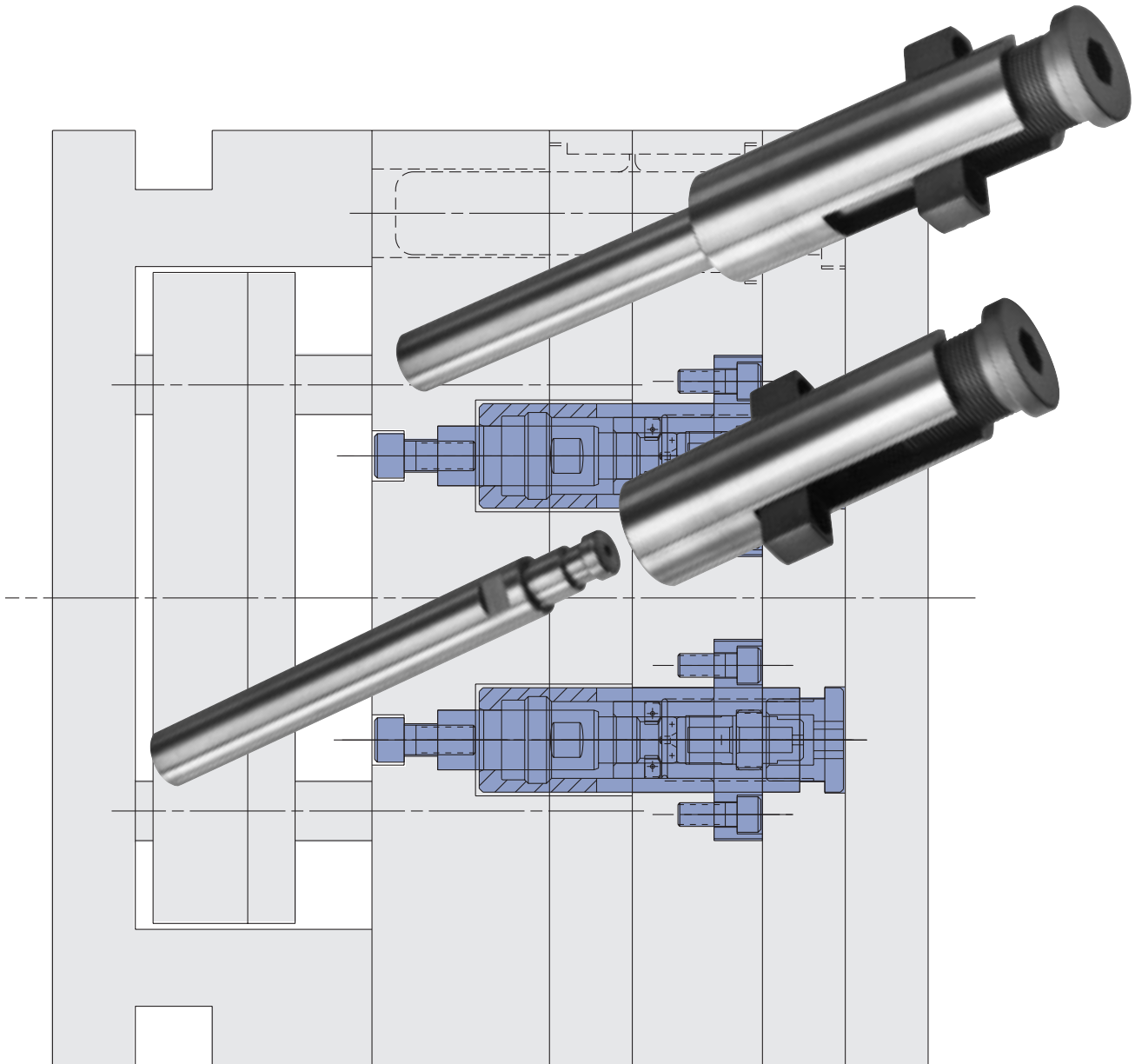


D-M-E Internal Latch Lock

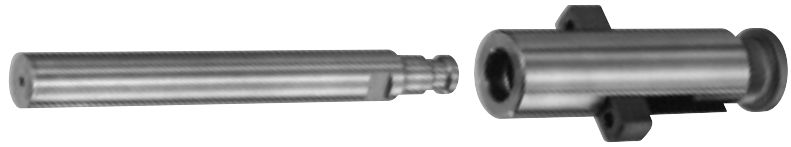
**Precision control
of mold plate
operation**



Internal Latch Lock Benefits and Selection Chart

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 – 28 mm, 34 mm, and 45 mm – 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

INTERNAL LATCH LOCK SELECTION CHART										
Basic Latch Size	Internal Latch Lock Assembly Catalog 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 mm	Minimum in.	Maximum mm	Maximum in.	mm	in.		Static	Dynamic
28 mm 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			
34 mm 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			
45 mm 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 K-28.17 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.

