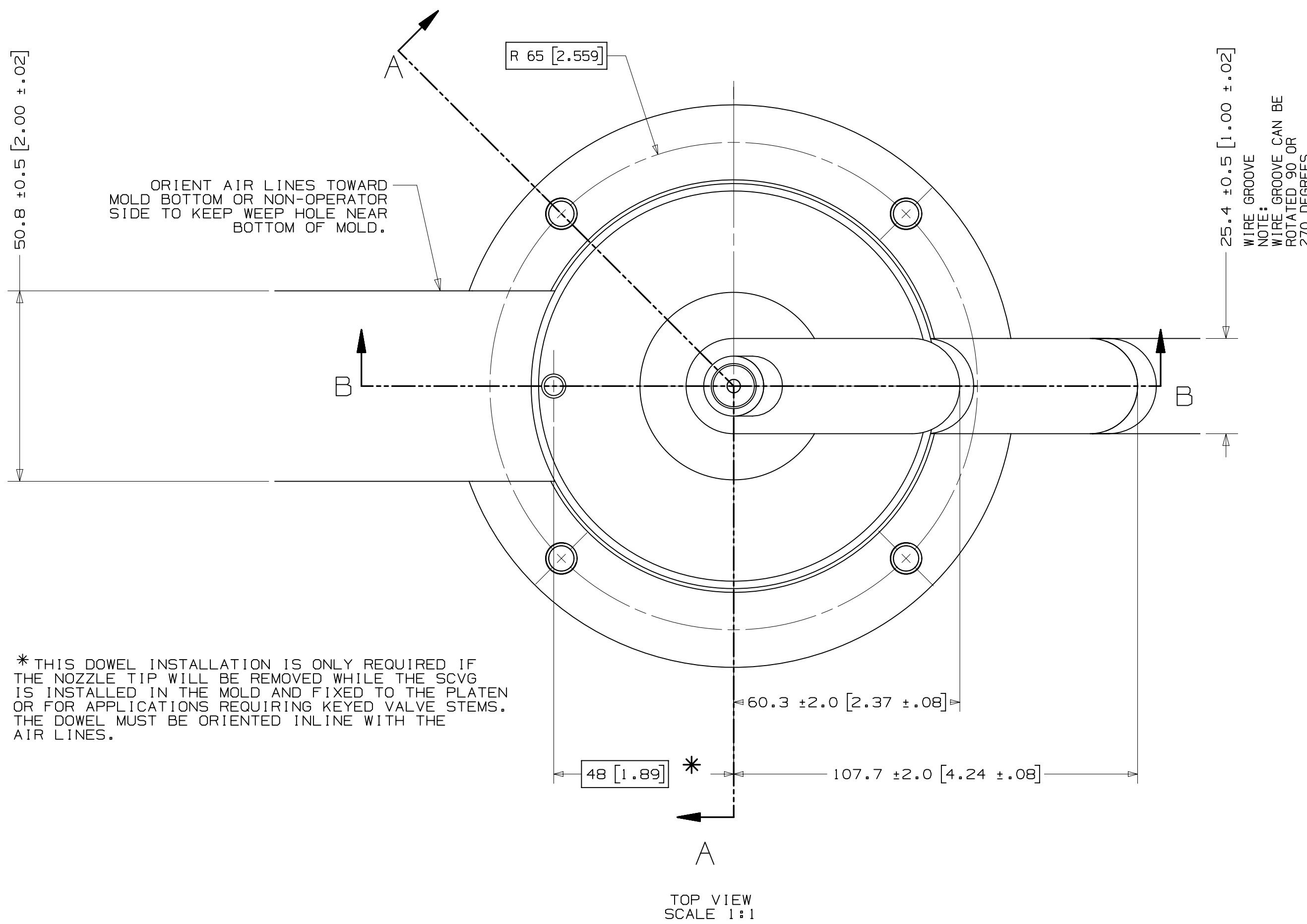


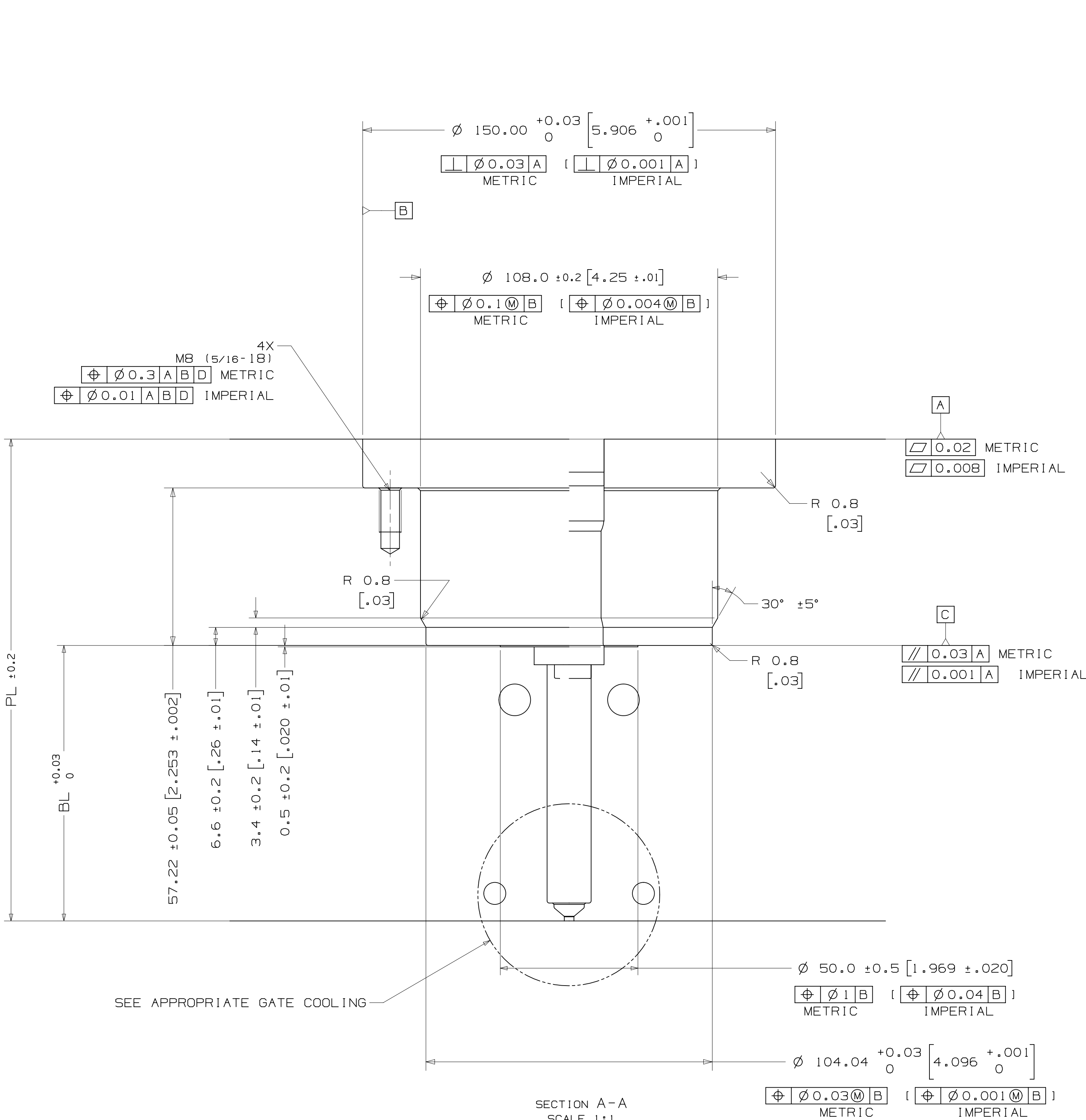
INSTALLATION DRAWING

REV: 0
8148773

