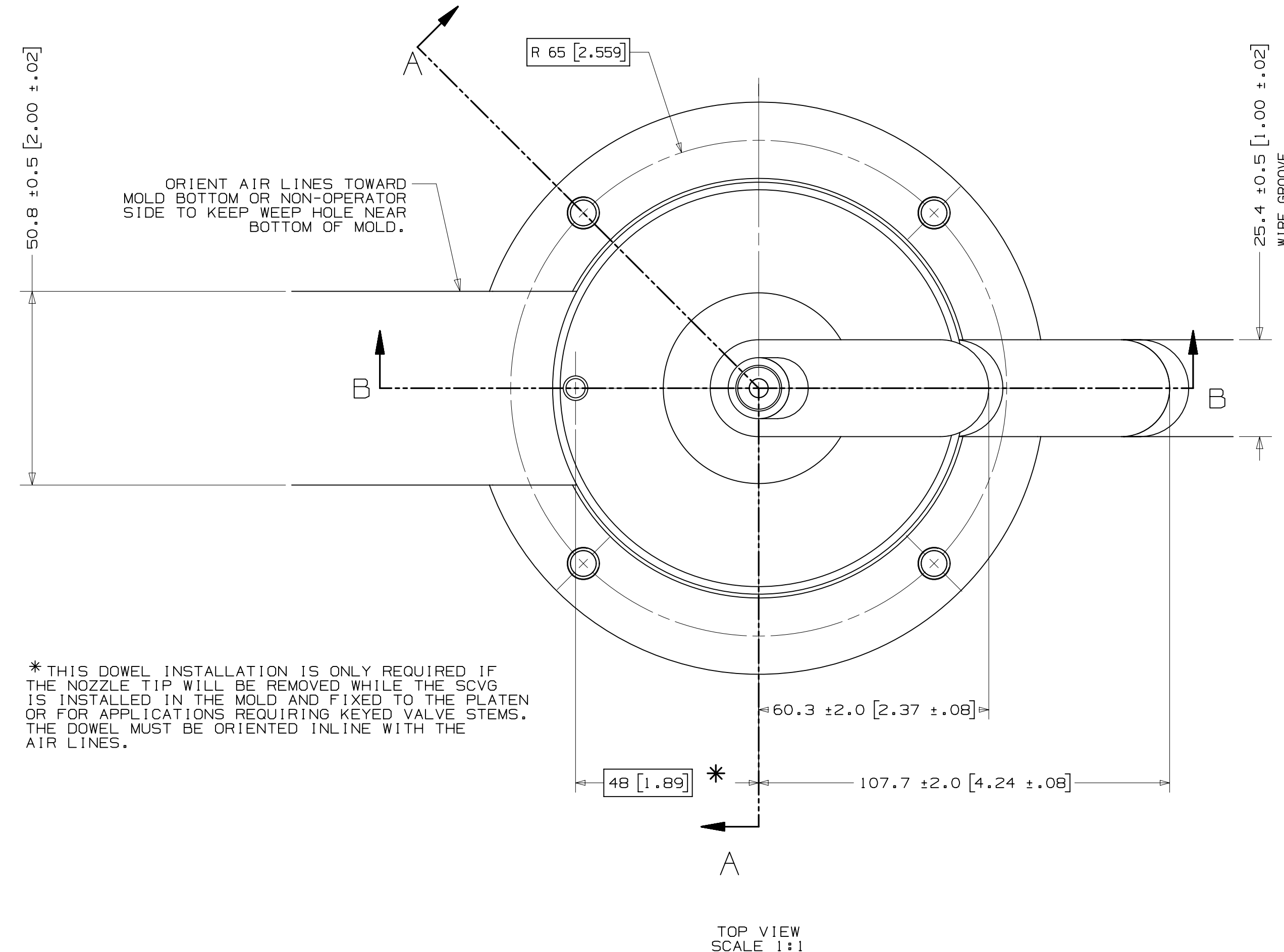
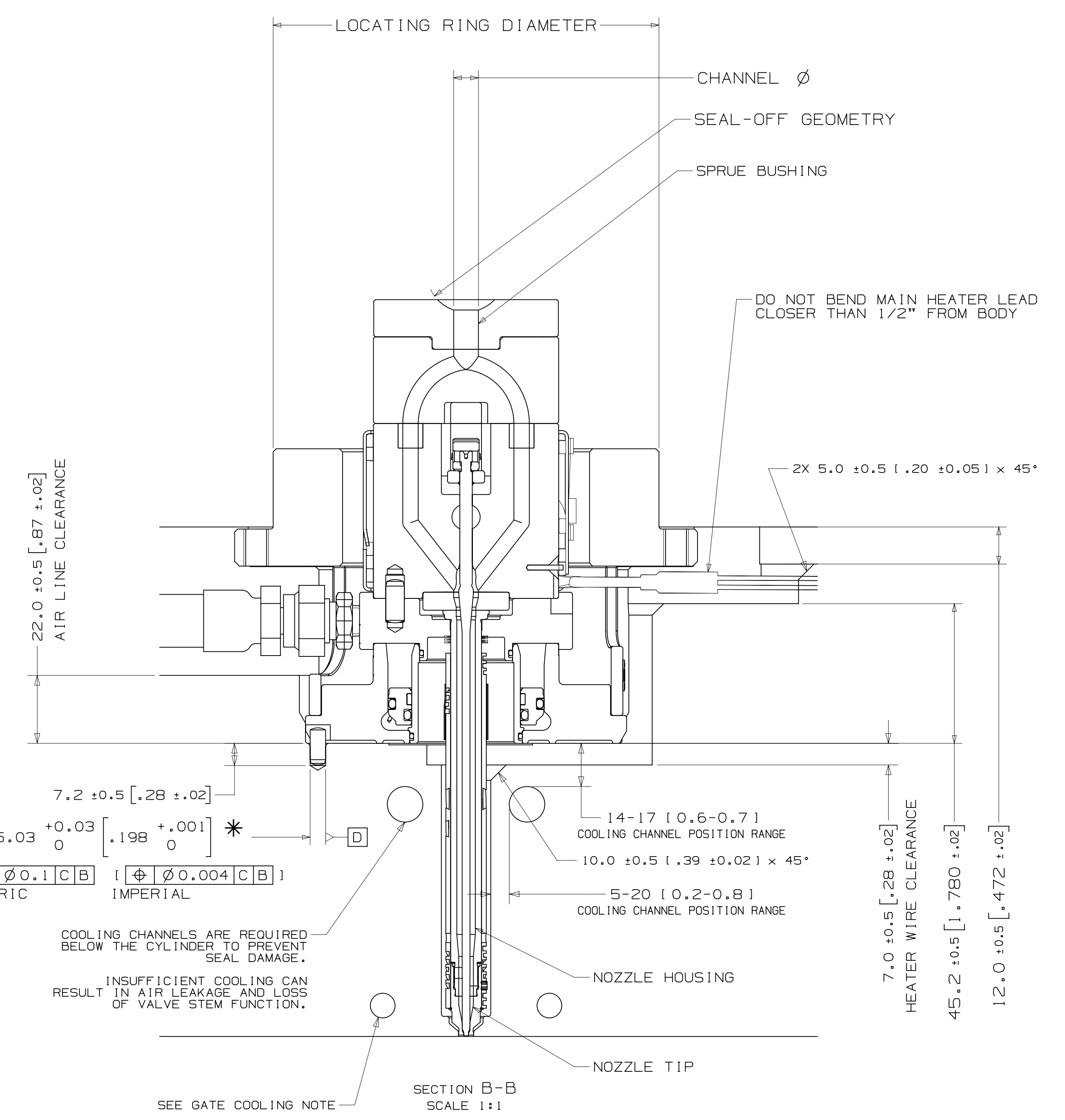
