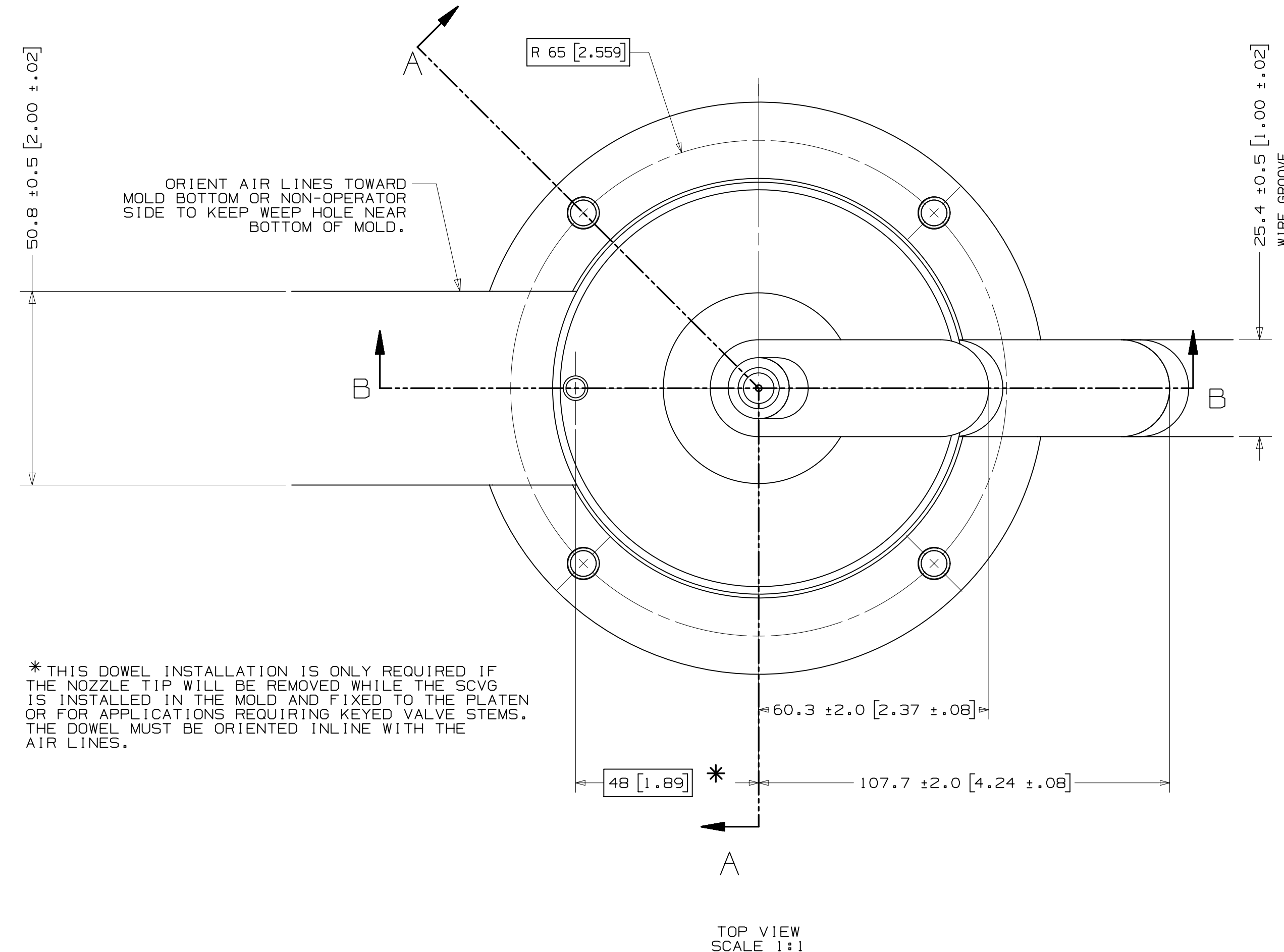
