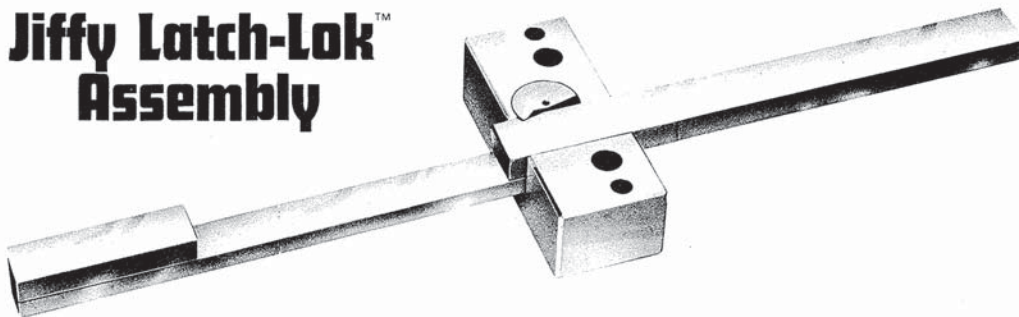
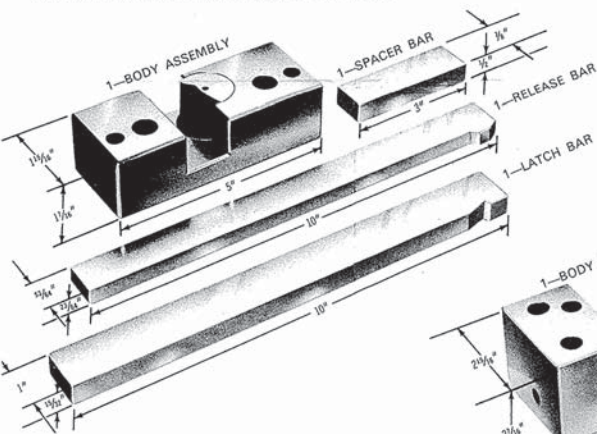


