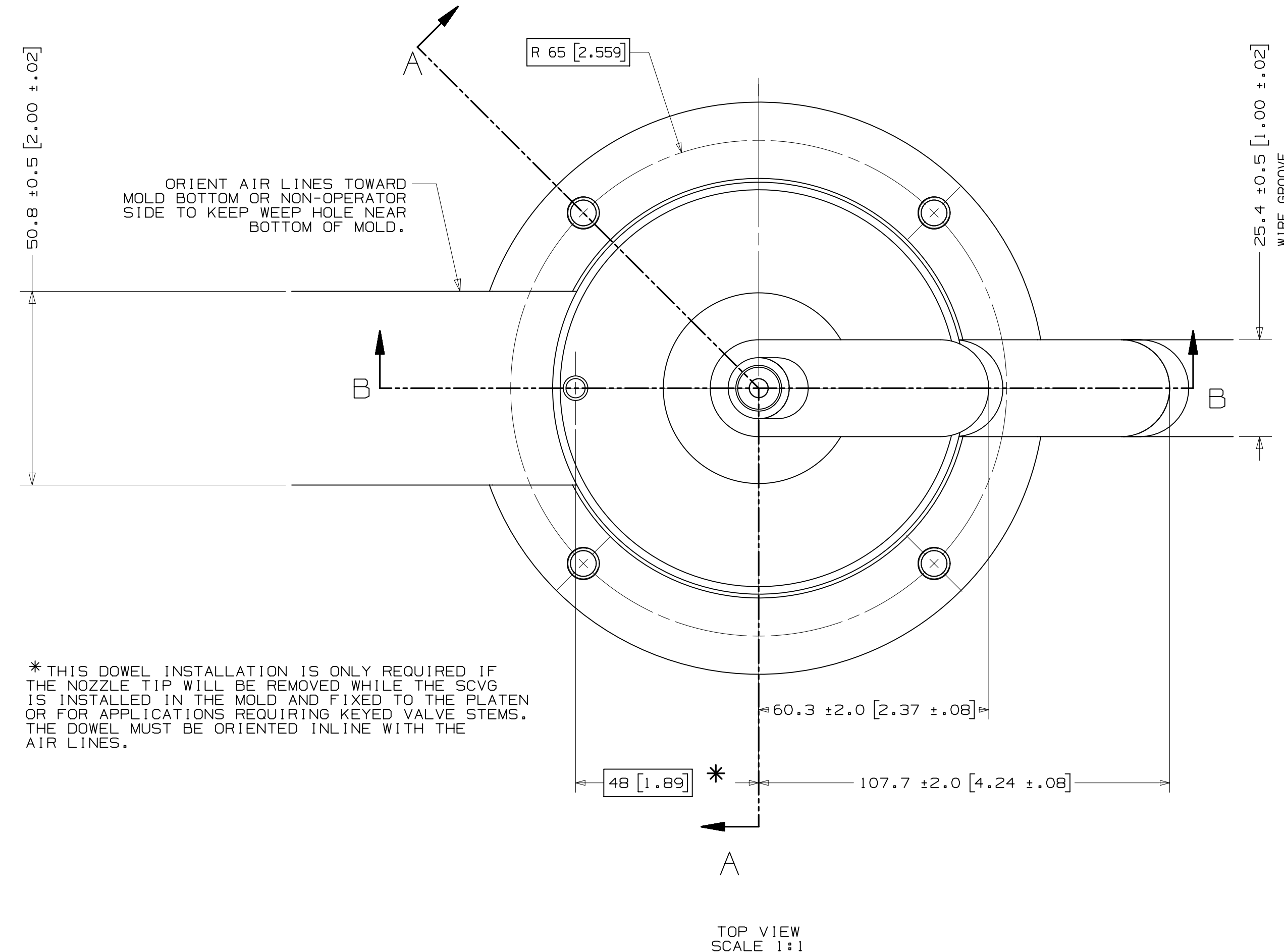
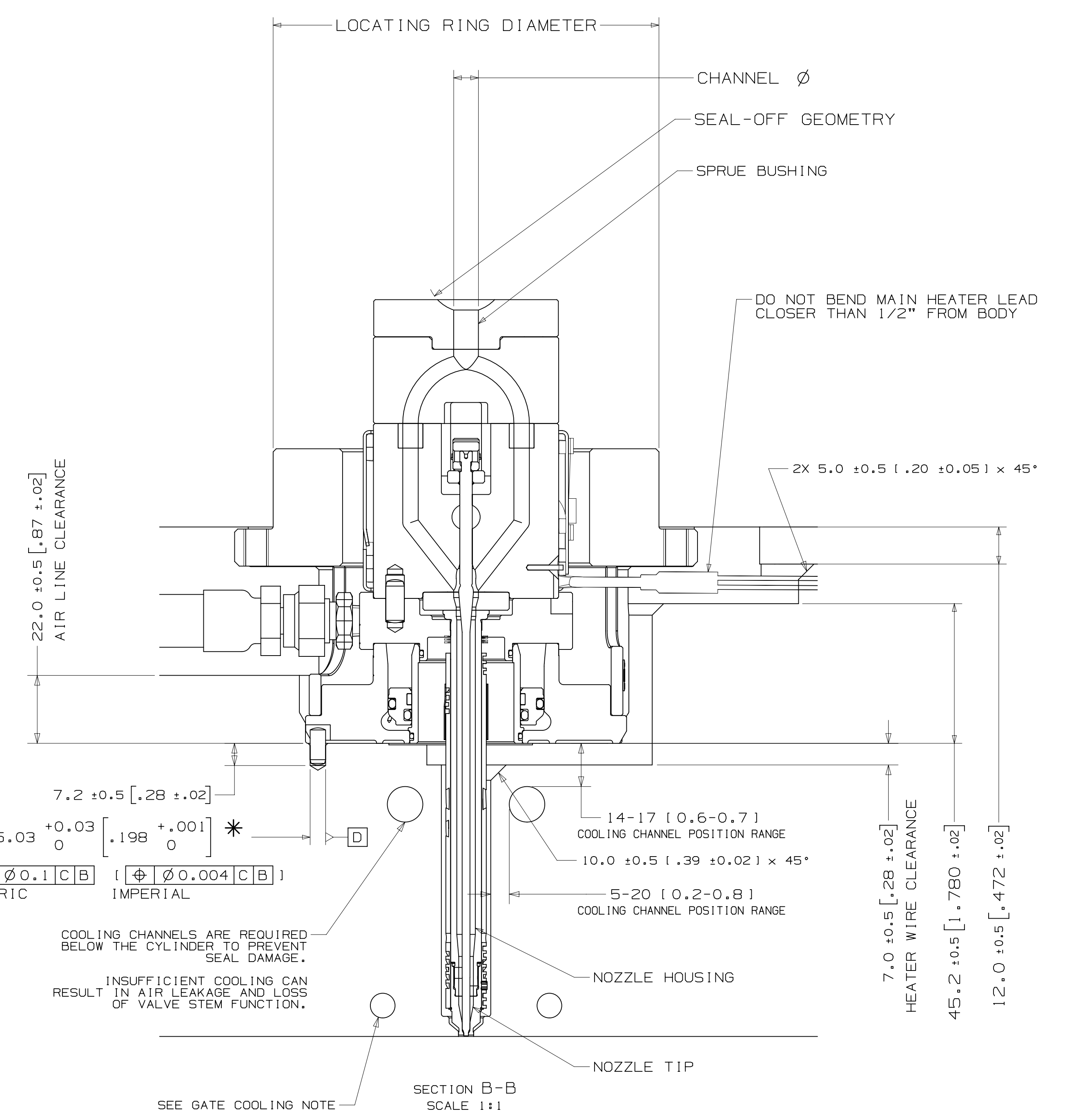
