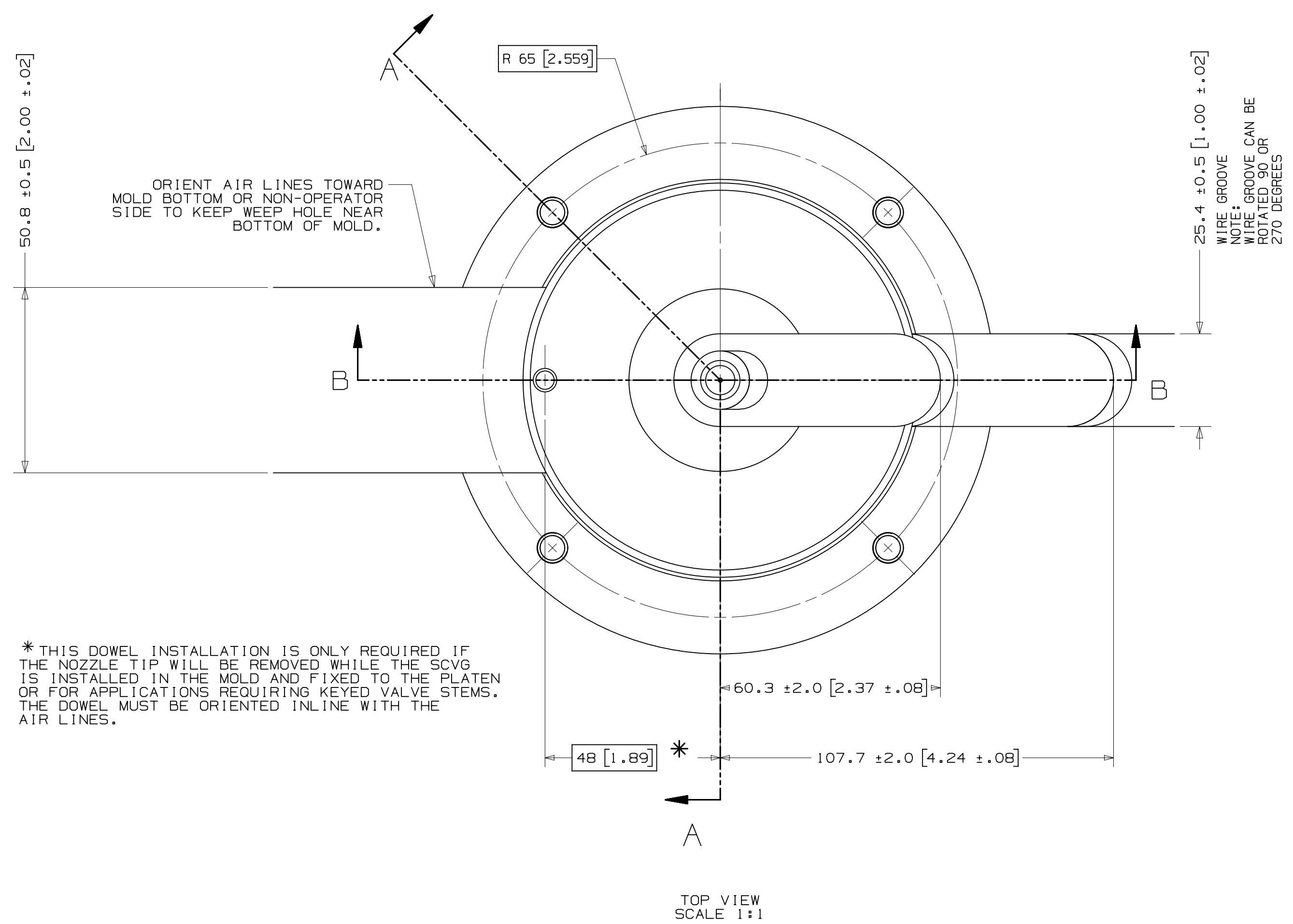
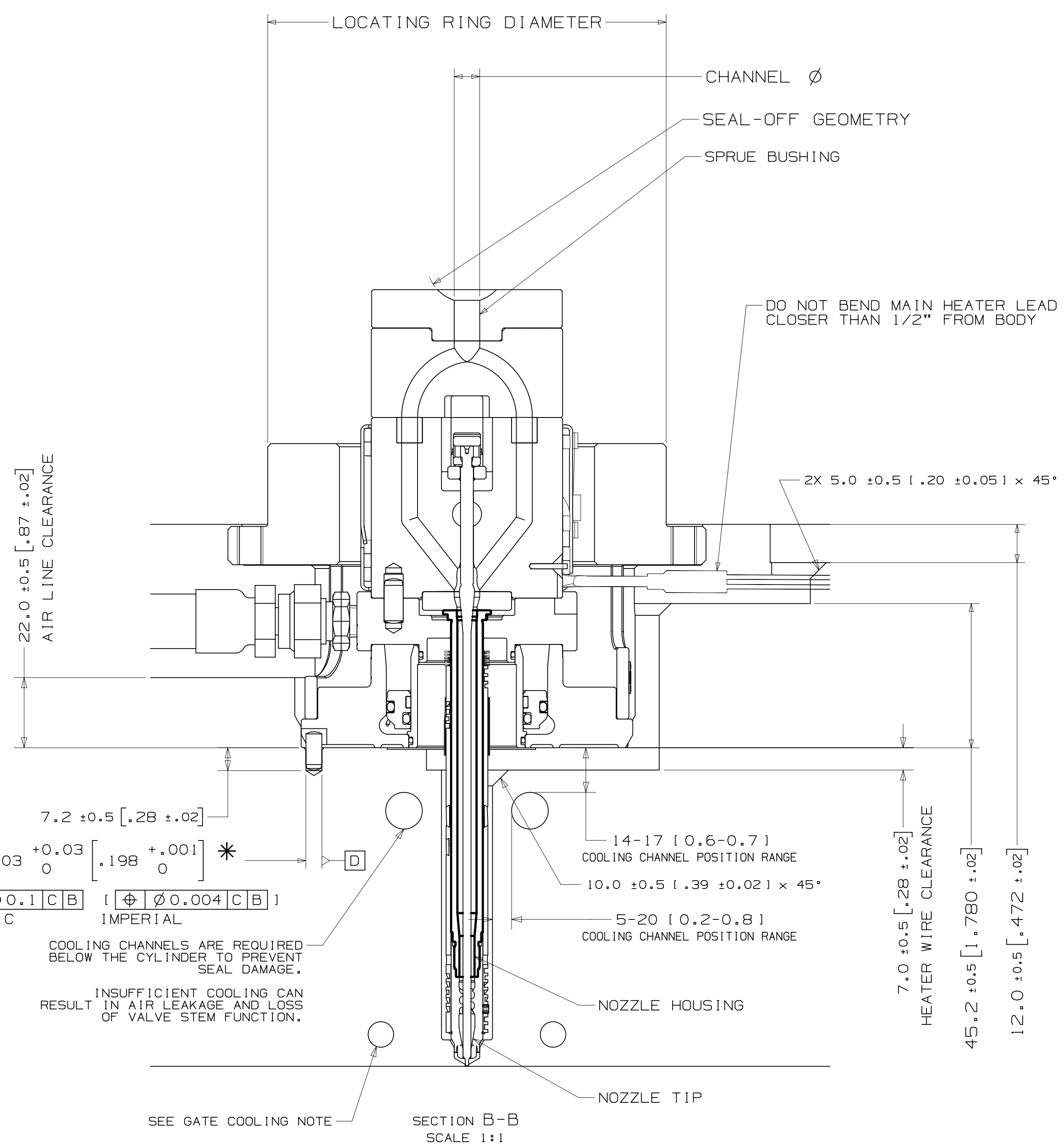
