

Tie Bar Stretch

IntElect			
Machine Size	Tie Bar Stretch	Variation in Stretch Between Tie Bars	Mold Block Thickness
50	.013 - .015	.001	8.125
80	.017 - .019	.001	8.125
110	.021 - .025	.002	8.125
165	.028 - .032	.002	10.25
220	.034 - .038	.002	10.25
280	.039 - .043	.002	12.375
385	.041 - .045	.003	17.00
HT Machines			
Machine Size	Tie Bar Stretch	Variation in Stretch Between Tie Bars	Lock-up Pressure
85	.014 - .018	.002	1600
120	.017 - .021	.002	1700
170	.020 - .024	.002	1500
230	.024 - .028	.002	1800
300	.030 - .034	.002	1550
400	.031 - .035	.003	1850
500	.037 - .041	.003	1750
650	.041 - .045	.003	2000