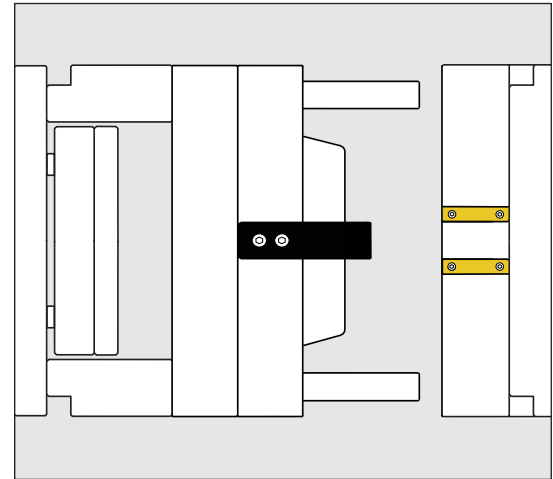
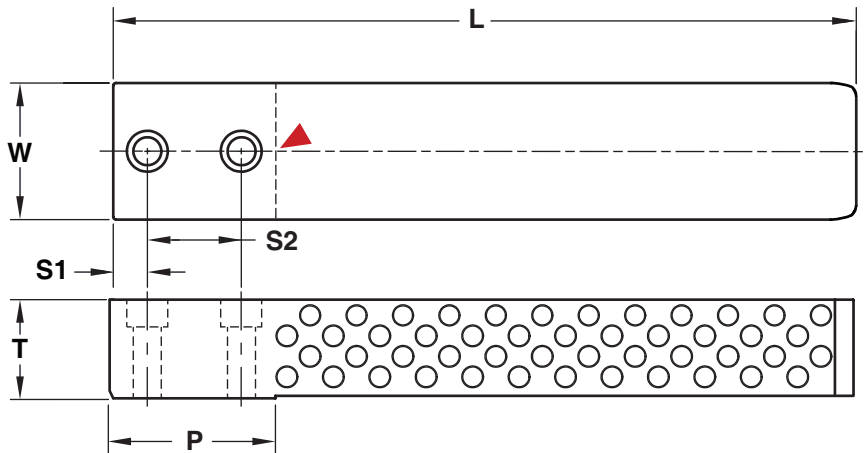
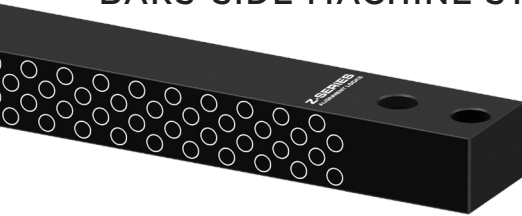


BAR LOCKS

BAR-SIDE MACHINE STYLE



Inch Standard

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	S1 ±.01	S2 ±.01	SHCS
BLB100L4	3.88	1.000	1.000	1.38	.38	.69	5/16-18 x 1-1/4
BLB100L6	6.00						
BLB125L5	4.88	1.250	1.500	1.88	.50	1.00	3/8 - 16 x 1-1/2
BLB125L9	8.88						
BLB137L6	5.88	1.375	2.000	2.38	.50	1.38	3/8 - 16 x 1-1/2
BLB137L11	10.88						
BLB150L8	7.88	1.500	3.000	3.38	.63	2.00	1/2 - 13 x 1-3/4
BLB150L16	15.88						

Bars are sold individually and include 2 screws.

Metric Standard

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

CATALOG NUMBER	L	T +.0 -.1	W +.00 -.01	P MINIMUM POCKET LENGTH	S1 ±.25	S2 ±.25	SHCS
BLBM25L125	125	25	25	36	10	18	M8-1.25 x 30
BLBM32L160	160	32	38	46	12.5	25	M10-1.5 x 35
BLBM38L250	250	38	50	56	15	30	M12-1.75 x 45

Bars are sold individually and include 2 screws.

