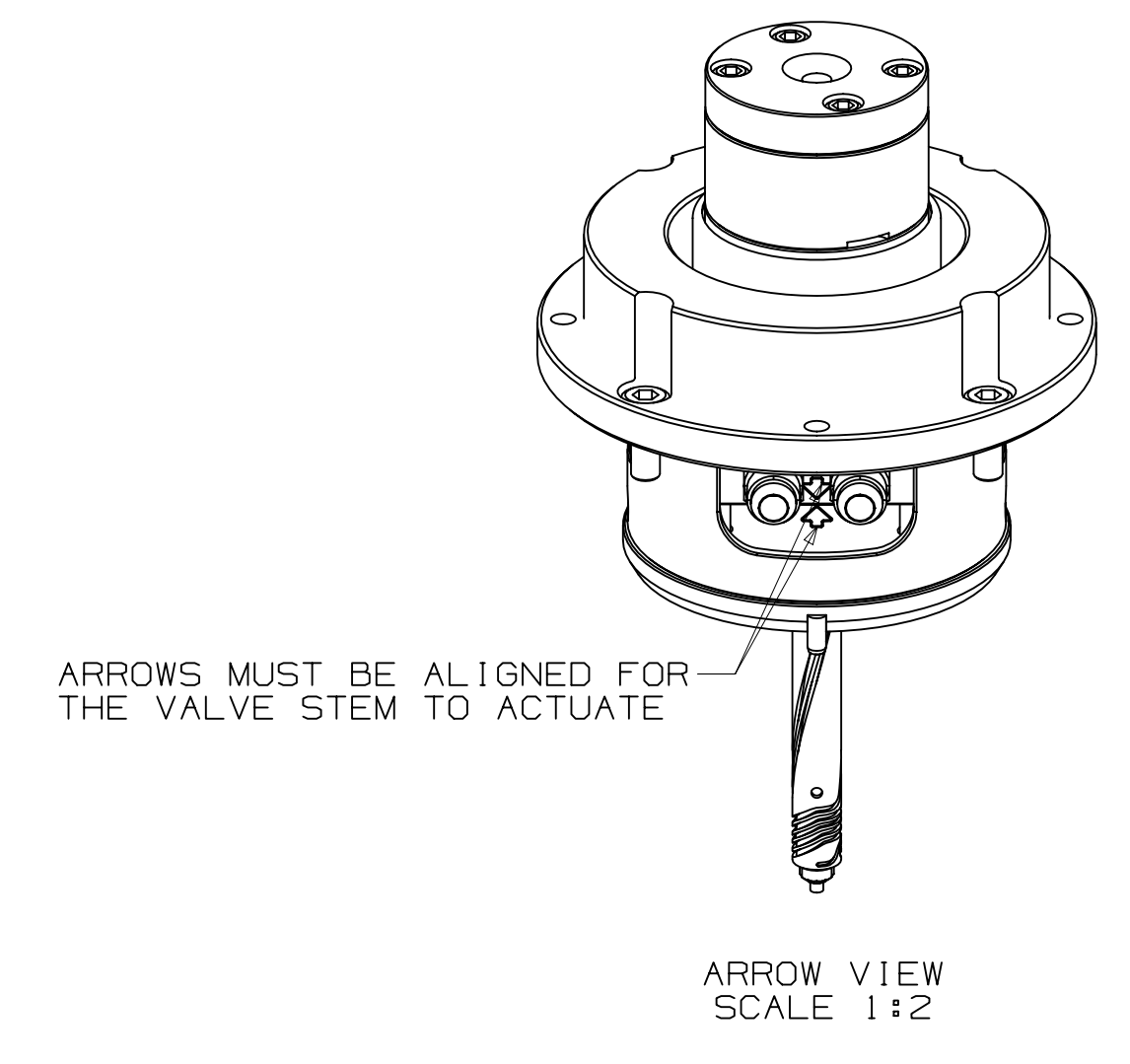
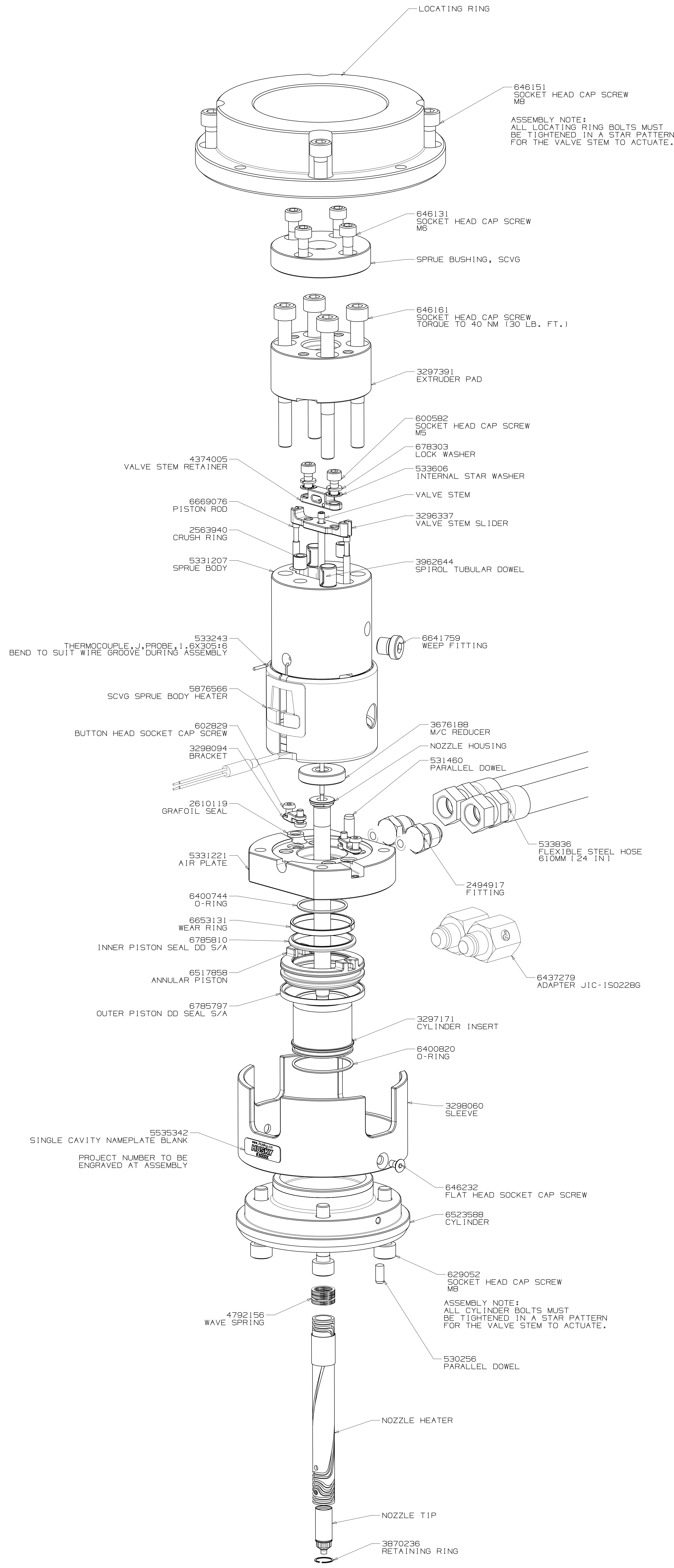