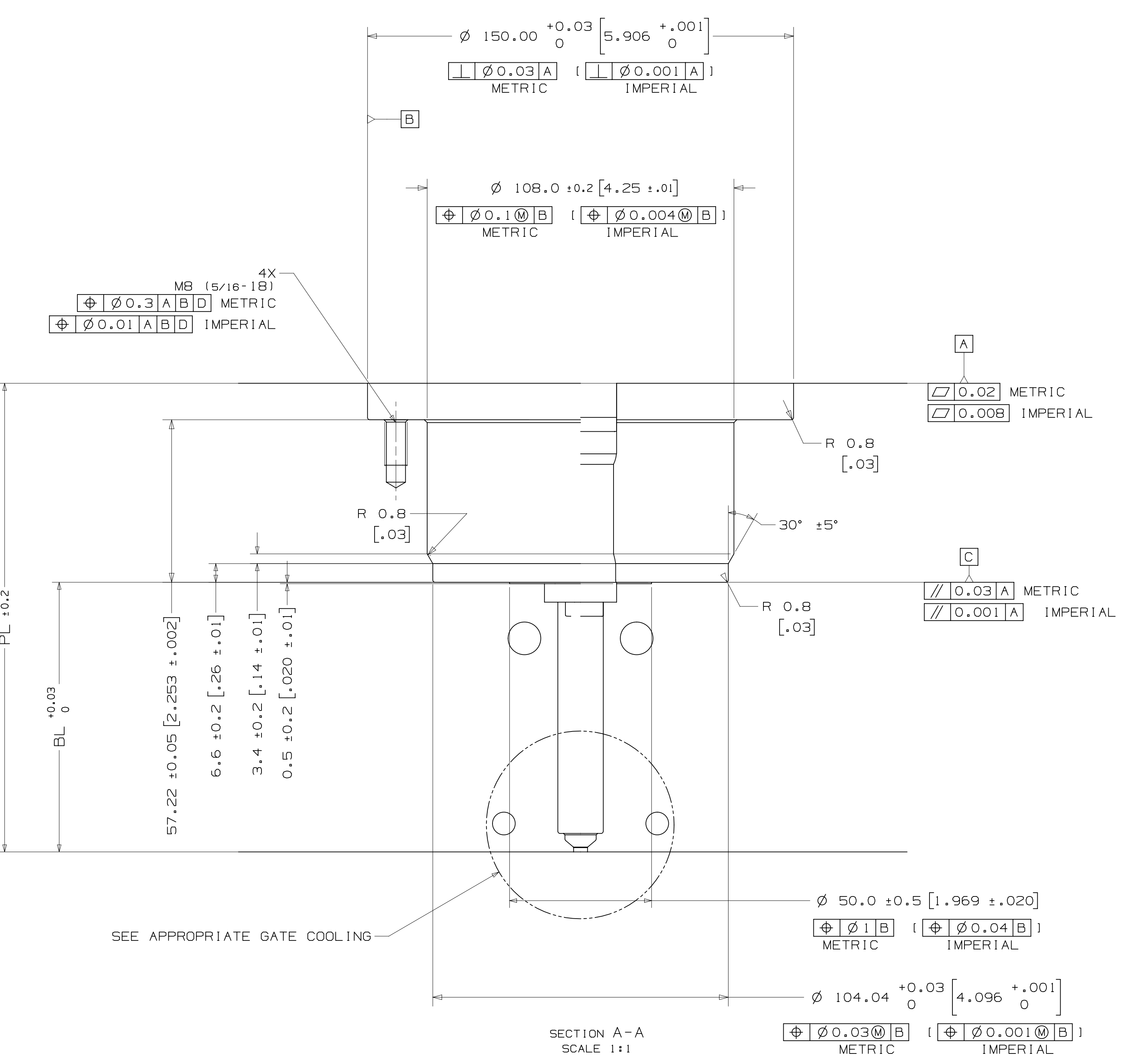