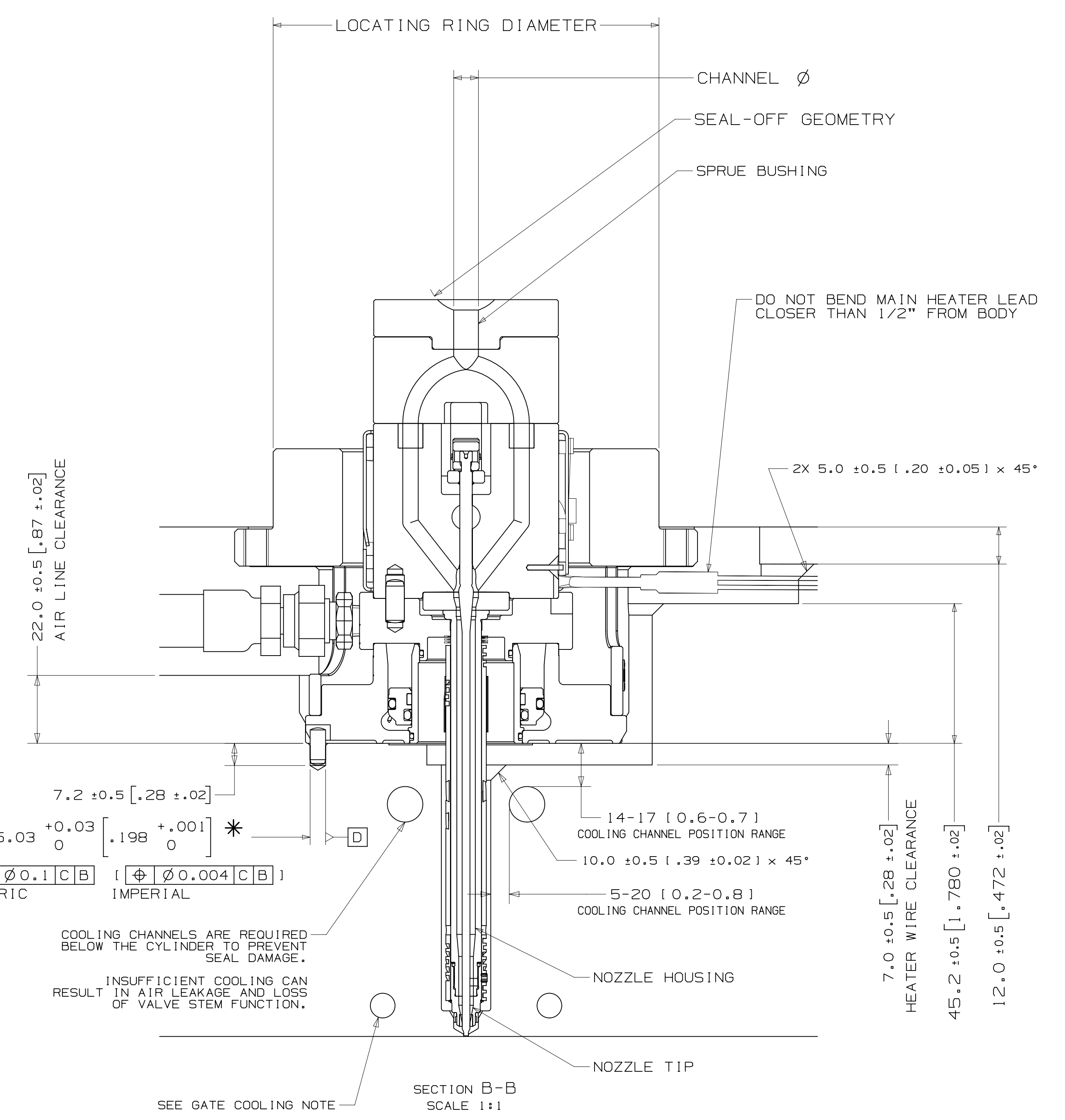
