

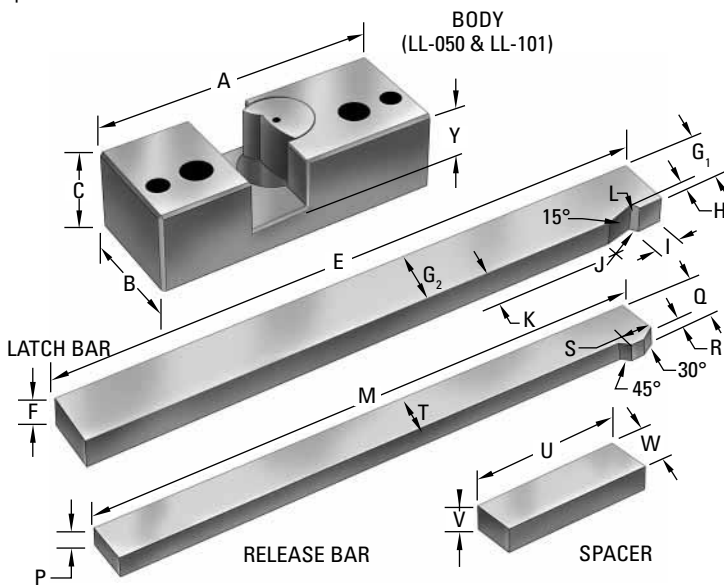
Jiffy Latch-Lok™ Assemblies – General Information

A Simple, Easy-to-Install Device to Mechanically Float Plates

The D-M-E Jiffy Latch-Lok™ provides new freedom in design to mechanically float plates. There is no need for electric switches, pneumatic controls or timing devices with delicate adjustments. The action of the Jiffy Latch-Lok is positive.

Once properly installed, the Latch-Lok eliminates the possibility of smashing the mold because there are no adjustments that can change, or connections that can be accidentally knocked off. The Jiffy Latch-Lok is available in sizes for regular or heavy-duty operation. It also comes in regular or 90° (right angle) designs to provide maximum installation flexibility.

A minimum of four assemblies required per mold. Large molds may require additional assemblies.

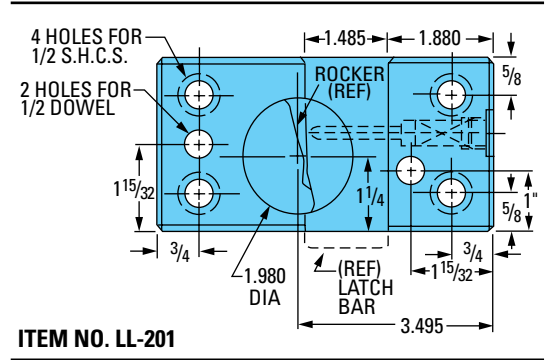
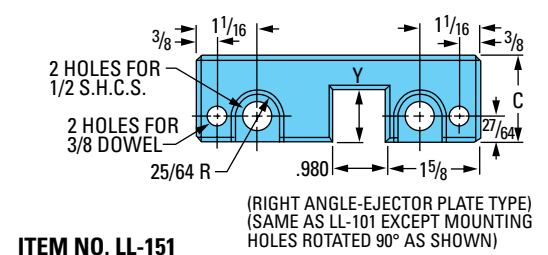
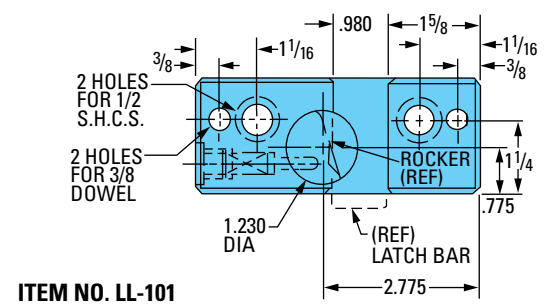
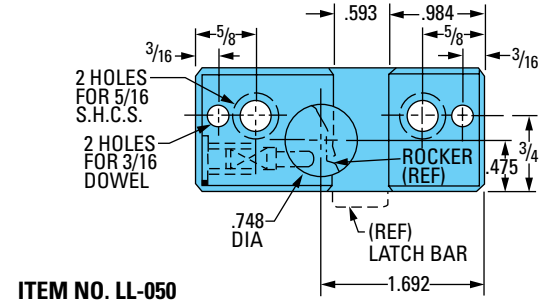


