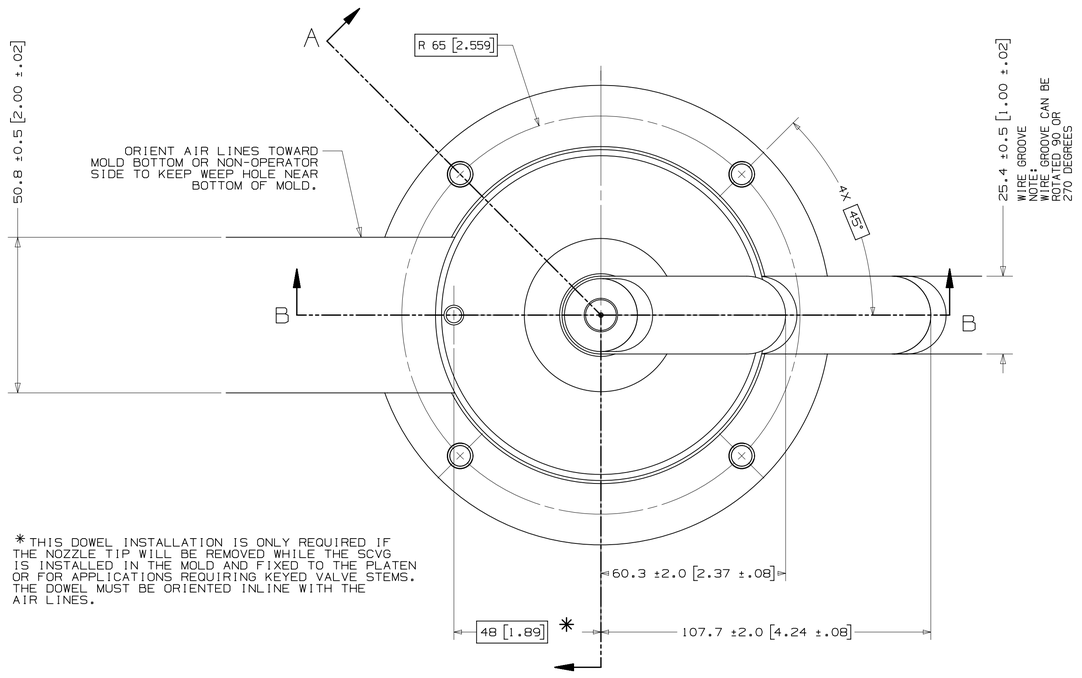
