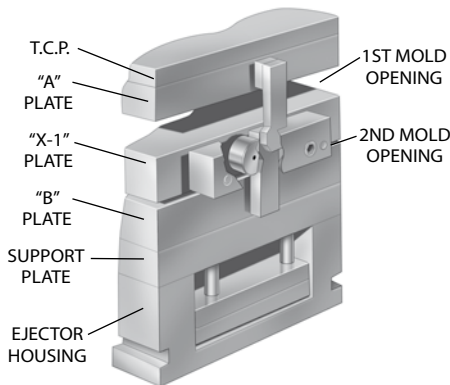


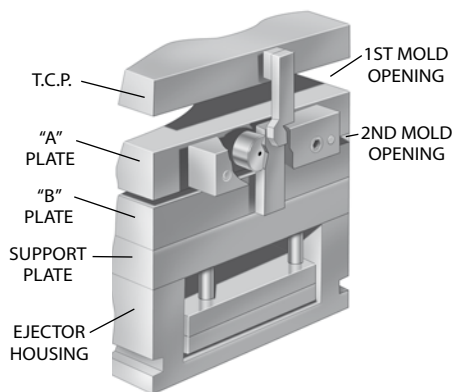
1. To control stripper plate.

Cycle time is often wasted waiting for the press knock-out bar to function. With the application of the **DME** Jiffy Latch-Lok, as illustrated to the left, the stripper plate is moved in a secondary action of the mold opening without the aid of the press knock-out bar. The Jiffy Latch-Lok permits you to shorten the ejection stroke, improve cycle time and increase the number of parts per shift.



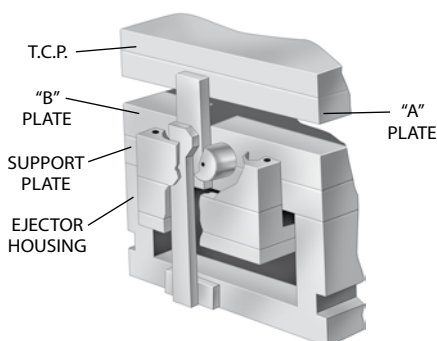
2. To float X-plate away from A-plate while locking X- and B- plates.

In this application of the Jiffy Latch-Lok, the "X-1" plate is floated away from the "A" plate in the first mold opening sequence. At a predetermined opening (you determine the distance) the "X-1" plate is released from the "B" plate for the second mold opening. This application of the Jiffy Latch-Lok is particularly effective on "AX" or three-plate top runner molds.



3. To float A-plate away from top clamping plate while locking A- and B-plates.

In the **DME** Latch-Lok application illustrated here, the "A" plate moves away from the top clamp plate in the first mold opening. During this portion of the cycle, the "A" and "B" plates are locked. As the release bar passes the rocker, the "A" and "B" plates part in the second mold opening.



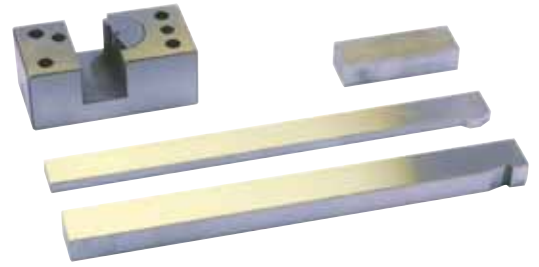
4. Actuation of ejector assembly without aid of press knock-out bar.

For those mold applications where a shorter press stroke is required, the **DME** Jiffy Latch-Lok is extremely effective. You can activate the Jiffy Latch-Lok at any time after the mold begins to open, and pull the ejector assembly forward. This simple action shortens cycle time and increases part production.

Jiffy Latch Lock

LL

REF	W = MOLD WIDTH
LL 051 E	W ≤ 200
LL 101 E	200 < W < 400
LL 151	200 < W < 400
LL 201	W > 400

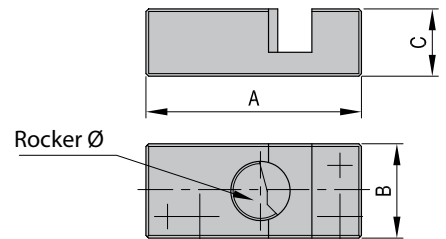


Body

LL

A	B	C	Rocker Ø	Spring	For REF
80,0	35,0	25,0	LL 052 E: 22	LL 059 E	LL 051 E
127,0	47,0	37,0	LL 102 E: 32	LL 109 E	LL 101 E
127,0	49,2	36,5	LL 102: 31,2	LL 109	LL 151
152,5	74,6	61,9	LL 202: 50,2	LL 209	LL 201