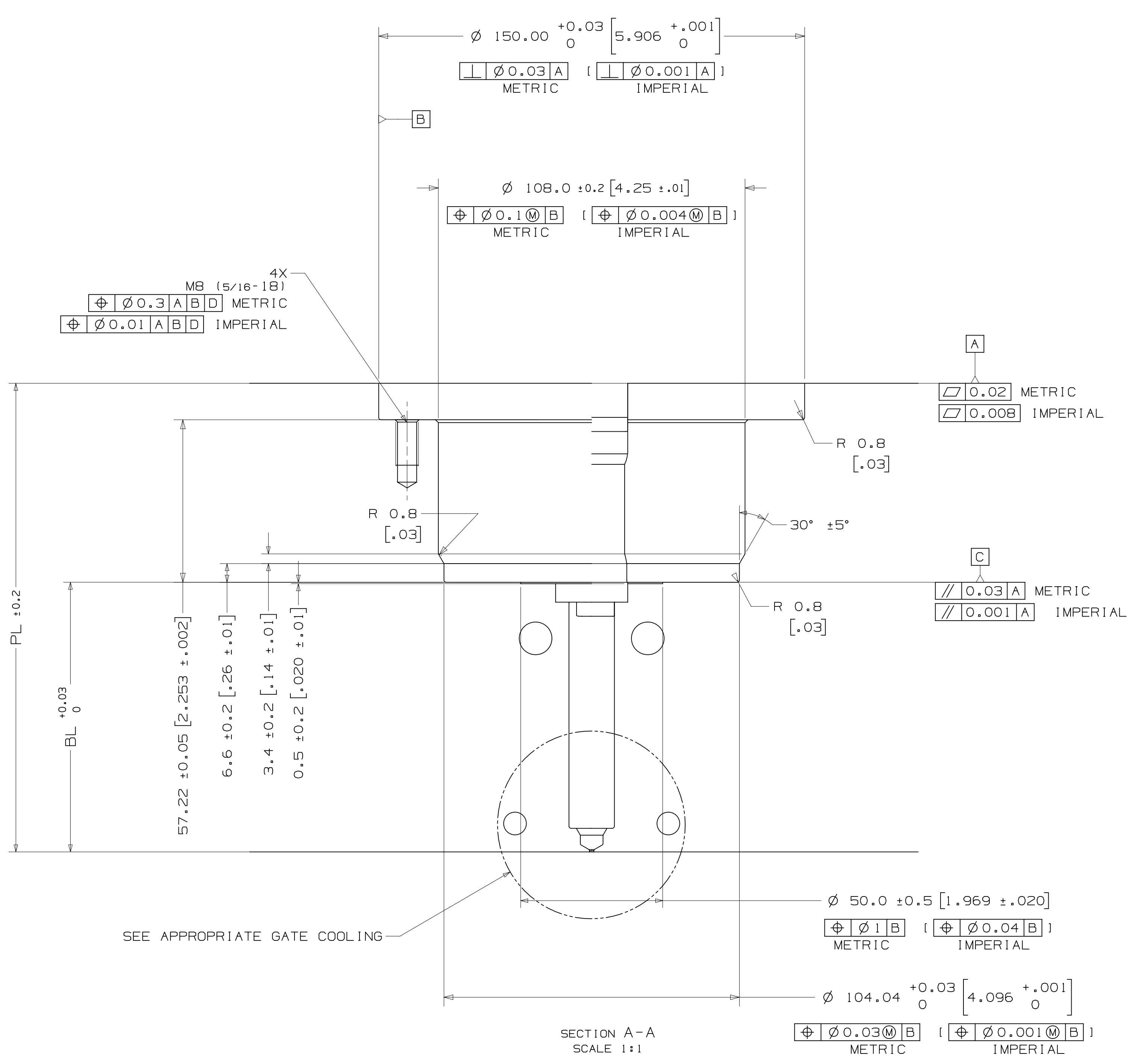