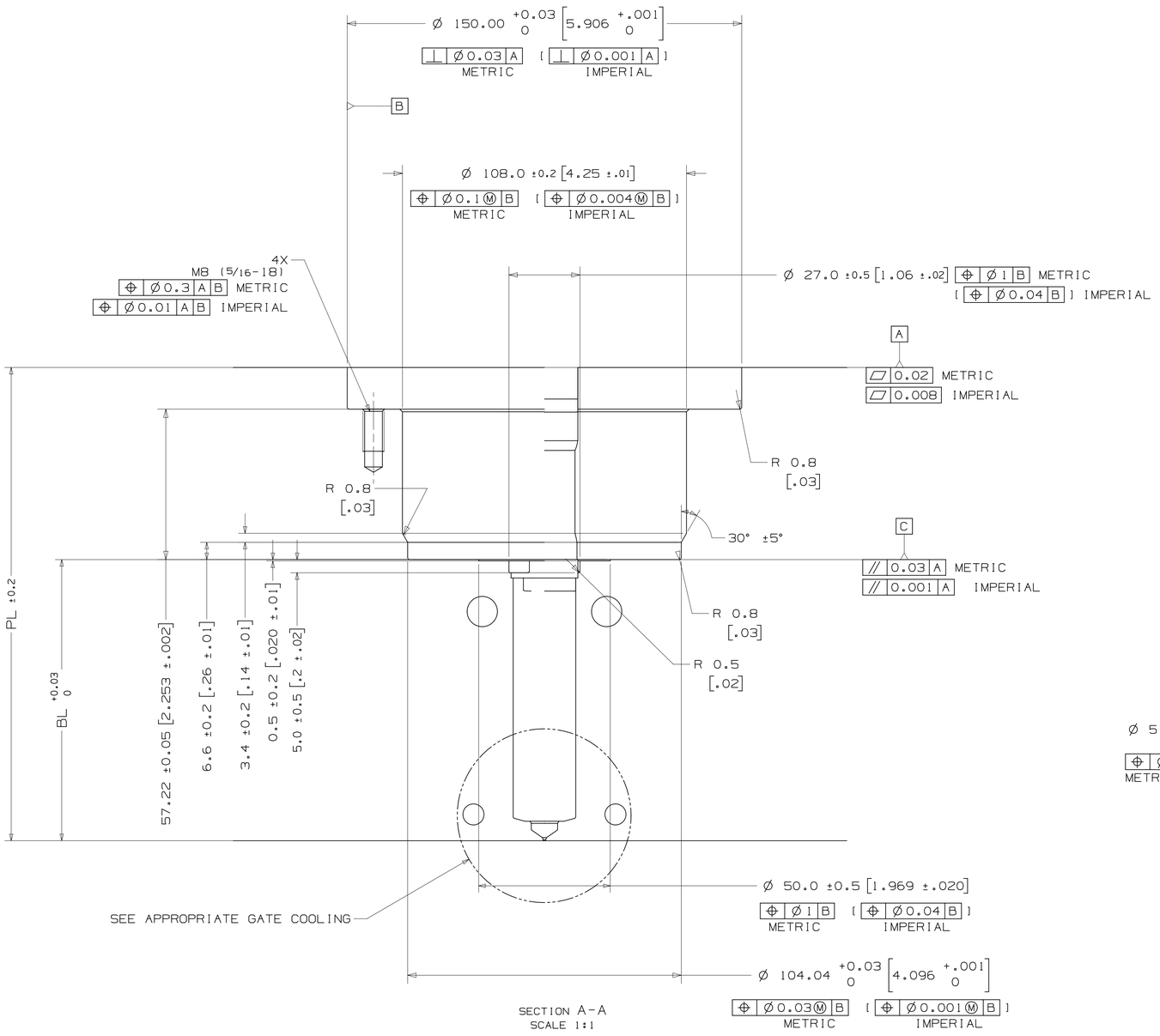
# INSTALLATION DRAWING