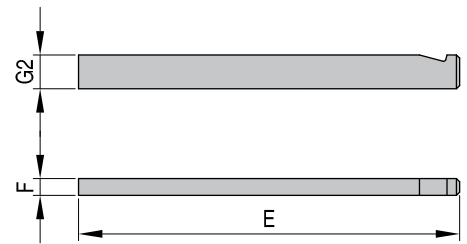
Body



Latch bar

LL

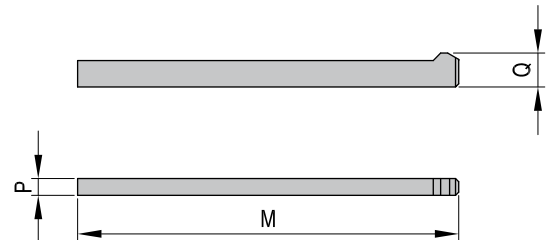
REF	E	F	G2	For REF
LL 053 E	180	7,9	16,0	LL 051 E
LL 103 E	254	11,9	24,0	LL 101 E
LL 153	254	12,1	24,8	LL 151
LL 203	406	24,8	37,5	LL 201



Release bar

LL

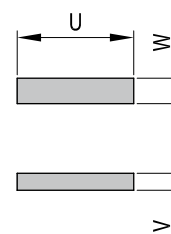
REF	M	P	Q	For REF
LL 054 E	180	7,9	16,0	LL 051 E
LL 104 E	254	9,9	24,0	LL 101 E
LL 104	254	9,0	24,8	LL 151
LL 204	406	12,1	37,5	LL 201



Spacer

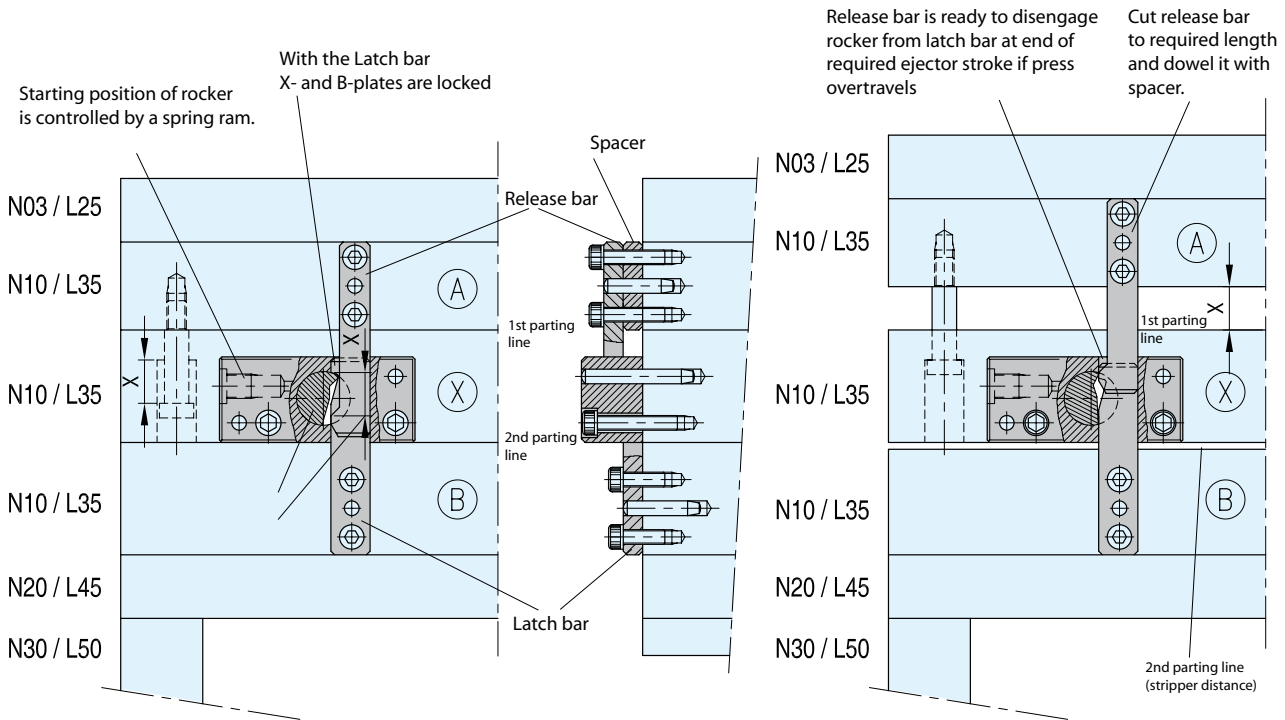
LL

REF	U	V	W	For REF
LL 056 E	55,0	8,0	12,0	LL 051 E
LL 106 E	75,0	12,0	20,0	LL 101 E
LL 106	76,2	12,4	22,2	LL 151
LL 206	114,3	25,3	38,1	LL 201





