

Benefits and Selection Table

D-M-E's Internal Latch Lock Allows Precision Control of Mold Plate Latching Operation

D-M-E's unique internally-mounted latch lock mechanism adapts to a number of mold base sizes and plate thicknesses. It is available in three sizes to accommodate most standard D-M-E stripper plate mold bases. Two travel ranges and two center puller pin lengths are available for each of the three latch lock sizes. Once installed, D-M-E's internal latch locks control the sequence of one parting line opening after the first parting line has traveled a predetermined distance. After installation there are no adjustments that can be accidentally changed. The internal latch locks are most commonly used on D-M-E AX-Series stripper plate mold bases but can be used on other D-M-E stripper plate mold bases as well.



U.S. Patent No. 5,494,435

D-M-E's internal latch lock allows control of the mold plate opening sequence on mold bases with stripper plates. It enables one plate or group of plates to be latched together while the first parting line opening occurs. Then, after a predetermined amount of travel, the latch lock releases the latched plate or group of plates for the remaining parting line or parting lines to open.

- Three diameter sizes to choose from – 28mm, 34mm, and 45mm – depending on the size of the mold and the application
- Two travel ranges and two center puller pin lengths to choose from for each of the three sizes
- Hardened steel components for longer life
- Latching mechanism has built-in travel limitation
- When latch is released, latching cams hold released stripper plate in fully traveled position
- Easy set-up of timing for latching mechanism
- Internal installation avoids interferences with water line connectors and externally mounted components

Basic Latch Size	Internal Latch Lock Assembly Item Number	"T" Travel Range				Center Puller Pin Length Options		Recommended Maximum Standard D-M-E Mold Base Width	Maximum Recommended Load Values (Per Ass'y.)	
		Minimum		Maximum		mm	in		Static	Dynamic
		mm	in	mm	in	mm	in			
28mm DIA (Small)	DKL-2811	5	.197	30	1.181	140	5.512	11-7/8 in	10 kN	100 kg
	DKL-2812					250	9.843			
	DKL-2821	30	1.181	55	2.165	140	5.512			
	DKL-2822					250	9.843			
34mm DIA (Medium)	DKL-3411	6	.236	41	1.614	160	6.299	16-1/2 in	20 kN	200 kg
	DKL-3412					280	11.024			
	DKL-3421	41	1.614	76	2.992	160	6.299			
	DKL-3422					280	11.024			
45mm DIA (Large)	DKL-4511	12	.472	58	2.283	200	7.874	23-3/4 in	30 kN	380 kg
	DKL-4512					310	12.205			
	DKL-4521	58	2.283	104	4.094	200	7.874			
	DKL-4522					310	12.205			

See page 111 for information regarding an additional option that provides guided ejection and return of the ejector assembly with guided ejection and return sleeves.

Supplied to provide maximum travel with no cutoff. To reduce travel between maximum and minimum, cut off slotted travel limiting sleeve on threaded end only per installation data.

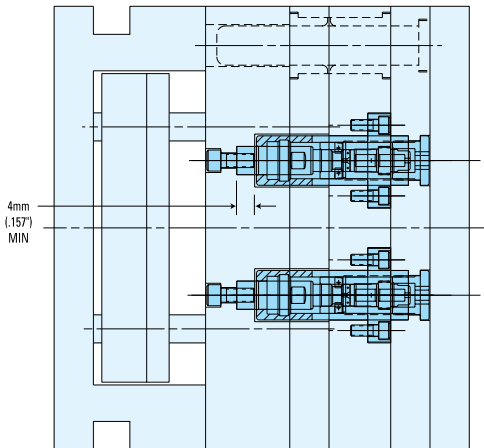
Center puller pin length ordered must be slightly longer than application requires. Moldmaker then cuts off as required. See installation data.

A minimum of four assemblies are recommended per mold. However, for larger molds, thick plates, or an application where loads are near maximum, additional assemblies and/or next largest size assemblies may be required. An application must never exceed the maximum recommended load values. A balanced load must be maintained to avoid cocking and binding, which could cause severe overloading. Only one size latch lock assembly should be used in each mold base.

