

INTERNAL LATCH LOCKS





These products have been developed in response to the needs of moldmakers for larger and more robust solutions in the field of plastic injection molds.

AHP MERKLE® has developed the largest and most robust solutions for:

Plate Sequencing for 2-Stage Ejection: This solution offers precise plate control for part ejection in injection molding. It ensures that plates move in the correct order, especially useful when lifters, mounted on one set of ejector plates, need to release undercuts before the main ejection. Designed for internal mounting within the ejector box, this system is made from high-quality materials for durability and long-term performance.

Synchronized Plate Sequencing: This solution ensures smooth and coordinated plate movement during part ejection. The two plates move together in perfect sync and then disengage after a set distance. This is particularly beneficial when the fixed side controls the ejection stroke. Designed for internal mounting within the plates, this system enhances precision and efficiency in your ejection process.



2-STAGE PLATE SEQUENCING FOR TOP LAST EJECTION

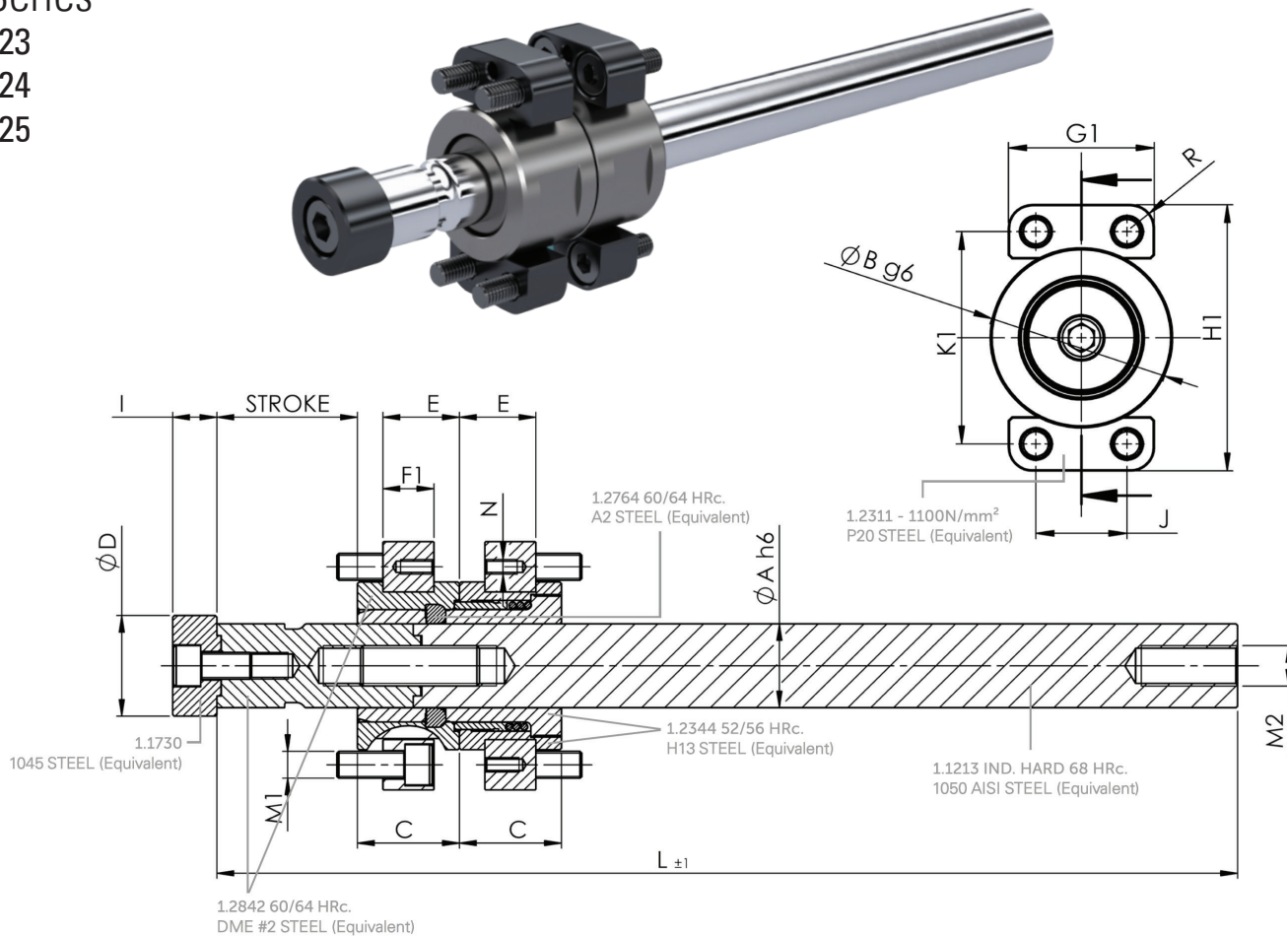
Models for TOP LAST EJECTION - 2 STAGE PLATE SEQUENCING

PT Series

367223

367224

367225

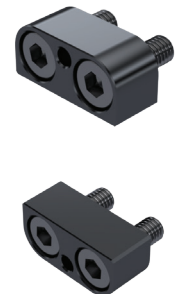


ITEM NUMBER	MODEL	GENERAL DIMENSIONS															
		A	B	C	D	E	F1	G1	H1	I	J	K1	L	M1	M2	N	R
367223	PT-14	14	30	18	18	14	10	24	50	10	13	39	250	M5	M8	M4	5.5
367224	PT-30	30	60	36	36	29	22	60	106	15	32	80	450	M12	M16	M6	13
367225	PT-50	50	100	60	60	45	30	80	148	26	50	118	600	M16	M24	M8	13

Ordering Information:

ITEM NO.	MODEL	STROKE		LATCH ITEM NO.	FLANGE ITEM NO.	Note: Order latch Lock + Flange*
		MIN	MAX			
367223	PT-14	5	220	367223	367230	For PT-14, Order 367223 + 367230 (2 Sets)
367224	PT-30	5	400	367224	367231	For PT-30, Order 367224 + 367231 (2 Sets)
367225	PT-50	5	550	367225	367232	For PT-50, Order 367225 + 367232 (2 Sets)

* Requires 2 sets of flanges (each set includes 2 pieces).

