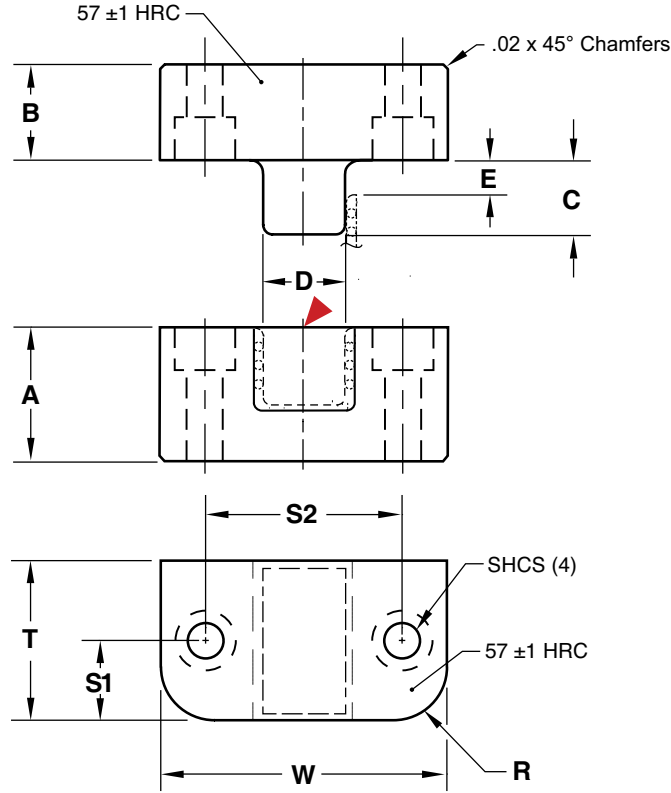


TOP LOCKS  
NEEDLE BEARING



Inch Standard

**M** O-2 **H** 56-58 HRC **S** Black Oxide

CAD insertion point

| CATALOG NUMBER | T<br>+.000<br>-.005 | W<br>+.0004<br>-.0000 | W<br>POCKET<br>WIDTH<br>+.0005<br>-.0000 | A<br>+.000<br>-.005 | B<br>+.000<br>-.005 | C    | D     | E    | S1<br>±.01 | S2<br>±.01 | R<br>POCKET<br>RADIUS | SHCS            |                   |
|----------------|---------------------|-----------------------|--|---------------------|---------------------|------|-------|------|------------|------------|-----------------------|-----------------|-------------------|
| TLR87X150      | .875                | 1.4995                | 1.500                                    | 1.375               | .750                | .66  | .550  | .225 | .43        | 1.14       | .250                  | M: #8-32 x 7/8  | F: #8-32 x 1-1/2  |
| TLR112X200     | 1.125               | 1.9995                | 2.000                                    | 1.375               | .625                | .62  | .660  | .425 | .56        | 1.37       | .375                  | M: 1/4-20 x 3/4 | F: 1/4-20 x 1-1/2 |
| TLR150X250     | 1.500               | 2.4995                | 2.500                                    | 1.375               | .625                | .62  | .900  | .400 | .75        | 1.75       | .375                  | M: 1/4-20 x 3/4 | F: 1/4-20 x 1-1/2 |
| TLR150X250-L   | 1.500               | 2.4995                | 2.500                                    | 1.875               | .875                | 1.02 | 1.015 | .350 | .75        | 1.87       | .375                  | M: 1/4-20 x 1   | F: 1/4-20 x 2     |

Note: Cages are resin on all Needle Bearing Top Locks.

Screws included.

**APPLICATION GUIDELINES**

- Needle Bearing Locks have zero clearance between male and female (D) dimensions.
- Bearings are 64 HRC.
- Maximum Mold Temperature: 300°F (150°C)
- Engagement occurs at E dimension shown.
- Locks are to be mounted in the mold base and not in the core or cavity inserts.
- For optimal performance, pockets are to be machined to nominal “W” pocket width dimensions in each table. If replacing locks in existing pockets, ensure .0004” clearance, and the lock may be modified to suit.
- As with other mold mechanisms, clean and maintain locks at the mold’s scheduled PMs.