Typical Application Design Guidelines

Basic Selection and Application Design Guidelines

1. Select the appropriate internal latch lock size – 28mm diameter (small), 34mm diameter (medium), or 45mm diameter (large) based on the width of the mold base, as indicated in the chart on page 105. However, large molds, thick plates or heavy load applications may require the next largest size assembly than is specified.
2. Select the appropriate travel range from the two choices for each size in the table on page 105. This selection is based on the specific application requirements for the amount of travel that must occur at one parting line prior to the latch being released. The total travel requirements are based on the amount needed for the application as explained above, plus 3mm (.12") minimum additional allowance. This added 3mm minimum will make sure the full required travel has occurred before the latch lock starts its releasing action.
3. Select the appropriate length for the center puller pin from the two choices for each size in the chart. The length of the pin is determined by the specific application including the mold base plate thicknesses, where the pin will be mounted, etc. If possible, the center puller pin should be mounted in the support plate. However, some applications require the center puller pin to be mounted in the bottom clamping plate. This will depend on the travel or the length of the split sleeve component which controls the travel and the plate thicknesses in the mold base.
4. The answers to the above items (1-3) should establish a specific item number assembly from the table on page 105.
5. A minimum of four assemblies are recommended per mold. However, for larger molds, thick plates, or an application where loads are near maximum, additional assemblies and/or next largest size assemblies may be required. An application must never exceed the maximum recommended load values. A balanced load must be maintained to avoid cocking and binding which could cause severe overloading. Only one size latch lock assembly should be used in each mold base.
6. The center puller pin should be counterbored into its mounting plate 4mm (.157") minimum for most applications, as shown in the drawings at right. This counterbore aligns the center puller pin with the other components in the assembly.

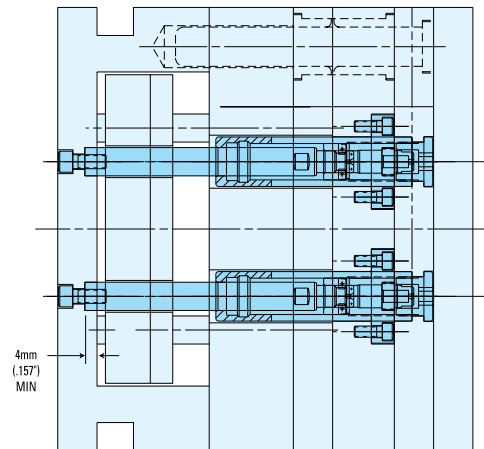


Internal latch lock application with center puller pins mounted in the support plate. This is typically done in applications where the travel is shorter and/or when mold plates are thicker. D-M-E AX-Series mold base is shown in this typical application.