# Jiffy Latch-Lok™ Assembly

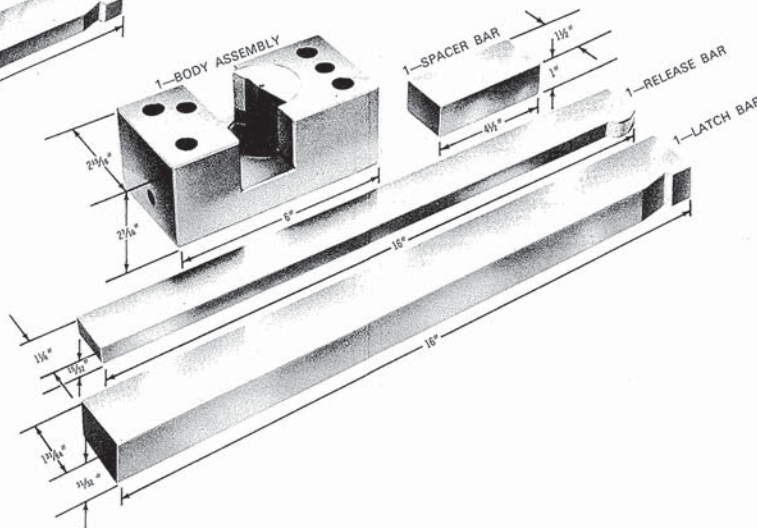


## Assembly Consists of:

CATALOG NUMBER LL 050, LL 101 & LL 151

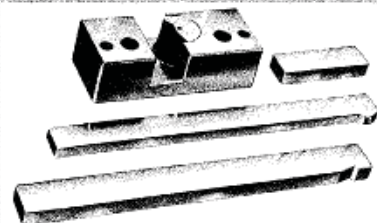


CATALOG NUMBER LL 201



# IMPORTANT Installation Instructions for D-M-E Jiffy Latch-Lok™

U.S. PAT. NO. 3,706,116



20111 STEPHENSON HIGHWAY • MADISON HEIGHTS, MICHIGAN 48071  
1-800-825-6653

224 Dumas Circle  
Suite 100  
HOMEWOOD, AL 35226

1051 Monterey Pass Road  
MONTEREY PARK (LOS ANGELES), CA 91754

502 Bookpark Road  
CLEVELAND, OH 44189

558 Leo Street  
DAYTON, OH 45404

1254 Solbner  
GRAND RAPIDS, MI 49504

1217 Central Avenue  
HILLSIDE, (NEWARK) NJ 07205

1075 N. 17th Avenue  
MELROSE PARK (CHICAGO), IL 60150

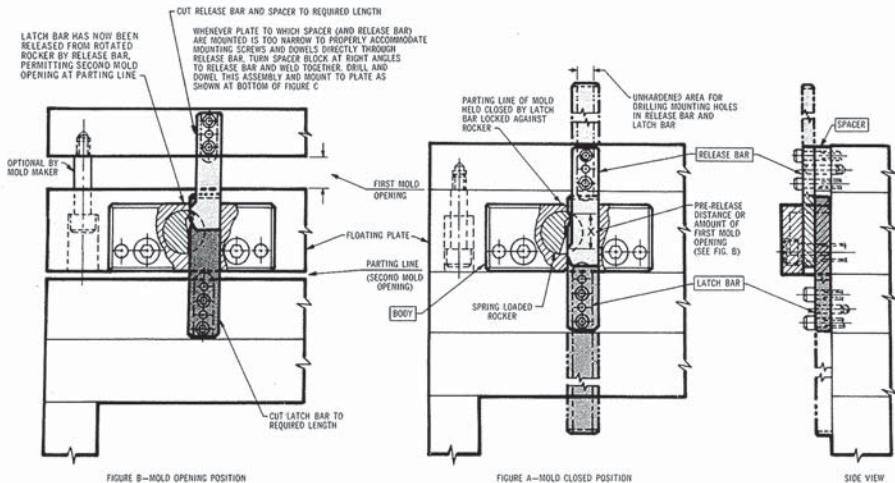
83 Keystone Drive  
LEMINSTER, MA 01453

WORLD HEADQUARTERS  
29111 Stephenson Highway  
MADISON HEIGHTS (DETROIT), MI 48071

12905 Industrial Park Blvd.  
PLYMOUTH, MI 55441

6210 Northwest Drive  
MISSISSAUGA (TORONTO), ONT CAN L4V 1J6

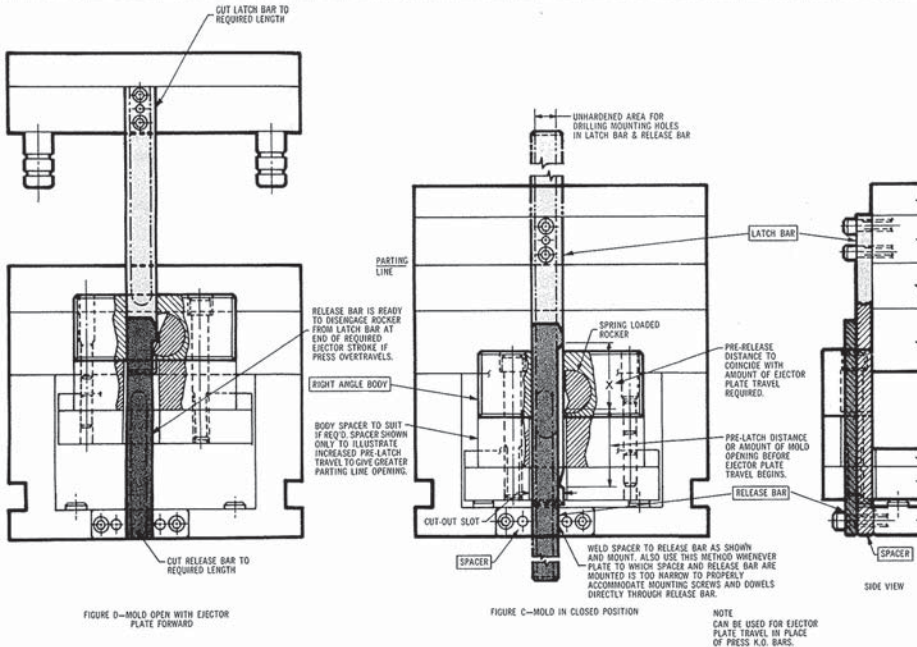
11839 Westline Industrial Dr.  
ST. LOUIS, MO 63149