ALTERNATIVE CONFIGURATIONS AVAILABLE

- Guides are sold separately on page C-5.
- Bars can be cut to length and/or have radii machined. Refer to page C-7 for details.
- Made-to-Order Bar Locks can be quoted using the templates at procomps.com.



BAR LOCKS

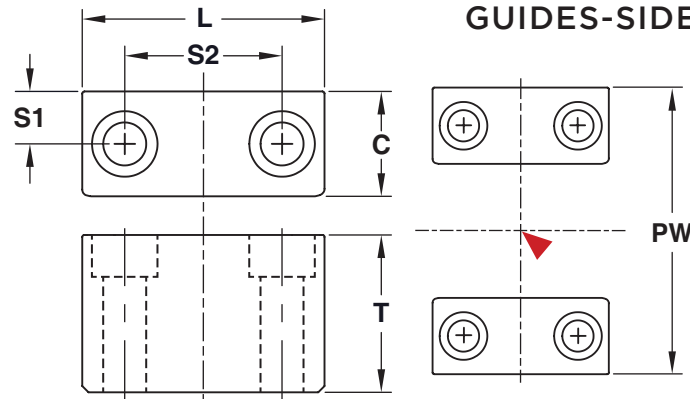
GUIDES-SIDE MACHINE STYLE

PW Tolerances:

Standard Bars:
+.0003/+.0006
(+.007/+.015mm)

Inserted Bars:
+.0010/+.0015
(+.025/+.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	1.500	3.810	1.000	.50	2.50	5.000 (6.000 for BLN150)	3/8-16 x 1-3/4	BLN150L8, BLB150L8, & BLB150L16
BLG150L1.8		1.810			1.00			
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

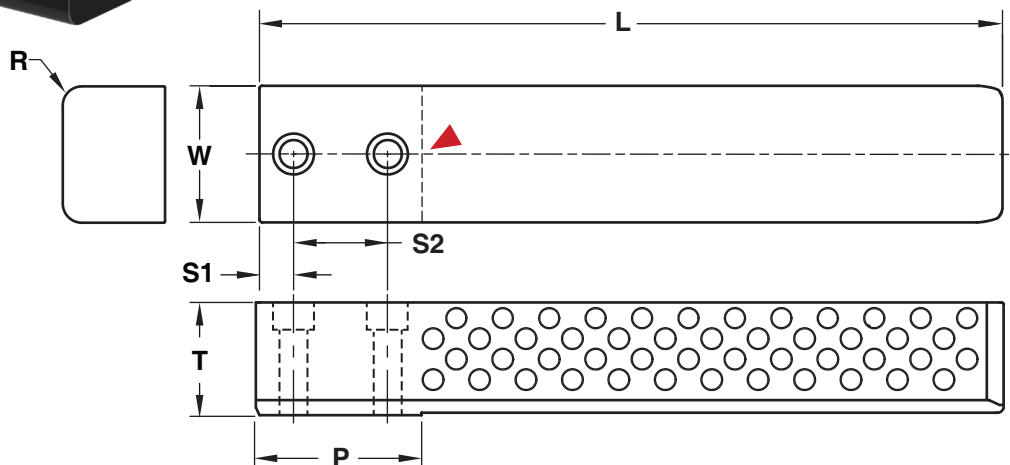
- Side Machine Bars are sold separately on page C-4. Inserted Bar Locks are sold on page C-9.
- Guides can have 2 or 4 radii machined. Refer to page C-7 for details.
- Made-to-Order Guides can be quoted using the templates at procomps.com.