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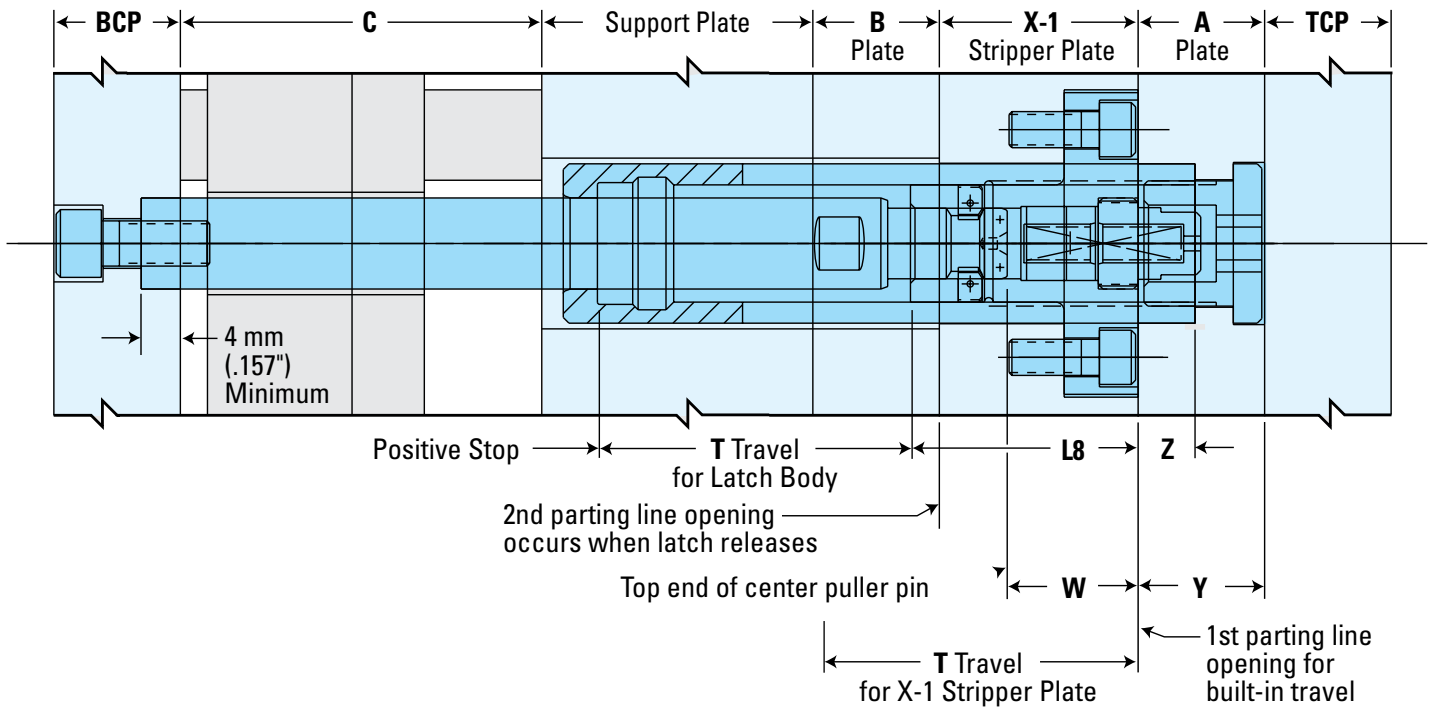
7. The most common applications for the latch locks are for the D-M-E AX-Series stripper plate mold bases. However, many other types of stripper plate mold bases can also be used with this internal plate latching mechanism. It is important to make sure that the leader pin lengths in all applications are long enough to fully engage the stripper plate through its full travel. The latch lock mechanism latches two plates together but is not intended to provide guidance. Instead, it relies on the leader pins in the mold for proper alignment and support of the actuated stripper plates.
8. In the fully latched position the internal latch lock mechanism will allow movement of approximately 0.4mm (.016") for the 28mm diameter and 34mm diameter assemblies and approximately 0.5mm (.020") for the 45mm diameter assemblies.
9. Injection molding machine mold opening speed may have to be reduced in order to make sure that excessive shock loading does not occur.
10. The internal latch lock is not recommended for severe load applications.
11. The internal latch lock must not be exposed to temperatures that exceed 150°C (300°F) at any time.
12. Lubricate all metal-to-metal contact areas initially and periodically as required. A good grade of moldmakers non-melting type grease for the appropriate temperature should be used.
13. An optional sleeve can be added to the latch lock that provides two additional functions. However, this optional sleeve is not required for the latch lock function. The optional sleeve can be added to incorporate guided ejection and/or normal ejector assembly return functions in the mold. Refer to page 111 for specific information regarding this sleeve option.



Internal latch lock application with center puller pin mounted in the bottom clamping plate. This is typically done in applications where the travel is longer and/or when mold plates are thinner. (Some applications may require a thicker than standard bottom clamping plate.) D-M-E AX-Series mold base is shown in this typical application.

Set-Up Dimensional Information

D-M-E AX-Series stripper plate mold base is shown



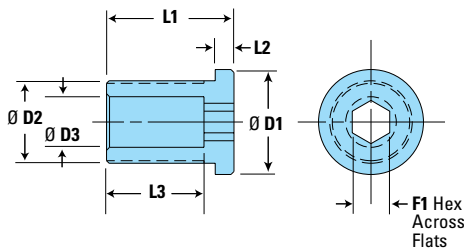
IMPORTANT SET-UP DIMENSIONS (Refer to Drawing Above)

Basic Latch Size	Internal Latch Lock Assembly Item Number	"T" ⁽¹⁾ Travel Range				L8 Body for Cam Fingers Length Dimension		W ⁽²⁾ Center Puller Pin Set-Up Dimensions		Y ⁽³⁾ Mounting Plate Thickness Range		Z ⁽⁴⁾ C'Bore Depth in Mounting Plate	
		Minimum		Maximum		mm	in	mm	in	mm	in	mm	in
		mm	in	mm	in								
28mm DIA (Small)	DKL-2811	5	.197	30	1.181	40	1.575	0.1	.004	22	.866	+0.04 -0	+0.016 -.0000
	DKL-2812			55	2.165								
	DKL-2821	30	1.181	55	2.165			35	1.378				
	DKL-2822									55	2.165		
34mm DIA (Medium)	DKL-3411	6	.236	41	1.614	51	2.008	0.1	.004	27	1.063	+0.04 -0	+0.016 -.0000
	DKL-3412			76	2.992								
	DKL-3421	41	1.614	76	2.992			47.6	1.875				
	DKL-3422									76	2.992		
45mm DIA (Large)	DKL-4511	12	.472	58	2.283	68	2.677	0.1	.004	35	1.375	+0.04 -0	+0.016 -.0000
	DKL-4512			104	4.094								
	DKL-4521	58	2.283	104	4.094			60	2.375				
	DKL-4522									104	4.094		