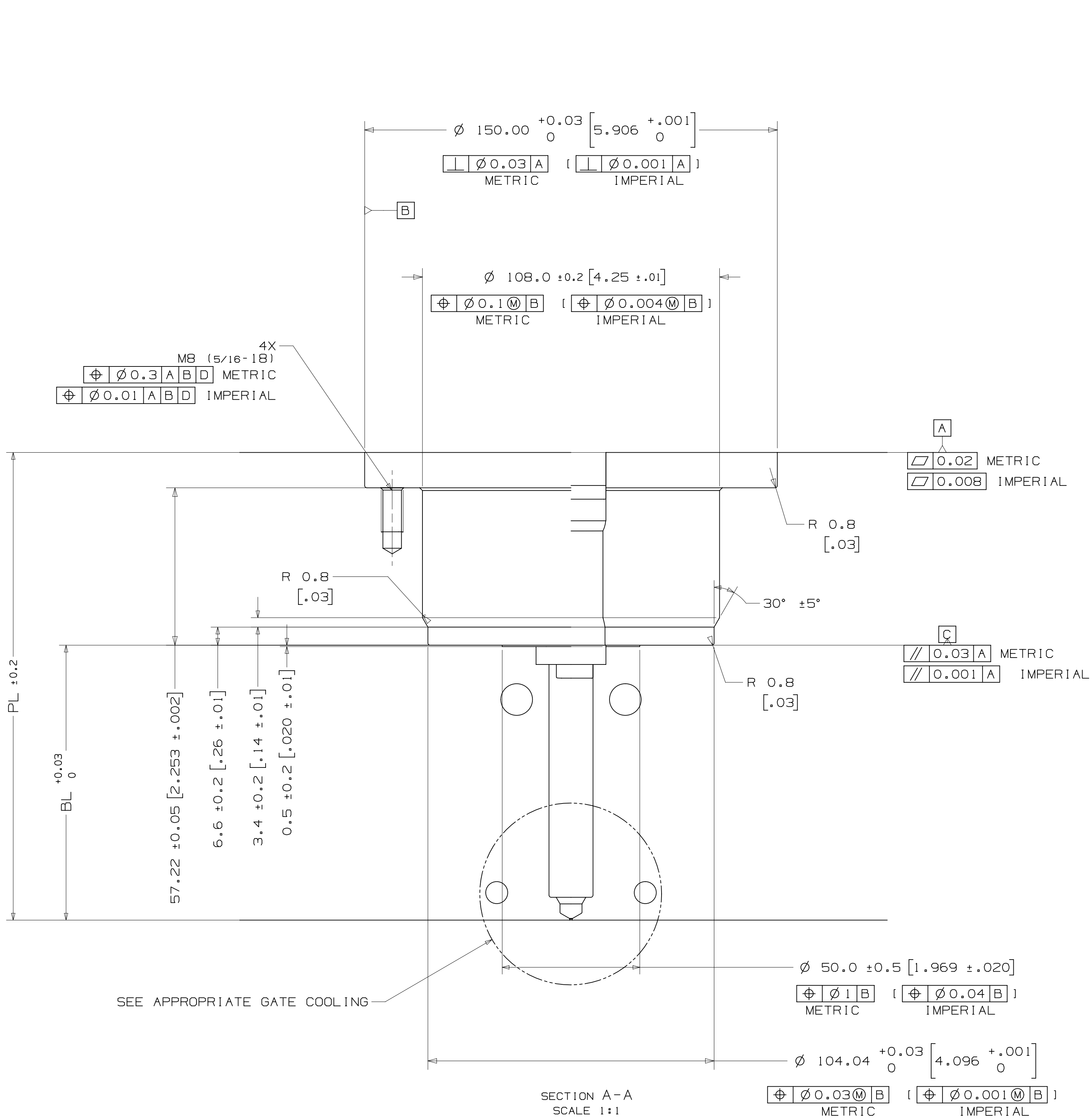