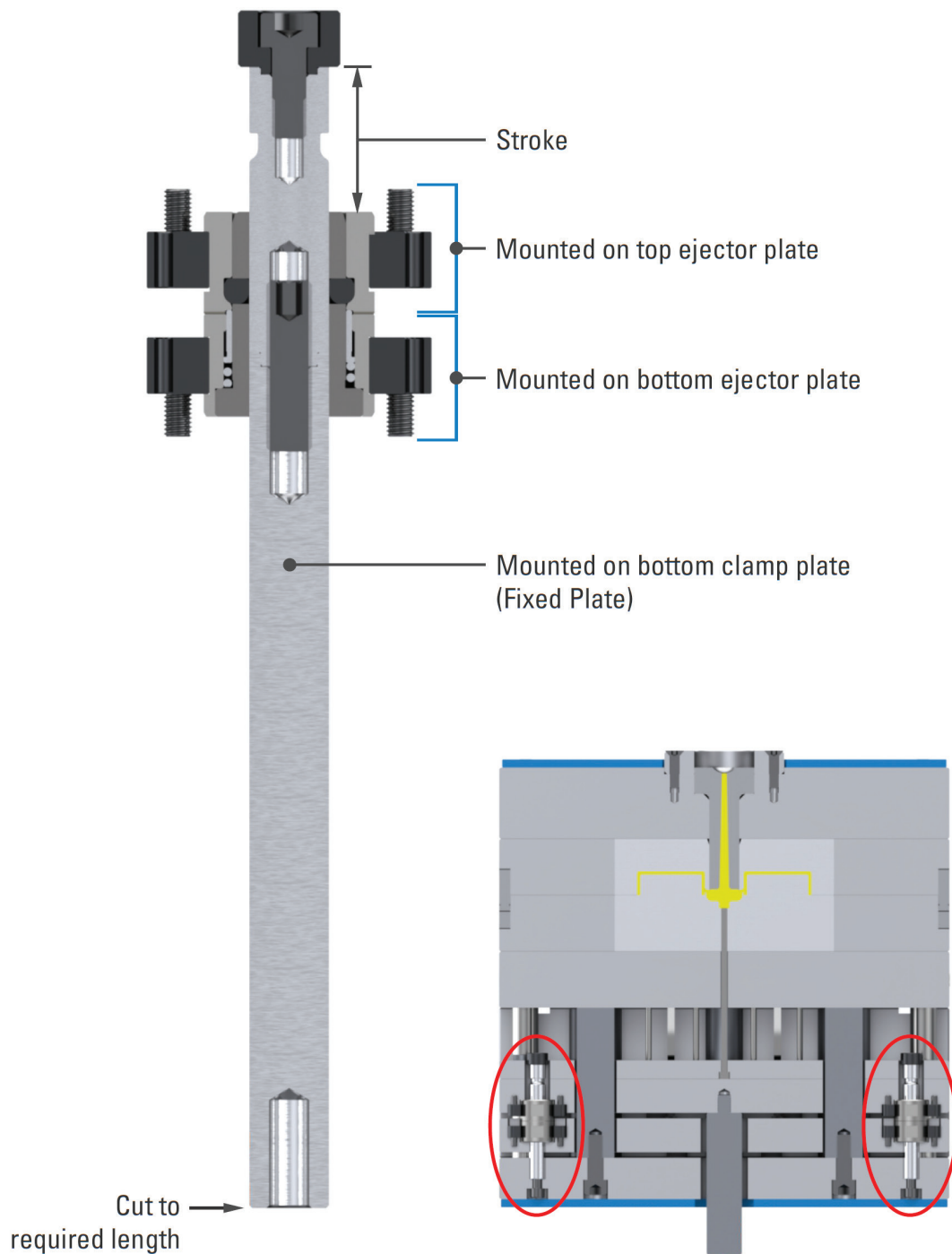


2-STAGE PLATE SEQUENCING FOR TOP LAST EJECTION

PT Series

INSTALLATION GUIDE FOR TOP LAST EJECTION

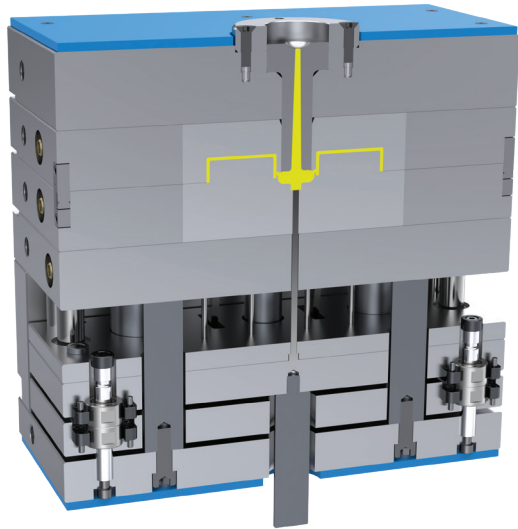
This solution offers precise plate control for 2-stage top last ejection. It ensures that both ejector plates placed together move for the required first stroke, which is especially useful when lifters, mounted on the bottom ejector plates, need to release undercuts before part ejection. After the first stroke, the top ejector plate moves freely for required final stroke, ejecting the part. Designed for internal mounting within the ejector box, this system is made from high-quality materials for durability and long-term performance.



