MOULD CONCEPTS

DAHANAN
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CAVITY INTERLOCKS
FLAT SERIES

L — S1 — D — S2 — L

.04" (1mm) Chamfer

W

SHCS

H

T

► CAD insertion point
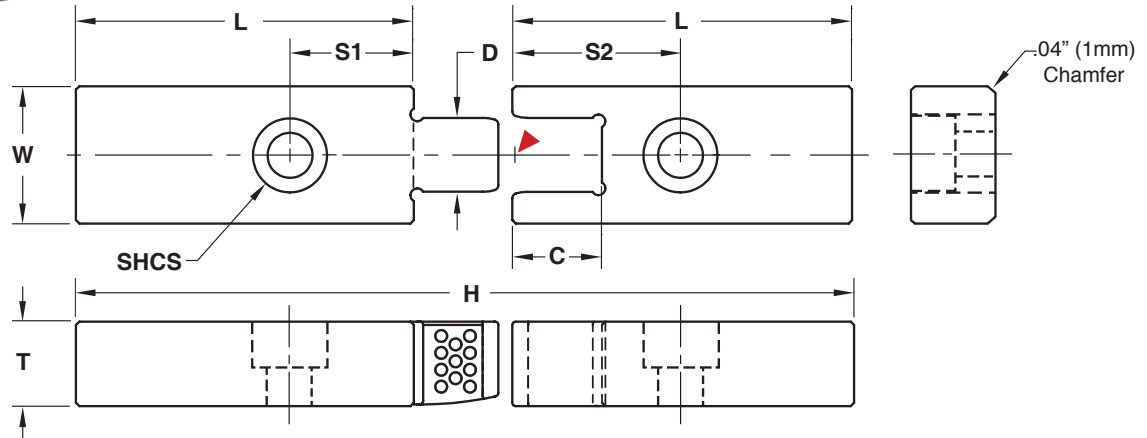
Inch Standard

Male: **M** H-13   **H** Core: 42-48 HRC, Surface: 70 HRC   **S** Black Nitride
Female: **M** DC53   **H** Core: 58-62 HRC, Surface: 80 HRC   **S** Titanium Nitride Coated

CATALOG NUMBER	T +.000 -.002	W +.0000 -.0002	L +.000 -.002	C	D .0001/.00025 CLEARANCE PER SIDE	H +.000 -.004	S1 ±.01	S2 ±.01	SHCS
CF31X62	.312	.625	1.875	.343	.312	3.750	.68	.68	#8-32 x 3/8
CF50X87	.500	.875	2.875	.530	.438	5.750	1.00	1.00	1/4-20 x 5/8

Screws included.

Metric Standard

Male: **M** H-13   **H** Core: 42-48 HRC, Surface: 70 HRC   **S** Black Nitride
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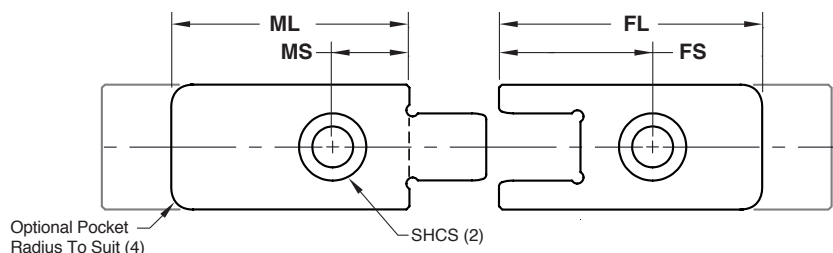| CATALOG NUMBER	T +.00 -.05	W +.000 -.005	L +.00 -.05	C	D .003/.006 CLEARANCE PER SIDE	H +.0 -.1	S1 ±.25	S2 ±.25	SHCS
CFM08X16	8	16	46	8.8	8	92	12.5	20	M4-0.7 X 10
CFM12X20	12	20	66	12.8	12	132	18.5	30	M6-1.0 X 14

Screws included.

ALTERNATIVE CONFIGURATIONS AVAILABLE

• To order Shuttle Mold sets or special male/female configurations, refer to page C-11.
• Progressive can supply Mold-Ready Flat Cavity Interlocks complete with screw hole locations and lengths modified to suit your application. To order, specify the item code that will be modified from the charts above and provide the following to Customer Service. Note: Minimum order quantity is 2 sets of locks.
  • ML=Male Length (Must be less than "L" above.)
  • MS=Male Screw Location (Will be on center.)
  • FL=Female Length (Must be less than "L" above.)
  • FS=Female Screw Location (Will be on center.)
  • Pocket Radius: If required, add "-R" to the specification. (Radius is designed to suit Interlock size.)
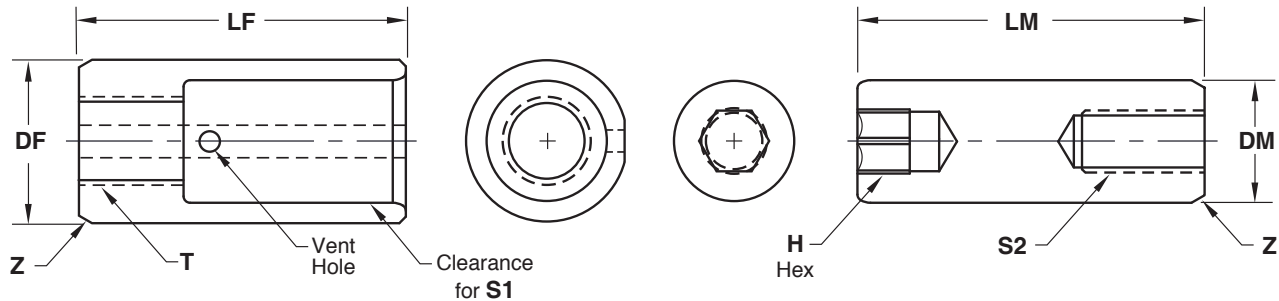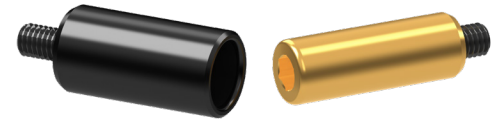
Note: Screw size will be the same as within the standards.
Any specifications outside of the modifications above can be quoted Made-to-Order by contacting tech@procomps.com.