INSTALLATION DRAWING



* THIS DOWEL INSTALLATION IS ONLY REQUIRED IF THE NOZZLE TIP WILL BE REMOVED WHILE THE SCVG IS INSTALLED IN THE MOLD AND FIXED TO THE PLATEN OR FOR APPLICATIONS REQUIRING KEYS VALVE STEMS. THE DOWEL MUST BE ORIENTED IN LINE WITH THE AIR LINES.



NOZZLE SERIES	NOZZLE TIP	PL RANGE	Approx. BL
U350	UH-T2	109.33(4,304) - 259.67(10,223)	40(1,57) - 180(7,07)

*Approx. BL VALUES IN THE TABLE ARE REFERENCES WHICH CAN DEVIATE BY +/-1mm. FINAL BL VALUE CAN BE FOUND ON GATE DETAIL DRAWING AND 3D AFTER FINISHED DESIGN. BL AVAILABLE IN THE INCREMENT OF 10mm WITHIN RANGE.

LOCATING RING DIAMETER
U350 100mm
101.3mm [3.99"]
125mm

SPRUE BUSHING	
SEAL-OFF GEOMETRY	CHANNEL Ø IN - OUT
FLAT	4 - 8
FLAT	
SEAL-OFF 12.7 [1/2"]	8 - THRU
SEAL-OFF 15.5	
SEAL-OFF 19.05 [3/4"]	
SEAL-OFF 20	
SEAL-OFF 40	

RECOMMENDED GATE COOLING GUIDELINES
ADEQUATE COOLING IS ESSENTIAL FOR THE PROPER FUNCTION OF THIS SYSTEM. REFER TO THE HOT RUNNER PRODUCT GUIDE FOR MORE DETAILED GUIDELINES.

RECOMMENDED GATE MATERIAL
NOTE: THESE MATERIALS MAY NOT OFFER THE DESIRED RESISTANCE TO ABRASIVE AND/OR CORROSIVE RESINS, FILLERS AND/OR ADDITIVES.
AISI H13 (49-51 Rc)
AISI 420 (49-51 Rc)

RECOMMENDED GATE MANUFACTURING GUIDELINES
- HARDENED GATE INSERTS (49-51) ARE RECOMMENDED WHEN USING SOFTER CAVITY STEELS. SOFTER CAVITIES MAY BE ACCEPTABLE FOR CERTAIN APPLICATIONS. CONTACT YOUR HUSKY REPRESENTATIVE WITH QUESTIONS.
- EDM'ING THE GATE AREA CAUSES MICRO CRACKS WHICH LEAD TO BRITTLE GATE FAILURES. ALSO - DO NOT EDM THE MOLDING SURFACE WITHIN 2mm OF THE GATE HOLE.
- MACHINE THE GATE HOLE AFTER HARDENING TO AVOID EXCESSIVE QUENCH IN THE THIN SECTION DURING HEAT TREAT & RESULTING OVERHARDENING IN THE GATE AREA.
- RECESSED GATES ON THE PRODUCT REDUCE THE GATE AREA STRENGTH LEADING TO GATE FAILURES.
- WELDING THE GATE AREA INCREASES STRESSES AT THE GATE, SOFTENS THE AREA AROUND THE WELD AND CAN CAUSE GATE FAILURES.