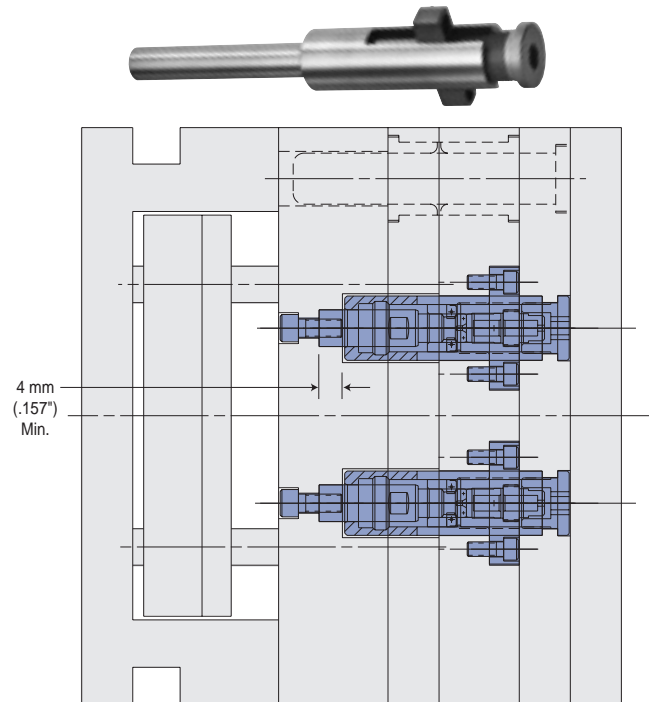
A minimum of four assemblies are recommended per mold. However, for larger molds, thick plates, or an application where loads are near maximum, additional assemblies and/or next largest size assemblies may be required. An application must never exceed the maximum recommended load values. A balanced load 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.

Internal Latch Lock – Typical Application Design Guidelines

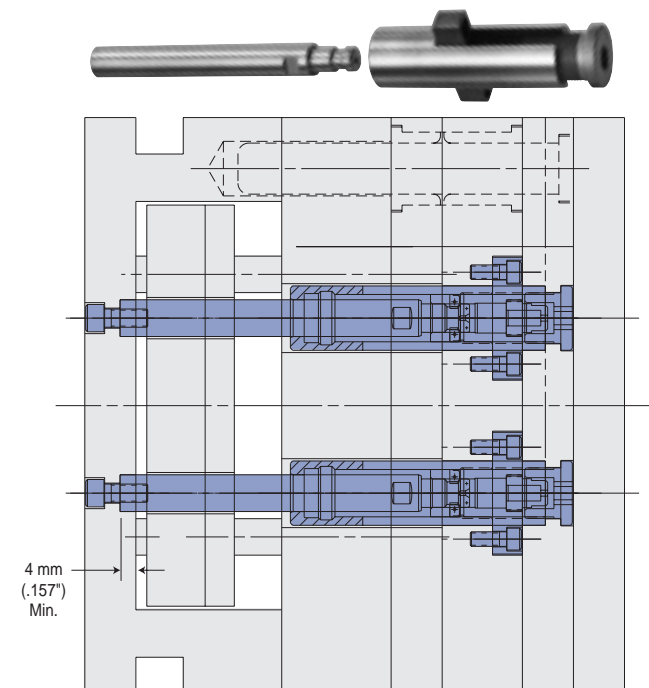
U.S. Patent No. 5,494,435

Basic selection and application design guidelines

1. Select the appropriate internal latch lock size – 28 mm diameter (small), 34 mm diameter (medium), or 45 mm diameter (large) based on the width of the mold base, as indicated in the chart on page K-28.11. 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 chart on page K-28.11. 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 3 mm (.12") minimum additional allowance. This added 3 mm 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 catalog number assembly from the chart on page K-28.11.
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 4 mm (.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.
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 0.4 mm (.016") for the 28 mm diameter and 34 mm diameter assemblies and approximately 0.5 mm (.020") for the 45 mm 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 K-28.17 for specific information regarding this sleeve option.