INSTALLATION DRAWING

REV 0
8147452



*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	VX	94,23(3,710) - 244,58(9,629)	25(0,98) - 165(6,50)

*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.

U350	SPRUE BUSHING	
	SEAL-OFF GEOMETRY SPHERICAL RADIUS	CHANNEL Ø IN - OUT
	FLAT	4 - 8
	SEAL-OFF 12,7 (1/2")	8 - THRU
	SEAL-OFF 15,5	
	SEAL-OFF 19,05 (3/4")	
	SEAL-OFF 20	
	SEAL-OFF 40	

U350	LOCATING RING DIAMETER	
		100mm
	101,3mm (3,99")	
	125mm	

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.
AISI H13 (49-51 Rc)
AISI 420 (49-51 Rc)

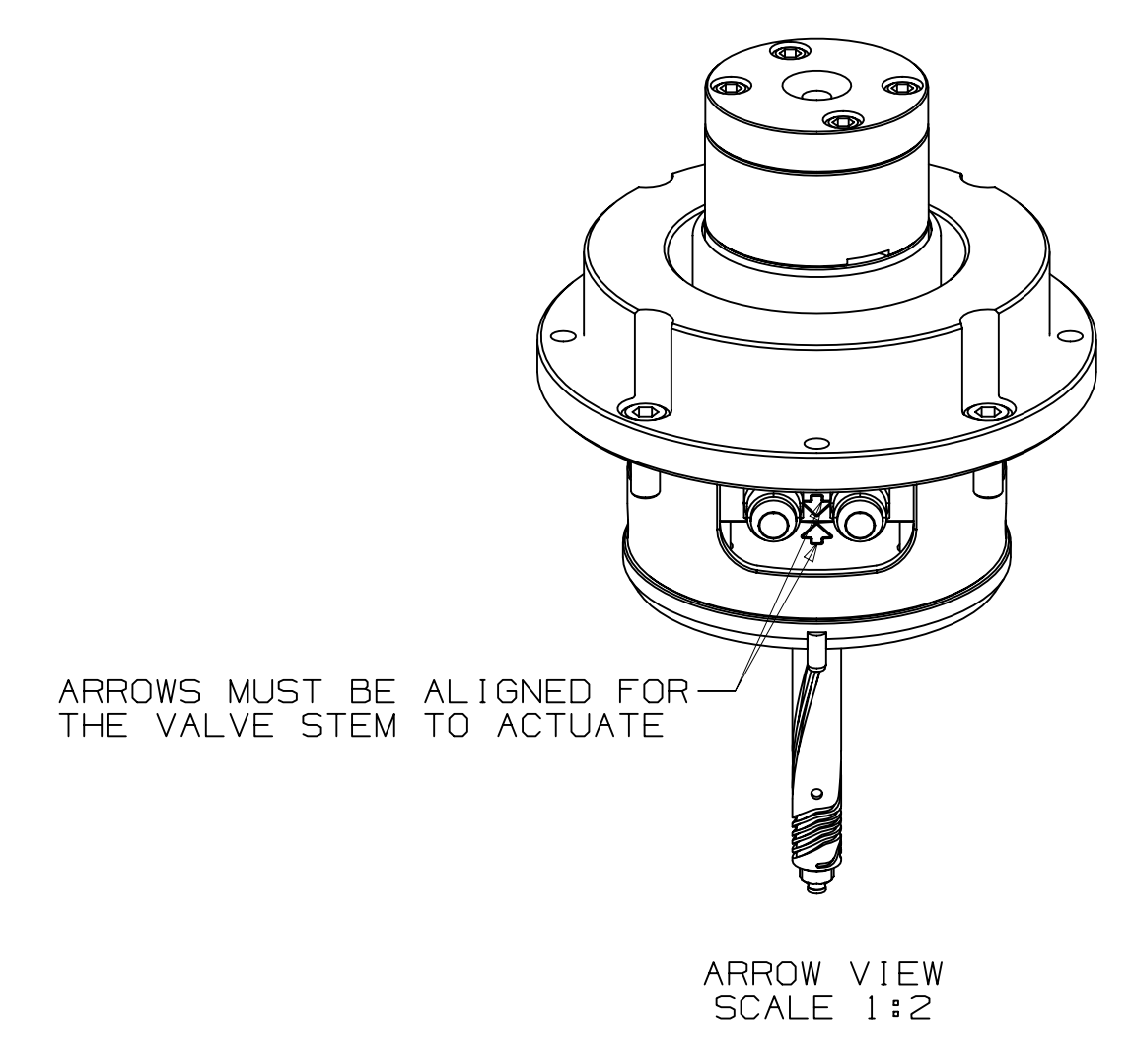
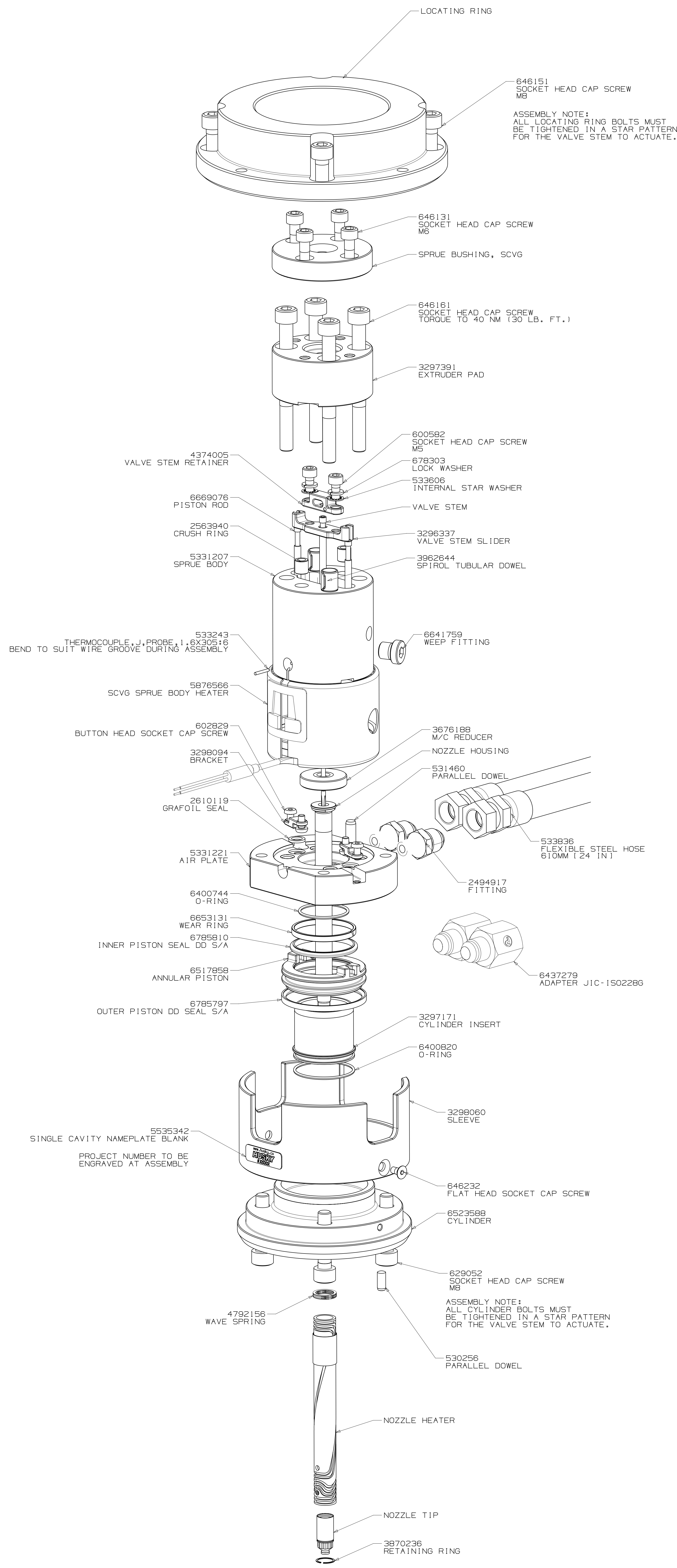
RECOMMENDED GATE MANUFACTURING GUIDELINES
- HARDENED GATE INSERTS (49-51) ARE RECOMMENDED WHEN USING SOFTER CAVITY STEELS. SOFTER CAVITIES MAY BE ACCEPTABLE FOR CERTAIN APPLICATIONS. CONTACT YOUR HUSKY REPRESENTATIVE WITH QUESTIONS.
- EDM'ING THE GATE AREA CAUSES MICRO CRACKS WHICH LEAD TO BRITTLE GATE 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	DESIGNED BY	CHECKED BY
4	2020-05-28	TABLE UPDATED PER LATEST CALCULATION	DRWIN DEEBAN N T	CHKD1
3	2019-07-09	TEMPLATE VALUES UPDATED AS PER SOL 2.0	DRWIN MURALIDHARAN	CHKD1
2	2018-04-06	DRAWING NAME CHANGED	DRWIN ANUSHAL	CHKD1
1	2018-01-12	BL NOTE UPDATED	DRWIN DHANALEYAN	CHKD1
0	2017-09-12	ORIGINAL ISSUE - DESIGNED BY: DHANALEYAN	DRWIN DHANALEYAN	CHKD1