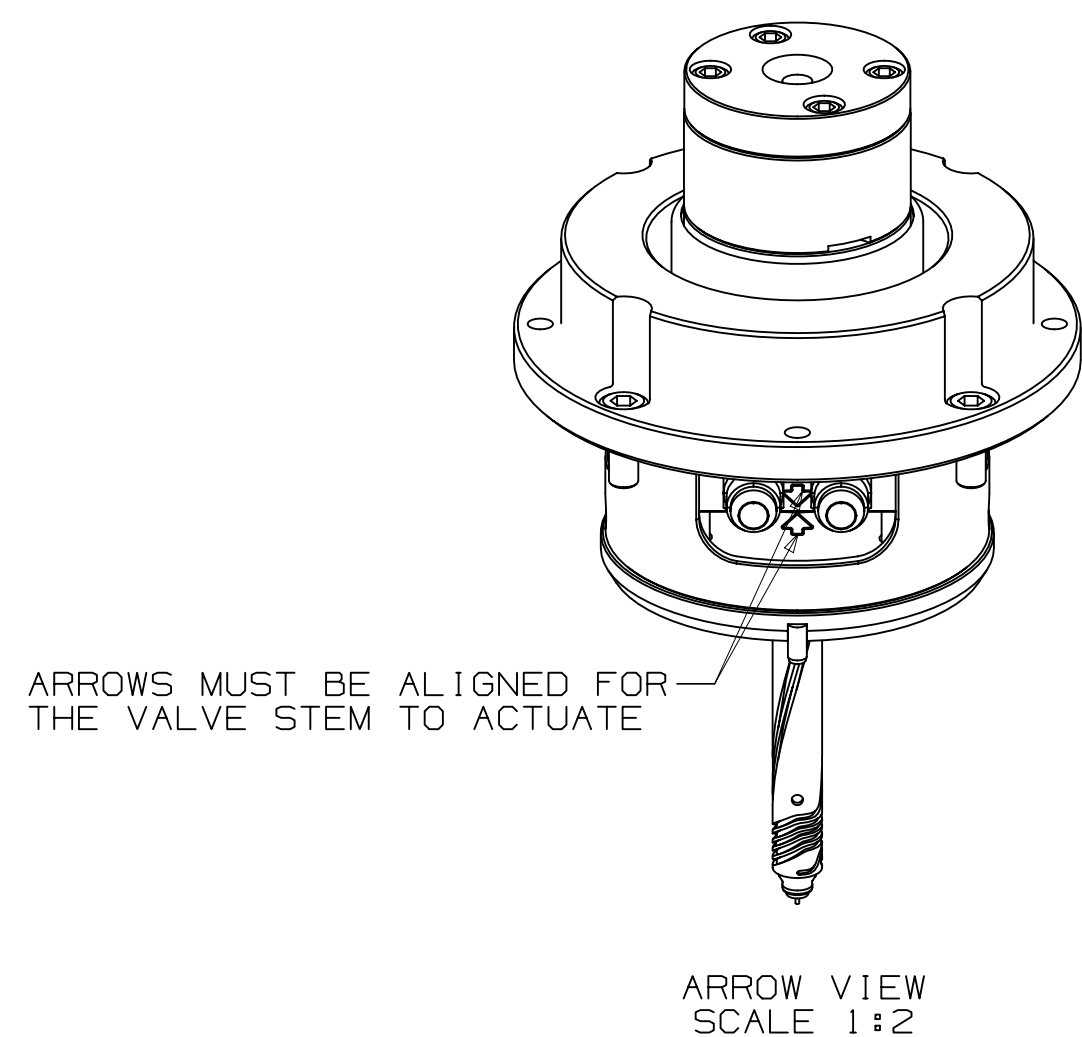
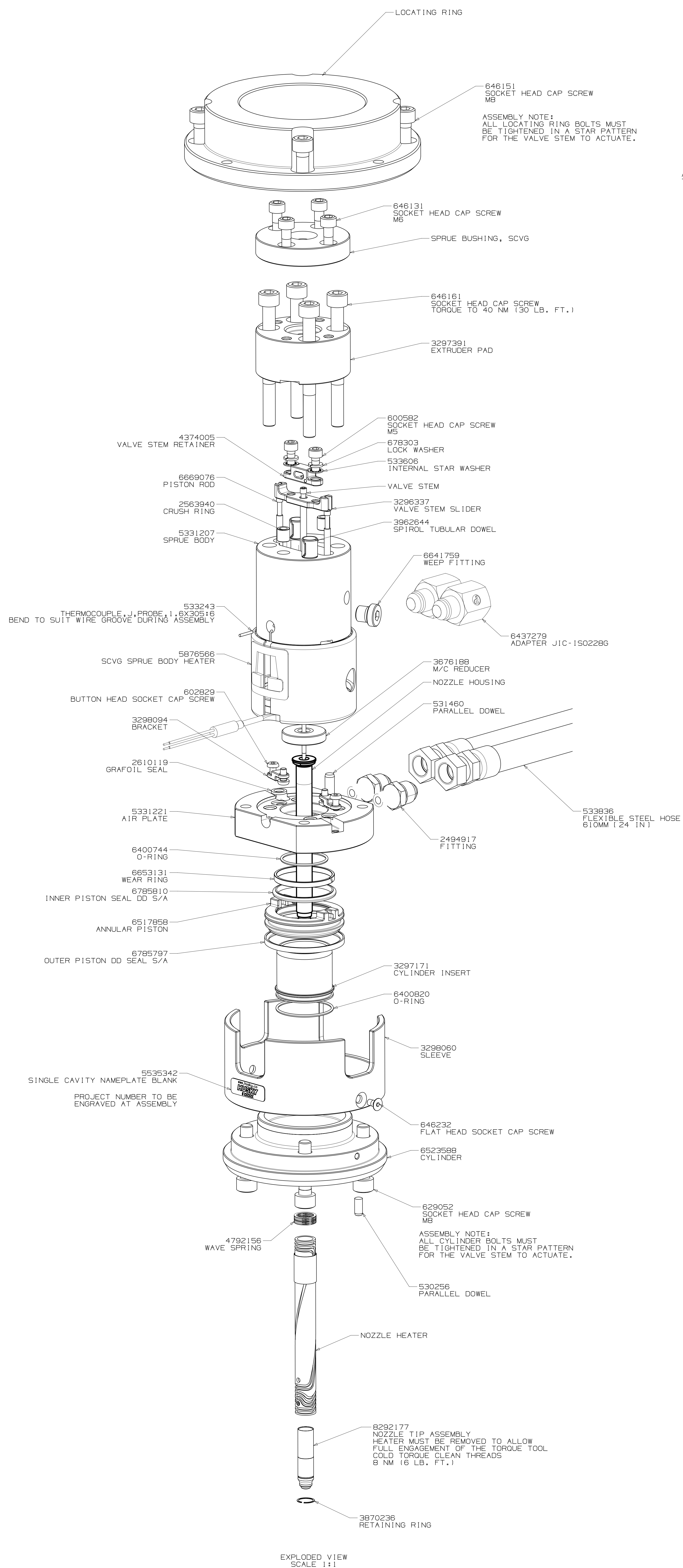
REV	DATE	DESCRIPTION	DRWN	CHKD
1	2020-05-30	TABLE UPDATED PER LATEST CALCULATION	DRWN: DEEBAN N T	CHKD: ANUSHAL S
0	2019-10-17	ORIGINAL ISSUE - DESIGNED BY DEEBAN N T	DRWN: DEEBAN N T	CHKD: ANUSHAL S