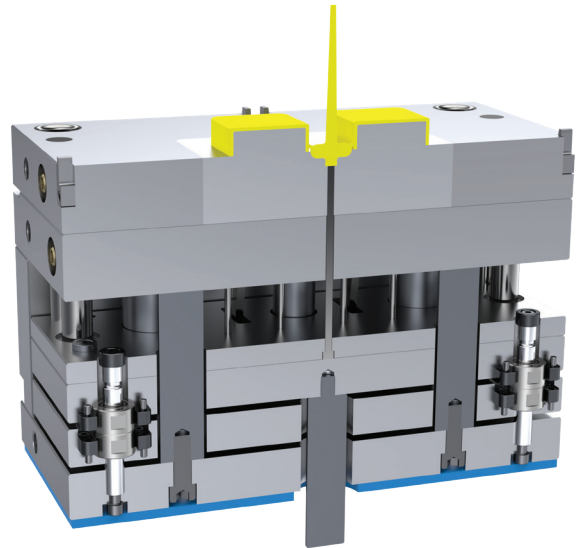
2-STAGE PLATE SEQUENCING FOR TOP LAST EJECTION

APPLICATION EXAMPLE

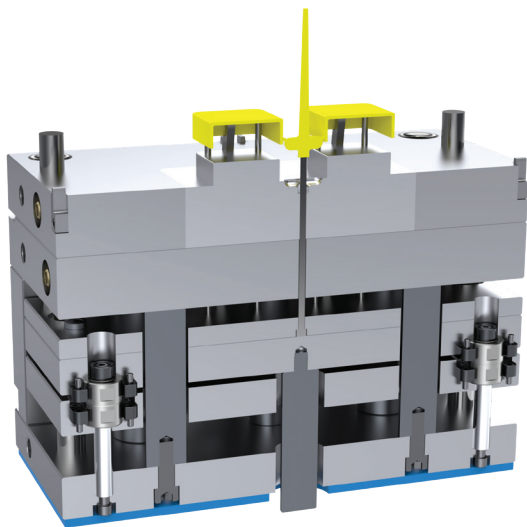
TOP LAST EJECTION - 2 STAGE PLATE SEQUENCING



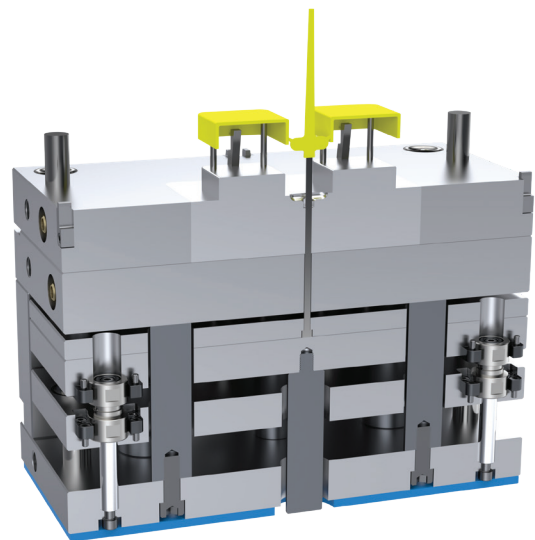
Tool closed



Tool open



1st Ejection Stroke
(Both ejector plates placed together
move together)