APPLICATION GUIDELINES

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

BAR LOCKS

BARS-TOP MACHINE STYLE



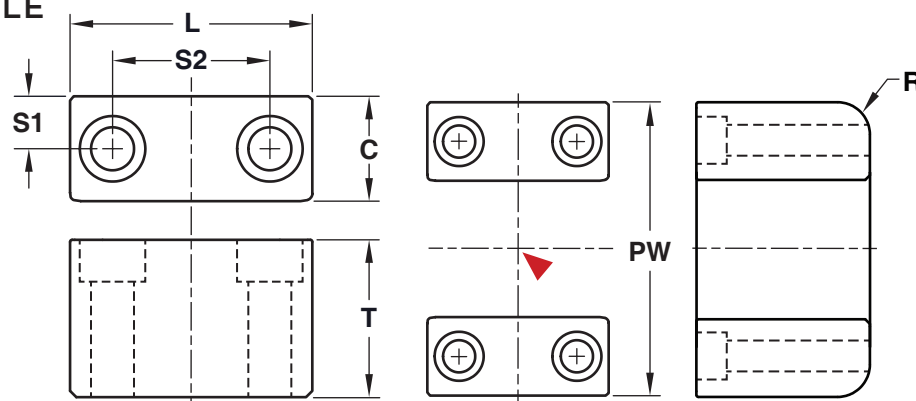
M H-13 **H** Core: 42-48 HRC, Surface 70 HRC **S** Black Nitride

▶ CAD insertion point

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

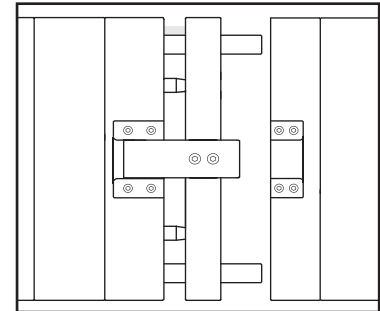
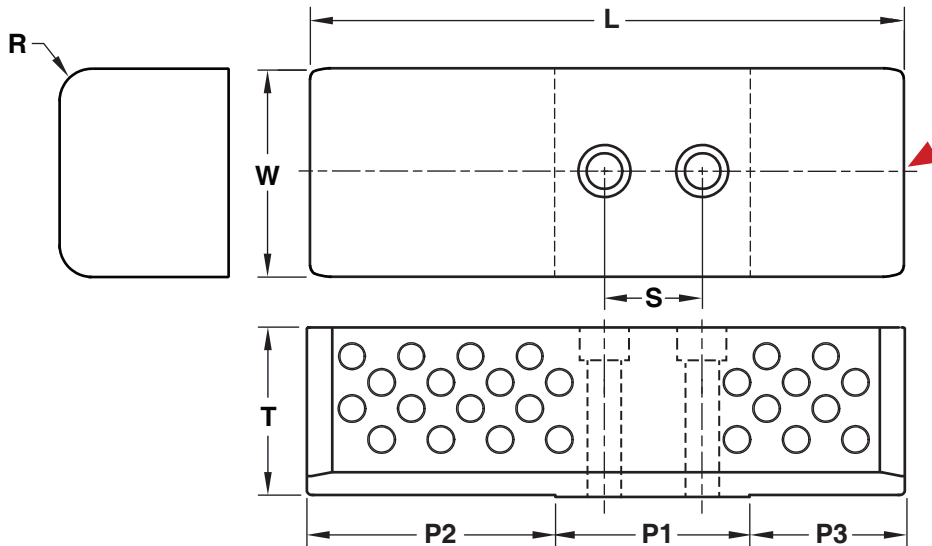
▶ CAD insertion point