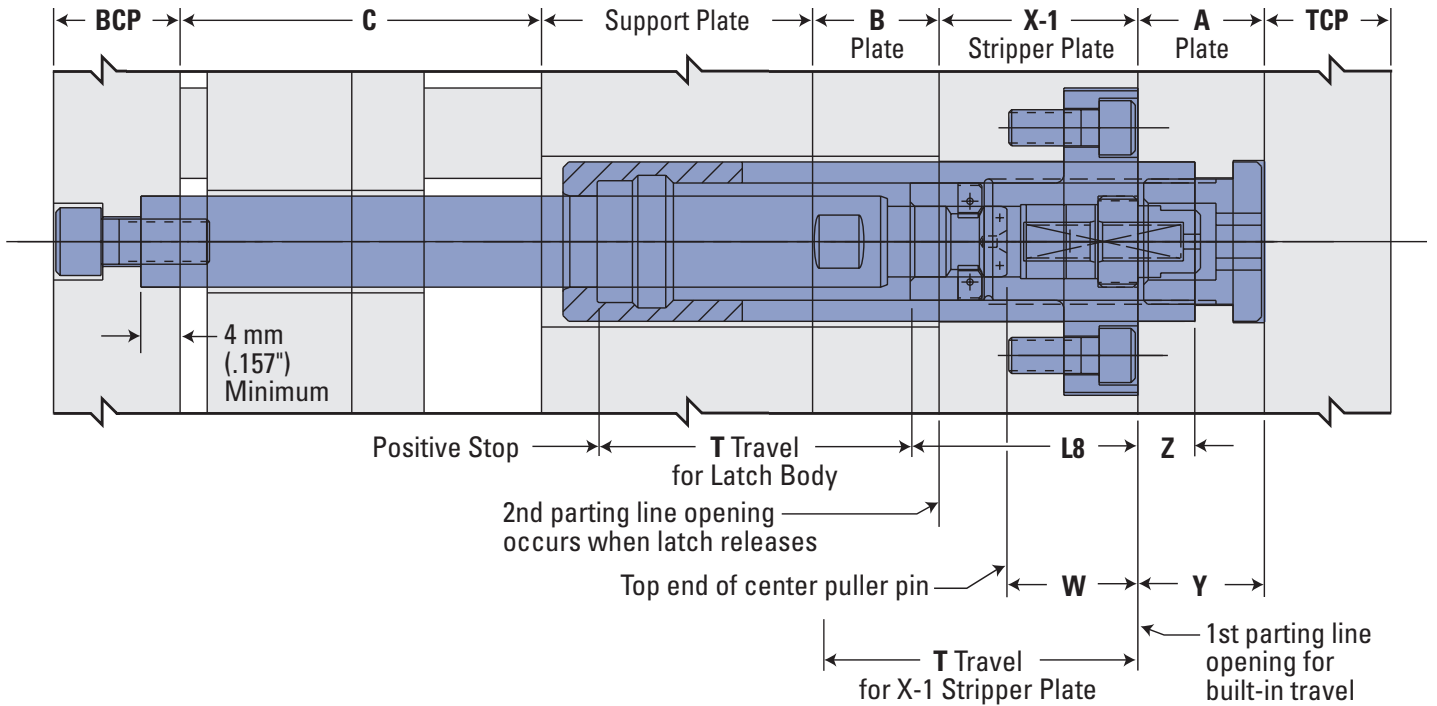
Internal latch lock application with center puller pins mounted in the support plate. This is typically done in applications where the travel is shorter and/or when mold plates are thicker. D-M-E AX-Series mold base is shown in this typical application.