U.S. Patent No. 3,706,116

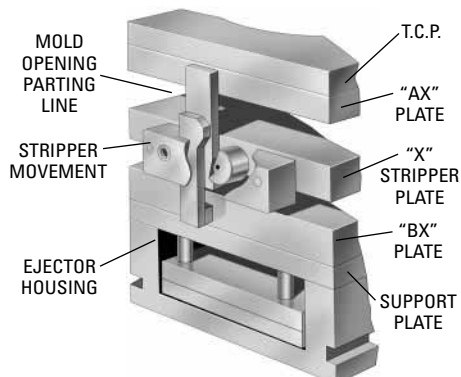
RECOMMENDED USAGE BASED ON MOLD BASE WIDTH	
≤ 10"	LL-050
11" to 15"	LL-101 or LL-151
> 16"	LL-201

Replacement parts are available.

ITEM NUMBER	BODY				LATCH BAR								RELEASE BAR					SPACER					
	A	B	C	Y	E	F	G1 NOM	G2 NOM	H	I NOM	J RAD	K	L RAD	M	P	Q	R NOM	S	T	U	V	W	
LL-050	3	1 ³ / ₁₆	1 ⁵ / ₁₆	.535	7	.285	.585	.590	.070	.30	.375	.103	.018	7	.230	.590	1 ¹ / ₈	3 ³ / ₈	1 ¹ / ₂	1 ³ / ₄	.295	1 ¹ / ₂	
LL-101	5	1 ¹⁵ / ₁₆	1 ⁷ / ₁₆	7 ⁷ / ₈	10	.475	.967	.977	.115	1 ¹ / ₂	.615	.170	.03	10	.355	.977	3 ³ / ₁₆	5 ⁵ / ₈	.825	3	.488	7 ⁷ / ₈	
LL-151																							
LL-201	6	2 ¹⁵ / ₁₆	2 ⁷ / ₁₆	1 ¹ / ₂	16	.975	1.465	1.475	.187	5 ⁵ / ₈	.989	.130	.04	16	.475	1.475	.275	7 ⁷ / ₈	1.255	4 ¹ / ₂	.995	1 ¹ / ₂	



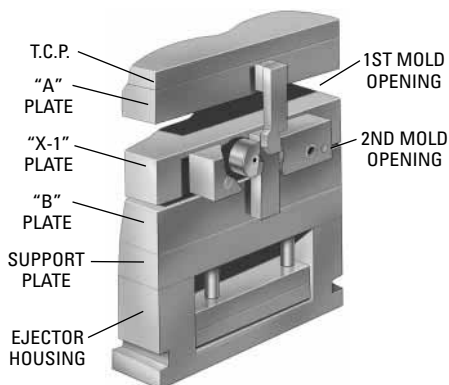
Jiffy Latch-Lok™ Assemblies – Application Information



To Control Stripper Plate

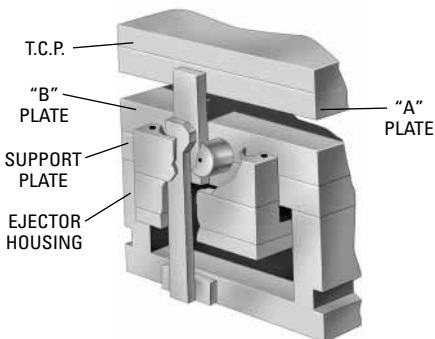
Cycle time is often wasted waiting for the press knock-out bar to function. With the application of the D-M-E Jiffy Latch-Lok, as illustrated to the right, the stripper plate is moved in a secondary action of the mold opening without the aid of the press knock-out bar.

The Jiffy Latch-Lok permits you to shorten the ejection stroke, improve cycle time and increase the number of parts per shift.