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

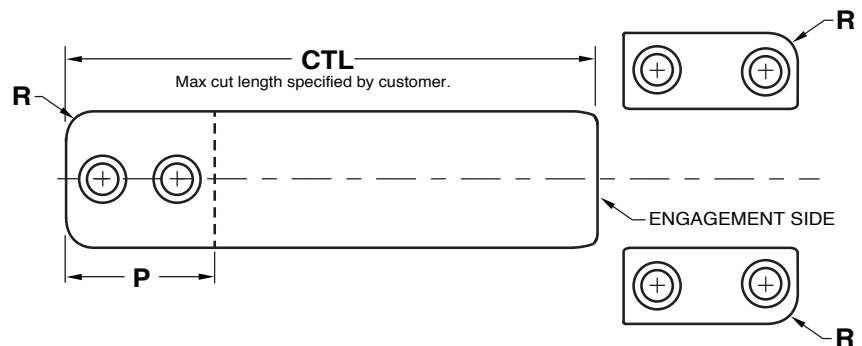
CATALOG NUMBER	L	T +.000 -.005	W +.0000 -.0005	P1 MINIMUM POCKET LENGTH	P2 MIN. PLATE THICKNESS	P3 MIN. PLATE THICKNESS	R POCKET RADIUS	S ±.01	SHCS
BLBX137L5	4.63	1.375	1.625	1.375	1.88	1.38	.250	.69	5/16-18 x 1-1/2
BLBX162L6	5.63	1.625	2.250	1.875	2.38	1.38	.312	1.00	3/8-16 x 1-3/4
BLBX200L7	7.13	2.000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

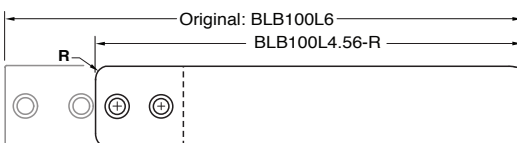
- For cut-to-length Side Machine Bars (pg C-4) or Top Machine Bars (pg C-6), specify the prefix of the Bar and the finished length. Ex. BLB100L4.56. (See max CTL length in the chart below.)
- For Side Machine Bars cut to length with pocket radii with sizes shown in the chart, specify the size, length 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.

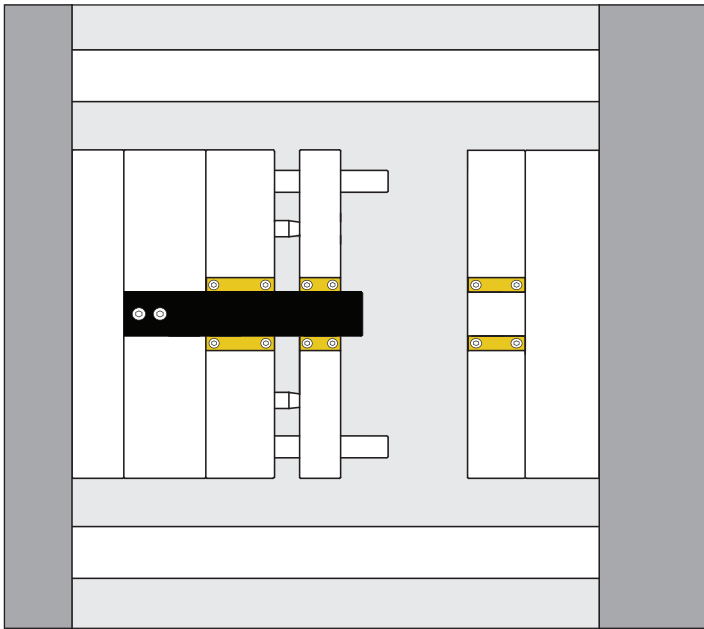


BAR CATALOG PREFIX	CTL MAX	R POCKET RADIUS
BLB100	4.62	.25
BLB125	7.00	.31
BLB137	8.50	.37
BLBT137	4.62	N/A
BLB150	12.50	.50
BLBT162	7.00	N/A
BLBT200	8.50	N/A
BLBM25	89mm	6 mm
BLBM32	114mm	8 mm
BLBM38	194mm	10 mm