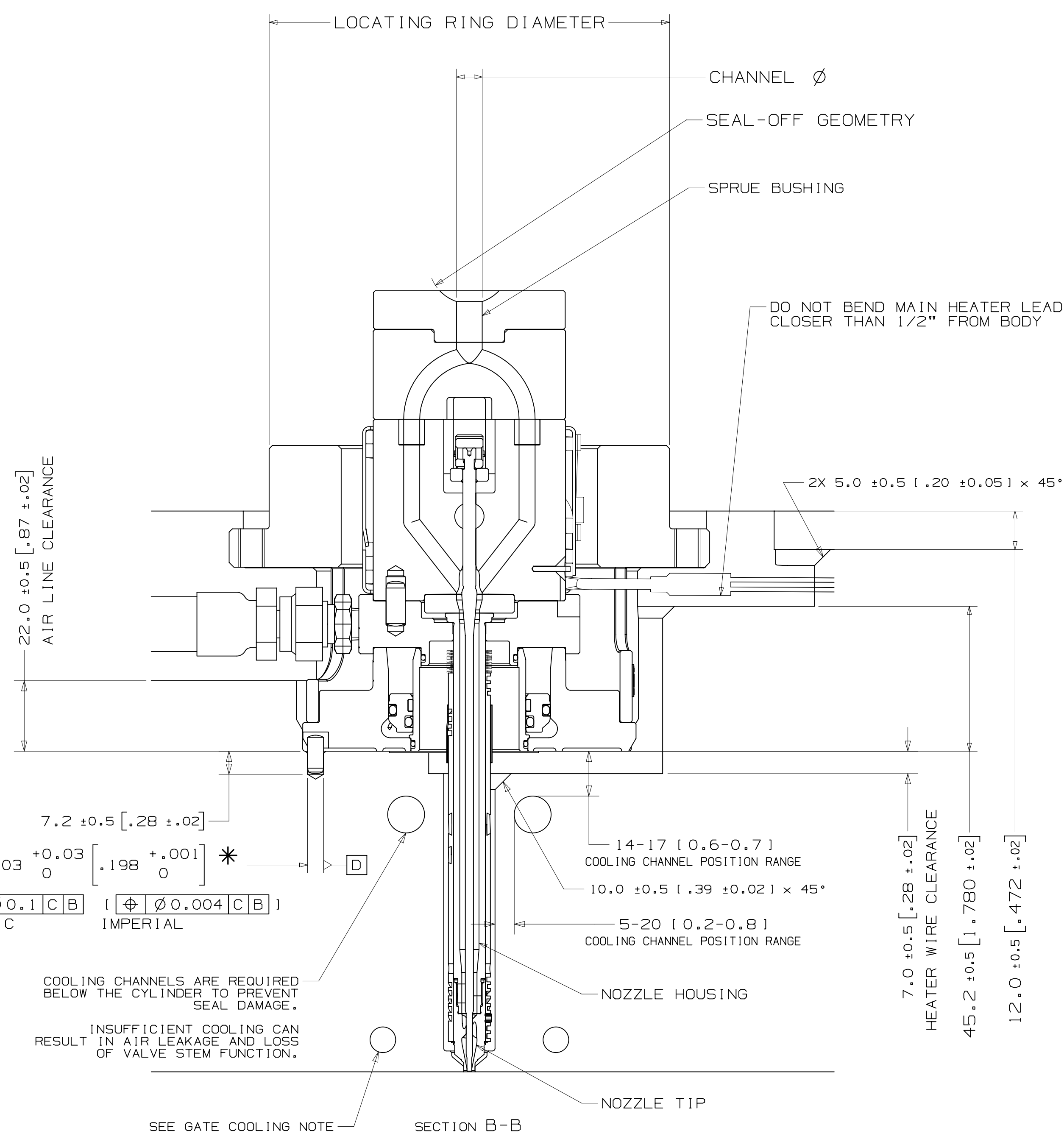


* THIS DOWEL INSTALLATION IS ONLY REQUIRED IF THE NOZZLE TIP WILL BE REMOVED WHILE THE SCVGS IS INSTALLED IN THE MOLD AND FIXED TO THE PLATEN OR FOR APPLICATIONS REQUIRING KEYS VALVE STEMS. THE DOWEL MUST BE ORIENTED IN LINE WITH THE AIR LINES.