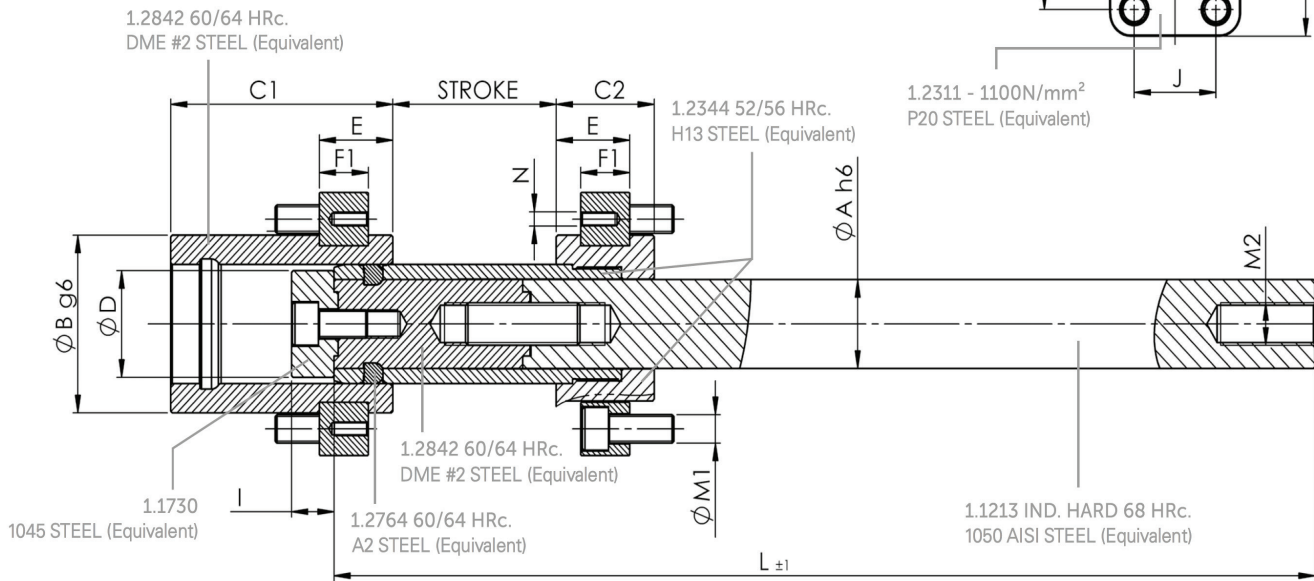
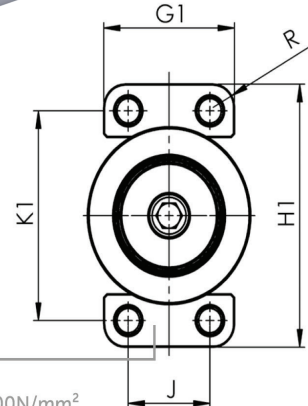
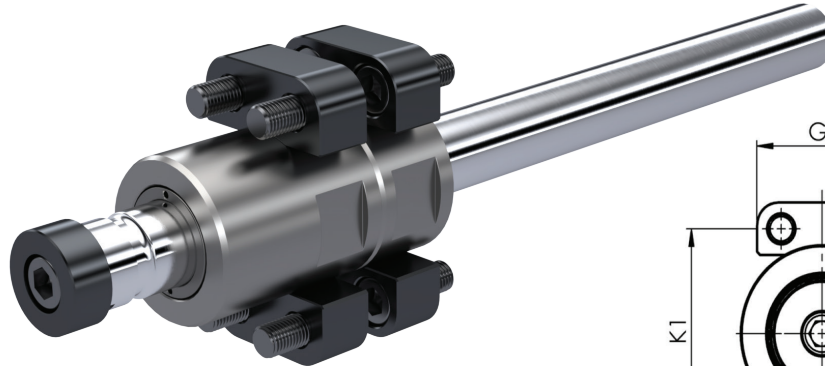
2nd Ejection Stroke
(Only the top ejector plate moves,
ejecting the part)

2-STAGE PLATE SEQUENCING FOR BOTTOM LAST EJECTION

Models for BOTTOM LAST EJECTION - 2 STAGE PLATE SEQUENCING PA Series

367226

367227



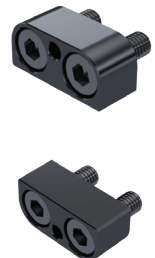
ITEM NUMBER	MODEL	GENERAL DIMENSIONS																
		A	B	C1	C2	D	E	F1	G1	H1	I	J	K1	L	M1	M2	N	R
367226	PA-30	30	60	36	72	36	29	22	60	106	15	32	80	450	M12	M16	M6	13
367227	PA-50	50	100	60	136	60	45	30	80	148	26	50	118	600	M16	M24	M8	13

Ordering Information:

ITEM NUMBER	MODEL	STROKE	
		MIN	MAX
367226	PA-30	6	50
367227	PA-50	10	100

LATCH ITEM NO.	FLANGE ITEM NO.	Note: Order latch Lock + Flange*
367226	367231	For PA-30, Order 367226 + 367231 (2 Sets)
367227	367232	For PA-50, Order 367227 + 367232 (2 Sets)

* Requires 2 sets of flanges (each set includes 2 pieces).