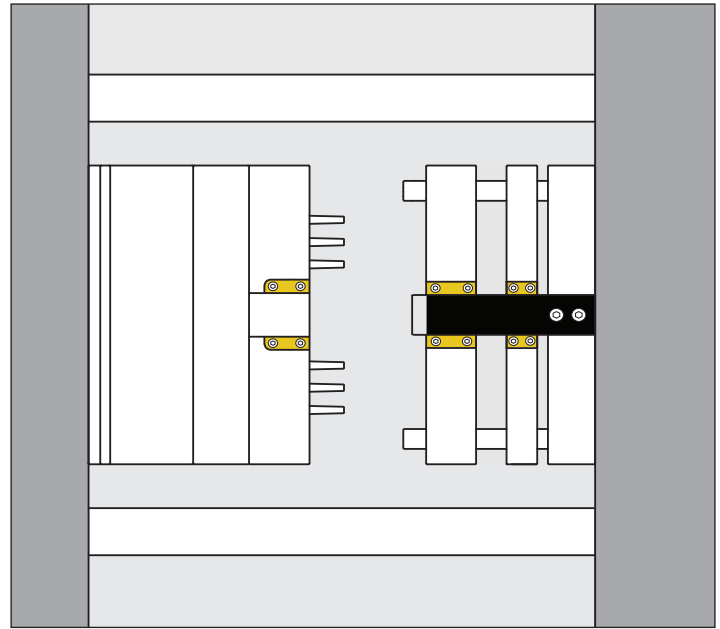
GUIDE CATALOG PREFIX	R POCKET RADIUS
BLG100	.18
BLG125	.25
BLG137	.31
BLG150	.37
BLG250	.37
BLG350	.50
BLGM25	5mm
BLGM32	6mm
BLGM38	7mm