ASSEMBLY DRAWING

REV: 0
STATUS: 8148773



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	5.2
5/16	16	12
3/8	25	18
7/16	35	26
1/2	50	37
5/8	75	55
3/4	100	74
7/8	150	110
1	200	148
M4	4.0	3.0
M5	5.0	3.7
M6	7.0	5.2
M8	11.0	8.1
M10	17.0	12.5
M12	23.0	17.0
M14	31.0	23.0
M16	40.0	29.5
M20	65.0	48.0
M25	110.0	81.0

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 = (-)	

RECOMMENDED GATE COOLING GUIDELINES
ADEQUATE COOLING IS ESSENTIAL FOR THE PROPER FUNCTION OF THIS SYSTEM. REFER TO THE HOT RUNNER PRODUCT GUIDE www.husky.ca 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	NAME
5	2020-05-28	TABLE UPDATED PER LATEST CALCULATION	DRWNI DEEBAN N T
4	2019-07-29	TIP PROTRUSION AND BL DIMENSIONS IN CHART UPDATED	DRWNI DEEBAN N T
3	2019-07-09	TEMPLATE VALUES UPDATED AS PER SOL 2.0	DRWNI MURALIDHARAN
2	2018-01-25	DRAWING NAME CHANGED	DRWNI ANUSHAL
0	2017-09-13	ORIGINAL ISSUE - DESIGNED BY: DHANANLEYAN	DRWNI DHANANLEYAN
			CHKDI PICHLER KLAUS

DEFINING DRAWING FEATURES		MATERIAL: N/A		FINISH/TREATMENT		WEIGHT	
METRIC HUSKY TITLE: Single Cavity Valve Gate U350-SCVG-UH_VG		SCALE: 1:1		DRAWING: 8148773		REV: 0	
SHEET 2 OF 2		AOR		8148773		0	