DWT PER ASME Y14.3M-1994 AND HEAVY ADDENDUM - H254		UNFINISHED DRAWING FEATURES		MATERIAL		FINISH/TREATMENT		WEIGHT	
GENERAL TOLERANCES	METRIC	ASME Y14.3M-1994	ISO 2768-M	N/A	NO FINISH/TREATMENT SPECIFIED	NO FINISH/TREATMENT SPECIFIED	NO FINISH/TREATMENT SPECIFIED	NO FINISH/TREATMENT SPECIFIED	NO FINISH/TREATMENT SPECIFIED
BROKEN EDGES/CHAMFER	1 ± 0.2 X 45°	RO, B ± 0.2	RO, D ± 0.01						
FILLET ROUNDS	RO, B ± 0.2	RO, D ± 0.01							
SURFACE FINISH	6.3								

TITLE	SCALE	SIZE	DRAWING	REV
Single Cavity Valve Gate	1:1	AOR	9615540	0

ASSEMBLY DRAWING

REV 0
9615540



FLEXIBLE STEEL HOSE HAS:		
METRIC		
3/8-ISO 228 G		
FEMALE THREAD ADAPTER		
UNLESS OTHERWISE SPECIFIED TORQUE TO HUSKY SPECIFICATION HS 252		
PRELOAD CLASS HGT-80		
SIZE	Nm	lb.-ft.
#8	5	4
#10	7	5
5/16	16	12
3/8	25	18
7/16	35	25
1/2	50	35
5/8	70	50
3/4	100	70
7/8	150	100
1	200	150
M4	4.0	3.0
M5	5.0	3.5
M6	7.0	5.0
M8	10.0	7.0
M10	15.0	10.0
M12	20.0	15.0
M14	30.0	20.0
M16	40.0	25.0
M20	60.0	40.0
M25	100.0	70.0

VALVE STEM STROKE IS 7.3 (.29)	
ELECTRICAL INFO (240 VAC)	
ZONE	ZONE DESCRIPTION
1	SPRUE BODY
2	NOZZLE TIP
T/C LEADS: WHITE = (+) RED = (-)	

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www.husky.ca

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REV	DATE	DESCRIPTION	DRWN	CHKD
1	2020-05-30	TABLE UPDATED PER LATEST CALCULATION	DRWN1 DEEBAN N T	CHKD1 DEEBAN N T
0	2019-10-17	ORIGINAL ISSUE - DESIGNED BY DEEBAN N T	DRWN1 DEEBAN N T	CHKD1 ANUSHAL S

DEFINING DRAWING FEATURES	METRIC	HUSKY
MATERIAL: N/A	SCALE: 1:1	TITLE: Single Cavity Valve Gate
FINISH/TREATMENT	SCALE: 1:1	SIZE: U350_SCVG-UH-T2
WEIGHT: - kg	SHEET 2 OF 2	REV: 0