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

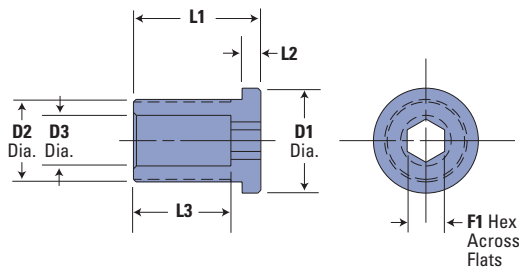
(Refer to Drawing Above)

Basic Latch Size	Internal Latch Lock Assembly Catalog 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.								
28 mm Dia. (Small)	DKL-2811	5	.197	30	1.181	40	1.575	±0.1	±.004	22 to 35	.866 to 1.378	+0.04 -0 10	+.0016 -0.0000 .3937
	DKL-2812												
	DKL-2821	30	1.181	55	2.165								
	DKL-2822												
34 mm Dia. (Medium)	DKL-3411	6	.236	41	1.614	51	2.008	±0.1	±.004	27 to 47.6	1.063 to 1.875	+0.04 -0 12	+.0016 -0.0000 .4724
	DKL-3412												
	DKL-3421	41	1.614	76	2.992								
	DKL-3422												
45 mm Dia. (Large)	DKL-4511	12	.472	58	2.283	68	2.677	±0.1	±.004	35 to 60	1.375 to 2.375	+0.04 -0 16	+.0016 -0.0000 .6299
	DKL-4512												
	DKL-4521	58	2.283	104	4.094								
	DKL-4522												

- (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

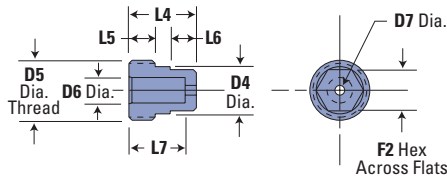
Assembly Retaining Screw



Basic Latch Size	Internal Latch Lock Assembly Catalog Number	ASSEMBLY RETAINING SCREW								mm
		Component Catalog No.	D1 Dia.	D2 Thread	D3 Dia.	L1 Length	L2 Length	L3 Length	F1 Hex Across Flats	
28 mm 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.
34 mm 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.
45 mm 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.

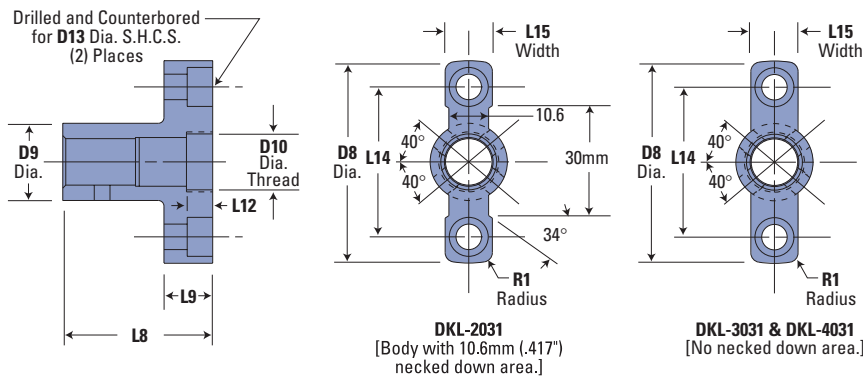
Cut-off length on thread end only per installation data ←

Spring Retainer



Basic Latch Size	Internal Latch Lock Assembly Catalog Number	SPRING RETAINER										mm
		Component Catalog No.	D4 Dia.	D5 Thread	D6 Dia.	D7 Dia.	L4 Length	L5 Length	L6 Length	L7 Length	F2 HEX. Across Flats	
28 mm 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.
34 mm 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.
45 mm 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 Catalog Number	BODY FOR CAM FINGERS											Mounting Holes & D13 S.H.C.S.				mm
		Component Catalog No.	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 S.H.C.S.	in.	
28 mm 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.	
34 mm 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.	
45 mm 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 ←

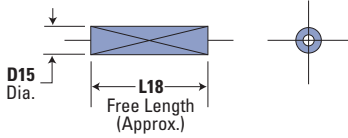
Use either metric or inch socket head cap screws ←

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.