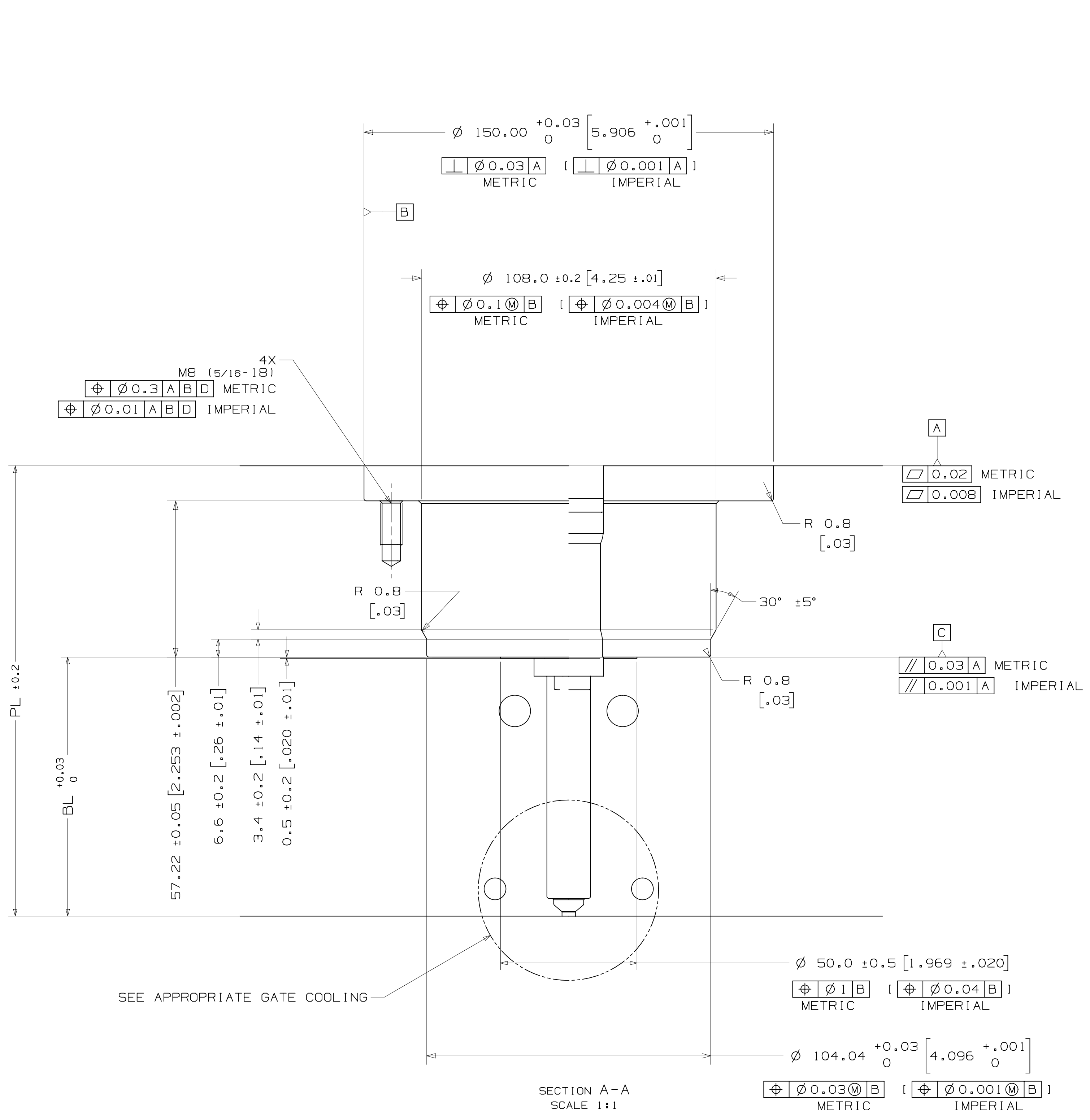


# INSTALLATION DRAWING

STATUS: 8147452 0



\* 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 KEVED VALVE STEMS. THE DOWEL MUST BE ORIENTED IN LINE WITH THE AIR LINES.