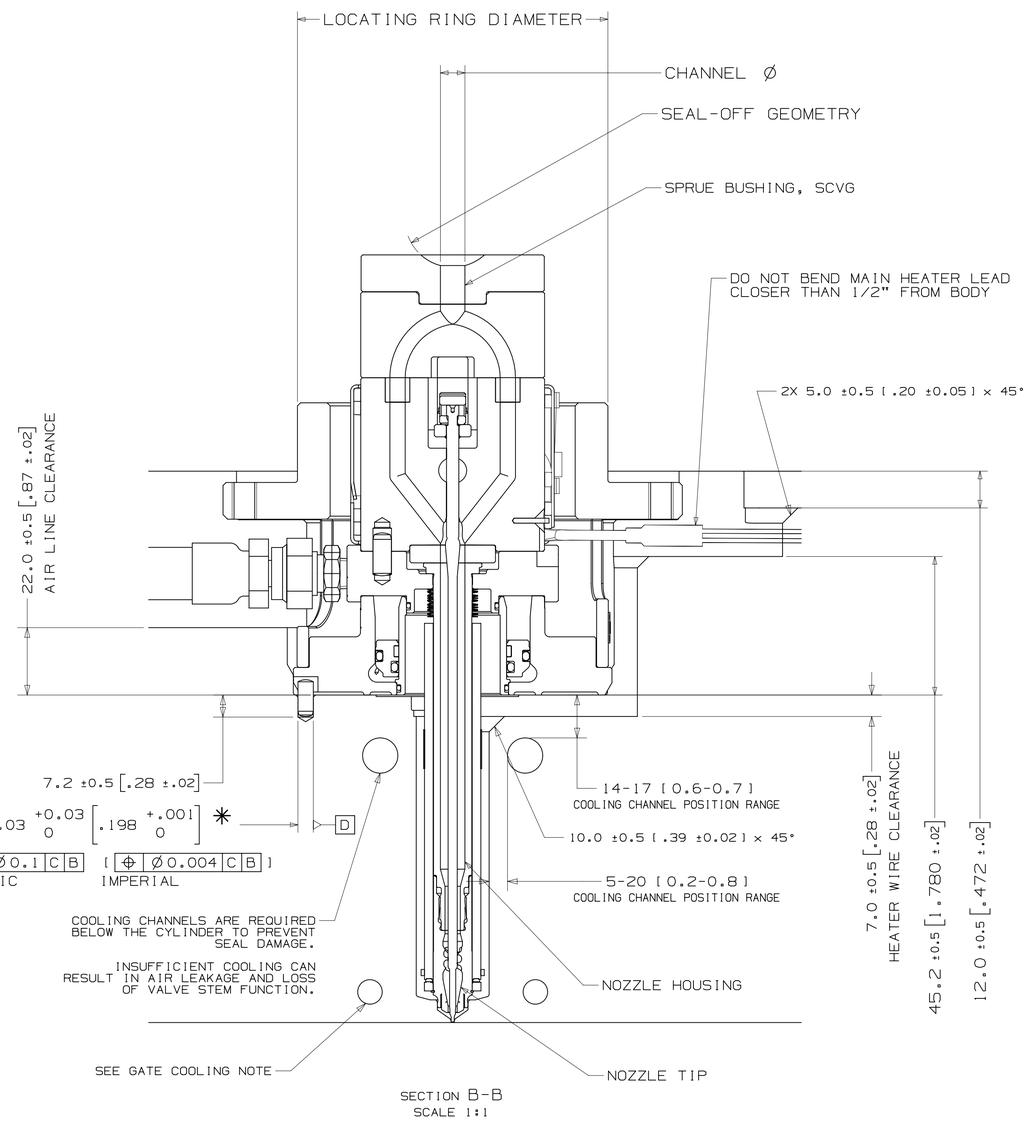
DRAWING 9618226 REV 0




TOP VIEW
SCALE 1:1




SECTION A-A
SCALE 1:1




SECTION B-B
SCALE 1:1

| NOZZLE SERIES | NOZZLE TIP | PL RANGE | Approx. BL* |
|---|---|---|---|
| U500 | UH-T2 | 106.26(4.183) - 266.62(10.497) | 37(1.46) - 187(7.36) |

*Approx.BL VALUES IN THE TABLE ARE REFERENCES WHICH CAN DEVIATE BY +/- 1mm.
FINAL BL VALUE CAN BE FIND ON GATE DETAIL DRAWING AND 3D AFTER FINISHED DESIGN.
BL AVAILABLE IN THE INCREMENT OF 10mm WITHIN RANGE.

| U500 | LOCATING RING DIAMETER |
|---|---|
| | 100mm |
| | 101.3mm [3.99"] |
| | 125mm |

| U500 | SPRUE BUSHING | |
|---|---|---|
| | SEAL-OFF GEOMETRY SPHERICAL RADIUS | CHANNEL Ø IN - OUT |
| | FLAT | 4 - 8 |
| | FLAT | 8 - THRU |
| | SEAL-OFF 12.7 [1/2"] | |
| | SEAL-OFF 15.5 | |
| | 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 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 |
|---|---|---|---|
| | | | DRWN: |
| | | | CHKD: |
| | | | DRWN: |
| | | | CHKD: |
| | | | DRWN: |
| | | | CHKD: |
| 1 | 2020-05-30 | TABLE UPDATED PER LATEST CALCULATION | DRWN: DEEBAN N T |
| | | | CHKD: |
| 0 | 2019-10-18 | ORIGINAL ISSUE - DESIGNED BY: DEEBAN N T | DRWN: DEEBAN N T |
| | | | CHKD: ANUSHLAL S |

GD&T PER ASME Y14.5M-1994 AND HUSKY ADDENDUM - HS254
UNLESS OTHERWISE SPECIFIED:
CAD MODEL IS BASIC. NON-TOLERANCED DIMENSIONS ARE BASIC.
GENERAL TOLERANCE: METRIC ⌓ 0.4 ? IMPERIAL ⌓ 0.02 ?
BROKEN EDGE/CHAMFER: 1 ±0.2 X 45° 0.04 ±0.01 X 45°
FILLET/ROUND: R0.8 ±0.2 R0.03 ±0.01
SURFACE FINISH: 6.3