- (1) Supplied to provide maximum travel with no cutoff. To reduce travel between maximum and minimum, cut off slotted travel limiting sleeve on threaded end only per installation data. Cut off to no less than minimum travel; maintain close tolerances per installation data.
- (2) This set-up dimension is critical and must be maintained as specified to properly locate pin and cam body to latch. Dimension W is from top of X-1 stripper plate to top end of center puller pin. See installation data for additional information.
- (3) "Y" mounting plate dimension will be the "A" plate for AX-Series stripper plate mold bases.
- (4) This counterbore depth is critical and must be maintained as specified to locate split sleeve, cam body, and pin to latch.

Component Dimensional Information

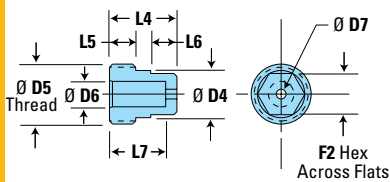
Assembly Retaining Screw



Basic Latch Size	Internal Latch Lock Assembly Item Number	ASSEMBLY RETAINING SCREW								
		Component Item No	D1 DIA	D2 Thread	D3 DIA	L1 Length	L2 Length	L3 Length	F1 Hex Across Flats	
28mm DIA (Small)	DKL-2811, DKL-2812, DKL-2821 & DKL-2822	DKL-2011	28	M22x1.25	13.5	34	5	26	10	mm
			1.102	None	.531	1.339	.197	1.024	.394	in
34mm DIA (Medium)	DKL-3411, DKL-3412, DKL-3421 & DKL-3422	DKL-3011	33	M26x1.5	16	46	6	35	12	mm
			1.299	None	.630	1.811	.236	1.378	.472	in
45mm DIA (Large)	DKL-4511, DKL-4512, DKL-4521 & DKL-4522	DKL-4011	42	M34x1.5	18.4	59	10	42	14	mm
			1.654	None	.724	2.323	.394	1.654	.551	in

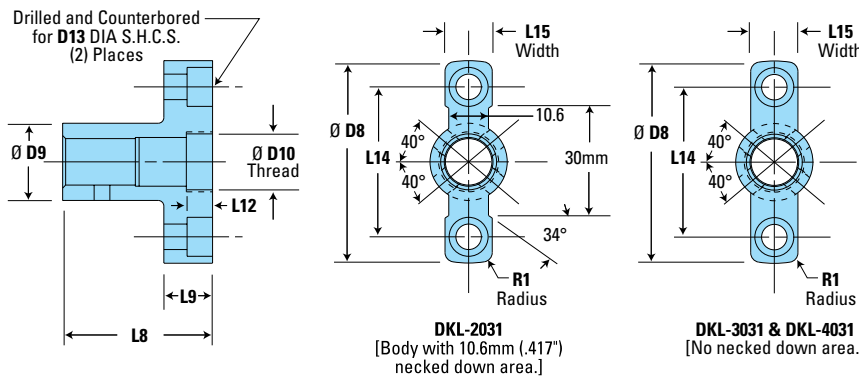
Cut-off length on thread end only per installation data ←

Spring Retainer



Basic Latch Size	Internal Latch Lock Assembly Item Number	Component Item No	SPRING RETAINER									
			D4 DIA	D5 Thread	D6 DIA	D7 DIA	L4 Length	L5 Length	L6 Length	L7 Length	F2 HEX. Across Flats	
28mm DIA (Small)	DKL-2811, DKL-2812, DKL-2821 & DKL-2822	DKL-2021	12.6	M16x1	6.8	2.6	18	7	7	15	11	mm
			.496	None	.268	.102	.709	.276	.276	.591	.433	in
34mm DIA (Medium)	DKL-3411, DKL-3412, DKL-3421 & DKL-3422	DKL-3021	15	M19x1	8.3	3	21	8	8	17	13	mm
			.591	None	.327	.118	.827	.315	.315	.669	.512	in
45mm DIA (Large)	DKL-4511, DKL-4512, DKL-4521 & DKL-4522	DKL-4021	17.2	M24x1	10	3.5	25	10	9	21	15	mm
			.677	None	.394	.138	.984	.394	.354	.827	.591	in

Body for Cam Fingers (Body Only Without Cam Fingers)