NOZZLE SERIES	NOZZLE TIP	NOZZLE HOUSING LENGTH	PL		"BL" AT DELTA TEMP (DELTA TEMP = TEMP OF MELT - TEMP OF MOLD) *																									
			MIN [INCH]	MAX [INCH]	60° C-79° F	100° C-212° F	120° C-249° F	140° C-284° F	160° C-318° F	180° C-354° F	200° C-392° F	220° C-428° F	240° C-464° F	260° C-500° F	280° C-536° F	300° C-572° F														
U350	VX	55	103	14.055	24.65	10.970	24.66	10.971	24.67	10.971	24.68	10.972	24.70	10.972	24.71	10.973	24.72	10.974	24.73	10.974	24.75	10.974	24.76	10.975	24.78	10.976	24.79	10.976		
		65	104	14.094	113	14.449	34.66	11.365	34.67	11.365	34.68	11.365	34.70	11.367	34.71	11.367	34.73	11.368	34.74	11.368	34.76	11.369	34.77	11.369	34.79	11.370	34.81	11.370	34.82	11.371
		75	114	14.488	123	14.843	44.66	11.758	44.68	11.759	44.70	11.760	44.71	11.760	44.73	11.761	44.75	11.762	44.77	11.763	44.80	11.764	44.82	11.765	44.84	11.765	44.86	11.766	44.88	11.766
		85	124	14.882	133	15.236	54.67	12.152	54.69	12.153	54.71	12.154	54.73	12.155	54.75	12.156	54.77	12.156	54.79	12.157	54.81	12.158	54.83	12.159	54.85	12.159	54.87	12.160	54.89	12.161
		95	134	15.276	143	15.630	64.68	12.546	64.70	12.547	64.72	12.548	64.74	12.549	64.77	12.550	64.79	12.551	64.81	12.552	64.83	12.552	64.86	12.554	64.88	12.554	64.91	12.556	64.93	12.556
		105	144	15.689	153	16.024	74.69	12.941	74.71	12.941	74.73	12.942	74.76	12.943	74.78	12.944	74.81	12.945	74.83	12.946	74.86	12.947	74.88	12.948	74.91	12.949	74.94	12.950	74.96	12.951