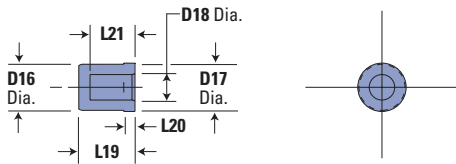
Component Dimensional Information

Spring for Holding Pin



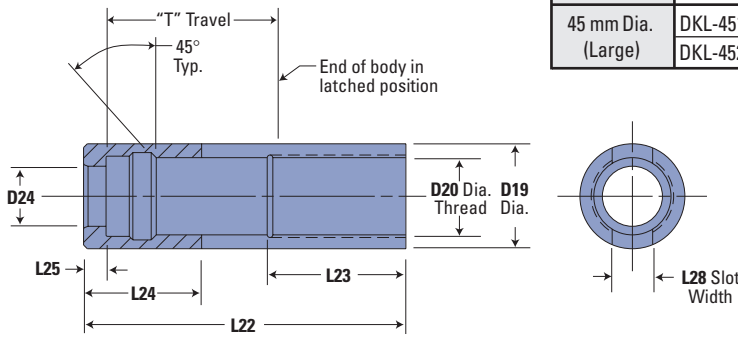
Basic Latch Size	Internal Latch Lock Assembly Catalog Number	SPRING FOR HOLDING PIN			
		Component Catalog No.	D15 Dia.	L18 Free Length	
28 mm Dia. (Small)	DKL-2811, DKL-2812, DKL-2821 & DKL-2822	DKL-2041	6.5	56	mm
			.256	2.20	in.
34 mm Dia. (Medium)	DKL-3411, DKL-3412, DKL-3421 & DKL-3422	DKL-3041	8	70	mm
			.315	2.76	in.
45 mm 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 Catalog Number	Component Catalog No.	HOLDING PIN FOR CAMS						
			D16 Dia.	D17 Dia.	D18 Dia.	L19 Length	L20 Length	L21 Length	
28 mm 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.
34 mm 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.
45 mm 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 Catalog Number	Component Catalog No.	SLOTTED TRAVEL LIMITING SLEEVE			
			"T" Travel Range – Minimum to Maximum		L22 Length	
			mm	in.	mm	in.
28 mm 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
34 mm 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
45 mm 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.

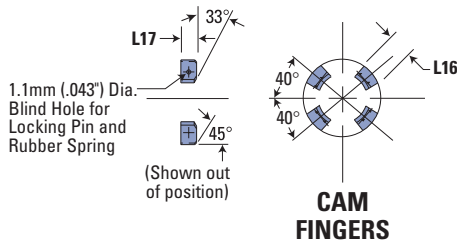
Basic Latch Size	Internal Latch Lock Assembly Catalog Number	Component Catalog No.	SLOTTED TRAVEL LIMITING SLEEVE							
			D19 Dia.	D20 Dia. Thread	D24 Dia.	L23 Length	L24 Length	L25 Length	L28 Slot	
28 mm Dia. (Small)	DKL-2811, DKL-2812, DKL-2821 & DKL-2822	DKL-2071 & DKL-2072	28	M22x1.25	16	37	31.5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

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

Cam Finger Replacement Kit

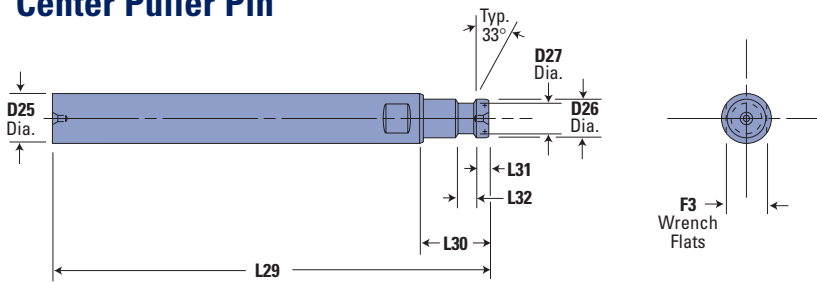
With (4) Cam Fingers, (6) Locking Pins, and (6) Rubber Springs*



Basic Latch Size	Internal Latch Lock Assembly Catalog Number	CAM FINGER REPLACEMENT KIT			
		Component Set Catalog No.	L16 Width	L17 Thick	
28 mm Dia. (Small)	DKL-2811, DKL-2812, DKL-2821 & DKL-2822	DKL-2062	5.8	4.2	mm
			.228	.165	in.
34 mm Dia. (Medium)	DKL-3411, DKL-3412, DKL-3421 & DKL-3422	DKL-3062	7.2	4.8	mm
			.283	.189	in.
45 mm 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 Catalog Number	Component Catalog No.	CENTER PULLER PIN	
			L29 Length	
28 mm Dia. (Small)	DKL-2811 & DKL-2821 DKL-2812 & DKL-2822	DKL-2081 DKL-2082	140	5.512
			250	9.843
34 mm Dia. (Medium)	DKL-3411 & DKL-3421 DKL-3412 & DKL-3422	DKL-3081 DKL-3082	160	6.299
			280	11.024
45 mm Dia. (Large)	DKL-4511 & DKL-4521 DKL-4512 & DKL-4522	DKL-4081 DKL-4082	200	7.874
			310	12.205

Cutoff on large diameter end only per installation data

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.