UNDEFINED DRAWING FEATURES TO COMPLY WITH HS534 "SUPPLIER QUICK REFERENCE"
MATERIAL N/A
FINISH/TREATMENT
WEIGHT - kg

METRIC



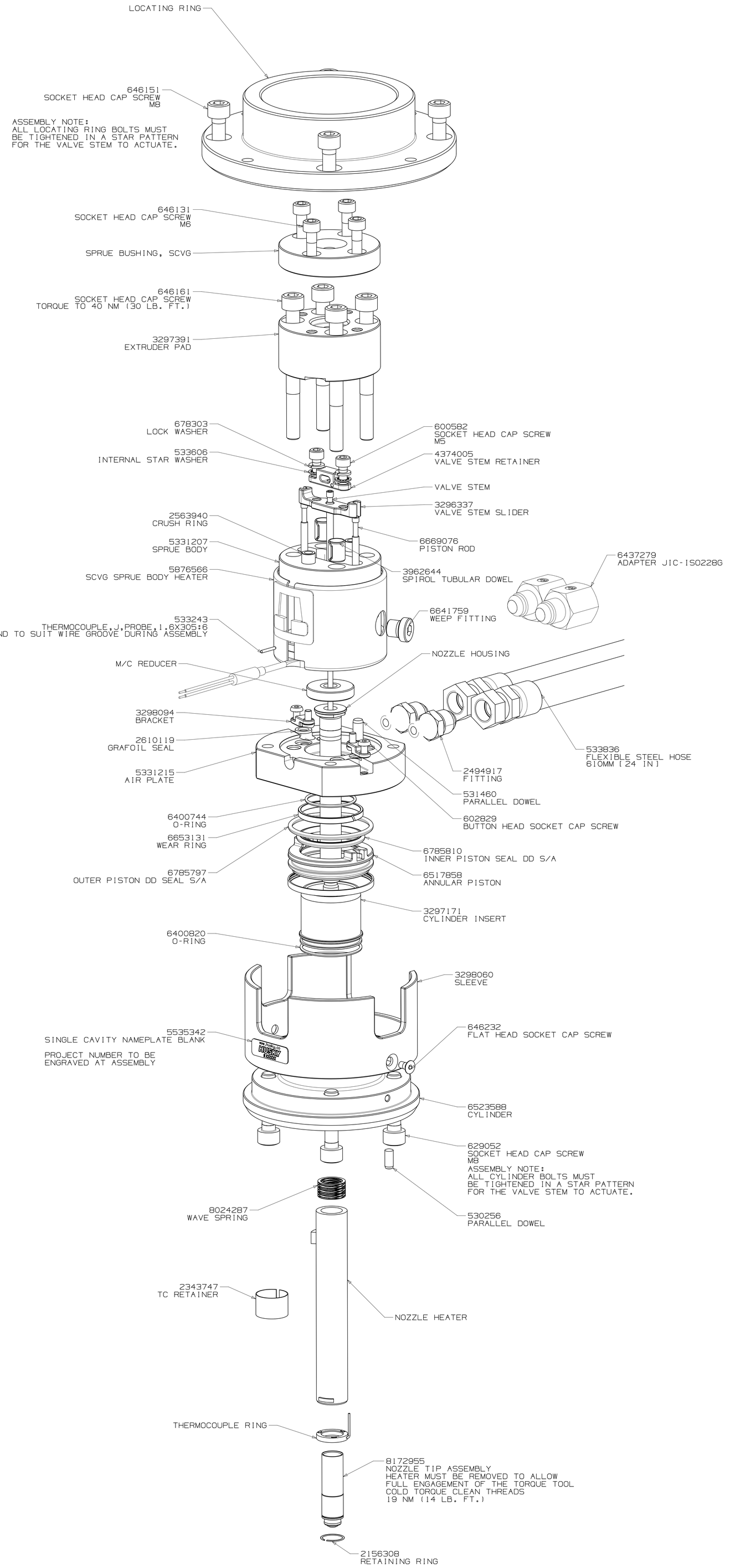
HUSKY

TITLE
SCVG
Single Cavity Valve Gate
U500_SCVG-UH-T2

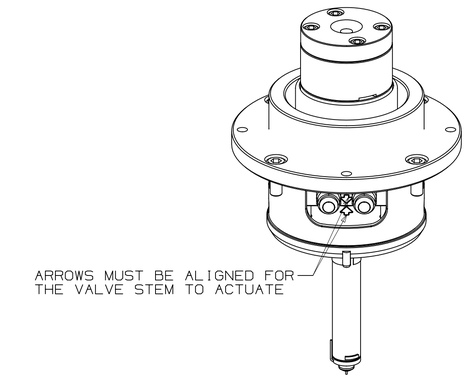
| SCALE | SIZE | DRAWING | REV. |
|---|---|---|---|
| 1:1 | A0R | 9618226 | 0 |
| SHEET 1 OF 2 | | | |

# ASSEMBLY DRAWING

DRAWING 9618226 REV 0




EXPLODED VIEW
SCALE 1:1




ARROW VIEW
SCALE 1:2

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 |
| 1/4 | 16 | 12 |
| 5/16 | 35 | 25 |
| 3/8 | 60 | 45 |
| 7/16 | 95 | 70 |
| 1/2 | 150 | 110 |
| 5/8 | 290 | 210 |
| 3/4 | 500 | 360 |
| 7/8 | 790 | 580 |
| 1 | 1180 | 865 |
| M4 | 4.6 | 3.4 |
| M5 | 9.5 | 7.1 |
| M6 | 16 | 12 |
| M8 | 39 | 29 |
| M10 | 77 | 57 |
| M12 | 135 | 100 |
| M14 | 215 | 160 |
| M16 | 330 | 245 |
| M20 | 650 | 480 |
| M24 | 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:<br>WHITE = (+)<br>RED = (-) |

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UNDEFINED DRAWING FEATURES TO COMPLY WITH HS52A "SUPPLIER QUICK REFERENCE"

MATERIAL: N/A

FINISH/TREATMENT:

WEIGHT: - kg

METRIC



HUSKY

TITLE
SCVG
Single Cavity Valve Gate
U500_SCVG-UH-T2

| SCALE | SIZE | DRAWING | REV |
|---|---|---|---|
| 1:1 | A0R | 9618226 | 0 |

SHEET 2 OF 2