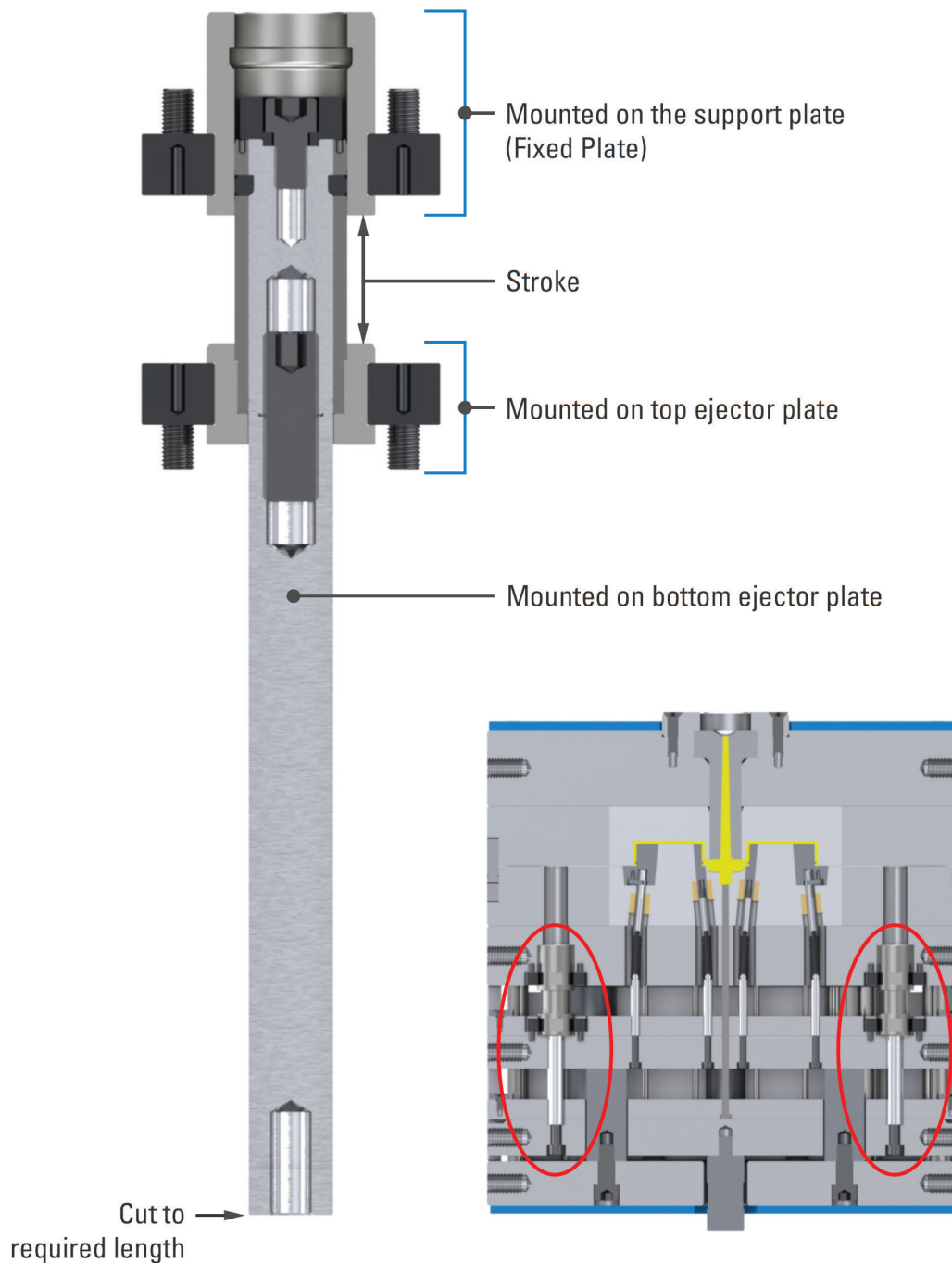


2-STAGE PLATE SEQUENCING FOR BOTTOM LAST EJECTION

PA Series

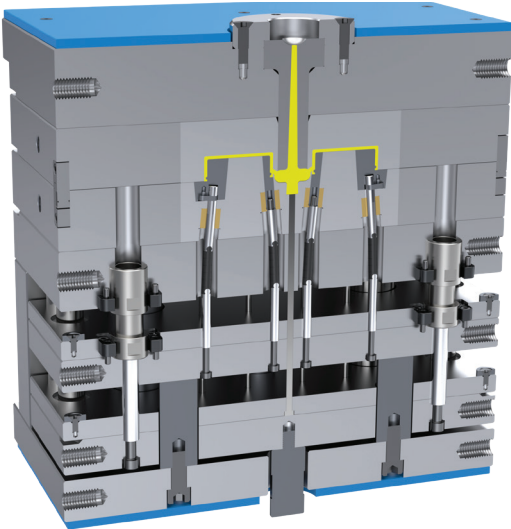
INSTALLATION GUIDE FOR BOTTOM LAST EJECTION

This solution offers precise plate control for 2-stage bottom last ejection. It ensures that both ejector plates, placed apart, move for the required stroke, which is especially useful when lifters, mounted on the top ejector plates, need to release undercuts before part ejection. After the first stroke, the bottom ejector plate moves freely for the required final stroke, ejecting the part. Designed for internal mounting within the ejector box, this system is made from high-quality materials for durability and long-term performance.