ML — MS — FL — FS

Optional Pocket Radius To Suit (4)

SHCS (2)

PROGRESSIVE COMPONENTS

US Patent No. 8,821,144 and others pending.

CAVITY INTERLOCKS
ROUND SERIES

LF
DF
Z
T
Vent Hole
Clearance for **S1**

LM
H Hex
S2
Z
DM

Female: **M** H-13 **H** Core: 42-48 HRC, Surface: 70 HRC **S** Black Nitride
Male: **M** DC53 **H** Core: 58-62 HRC, Surface: 80 HRC **S** Titanium Nitride Coated

Inch Standard

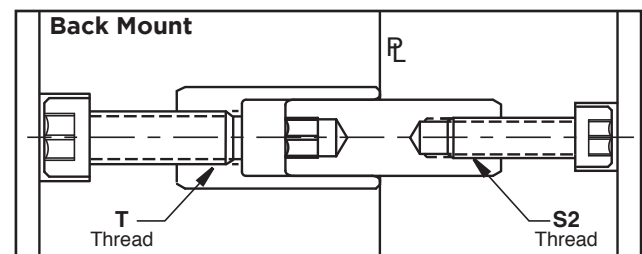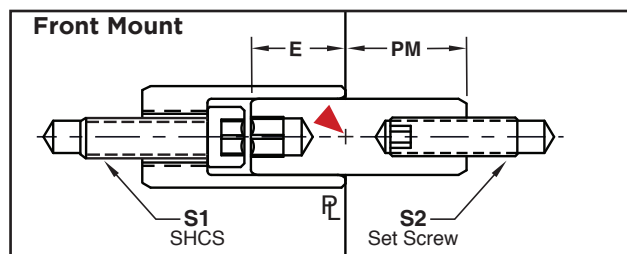| CATALOG NUMBER	DM -.0001 -.0002	DF +.0000 -.0002	LF +.000 -.002	LM +.000 -.002	PM	E	Z	S1 SHCS SIZE	T	S2 SET SCREW SIZE	H
CRS250	.2500	.3750	.687	.812	.500	.31	.03	#6-32 x 3/8	#10-32	#6-32 x 1/2	1/8
CRS375	.3750	.5000	1.000	1.062	.625	.44	.04	#10-32 x 5/8	1/4-20	#10-32 x 5/8	3/16
CRS500	.5000	.6250	1.375	1.375	.750	.63	.04	1/4-20 x 7/8	5/16-18	1/4-20 x 3/4	3/16

Socket Head Cap Screw & Set Screw included.

Female: **M** H-13 **H** Core: 42-48 HRC, Surface: 70 HRC **S** Black Nitride
Male: **M** DC53 **H** Core: 58-62 HRC, Surface: 80 HRC **S** Titanium Nitride Coated

Metric Standard

CATALOG NUMBER	DM -.002 -.006	DF +.000 -.005	LF +.0 -.1	LM +.0 -.1	PM	E	Z	S1 SHCS SIZE	T	S2 SET SCREW SIZE	H
CRSM06	6	8	16	18	10	8	.3	M3-0.5 x 8	M4-0.7	M4-0.7 x 12	3
CRSM08	8	12	20	24	14	10	.3	M4-0.7 x 10	M5-0.8	M5-0.8 x 16	4
CRSM10	10	14	22	26	14	12	.3	M4-0.7 x 10	M5-0.8	M6-1.0 x 16	5
CRSM12	12	16	30	32	17	15	.5	M6-1.0 x 16	M8-1.25	M6-1.0 x 16	5

Socket Head Cap Screw & Set Screw included.

Front Mount
E PM
S1 SHCS
S2 Set Screw

Back Mount
T Thread
S2 Thread

APPLICATION GUIDELINES

- Interlocks Can be mounted from parting line or bolted from the back of the inserts.
- Vent hole and flat provided on female insert.
- Maximum clearance between female and male insert is .0006" / .015mm total.
- Diameter (DF & DM) Machining Tolerances: Inch: +.0002" / Metric: +.005mm
- Maximum chamfer size should be .02"/.5mm on counterbore.
- The fasteners provided are for parting line installation shown in the graphic above left. For bolting in back, select fasteners to accommodate insert thickness.
- When installing, limit torque specifications according to the chart at right.

CATALOG NUMBER	TORQUE
CRS250 CRSM06	25 IN LB
CRS375	75 IN LB
CRS500	195 IN LB
CRSM08	58 IN LB
CRSM10 CRSM12	140 IN LB

▶ CAD insertion point

ALTERNATIVE CONFIGURATIONS AVAILABLE

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PROGRESSIVE COMPONENTS