## Typical Installation D-M-E JIFFY LATCH-LOK™

CAT. NO. LL-050, LL-101 & LL-201

- All latch bars must be timed closely to prevent cocking of the plate they are actuating.
- All release bars must also be timed closely to prevent cocking of the plate, which would occur if some latch bars are released prior to others.
- Mount body to floating or moving plate with screws and dowels, parallel with parting line. Mount body in relation to desired press and mold opening to allow disengagement of latch bar from rocker by release bar.
- Engage latch bar in position on rocker as shown in Figure (A) with mold closed. (If pre-latch dwell or movement is required, position accordingly.) Measure and cut latch bar to required length. Drill screw mounting holes. (Drill and ream dowel holes after final alignment.) Mount latch bar to side of mold. (See Figure A).
- Insert release bar into assembly and adjust for amount of first mold opening. Measure and cut release bar to required length. (See Dim. X.) Drill screw mounting holes. (Drill and ream dowel holes after final alignment.) Mount release bar to side of mold. (See Figure A.)
- Be sure that final assembly is mounted square and parallel in relation to proper mold surfaces and with proper clearances to ensure free movement and correct alignment during mold operation.
- Minimum of two units required per mold. However, four units per mold are recommended. Larger molds may require additional units.
- When only two units are used, the bodies should be mounted on the center of the mold for balanced operation. However, if there is uneven loading of the plate to be actuated, four or more units are required.
- Keep D-M-E Jiffy Latch-Lok assembly lubricated while in operation.



## Typical Installation D-M-E JIFFY LATCH-LOK™

RIGHT ANGLE TYPE  
CAT. NO. LL-151

- All latch bars must be timed closely to prevent cocking of the plate they are actuating.
- All release bars must also be timed closely to prevent cocking of the plate, which would occur if some latch bars are released prior to others.
- Mount right angle body and body spacer (if req'd.) with screws and dowels to ejector plate, maintaining clearance between body and end of mold. Mount body in relation to desired press and mold opening to allow latch bar to engage rocker and move ejector plate. (See Figure C.)
- Engage latch bar in position on rocker as shown in Figure (A) with mold closed. (If pre-latch dwell or movement is required, position accordingly.) Measure and cut latch bar to required length. Drill screw mounting holes. (Drill and ream dowel holes after final alignment.) Mount latch bar to side of mold. (See Figure C.)
- Insert release bar into assembly and adjust position so that amount of pre-release movement is less than maximum possible ejector plate travel. Measure and cut release bar to this required length. See dimension "X" in View C. (This is a precautionary measure.) Drill screw mounting holes. (Drill and ream dowel holes after final alignment.) Mount release bar to side of mold. (See Figure C.)
- Be sure that final assembly is mounted square and parallel in relation to proper mold surfaces and with proper clearances to ensure free movement and correct alignment during mold operation.
- Minimum of two units required per mold. However, four units per mold are recommended. Larger molds may require additional units.
- When only two units are used, the bodies should be mounted on the center of the mold for balanced operation. However, if there is uneven loading of the plate to be actuated, four or more units are required.
- Keep D-M-E Jiffy Latch-Lok assembly lubricated while in operation.