Basic Latch Size	Internal Latch Lock Assembly Item Number	Component Item No	BODY FOR CAM FINGERS											Mounting Holes & D13 SHCS			
			D8 DIA	D9 DIA	D10 Thread	L8 Length	L9 Length	L12 Length	L14 Length	L15 Width	R1 Radius	Drill DIA	C'Bore DIA	C'Bore Depth	D13 SHCS		
28mm DIA (Small)	DKL-2811, DKL-2812, DKL-2821 & DKL-2822	DKL-2031	54	20.6	M16x1	40	13	7	40	12.6	2.5	6.8	10.4	6.8	M6x1	mm	
			2.126	.811	None	1.575	.512	.276	1.575	.496	.098	.268	.409	.268	1/4-20	in	
34mm DIA (Medium)	DKL-3411, DKL-3412, DKL-3421 & DKL-3422	DKL-3031	60	24.4	M19x1	51	15	8	46	12.6	2.5	6.8	10.4	6.8	M6x1	mm	
			2.362	.961	None	2.008	.591	.315	1.811	.496	.098	.268	.409	.268	1/4-20	in	
45mm DIA (Large)	DKL-4511, DKL-4512, DKL-4521 & DKL-4522	DKL-4031	78	32.4	M24x1	68	20	10	60	17	4	8.4	13.7	8.5	M8x1.25	mm	
			3.071	1.276	None	2.677	.787	.394	2.362	.669	.157	.331	.539	.335	5/16-18	in	

Do not alter body in any way ←

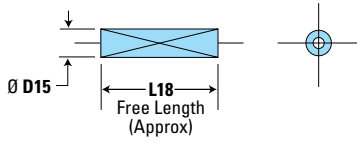
Use either metric or inch socket head cap screws ←

NOTE:

All dimensions shown for components are intended for drawing layout purposes only and in some cases have been rounded off. These dimensions are not intended to be used for the manufacturing of any components. Also, where the same diameter dimension is shown for parts that fit together, the tolerances create the appropriate clearance or fit.

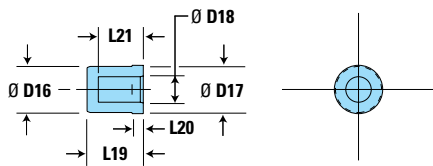
Component Dimensional Information

Spring for Holding Pin



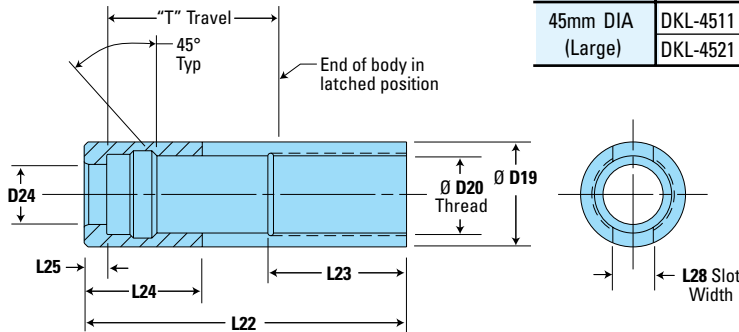
Basic Latch Size	Internal Latch Lock Assembly Item Number	SPRING FOR HOLDING PIN			
		Component Item No	D15 DIA	L18 Free Length	
28mm DIA (Small)	DKL-2811, DKL-2812, DKL-2821 & DKL-2822	DKL-2041	6.5	56	mm
			.256	2.20	in
34mm DIA (Medium)	DKL-3411, DKL-3412, DKL-3421 & DKL-3422	DKL-3041	8	70	mm
			.315	2.76	in
45mm DIA (Large)	DKL-4511, DKL-4512, DKL-4521 & DKL-4522	DKL-4041	9.7	90	mm
			.382	3.54	in

Holding Pin for Cams



Basic Latch Size	Internal Latch Lock Assembly Item Number	HOLDING PIN FOR CAMS							
		Component Item No	D16 DIA	D17 DIA	D18 DIA	L19 Length	L20 Length	L21 Length	
28mm DIA (Small)	DKL-2811, DKL-2812, DKL-2821 & DKL-2822	DKL-2051	12.3	12.9	6.8	15	3	12	mm
			.484	.508	.268	.591	.118	.472	in
34mm DIA (Medium)	DKL-3411, DKL-3412, DKL-3421 & DKL-3422	DKL-3051	14.4	15.4	8.3	23	5	19.5	mm
			.567	.606	.327	.906	.197	.768	in
45mm DIA (Large)	DKL-4511, DKL-4512, DKL-4521 & DKL-4522	DKL-4051	19.4	20.4	10	32	7	28	mm
			.764	.803	.394	1.260	.276	1.102	in