TOP VIEW
SCALE 1:1



SECTION A-A
SCALE 1:1



SECTION B-B
SCALE 1:1

NOZZLE SERIES	NOZZLE TIP	NOZZLE HOUSING	PL		"BL" AT DELTA TEMP (DELTA TEMP = TEMP OF MELT - TEMP OF MOLD) *															
			MIN [INCH]	MAX [INCH]	60° C-79° C [149° F-174° F]	80° C-99° C [176° F-210° F]	100° C-119° C [212° F-245° F]	120° C-139° C [248° F-282° F]	140° C-159° C [284° F-318° F]	160° C-179° C [320° F-354° F]	180° C-199° C [356° F-390° F]	200° C-219° C [392° F-428° F]	220° C-239° C [428° F-462° F]	240° C-259° C [464° F-498° F]	260° C-279° C [500° F-534° F]	280° C-300° C [536° F-572° F]				
U350	UH-V6	55	99.33 [3.911]	108.25 [4.266]	29.55 [1.163]	29.56 [1.164]	29.58 [1.165]	29.59 [1.165]	29.60 [1.165]	29.62 [1.166]	29.63 [1.167]	29.65 [1.167]	29.66 [1.168]	29.67 [1.168]	29.69 [1.169]	29.71 [1.170]				
		65	109.35 [4.305]	118.37 [4.660]	39.56 [1.557]	39.57 [1.558]	39.59 [1.559]	39.61 [1.559]	39.62 [1.560]	39.64 [1.561]	39.65 [1.561]	39.67 [1.562]	39.69 [1.563]	39.70 [1.563]	39.72 [1.564]	39.74 [1.565]				
		75	119.37 [4.700]	128.39 [5.055]	49.57 [1.952]	49.58 [1.952]	49.60 [1.953]	49.62 [1.954]	49.64 [1.954]	49.66 [1.955]	49.68 [1.956]	49.70 [1.957]	49.71 [1.957]	49.73 [1.958]	49.76 [1.959]	49.78 [1.960]				
		85	129.39 [5.094]	138.41 [5.449]	59.57 [2.345]	59.59 [2.346]	59.61 [2.347]	59.64 [2.348]	59.66 [2.349]	59.68 [2.350]	59.70 [2.350]	59.72 [2.351]	59.74 [2.352]	59.76 [2.353]	59.79 [2.354]	59.81 [2.355]				
		95	139.41 [5.489]	148.43 [5.844]	69.58 [2.739]	69.60 [2.740]	69.63 [2.741]	69.65 [2.742]	69.67 [2.743]	69.70 [2.744]	69.72 [2.745]	69.74 [2.746]	69.77 [2.747]	69.79 [2.748]	69.82 [2.749]	69.85 [2.750]				
		105	149.43 [5.883]	158.45 [6.238]	79.59 [3.133]	79.61 [3.134]	79.64 [3.135]	79.66 [3.136]	79.69 [3.137]	79.72 [3.139]	79.74 [3.139]	79.77 [3.141]	79.80 [3.142]	79.82 [3.143]	79.85 [3.144]	79.88 [3.145]				
		115	159.45 [6.278]	168.47 [6.633]	89.60 [3.528]	89.62 [3.528]	89.65 [3.530]	89.68 [3.531]	89.71 [3.532]	89.74 [3.533]	89.76 [3.534]	89.79 [3.535]	89.82 [3.536]	89.85 [3.537]	89.89 [3.539]	89.92 [3.540]				
		125	169.47 [6.672]	178.49 [7.027]	99.61 [3.922]	99.63 [3.922]	99.66 [3.924]	99.69 [3.925]	99.72 [3.926]	99.76 [3.928]	99.79 [3.929]	99.82 [3.930]	99.85 [3.931]	99.88 [3.932]	99.92 [3.934]	99.95 [3.935]				
		135	179.49 [7.067]	188.52 [7.422]	109.61 [4.315]	109.65 [4.317]	109.68 [4.318]	109.71 [4.319]	109.74 [4.320]	109.77 [4.322]	109.81 [4.323]	109.84 [4.324]	109.88 [4.326]	109.91 [4.327]	109.95 [4.329]	109.99 [4.330]				
		145	189.52 [7.461]	198.54 [7.817]	119.62 [4.709]	119.66 [4.711]	119.69 [4.712]	119.72 [4.713]	119.76 [4.715]	119.79 [4.716]	119.83 [4.718]	119.87 [4.719]	119.90 [4.720]	119.94 [4.722]	119.98 [4.724]	120.02 [4.725]				
		155	199.54 [7.856]	208.56 [8.211]	129.63 [5.104]	129.67 [5.105]	129.70 [5.106]	129.74 [5.108]	129.78 [5.109]	129.81 [5.111]	129.85 [5.112]	129.89 [5.114]	129.93 [5.115]	129.97 [5.117]	130.02 [5.119]	130.06 [5.120]				
		165	209.56 [8.250]	218.58 [8.606]	139.64 [5.498]	139.68 [5.499]	139.71 [5.500]	139.75 [5.502]	139.79 [5.504]	139.83 [5.505]	139.87 [5.507]	139.92 [5.509]	139.96 [5.510]	140.00 [5.512]	140.05 [5.514]	140.09 [5.515]				
		175	219.58 [8.645]	228.60 [9.000]	149.64 [5.891]	149.69 [5.893]	149.73 [5.895]	149.77 [5.896]	149.81 [5.898]	149.85 [5.900]	149.90 [5.902]	149.94 [5.903]	149.98 [5.905]	150.03 [5.907]	150.08 [5.909]	150.13 [5.911]				
		185	229.60 [9.039]	238.62 [9.394]	159.65 [6.285]	159.70 [6.287]	159.74 [6.289]	159.78 [6.291]	159.83 [6.293]	159.87 [6.294]	159.92 [6.296]	159.96 [6.298]	160.01 [6.300]	160.06 [6.302]	160.11 [6.304]	160.16 [6.306]				
195	239.62 [9.434]	250.00 [9.843]	169.66 [6.680]	169.71 [6.681]	169.75 [6.683]	169.80 [6.685]	169.84 [6.687]	169.89 [6.689]	169.94 [6.691]	169.99 [6.693]	170.04 [6.694]	170.09 [6.696]	170.15 [6.699]	170.20 [6.701]						