BAR LOCKS APPLICATIONS

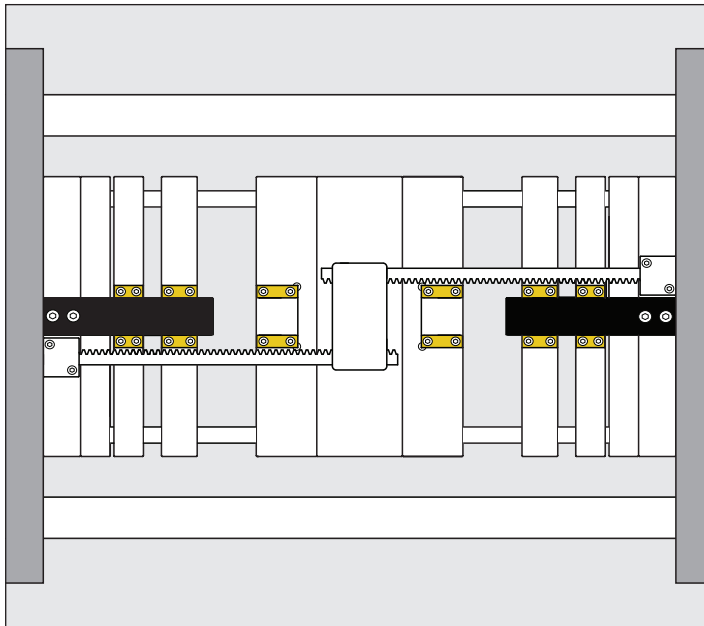
Stripper Plate Application



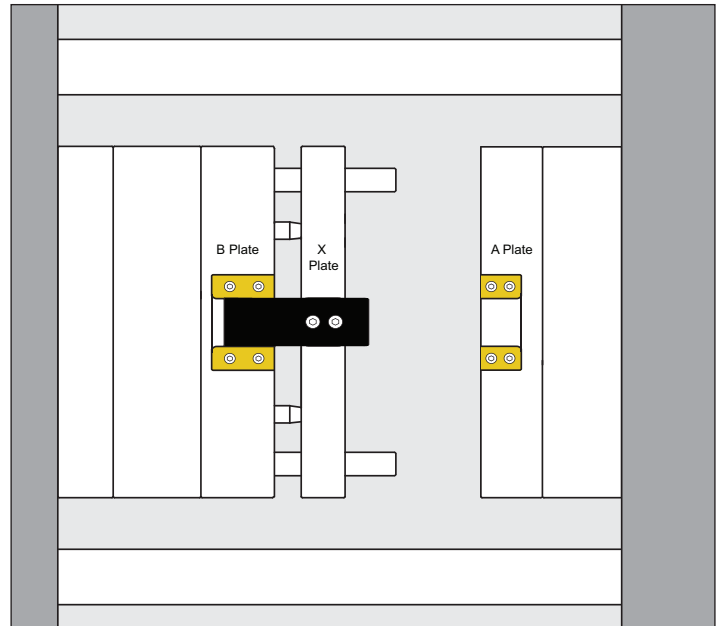
Three Plate Application



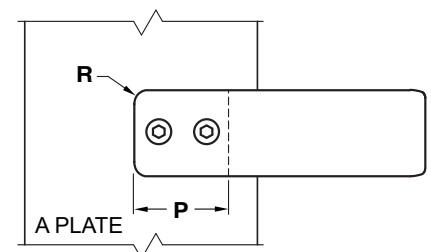
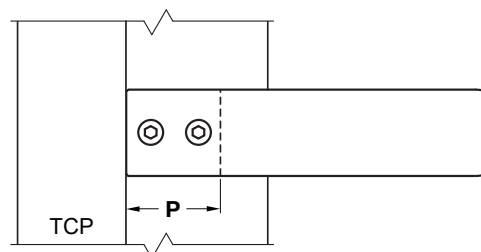
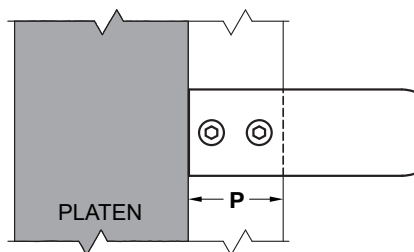
Stack Mold Application



Floating Plate Application

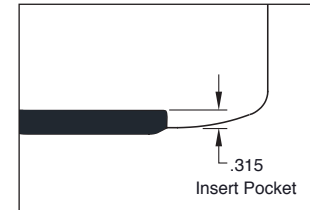
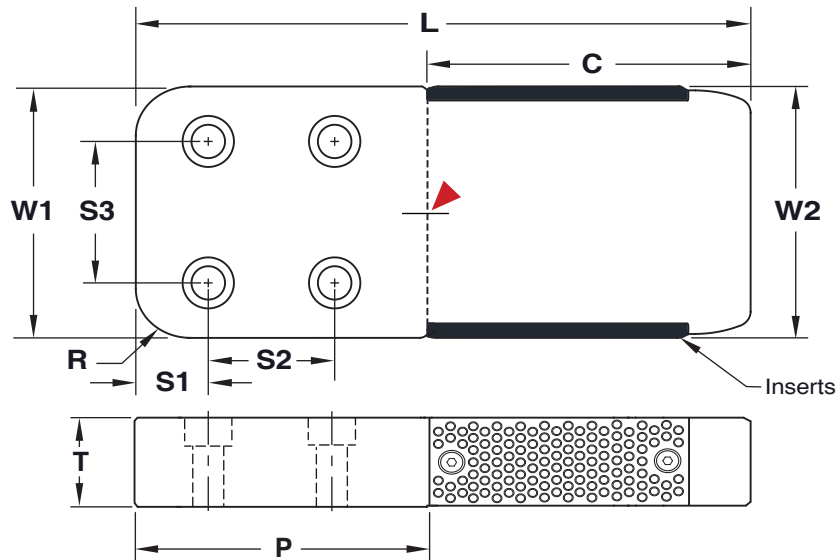
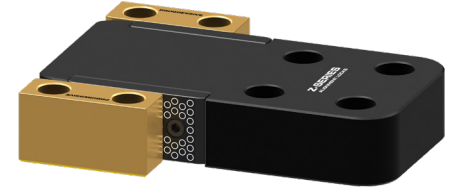


The minimum pocket length (P) is shown below in different applications.





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 +.000 -.002	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.

