) is .313"/8mm.



Inch Standard

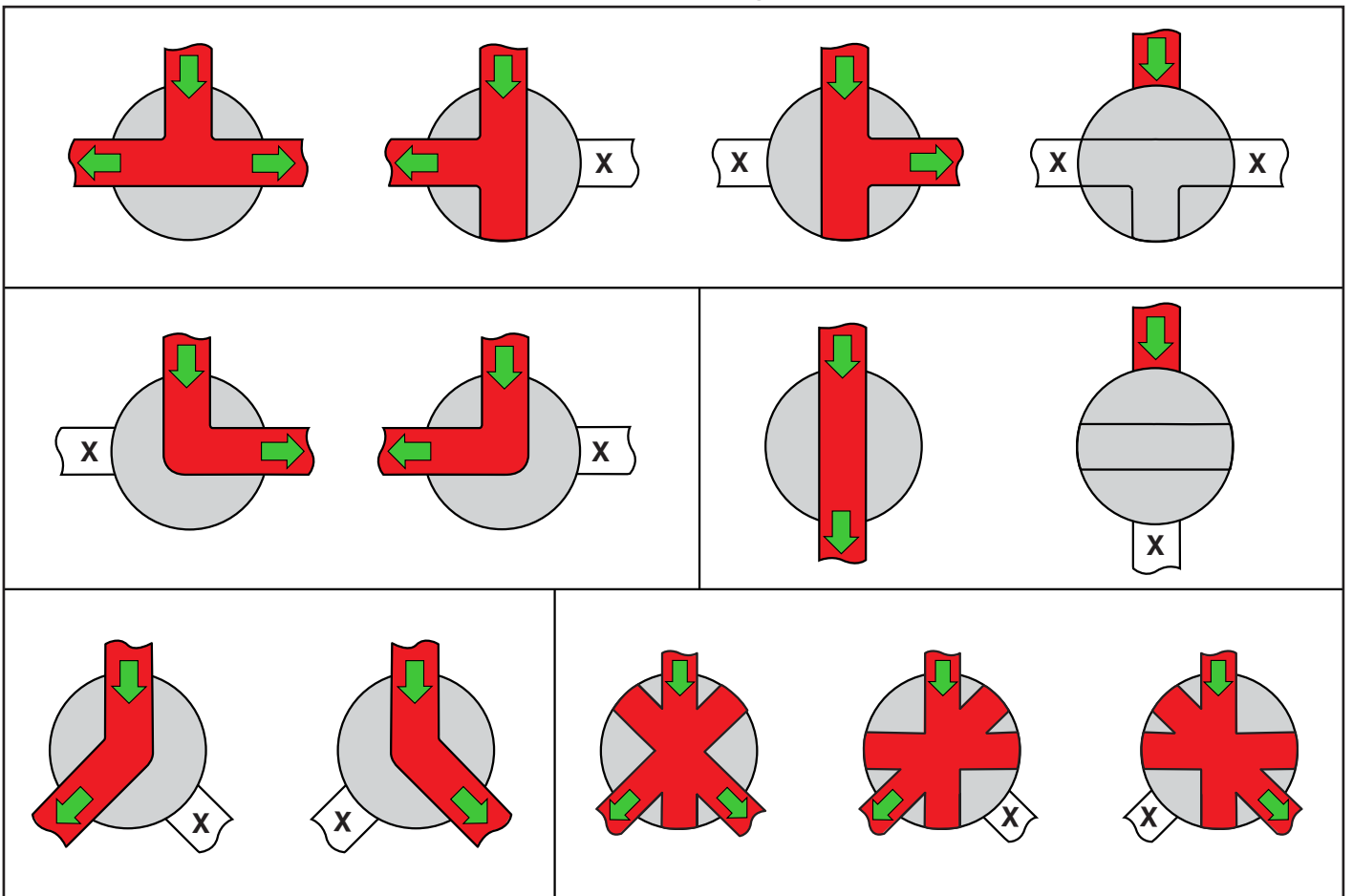
RUNNER SIZE	H	R	W	AREA (SQ. INCH)
3/32	.094	.047	.112	.008
1/8	.125	.063	.149	.015
5/32	.156	.078	.186	.023
3/16	.188	.094	.223	.033
7/32	.219	.109	.261	.045
1/4	.250	.125	.298	.059
9/32	.281	.140	.335	.075
5/16	.313	.156	.372	.092



Metric Standard

RUNNER SIZE	H	R	W	AREA (SQ. MM)
3.2	3.2	1.6	3.81	9.7
4.0	4.0	2.0	4.77	14.8
4.8	4.8	2.4	5.72	21.8
6.4	6.4	3.2	7.63	38.7
8.0	8.0	4.0	9.53	59.0