		115	154	16.063	163	16.417	84.70	13.335	84.72	13.335	84.75	13.337	84.77	13.337	84.80	13.339	84.83	13.340	84.85	13.341	84.88	13.342	84.91	13.343	84.94	13.344	84.97	13.345	85.00	13.346
		125	164	16.457	173	16.811	94.70	13.728	94.73	13.730	94.76	13.731	94.79	13.732	94.82	13.733	94.85	13.734	94.88	13.735	94.91	13.737	94.94	13.738	94.97	13.739	95.00	13.740	95.04	13.742
		135	174	16.850	183	17.205	104.71	14.122	104.74	14.124	104.77	14.125	104.80	14.126	104.83	14.127	104.87	14.129	104.90	14.130	104.93	14.131	104.96	14.132	105.00	14.134	105.04	14.135	105.07	14.137
		145	184	17.244	193	17.598	114.72	14.517	114.75	14.518	114.78	14.519	114.82	14.520	114.85	14.522	114.89	14.523	114.92	14.524	114.96	14.526	114.99	14.527	115.03	14.529	115.07	14.530	115.11	14.532
		155	194	17.638	203	17.992	124.73	14.911	124.76	14.912	124.80	14.913	124.83	14.915	124.87	14.916	124.90	14.917	124.94	14.919	124.98	14.920	125.02	14.922	125.06	14.924	125.10	14.925	125.14	14.927
		165	204	18.031	213	18.386	134.73	15.304	134.77	15.306	134.81	15.307	134.85	15.309	134.89	15.311	134.92	15.312	134.96	15.313	135.00	15.315	135.04	15.317	135.09	15.319	135.13	15.320	135.18	15.322
		175	214	18.425	223	18.780	144.74	15.698	144.78	15.700	144.82	15.702	144.86	15.703	144.90	15.705	144.94	15.706	144.99	15.708	145.03	15.710	145.07	15.711	145.12	15.713	145.17	15.715	145.21	15.717