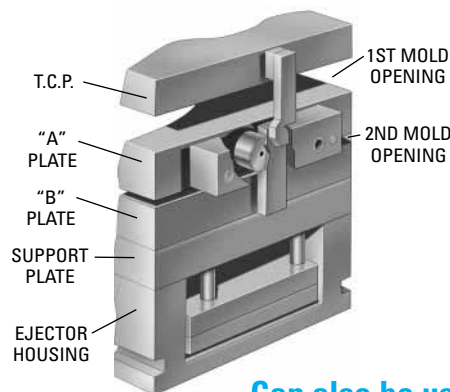
To Float "X-1" Plate Away from "A" Plate while Locking "X-1" and "B" Plates

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.



To Float "A" Plate Away from Top Clamp Plate while Locking "A" and "B" Plates

In the D-M-E 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.



Actuation of Ejector Assembly Without Aid of Press Knock-Out Bar (LL-151 only)

For those mold applications where a shorter press stroke is required, the D-M-E 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.

Can also be used for "Reverse" Ejection from the Stationary Side of the Mold.

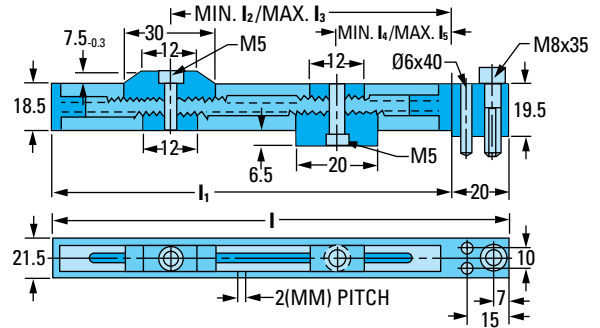
D-M-E Jiffy Latch-Lok Replacement Parts

DESCRIPTION	FOR LATCH-LOK LL-050	FOR LATCH-LOK LL-101	FOR LATCH-LOK LL-151	FOR LATCH-LOK LL-201
	ITEM NUMBER	ITEM NUMBER	ITEM NUMBER	ITEM NUMBER
ROCKER	LL-052	LL-102	LL-102	LL-202
LATCH BAR	LL-053	LL-103	LL-103	LL-203
RELEASE BAR	LL-054	LL-104	LL-104	LL-204

Latch Locks – General Information

KU: Latch Locks – Baffle Bars

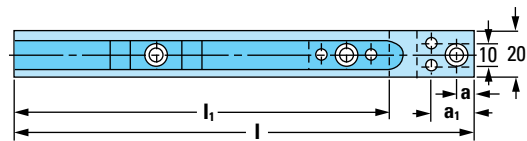
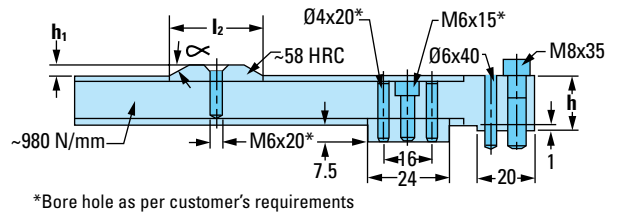
KU 1-1-...
appropriate for KL 1-1-70
KL 1-2-...



ITEM NUMBER	l ₁	l ₂	l ₃	l ₄	l ₅
KU 11140	120	20	100	20	104
KU 11204	184	20	164	20	168
KU 11254	234	20	214	20	218

KU 1-2-...
appropriate for KL 1-1-70
KL 1-2-...
KL 1-3-...