Basic Latch Size	Internal Latch Lock Assembly Catalog Number	Component Catalog No.	CENTER PULLER PIN								
			D25 Dia.	D26 Dia.	D27 Dia.	L30 Length	L31 Length	L32 Length	F3 Across Flats	D28 Tap - Rec.	
28 mm 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.
34 mm 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.
45 mm 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 Catalog No.	Center Puller Pin		Slotted Travel Limiting Sleeve		Component Catalog Numbers								
		Component Catalog No.	L17 Length	Component Catalog No.	"T" Travel Range		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	
					mm	in.								
28 mm 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	DKL-2072	6 to 41	.236 to 1.614							
	DKL-2822	DKL-2082	250	9.843										
34 mm Dia. (Medium)	DKL-3411	DKL-3081	160	6.299	DKL-3071	41 to 76	1.614 to 2.992	DKL-3011	DKL-3021	DKL-3031	DKL-3032	DKL-3062	DKL-3041	DKL-3051
	DKL-3412	DKL-3082	280	11.024										
	DKL-3421	DKL-3081	160	6.299	DKL-3072	12 to 58	.472 to 2.283							
	DKL-3422	DKL-3082	280	11.024										
45 mm Dia. (Large)	DKL-4511	DKL-4081	200	7.874	DKL-4071	58 to 104	2.283 to 4.094	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										

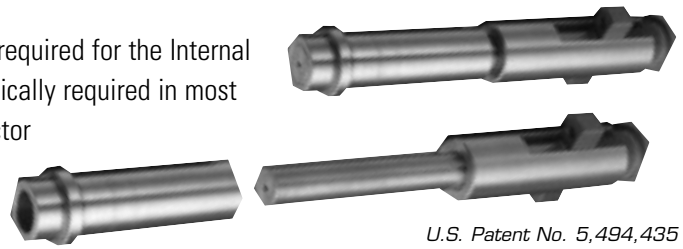
Body for Cam Fingers with Cam Fingers installed includes: (1) body, (4) cam fingers, (4) locking pins, and (4) rubber springs

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

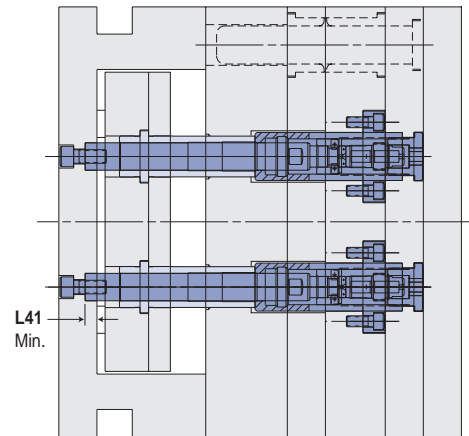
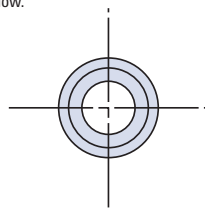
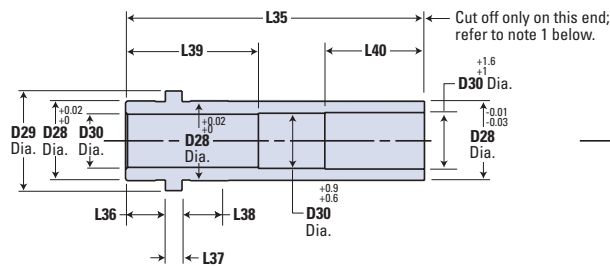
Add guided ejection and return pin functions to Internal Latch Lock mechanism with the optional sleeve

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.



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- 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



Basic Latch Size	Internal Latch Lock Assembly Catalog Number	OPTIONAL SLEEVES – GUIDED EJECTION AND RETURN SLEEVE DIMENSIONS																				
		Component Catalog No.	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.
28 mm 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																		
34 mm 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																		
45 mm 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.



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