INSTALLATION DRAWING

REV 0
STATUS 8146855



* 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 FOR APPLICATIONS REQUIRING KEYS VALVE STEMS. THE DOWEL MUST BE ORIENTED IN LINE WITH THE AIR LINES.



NOZZLE SERIES	NOZZLE TIP	NOZZLE HOUSING	PL	*BL* AT DELTA TEMP (DELTA TEMP = TEMP OF MELT - TEMP OF MOLD) *															
				60° C-79° C 140° F-174° F	80° C-99° C 176° F-210° F	100° C-119° C 212° F-246° 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 382° 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	VG	55	94 [3.701]	103 [4.055]	24.65 [0.970]	24.66 [0.971]	24.68 [0.972]	24.69 [0.972]	24.70 [0.972]	24.71 [0.973]	24.73 [0.974]	24.74 [0.974]	24.75 [0.974]	24.77 [0.975]	24.79 [0.976]	24.80 [0.976]			
		65	104 [4.094]	113 [4.449]	34.66 [1.365]	34.67 [1.365]	34.69 [1.366]	34.70 [1.366]	34.72 [1.367]	34.73 [1.367]	34.75 [1.368]	34.77 [1.369]	34.78 [1.369]	34.80 [1.370]	34.82 [1.371]	34.83 [1.371]			
		75	114 [4.488]	123 [4.843]	44.67 [1.759]	44.68 [1.759]	44.70 [1.760]	44.72 [1.761]	44.74 [1.761]	44.75 [1.762]	44.77 [1.763]	44.79 [1.763]	44.81 [1.764]	44.83 [1.765]	44.85 [1.766]	44.87 [1.767]			
		85	124 [4.882]	133 [5.236]	54.67 [2.152]	54.69 [2.153]	54.71 [2.154]	54.73 [2.155]	54.75 [2.156]	54.77 [2.156]	54.79 [2.157]	54.81 [2.158]	54.84 [2.159]	54.86 [2.160]	54.88 [2.161]	54.90 [2.161]			
		95	134 [5.276]	143 [5.630]	64.68 [2.546]	64.70 [2.547]	64.72 [2.548]	64.75 [2.549]	64.77 [2.550]	64.79 [2.551]	64.82 [2.552]	64.84 [2.553]	64.86 [2.554]	64.89 [2.555]	64.92 [2.556]	64.94 [2.557]			
		105	144 [5.689]	153 [6.024]	74.69 [2.941]	74.71 [2.941]	74.74 [2.943]	74.76 [2.943]	74.79 [2.944]	74.81 [2.945]	74.84 [2.946]	74.86 [2.947]	74.89 [2.948]	74.92 [2.949]	74.95 [2.951]	74.97 [2.952]			
		115	154 [6.063]	163 [6.417]	84.70 [3.335]	84.72 [3.335]	84.75 [3.337]	84.78 [3.338]	84.80 [3.339]	84.83 [3.340]	84.86 [3.341]	84.89 [3.342]	84.92 [3.343]	84.95 [3.344]	84.98 [3.346]	85.01 [3.347]			
		125	164 [6.457]	173 [6.811]	94.70 [3.730]	94.73 [3.730]	94.76 [3.731]	94.79 [3.732]	94.82 [3.733]	94.85 [3.734]	94.88 [3.735]	94.91 [3.737]	94.94 [3.738]	94.98 [3.739]	95.01 [3.741]	95.04 [3.742]			
		135	174 [6.850]	183 [7.205]	104.71 [4.122]	104.74 [4.124]	104.77 [4.125]	104.81 [4.126]	104.84 [4.128]	104.87 [4.129]	104.90 [4.130]	104.94 [4.131]	104.97 [4.133]	105.01 [4.134]	105.04 [4.135]	105.08 [4.137]			
		145	184 [7.244]	193 [7.598]	114.72 [4.517]	114.75 [4.518]	114.79 [4.519]	114.82 [4.520]	114.86 [4.522]	114.89 [4.523]	114.93 [4.525]	114.96 [4.526]	115.00 [4.528]	115.03 [4.529]	115.08 [4.531]	115.12 [4.532]			
		155	194 [7.638]	203 [7.992]	124.73 [4.911]	124.76 [4.912]	124.80 [4.913]	124.84 [4.915]	124.87 [4.916]	124.91 [4.918]	124.95 [4.919]	124.99 [4.921]	125.03 [4.922]	125.06 [4.924]	125.11 [4.926]	125.15 [4.927]			
		165	204 [8.031]	213 [8.386]	134.74 [5.305]	134.77 [5.306]	134.81 [5.307]	134.85 [5.309]	134.89 [5.311]	134.93 [5.312]	134.97 [5.314]	135.01 [5.315]	135.05 [5.317]	135.09 [5.319]	135.14 [5.320]	135.19 [5.322]			
		175	214 [8.425]	223 [8.780]	144.74 [5.698]	144.78 [5.700]	144.82 [5.702]	144.86 [5.703]	144.91 [5.705]	144.95 [5.707]	144.99 [5.709]	145.04 [5.710]	145.08 [5.712]	145.12 [5.713]	145.17 [5.715]	145.22 [5.717]			
		185	224 [8.819]	234 [9.213]	154.75 [6.093]	154.79 [6.094]	154.84 [6.096]	154.88 [6.098]	154.92 [6.099]	154.97 [6.101]	155.01 [6.103]	155.06 [6.105]	155.11 [6.107]	155.15 [6.108]	155.21 [6.111]	155.26 [6.113]			
195	235 [9.252]	245 [9.646]	164.76 [6.487]	164.80 [6.488]	164.85 [6.490]	164.89 [6.492]	164.94 [6.494]	164.99 [6.496]	165.04 [6.498]	165.09 [6.499]	165.13 [6.501]	165.18 [6.503]	165.24 [6.506]	165.29 [6.507]					