DWT PER ASM: 114,50(4,08) AND HEAVY ASSEMBLY - H25H FINISH: CHROME PLATE GENERAL TOLERANCES: METRIC IMPERIAL SURFACE FINISH: Ra 0.4 FILLET/RADIUS: R0.8 ± 0.2 R0.03 ± 0.01 WEIGHT: - kg	HUSKY TITLE: Single Cavity SCVG U350-SCVG-VX SCALE: 1:1 SHEET: 1 OF 2 AOR: 8147452 REV: 0
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ASSEMBLY DRAWING

DRAWING NO. 8147452 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	16	12
5/16	25	18
3/8	60	45
7/16	150	110
1/2	250	180
3/4	500	360
7/8	750	540
1	1180	860
M4	4.6	3.4
M5	9.1	7.1
M6	16	12
M8	39	29
M10	77	57
M12	135	100
M14	215	160
M16	350	245
M20	650	480
M25	1100	810

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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0	2017-09-12	ORIGINAL ISSUE - DESIGNED BY: DHANALEYAN	DRWNI DHANALEYAN
			CHKDI PICHLER KLAUS

UNFINISHED DRAWING FEATURES	METRIC	HUSKY
MATERIAL: N/A	SCALE: 1:1	TITLE: SCVG Single Cavity Valve Gate
FINISH/TREATMENT	SCALE: 1:1	SIZE: U350-SCVG-VX
WEIGHT: - kg	SHEET 2 OF 2	DRAWING NO. 8147452
		REV 0