KU 2-2-...
appropriate for KL 2-2-256



ITEM NUMBER	a	a ₁	h	h ₁	l ₁	l ₂	∠
KU 12200	7	15	20	7	170	30	35
KU 12250	7	15	20	7	220	30	35
KU 12300	7	15	20	7	270	30	35
KU 22400	10	19.5	30	8	360	50	40

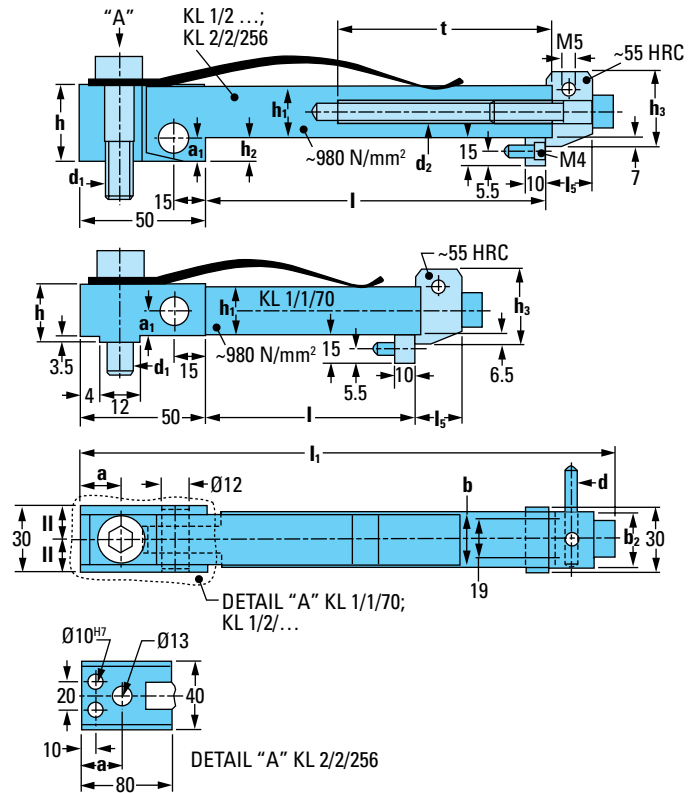
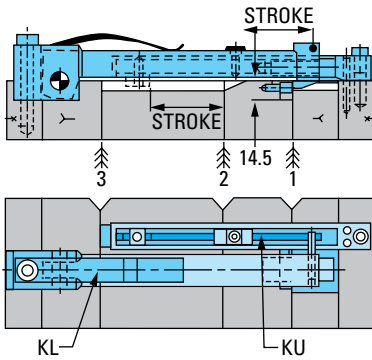
SPARE PARTS FOR:	KF: SPRINGS	KK: HEADS	KV: WEARING BARS
ITEM NUMBER	ITEM NUMBER	ITEM NUMBER	ITEM NUMBER
KL 1170	KF 1270	KK 1112	KV 1122
KL 1290	KF 1290	KK 1112	KV 1122
KL 12170	KF 12170	KK 1112	KV 1122
KL 12220	KF 12220270	KK 1112	KV 1122
KL 12270	KF 12220270	KK 1112	KV 1122
KL 13110	WZ 8030 M1	—	KV 1122
KL 13170	WZ 8030 M1	—	KV 1122
KL13220	WZ 8030 M1	—	KV 1122
KL 22256	KF 22256	KK 22	KV 1122

Latch Locks – Typical Application

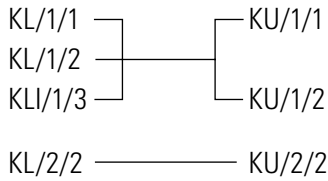
Latch Locks – KL



Typical Application



Combinations



ITEM NUMBER	a	a1	b	b2	d	d1	d2	h	h1	h2	h3	l1	l5	t	Fmax daN
KL 1170	10	15	25	27	6	M10	M12	31.5	23.5	15	37.5	152	20	45	6000
KL 1290	10	15	25	27	6	M10	M12	42.0	23.5	15	37.5	172	20	80	6000
KL 12170	10	15	25	27	6	M10	M12	42.0	23.5	15	37.5	252	20	80	6000
KL 12220	10	15	25	27	6	M10	M12	42.0	23.5	15	37.5	302	20	80	6000
KL 12270	10	15	25	27	6	M10	M12	42.0	23.5	15	37.5	352	20	80	6000
KL 22256	30	14	30	30	12	M12	M16	56.0	40.0	16	55.0	379	27	80	11000



ITEM NUMBER	I3
KL 13120	182
KL 13170	232
KL 13220	282