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

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

SPRUE BUSHING	
U350	SEAL-OFF GEOMETRY SPHERICAL RADIUS
	FLAT
	FLAT
	SEAL-OFF 12.7 [1/2"]
	SEAL-OFF 15.5
	SEAL-OFF 19.05 [3/4"]
	SEAL-OFF 20
	SEAL-OFF 40
	CHANNEL Ø IN - OUT
	4 - B
	B - THRU

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 ABRASION 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
0	2017-09-12	ORIGINAL ISSUE - DESIGNED BY: DHANANLEYAN

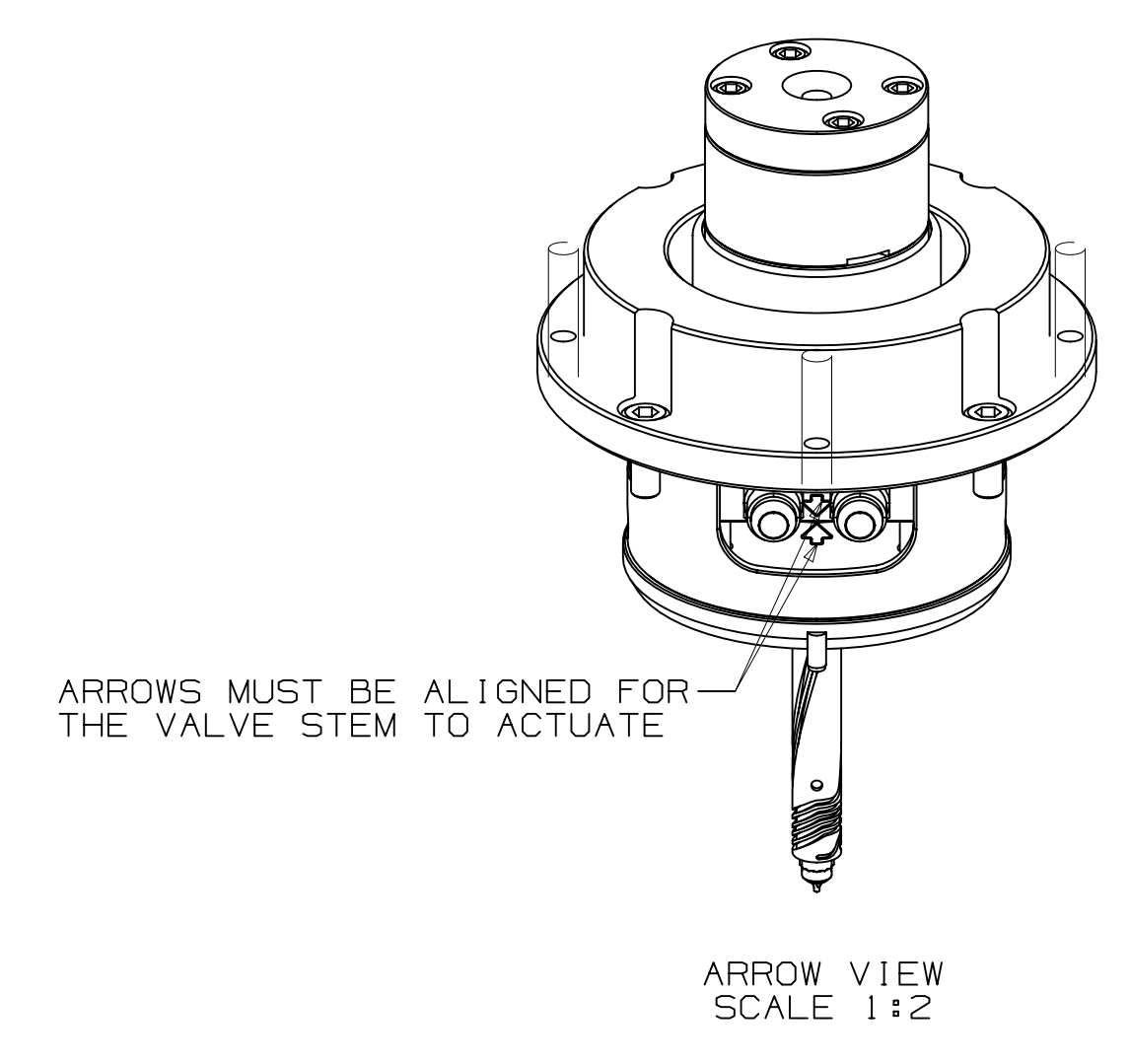
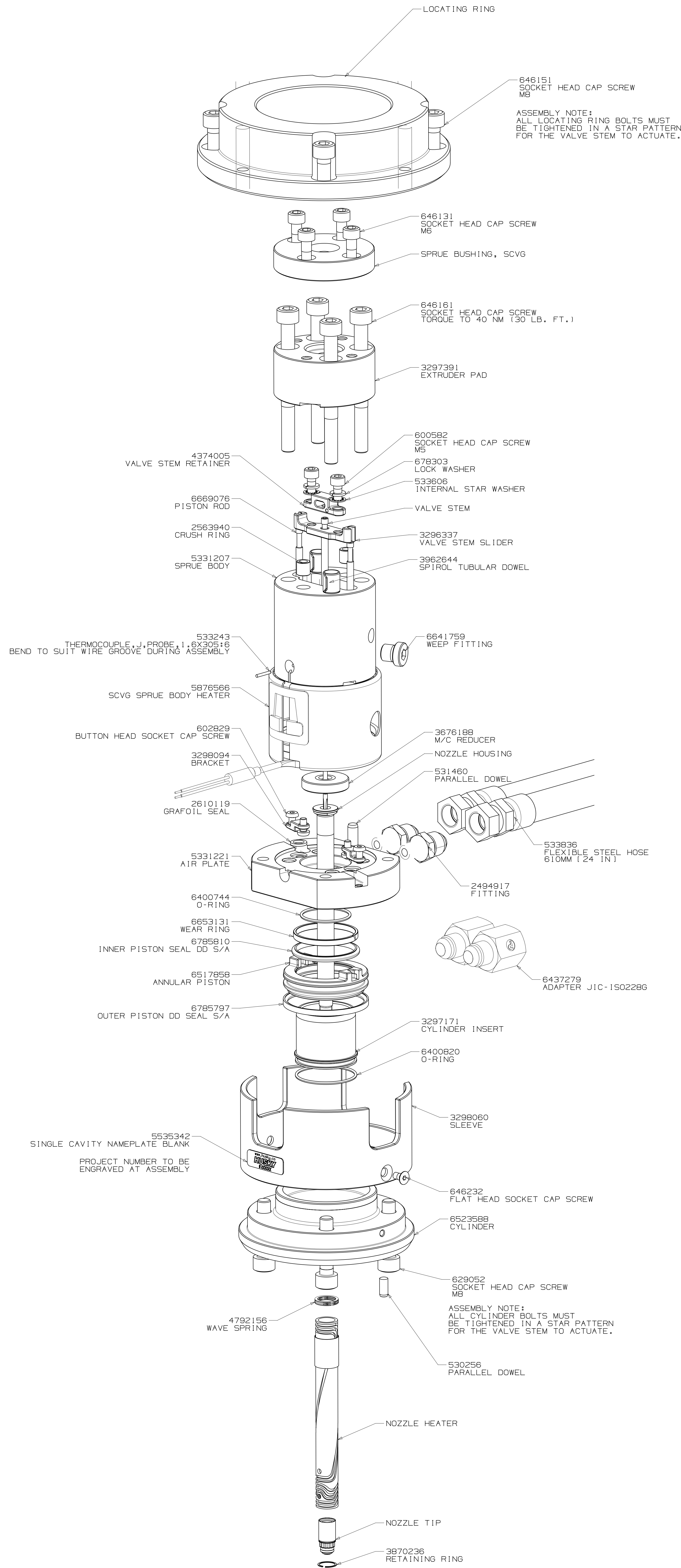
DRWN	CHKD
DRWN: DHANANLEYAN	CHKD: PICHLER KLAUS