## 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.

| RECOMMENDED 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<br>SL50X150, SL50X200<br>SLS62X150, SLS62X200<br>SLR50X125, SLR50X150               | SLM16X50, SLPM16X20<br>SLPM16X40, SLPM20X25<br>SLPM20X50, SLSM13X38<br>SLSM16X50                           | GL100X150<br>GLM25X45              | TL75X75, TLM20X20<br>TL50X100, TL62X125<br>TL75X125, TLM26X35<br>TLR87X150                  | 2,000 / 900                                     |
| <b>11 X 16 X 10</b>                        | SL50X125, SL50X150<br>SL50X200, SLS62X150<br>SLS62X200, SLS75X300<br>SLS75X400, SLR50X150<br>SLR50X200 | SLM16X50, SLSM19X75<br>SLPM25X32, SLPM25X63<br>SLPM32X40, SLPM32X80<br>SLPM40X50, SLPM40X100<br>SLSM19X100 | GL100X150<br>GL150X250<br>GLM25X45 | TL62X125, TL75X125<br>TL100X100, TLM25X25<br>TLM26X35<br>TLR87X150,<br>TLR112X200           | 5,000 / 2,300                                   |
| <b>16 X 24 X 16</b>                        | SL50X150, SL50X200<br>SL75X300, SLS112X500<br>SLS75X300, SLS75X400<br>SLR75X300, SLR100X400            | SLM19X75, SLM19X100<br>SLSM25X125<br>SLPM50X56, SLPM50X112<br>SLRM32X63<br>SLRM40X100                      | GL150X250<br>GLM40X65              | TL75X125, TL87X150<br>TL137X137, TLM32X32<br>TLM26X35, TLM30X45<br>TLR112X200<br>TLR150X250 | 7,000 / 3,200                                   |
| <b>28 X 34 X 24</b>                        | SL75X300, SLS112X500   | SLM19X75, SLM19X100  | GL200X350<br>GL150X250<br>GLM40X65 | TL100X150, TL100X200<br>TL112X200, TL112X300<br>TLM26X35, TLM30X45                          | 10,000 / 4,500                                  |
| <b>32 X 40 X 28</b>                        | SL100X400  | SLM25X125  | GL200X350<br>GLM40X65              | TL112X200, TL112X300<br>TLM36X55, TLM36X75  | 15,000 / 6,800                                  |
| <b>42 X 48 X 34</b>                        | SL125X500  |  | GL250X450<br>GLM50X90              | TL150X250, TL175X300<br>TLM36X55, TLM36X75  | 20,000 / 9,000                                  |
| <b>48 X 52 X 38</b>                        | SL150X600  |  | GL250X450                          | TL175X300, TL200X350<br>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<br>BLG100L2.3, BLG100L2.8             | 2.50                | 10,000 / 4,500                      |
| BLBX137L5               | BLGT137L1.3, BLGT137L1.8                                     | 3.00                |                                     |
| BLB100L6                | BLG100L1.3, BLG100L1.8<br>BLG100L2.3, BLG100L2.8             | 4.50                |                                     |
| BLBT137L6               | BLGT137L1.3, BLGT137L1.8                                     |                     |                                     |
| BLBM25L125              | BLGM25L27, BLGM25L36   | 89mm                |                                     |
| BLB125L5                | BLG125L1.3, BLG125L1.8<br>BLG125L2.3, BLG125L2.8             | 3.00                | 15,000 / 6,800                      |
| BLBX162L6               | BLGT162L1.3, BLGT162L2.3                                     | 3.50                |                                     |
| BLB125L9                | BLG125L1.3, BLG125L1.8<br>BLG125L2.3, BLG125L2.8             | 7.00                |                                     |
| BLBT162L9               | BLGT162L1.3, BLGT162L2.3                                     |                     |                                     |
| BLBM32L160              | BLGM32L36, BLGM32L46   | 114mm               |                                     |
| BLB137L6                | BLG137L1.8, BLG137L2.3<br>BLG137L2.8, BLG137L3.3, BLG137L3.8 | 3.50                | 20,000 / 9,000                      |
| BLBX200L7               | BLGT200L1.8 & BLGT200L2.8                                    | 4.50                |                                     |
| BLB137L11               | BLG137L1.8, BLG137L2.3<br>BLG137L2.8, BLG137L3.3, BLG137L3.8 | 8.50                |                                     |
| BLBT200L11              | BLGT200L1.8 & BLGT200L2.8                                    |                     |                                     |
| BLBM38L250              | BLGM38L46, BLGM38L76   | 194 mm              |                                     |
| BLB150L8                | BLG150L1.8, BLG150L2.3                                       | 4.50                | 26,000 / 11,800                     |
| BLB150L16               | BLG150L2.8, BLG150L3.3, BLG150L3.8                           | 12.50               |                                     |
| BLN150L8                | BLG150L1.8, BLG150L2.3<br>BLG150L2.8, BLG150L3.3, BLG150L3.8 | 3.75                |                                     |
| BLN250L10               | BLG250L4.3   | 5.00                |                                     |
| BLN350L13               | BLG350L4.8   | 6.00                |                                     |