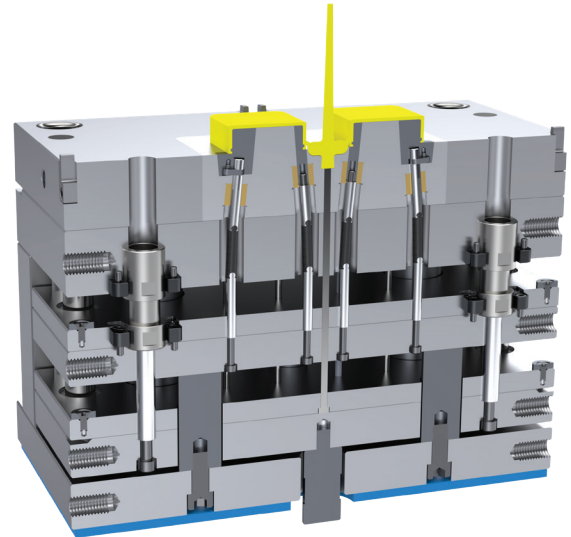


2-STAGE PLATE SEQUENCING FOR BOTTOM LAST EJECTION

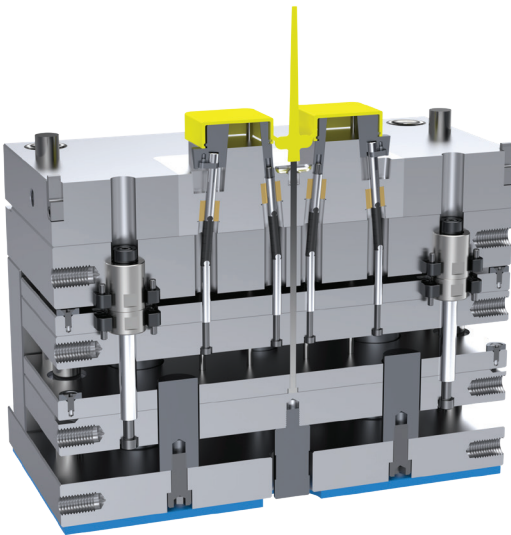
APPLICATION EXAMPLE

BOTTOM LAST EJECTION - 2 STAGE PLATE SEQUENCING

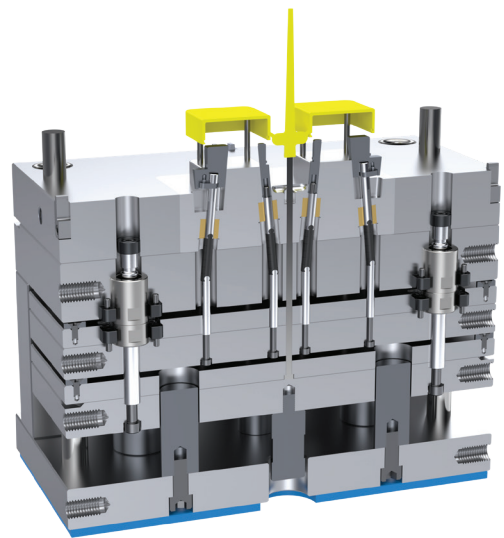
Tool closed



Tool open



1st Ejection Stroke
(Both ejector plates placed apart
move together)



2nd Ejection Stroke
(Only the bottom ejector plate moves,
ejecting the part)

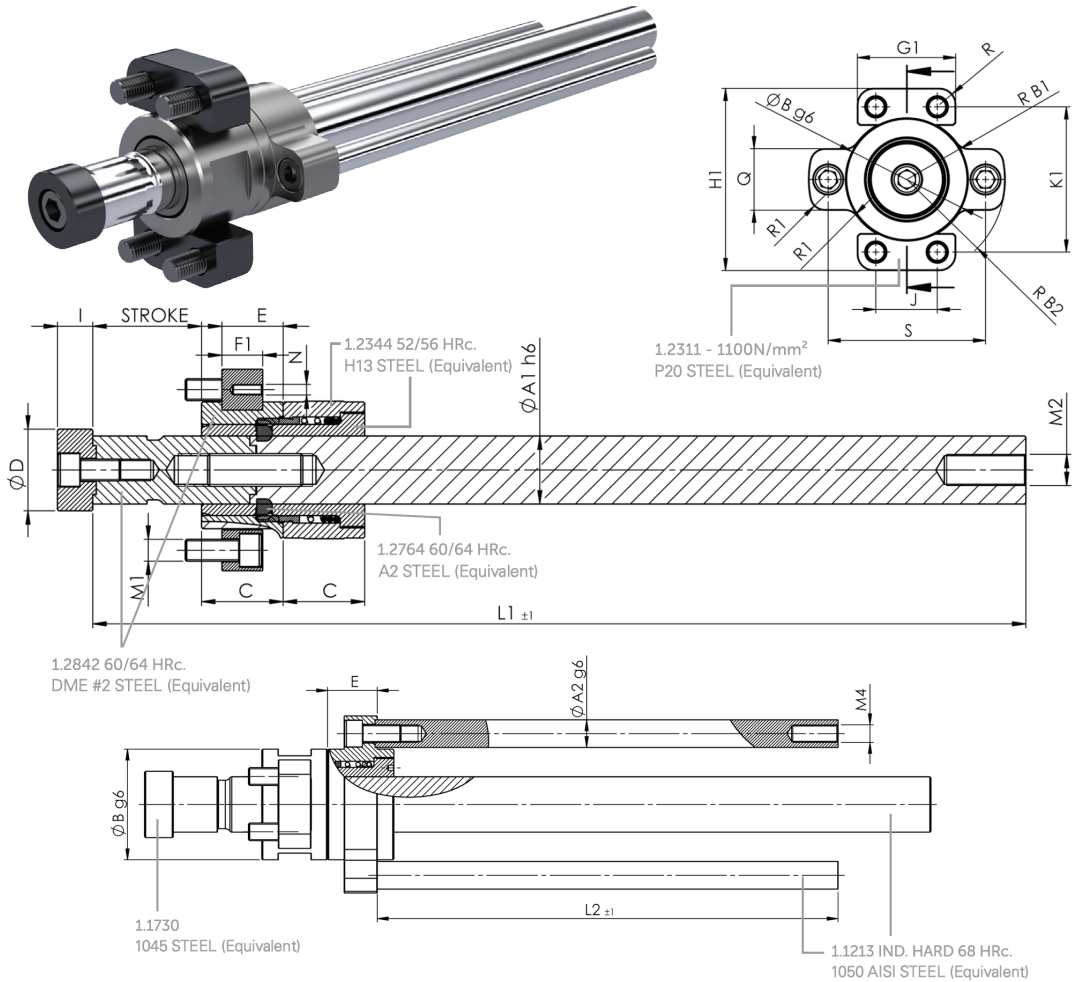
SYNCHRONIZED PLATE SEQUENCING

Models for SYNCHRONIZED PLATE SEQUENCING

PS Series

367228

367229



ITEM NUMBER	MODEL	GENERAL DIMENSIONS											
		A1	A2	B	C	D	E	F1	G1	H1	I	J	K1
367228	PS-30	30	14	60	36	36	29	22	60	106	15	32	80
367229	PS-50	50	25	100	60	60	45	30	80	148	26	50	118

ITEM NUMBER	MODEL	GENERAL DIMENSIONS											
		L1	L2	M1	M2	M4	Q	N	R	R1	RB1	RB2	S
367228	PS-30	450	298	M12	M16	M10	26	M6	13	8	10	49	78
367229	PS-50	600	348	M16	M24	M16	50	M8	13	12	12	80	128

Ordering Information

ITEM NUMBER	MODEL	STROKE		LATCH ITEM NO.	FLANGE ITEM NO.	Note: Order latch Lock + Flange*
		MIN	MAX			
367228	PS-30	5	400	367228	367231	For PS-30, Order 367228 + 367231 (1 Set)
367229	PS-50	5	550	367229	367232	For PS-50, Order 367229 + 367232 (1 Set)

* Requires 1 set of flanges (set includes 2 pieces).