* BL VALUES IN THE TABLE ARE REFERENCES WHICH CAN DEVIATE BY +/-0.03mm
FINAL BL VALUE CAN BE FIND ON GATE DETAIL DRAWING AND 3D AFTER FINISHED DESIGN.

NOTE:
TIP PROTRUSION INTO CAVITY IN HOT CONDITION 0.2 mm

NOZZLE SERIES	LOCATING RING DIAMETER	SPRUE BUSHING	
		SEAL-OFF GEOMETRY SPHERICAL RADIUS	CHANNEL Ø IN - OUT
U350	100mm	FLAT	4 - B
		FLAT	B - THRU
	101.3mm [3.99"]	SEAL-OFF [2.7 [1/2"]	
		SEAL-OFF 15.5	
125mm	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.
www.husky.co

RECOMMENDED GATE MATERIAL
NOTE: THESE MATERIALS MAY NOT OFFER THE DESIRED RESISTANCE TO ABRASIVE AND/OR CORROSIVE RESINS, FILLERS AND/OR ADDITIVES
A1S1 H13 [49-51 Rc]
A1S1 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
0	2017-09-13	ORIGINAL ISSUE - DESIGNED BY: DHANALEKIAN

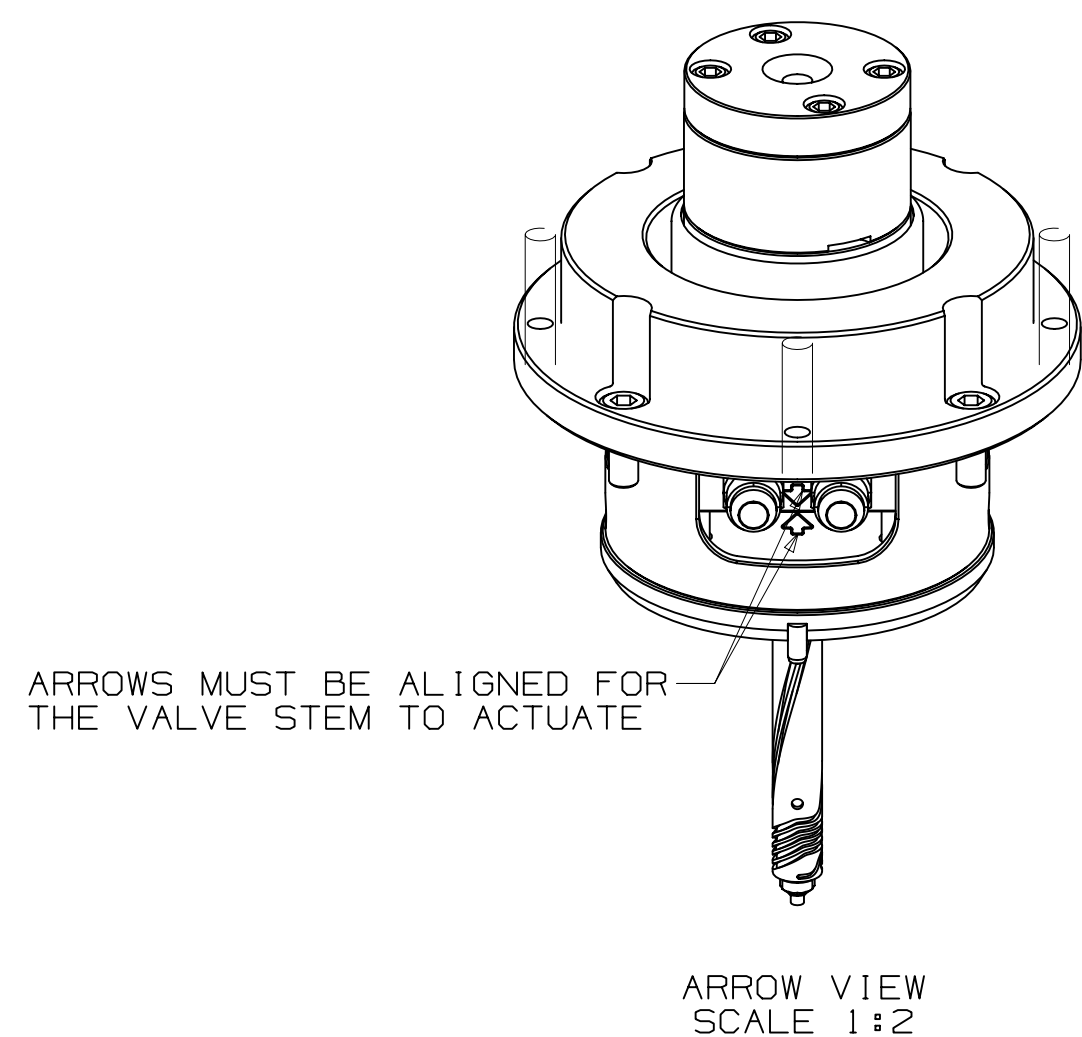
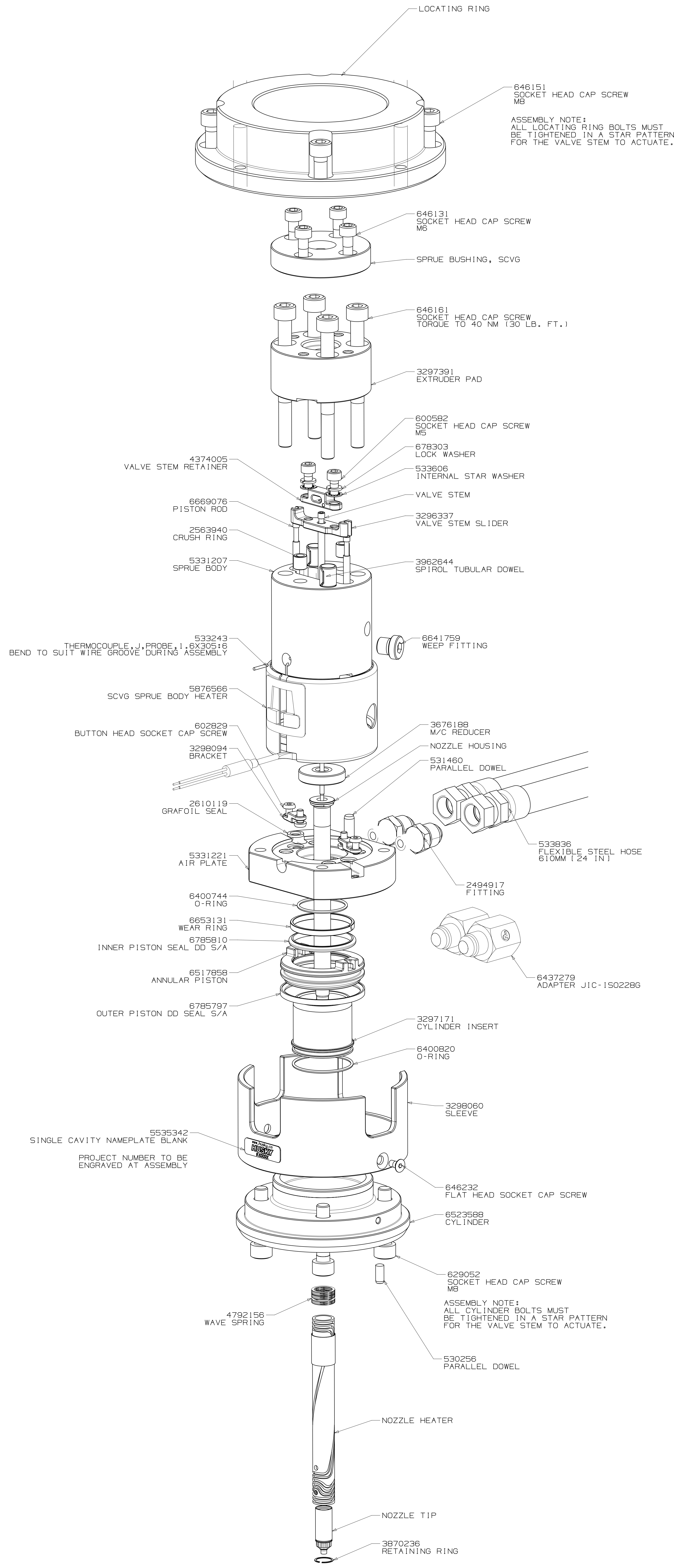
DRWN	CHKD	APPV