		185	224	18.819	234	19.213	154.75	16.093	154.79	16.094	154.83	16.096	154.88	16.098	154.92	16.099	154.96	16.101	155.01	16.103	155.05	16.104	155.10	16.106	155.14	16.108	155.20	16.110	155.25	16.112
		195	235	19.252	245	19.646	164.76	16.487	164.80	16.488	164.85	16.490	164.89	16.492	164.94	16.494	164.98	16.495	165.03	16.497	165.08	16.499	165.13	16.501	165.17	16.503	165.23	16.505	165.28	16.507

\* 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	SPRUE BUSHING	
	SEAL-OFF GEOMETRY	CHANNEL Ø
U350	100mm	4 - B
	101.3mm [3.99"]	8 - THRU
	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](http://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)

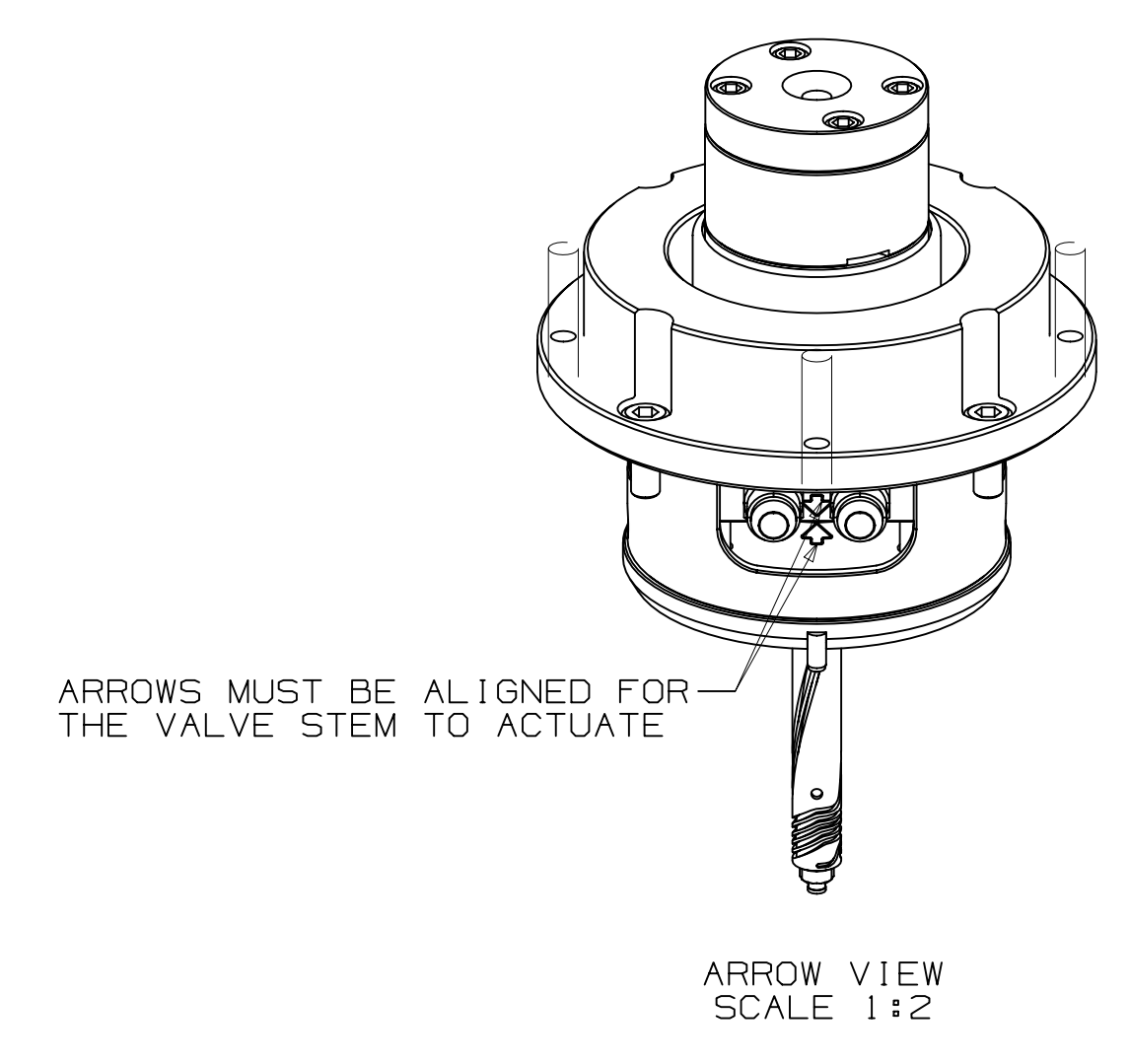
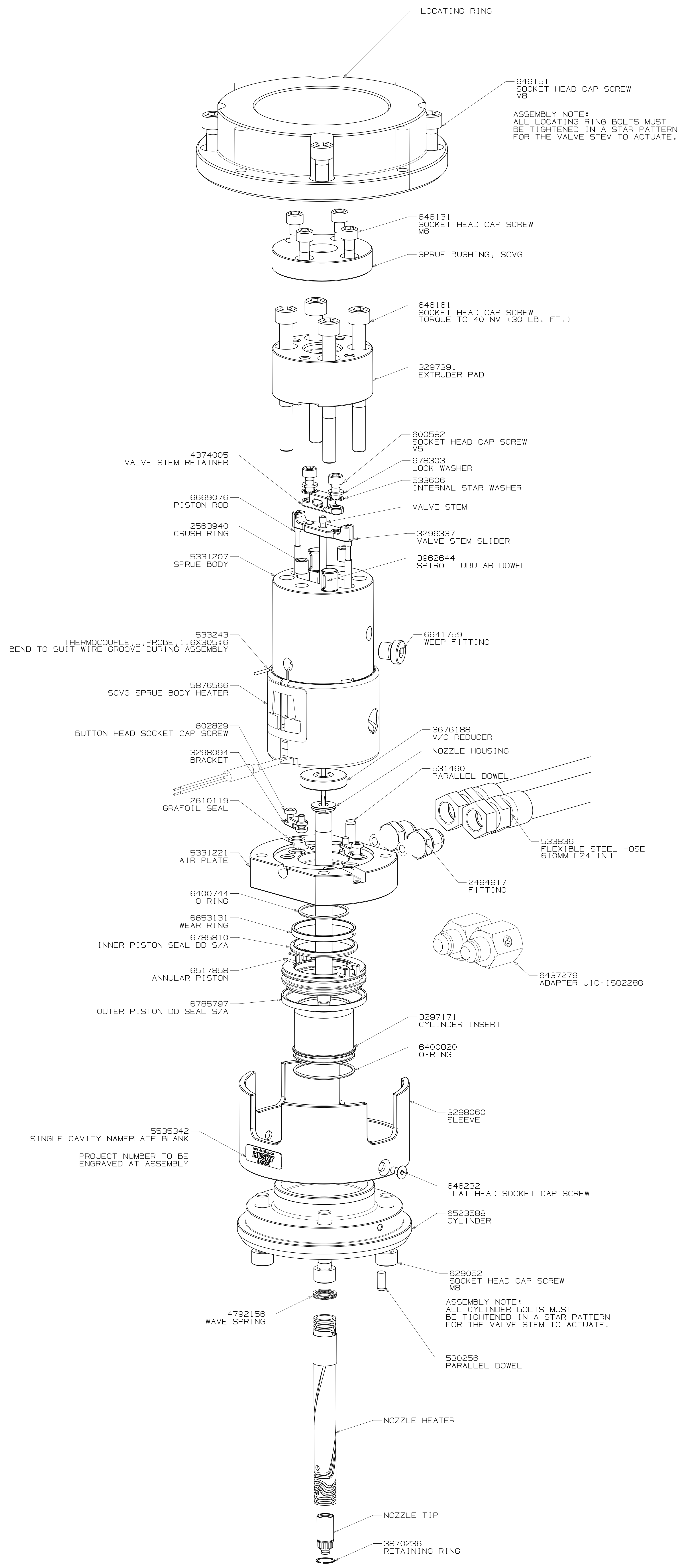
**RECOMMENDED GATE MANUFACTURING GUIDELINES**  
- HARDENED GATE INSERTS (49-51) ARE RECOMMENDED WHEN USING SOFTER CAVITY STEELS. SOFTER CAVITIES MAY BE ACCEPTABLE FOR CERTAIN APPLICATIONS. CONTACT YOUR HUSKY REPRESENTATIVE WITH QUESTIONS.  
- EDM'ING THE GATE AREA CAUSES MICRO CRACKS WHICH LEAD TO BRITTLE 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	DRWN	CHKD
0	2017-09-12	ORIGINAL ISSUE - DESIGNED BY DHANANLEYAN	DRWN: DHANANLEYAN	CHKD: PICHLER KLAUS