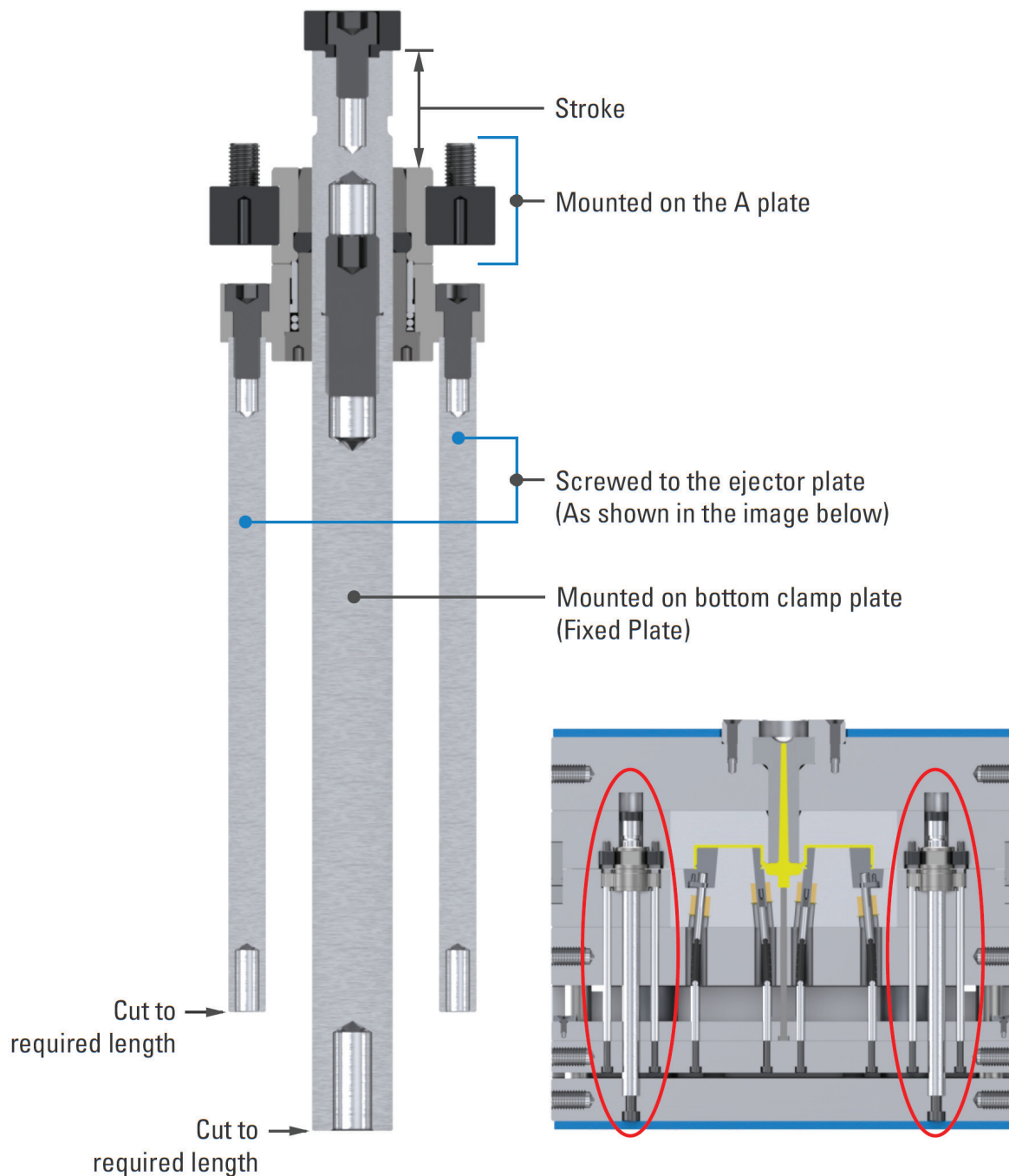


SYNCHRONIZED PLATE SEQUENCING

PS Series

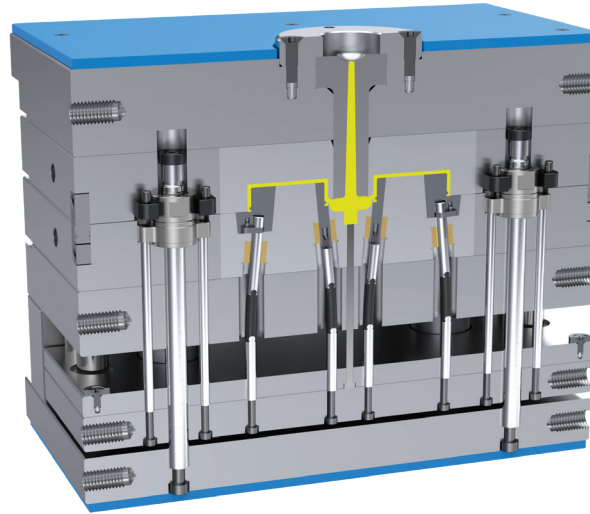
INSTALLATION GUIDE FOR SYNCHRONIZED PLATE SEQUENCING

This solution offers precise plate control for synchronized plate sequencing during part ejection. It ensures that during parting line opening, the A plate pulls the ejector plate, resulting in a synchronized tool opening and starting the ejection process. This is especially useful when lifters, mounted on ejector plates, need to release undercuts to eject the part and when the ejection process needs to be controlled by the A side. Designed for internal mounting, this system is made from high-quality materials for durability and long-term performance.