Slotted Travel Limiting Sleeve



Basic Latch Size	Internal Latch Lock Assembly Item Number	Component Item No	"T" Travel Range - Minimum to Maximum		L22 Length	
			mm	in	mm	in
28mm DIA (Small)	DKL-2811 & DKL-2812 DKL-2821 & DKL-2822	DKL-2071 DKL-2072	5 to 30	.197 to 1.181	86	3.386
			30 to 55	1.181 to 2.165	111	4.370
34mm DIA (Medium)	DKL-3411 & DKL-3412 DKL-3421 & DKL-3422	DKL-3071 DKL-3072	6 to 41	.236 to 1.614	111	4.370
			41 to 76	1.614 to 2.992	146	5.748
45mm DIA (Large)	DKL-4511 & DKL-4512 DKL-4521 & DKL-4522	DKL-4071 DKL-4072	12 to 58	.472 to 2.283	152	5.984
			58 to 104	2.283 to 4.094	198	7.795

Supplied to provide maximum travel with no cutoff. To reduce travel between maximum and minimum, cut off on threaded end only per installation data.

Basic Latch Size	Internal Latch Lock Assembly Item Number	Component Item No	SLOTTED TRAVEL LIMITING SLEEVE							
			D19 DIA	D20 DIA Thread	D24 DIA	L23 Length	L24 Length	L25 Length	L28 Slot	
28mm DIA (Small)	DKL-2811, DKL-2812, DKL-2821 & DKL-2822	DKL-2071 &	28	M22x1.25	16	37	31.5	6	10.8	mm
		DKL-2072	1.1024	None	.630	1.457	1.240	.236	.425	in
34mm DIA (Medium)	DKL-3411, DKL-3412, DKL-3421 & DKL-3422	DKL-3071 &	34	M26x1.5	19	49	41	7	12.8	mm
		DKL-3072	1.3386	None	.748	1.929	1.614	.276	.504	in
45mm DIA (Large)	DKL-4511, DKL-4512, DKL-4521 & DKL-4522	DKL-4071 &	45	M34x1.5	26	65	56	10	17.3	mm
		DKL-4072	1.7717	None	1.024	2.559	2.205	.394	.681	in

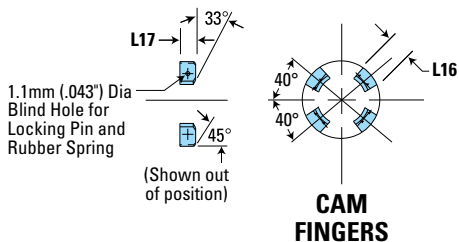
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Component Dimensional Information

Cam Finger Replacement Kit

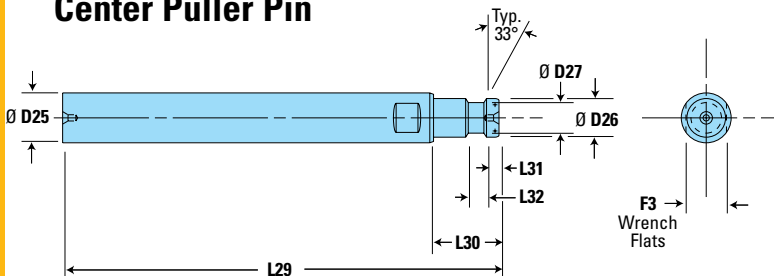
With (4) Cam Fingers, (6) Locking Pins, and (6) Rubber Springs*



Basic Latch Size	Internal Latch Lock Assembly Item Number	CAM FINGER REPLACEMENT KIT			
		Component Set Item No	L16 Width	L17 Thick	
28mm DIA (Small)	DKL-2811, DKL-2812, DKL-2821 & DKL-2822	DKL-2062	5.8	4.2	mm
			.228	.165	in
34mm DIA (Medium)	DKL-3411, DKL-3412, DKL-3421 & DKL-3422	DKL-3062	7.2	4.8	mm
			.283	.189	in
45mm DIA (Large)	DKL-4511, DKL-4512, DKL-4521 & DKL-4522	DKL-4062	9	6	mm
			.354	.236	in

*Two extra locking pins and rubber springs are included.