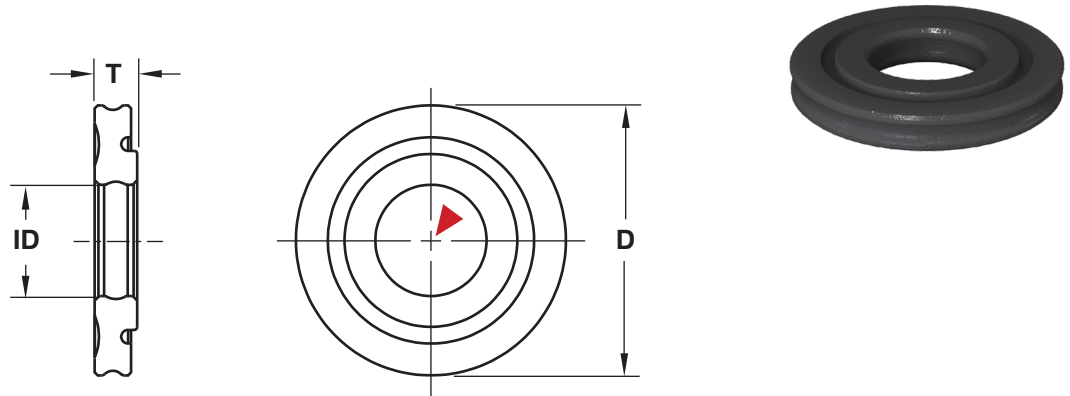
Possible Runner Configurations





RADIAL SPRINGS

FLOATING INSERT CENTERING SPRING



Inch Standard

M TPA **H** 91A

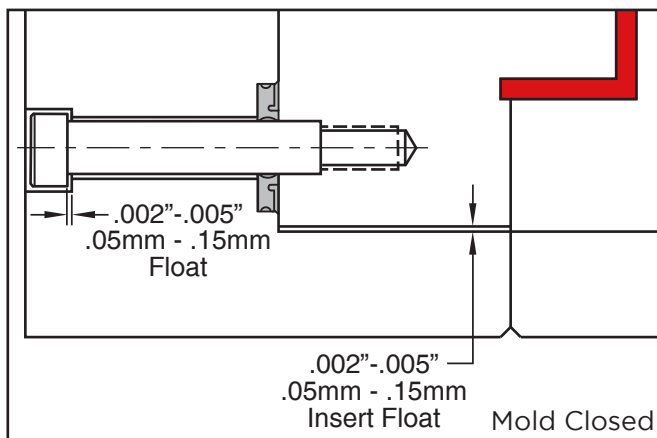
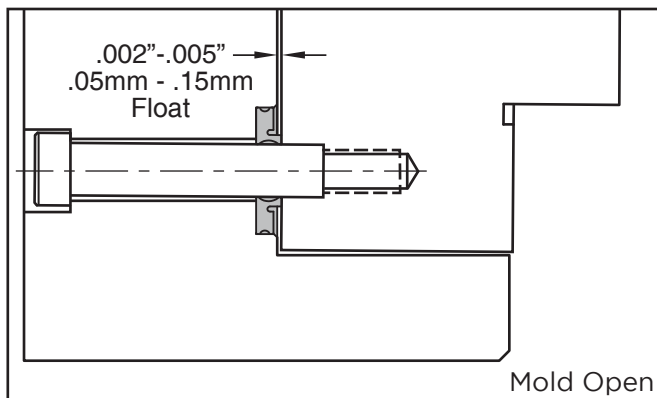
CATALOG NUMBER	ID STRIPPER BOLT DIAMETER	D POCKET DIAMETER ±.001	T POCKET DEPTH ±.001	MAX INSERT WEIGHT (LBS) FOR 4 SPRINGS
RS250	1/4	.500	.125	50
RS312	5/16	.750	.125	75
RS375	3/8	.875	.125	100
RS500	1/2	1.000	.125	150

Metric Standard

M TPA **H** 91A

CATALOG NUMBER	ID STRIPPER BOLT DIAMETER	D POCKET DIAMETER ±.03	T POCKET DEPTH ±.03	MAX INSERT WEIGHT (KG) FOR 4 SPRINGS
RSM06	6	12	3	22
RSM08	8	16	3	35
RSM10	10	20	3	45
RSM12	12	24	3	70

▶ CAD insertion point



APPLICATION GUIDELINES

- Radial Springs both lift and center floating inserts before locks engage to protect telescoping shut offs.
- Install on core half as shown below.
- For best performance, use four Stripper Bolts and Radial Springs per insert with four Cavity Locks. Inch Stripper Bolts are sold on page B-30 and both Inch and Metric Cavity Locks are on pages C-16 (Flat) and C-17 (Round).
- Max Temperature: 200°F (93°C)