DWT PER ASME Y14.5M-1994 AND HEAVY ADDENDUM - H25.4 UNLESS OTHERWISE SPECIFIED: DIM MODEL IS BASIC UNF TOLERANCES UNLESS OTHERWISE SPECIFIED: ARE BASIC METRIC IMPERIAL FINISH/TREATMENT SURFACE FINISH: R0.8 ± 0.2 R0.03 ± 0.01 WEIGHT: - kg	UNFINISHED DRAWING FEATURES: DIM MODEL IS BASIC UNF TOLERANCES UNLESS OTHERWISE SPECIFIED: ARE BASIC METRIC IMPERIAL FINISH/TREATMENT SURFACE FINISH: R0.8 ± 0.2 R0.03 ± 0.01 WEIGHT: - kg	<b>HUSKY</b> TITLE: SCVG Single Cavity Valve Gate U350-SCVG-VX SCALE: 1:1 SHEET 1 OF 2 AOR 8147452 0
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# ASSEMBLY DRAWING

REV 0  
8147452



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	35	25
7/16	60	45
1/2	90	65
5/8	150	110
3/4	250	180
7/8	500	360
1	750	540
1 1/8	1180	860
M4	4.0	3.0
M5	9.0	6.5
M6	16	12
M8	39	29
M10	77	57
M12	135	100
M14	215	160
M16	350	260
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 = (-)	
RECOMMENDED GATE COOLING GUIDELINES ADEQUATE COOLING IS ESSENTIAL FOR THE PROPER FUNCTION OF THIS SYSTEM. REFER TO THE HOT RUNNER PRODUCT GUIDE <a href="http://www.husky.ca">www.husky.ca</a> 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.	

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0	2017-09-12	ORIGINAL ISSUE - DESIGNED BY DHANALEKIAN	DRWN	CHKD
			DRWN	CHKD
			DRWN	CHKD
			DRWN	CHKD
			DRWN	CHKD
			DRWN	CHKD
			DRWN	CHKD

DEFINING DRAWING FEATURES	METRIC	HUSKY
MATERIAL	N/A	TITLE
FINISH/TREATMENT		Single Cavity Valve Gate
WEIGHT	- kg	U350-SCVG-VX
		SCALE 1:1
		SIZE AOR
		8147452
		REV 0
		SHEET 2 OF 2