Center Puller Pin



Basic Latch Size	Internal Latch Lock Assembly Item Number	Component Item No	CENTER PULLER PIN	
			L29 Length mm	L29 Length in
28mm DIA (Small)	DKL-2811 & DKL-2821	DKL-2081	140	5.512
	DKL-2812 & DKL-2822	DKL-2082	250	9.843
34mm DIA (Medium)	DKL-3411 & DKL-3421	DKL-3081	160	6.299
	DKL-3412 & DKL-3422	DKL-3082	280	11.024
45mm DIA (Large)	DKL-4511 & DKL-4521	DKL-4081	200	7.874
	DKL-4512 & DKL-4522	DKL-4082	310	12.205

Cutoff on large diameter end only per installation data

NOTE:

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Basic Latch Size	Internal Latch Lock Assembly Item Number	Component Item No	CENTER PULLER PIN							D28 Tap - Rec.	
			D25 DIA	D26 DIA	D27 DIA	L30 Length	L31 Length	L32 Length	F3 Across Flats		
28mm DIA (Small)	DKL-2811, DKL-2812, DKL-2821 & DKL-2822	DKL-2081 & DKL-2082	16	12.4	9.8	21	4	6.7	13	M8x1.25	mm
			.6299	.488	.386	.827	.157	.264	.512	5/16-18	in
34mm DIA (Medium)	DKL-3411, DKL-3412, DKL-3421 & DKL-3422	DKL-3081 & DKL-3082	19	14.5	11.7	24	4.6	7.6	15	M10x1.5	mm
			.7480	.571	.461	.945	.181	.299	.591	3/8-16	in
45mm DIA (Large)	DKL-4511, DKL-4512, DKL-4521 & DKL-4522	DKL-4081 & DKL-4082	26	19.5	15.9	31	5.5	9.5	22	M12x1.75	mm
			1.0236	.768	.626	1.220	.217	.374	.866	1/2-13	in

Use either metric or inch tap and socket head cap screw (tap after pin cutoff)

Replacement Components

Basic Latch Size	Internal Latch Lock Assembly Item No.	Center Puller Pin		Slotted Travel Limiting Sleeve		Component Item Numbers								
		Component Item No	L17 Length mm	L17 Length in	Component Item No.	"T" Travel Range mm	"T" Travel Range in	Assembly Retaining Screw	Spring Retainer	Body for Cam Fingers Without Cam Fingers	Body for Cam Fingers With (4) Cam Fingers	Cam Finger Replacement Kit	Spring for Holding Pin	Holding Pin for Cams
28mm DIA (Small)	DKL-2811	DKL-2081	140	5.512	DKL-2071	5 to 30	.197 to 1.181	DKL-2011	DKL-2021	DKL-2031	DKL-2032	DKL-2062	DKL-2041	DKL-2051
	DKL-2812	DKL-2082	250	9.843		30 to 55	1.181 to 2.165							
	DKL-2821	DKL-2081	140	5.512		6 to 41	.236 to 1.614							
	DKL-2822	DKL-2082	250	9.843		41 to 76	1.614 to 2.992							
34mm DIA (Medium)	DKL-3411	DKL-3081	160	6.299	DKL-3071	6 to 41	.236 to 1.614	DKL-3011	DKL-3021	DKL-3031	DKL-3032	DKL-3062	DKL-3041	DKL-3051
	DKL-3412	DKL-3082	280	11.024		12 to 58	.472 to 2.283							
	DKL-3421	DKL-3081	160	6.299		58 to 104	2.283 to 4.094							
	DKL-3422	DKL-3082	280	11.024										
45mm DIA (Large)	DKL-4511	DKL-4081	200	7.874	DKL-4071	12 to 58	.472 to 2.283	DKL-4011	DKL-4021	DKL-4031	DKL-4032	DKL-4062	DKL-4041	DKL-4051
	DKL-4512	DKL-4082	310	12.205										
	DKL-4521	DKL-4081	200	7.874										
	DKL-4522	DKL-4082	310	12.205										

Body for Cam Fingers with Cam Fingers installed includes: (1) body, (4) cam fingers, (4) locking pins, and (4) rubber springs

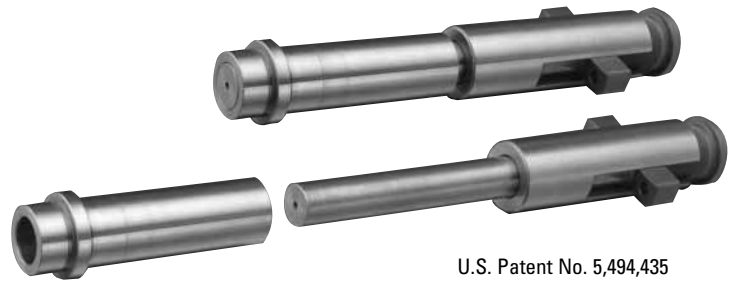
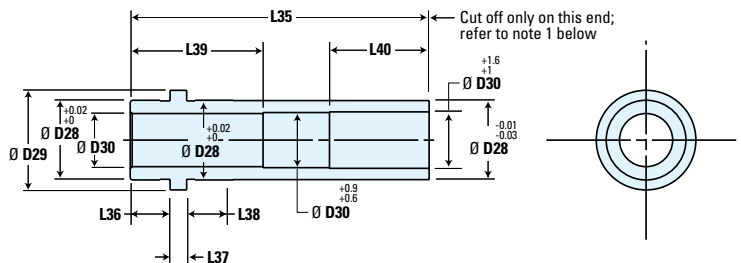
Cam Finger Replacement Kit includes: (4) cam fingers, (6) locking pins, and (6) rubber springs (two extra locking pins and rubber springs are included).