Installation instructions LL-051 / LL-101 / LL-201



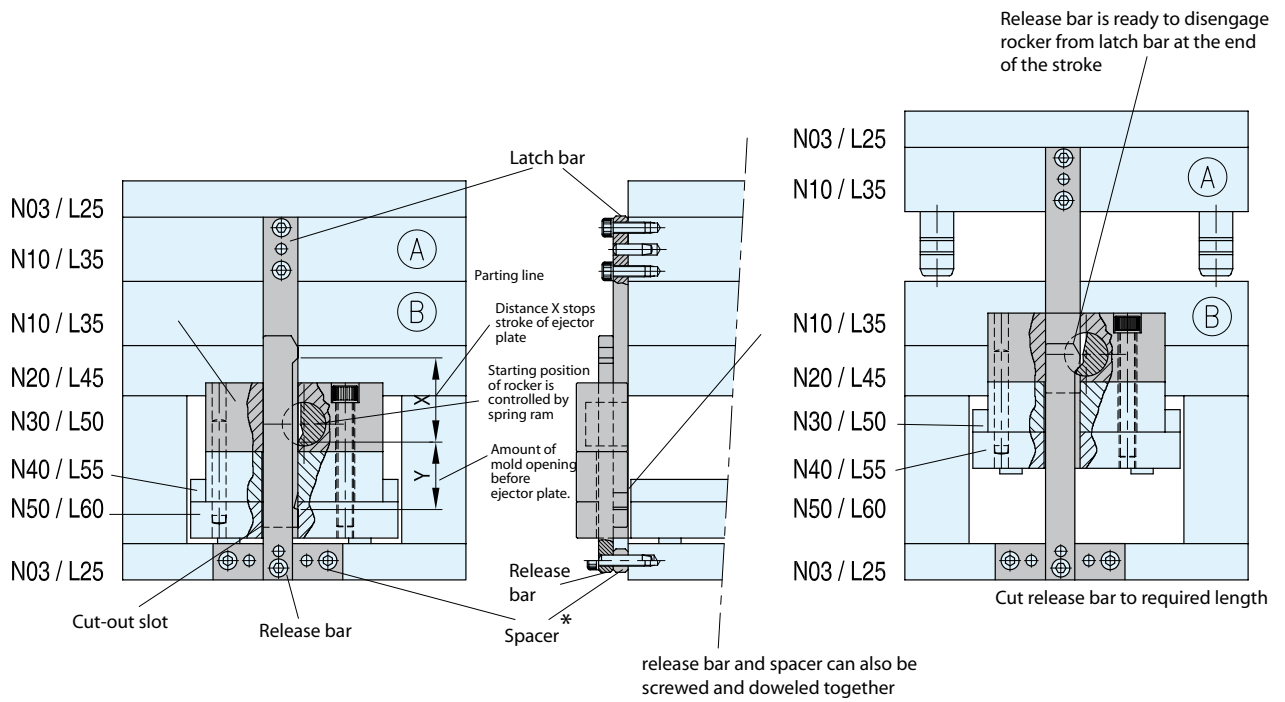
For one mold at least 2 Latch-loks are required, which are respectively mounted at outer surfaces (center of the mold). Body must be parallel screwed and doweled at the molding plate. Latch and release bars must be screwed at 90° to the parting line (Slotted holes facilitate final adjustment). The bars have to slide properly in the body.

Adjustment:

Both Latch-loks must be accurately adjusted. Inaccuracies can lead to canting of stripper plates and to breaking of the bars. Latch bars and release bars must be preset when the mold is closed. Open mold and check motion sequence of bars and stripper plate. Fine tuning is necessary. Repeat this procedure until both Latch-loks work together exactly. Then latch bar and release bar can be doweled. Before and during operation apply to all moving parts of the Latch-lok C 168 type grease.



Installation instructions LL-151



With Latch-lok LL-151 especially the ejector plate is moved, ejector plate (N 50) has to overhang enough, so that body and, if necessary spacer* could be mounted. Body and spacer are to be screwed and doweled with N 50. Machine cut-out slot for bars in spacer* and overhanging ejector plates. All other installation instructions as described on LL-051, LL-101 and LL-201.