GENERAL TOLERANCES	METRIC	IMPERIAL
UNLESS OTHERWISE SPECIFIED:		
BROKEN EDGES/CHAMFER	R0.5 ± 0.2	R0.03 ± 0.01
FILLET ROUNDS	R0.5 ± 0.2	R0.03 ± 0.01
SURFACE FINISH	3.2	

<p>ISO 9001:2015 ISO 14001:2015 ISO 45001:2018</p>	<p>ISO 9001:2015 ISO 14001:2015 ISO 45001:2018</p>	<p>ISO 9001:2015 ISO 14001:2015 ISO 45001:2018</p>	<p>ISO 9001:2015 ISO 14001:2015 ISO 45001:2018</p>	<p>ISO 9001:2015 ISO 14001:2015 ISO 45001:2018</p>	<p>ISO 9001:2015 ISO 14001:2015 ISO 45001:2018</p>	<p>ISO 9001:2015 ISO 14001:2015 ISO 45001:2018</p>	<p>ISO 9001:2015 ISO 14001:2015 ISO 45001:2018</p>	<p>ISO 9001:2015 ISO 14001:2015 ISO 45001:2018</p>	<p>ISO 9001:2015 ISO 14001:2015 ISO 45001:2018</p>	<p>ISO 9001:2015 ISO 14001:2015 ISO 45001:2018</p>	<p>ISO 9001:2015 ISO 14001:2015 ISO 45001:2018</p>	<p>ISO 9001:2015 ISO 14001:2015 ISO 45001:2018</p>	<p>ISO 9001:2015 ISO 14001:2015 ISO 45001:2018</p>	<p>ISO 9001:2015 ISO 14001:2015 ISO 45001:2018</p>	<p>ISO 9001:2015 ISO 14001:2015 ISO 45001:2018</p>	<p>ISO 9001:2015 ISO 14001:2015 ISO 45001:2018</p>	<p>ISO 9001:2015 ISO 14001:2015 ISO 45001:2018</p>	<p>ISO 9001:2015 ISO 14001:2015 ISO 45001:2018</p>
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ASSEMBLY DRAWING

STATUS: 8148773 0



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	26
1/2	50	37
5/8	70	52
3/4	100	74
7/8	150	110
1	200	148
M4	4.0	3.0
M5	5.0	3.7
M6	6.0	4.4
M8	10.0	7.4
M10	15.0	11.0
M12	20.0	14.8
M14	25.0	18.5
M16	35.0	25.8
M20	50.0	36.8
M25	75.0	55.1

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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REV	DATE	DESCRIPTION	DRWN	CHKD
0	2017-09-13	ORIGINAL ISSUE - DESIGNED BY: DHANALEKIAN	DRWN1	CHKD1
			DRWN2	CHKD2
			DRWN3	CHKD3
			DRWN4	CHKD4
			DRWN5	CHKD5
			DRWN6	CHKD6
			DRWN7	CHKD7
			DRWN8	CHKD8
			DRWN9	CHKD9
			DRWN10	CHKD10

UNFINISHED DRAWING FEATURES		MATERIAL: N/A		FINISH/TREATMENT	
SCALE: 1:1		DRAWING: 8148773		REV: 0	
SHEET 2 OF 2		AOR			