UNFINISHED DRAWING FEATURES		MATERIAL		FINISH/TREATMENT		WEIGHT	
DRW PER ASME Y14.5M-1994 AND HEAVY ADDENDUM - H254	BASED ON THE SPECIFIED	N/A	N/A				
NO DIMENSIONS UNLESS OTHERWISE SPECIFIED	NO UNFINISHED DIMENSIONS ARE BASIC						
GENERAL TOLERANCES:							
BROKEN EDGE/CHAMFER:							
FILLET/RADIUS:							
SURFACE FINISH:							

TITLE	SCALE	SHEET	OF	REV
Single Cavity Valve Gate U350-SCVG-VG	SCALE 1:1	2	AOR	0

ASSEMBLY DRAWING

REV 0
8146855



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	7.0	5.2
M8	11.0	8.1
M10	17.0	12.5
M12	25.0	18.4
M14	35.0	25.8
M16	50.0	36.8
M20	75.0	55.1
M25	110.0	80.6

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
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- 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
0	2017-09-12	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	METRIC	HUSKY
MATERIAL: N/A	SCALE: 1:1	TITLE: Single Cavity Valve Gate
FINISH/TREATMENT	SIZE: AOR	DRAWING: U350-SCVG-VG
WEIGHT: - kg	SHEET 2 OF 2	REV: 0
		8146855