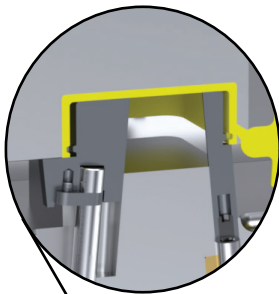


SYNCHRONIZED PLATE SEQUENCING

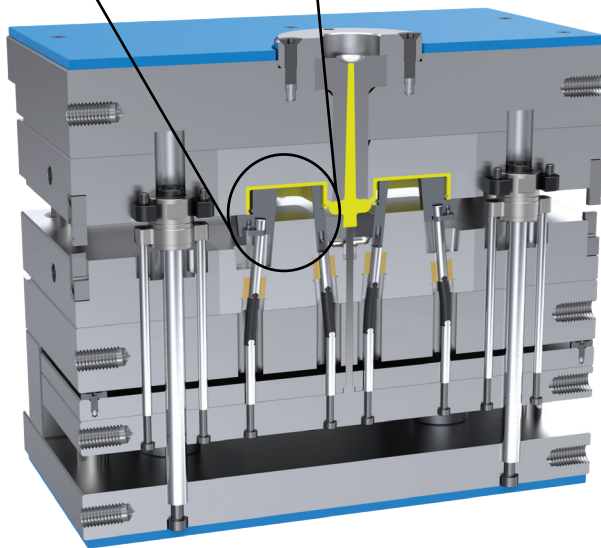
Application Example
SYNCHRONIZED PLATE SEQUENCING



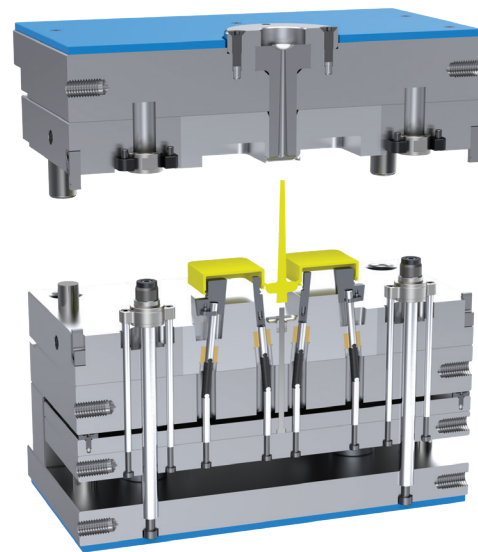
Tool closed



Undercut
is released

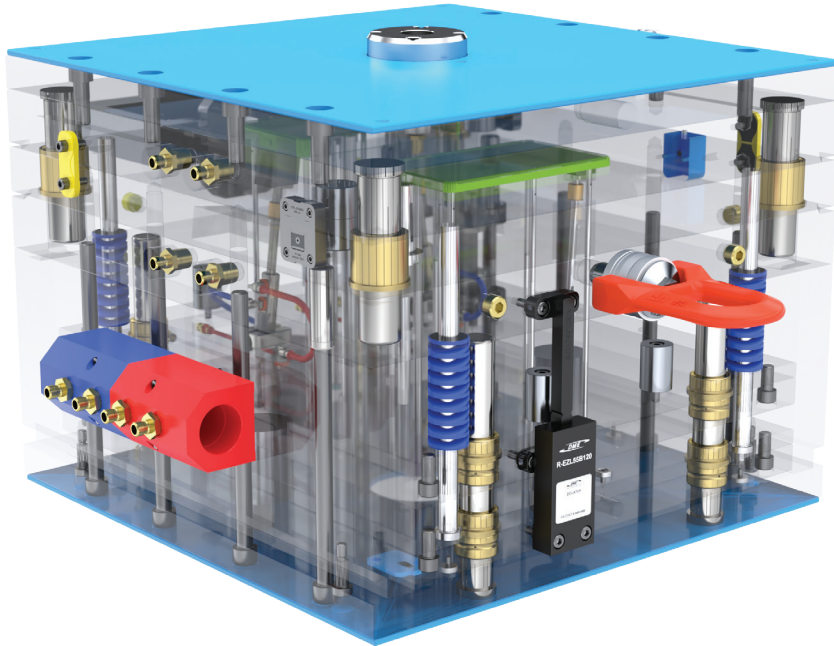


Synchronized tool opening with the
movement of the ejector plates



The tool fully opens, and the
part is ejected

With tens of thousands of products to choose from, DME is your one-stop shop for everything molding. From complex undercuts solutions and plate control to standard pins, bushings and interlocks, the DME line of mold components will help you build or rebuild your mold base inside out, top to bottom. Industrial Supplies, Mold Bases, MUD Quick-Change, Control Systems, and Hot Runner solutions round out our extensive offering to truly be your one-stop shop.



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