Optional Guided Ejection and Return Sleeves

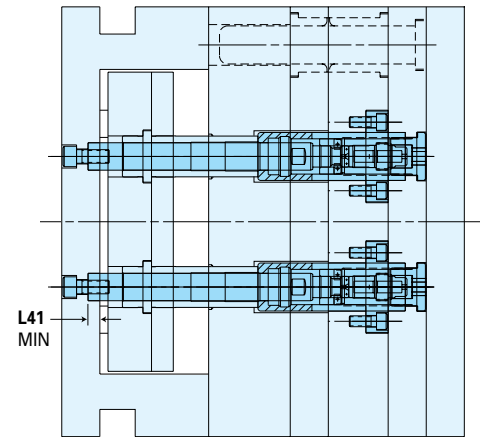
Add Guided Ejection and Return Pin Functions to Internal Latch Lock Mechanism with the Optional Sleeve

The optional Guided Ejection and Return Sleeves, although not required for the Internal Latch Lock, can add two functions to the mold base that are typically required in most molds. These optional sleeves can add guided ejection and ejector assembly return functions to the mold base. Additionally, these added functions fall within the space requirements of the plate latching mechanism. However, these optional sleeves do not create an early ejection return system that is occasionally required in some applications.

- Sleeves can add guided ejection function to mold base along with plate latching mechanism
- Sleeves can replace function of return pins in mold base for most applications using the plate latching mechanism
- Sleeves fit around the center puller pin of the plate latching mechanism and are mounted in the ejector assembly, thus eliminating the need for additional mold space usually required for the guided ejection and return pin functions



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Basic Latch Size	Internal Latch Lock Assembly Item Number	Component Item No	OPTIONAL SLEEVES – GUIDED EJECTION AND RETURN SLEEVE DIMENSIONS																			
			L35 Length		D28 DIA		D29 DIA		D30 DIA		L36 Length		L37 Thickness		L38 Length		L39 Length		L40 Length		L41 Min	
			mm	in	mm	in	mm	in	mm	in	mm	in	mm	in	mm	in	mm	in	mm	in	mm	in
28mm DIA (Small)	DKL-2811, DKL-2812, DKL-2821 & DKL-2822	DKL-2101	90	3.543	24	.9449	30	1.181	16	.630	12	.472	5	.197	14	.55	40	1.57	30	1.18	12	.472
		DKL-2102	140	5.512																		
34mm DIA (Medium)	DKL-3411, DKL-3412, DKL-3421 & DKL-3422	DKL-3101	110	4.331	28	1.1024	35	1.378	19	.748	14	.551	6	.236	16	.63	50	1.97	35	1.38	15	.591
		DKL-3102	160	6.299																		
45mm DIA (Large)	DKL-4511, DKL-4512, DKL-4521 & DKL-4522	DKL-4101	140	5.512	38	1.4961	46	1.811	26	1.024	18	.709	8	.315	20	.79	70	2.76	40	1.57	20	.787
		DKL-4102	200	7.874																		

NOTES:

1. Choose the appropriate length sleeve so that it can be cut off to a length that will fully return the ejector assembly. See installation data.
2. The center puller pins must support and guide the sleeves, as well as the ejector assembly. The pins must have sufficient bearing surface contact as specified by dimension "L41" minimum.
3. Additional bearing surface contact for the center puller pins may require a thicker bottom clamping plate or the addition of another plate to the bottom of the mold for some applications. See installation data.
4. A minimum of four assemblies are typically recommended per mold. However, for larger molds, thick plates, or an application where loads are near maximum, additional assemblies and/or next largest size assemblies may be required. An application must never exceed the maximum recommended load values. A balanced load must be maintained to avoid cocking and binding which could cause severe overloading. Only one size latch lock assembly should be used in each mold base.