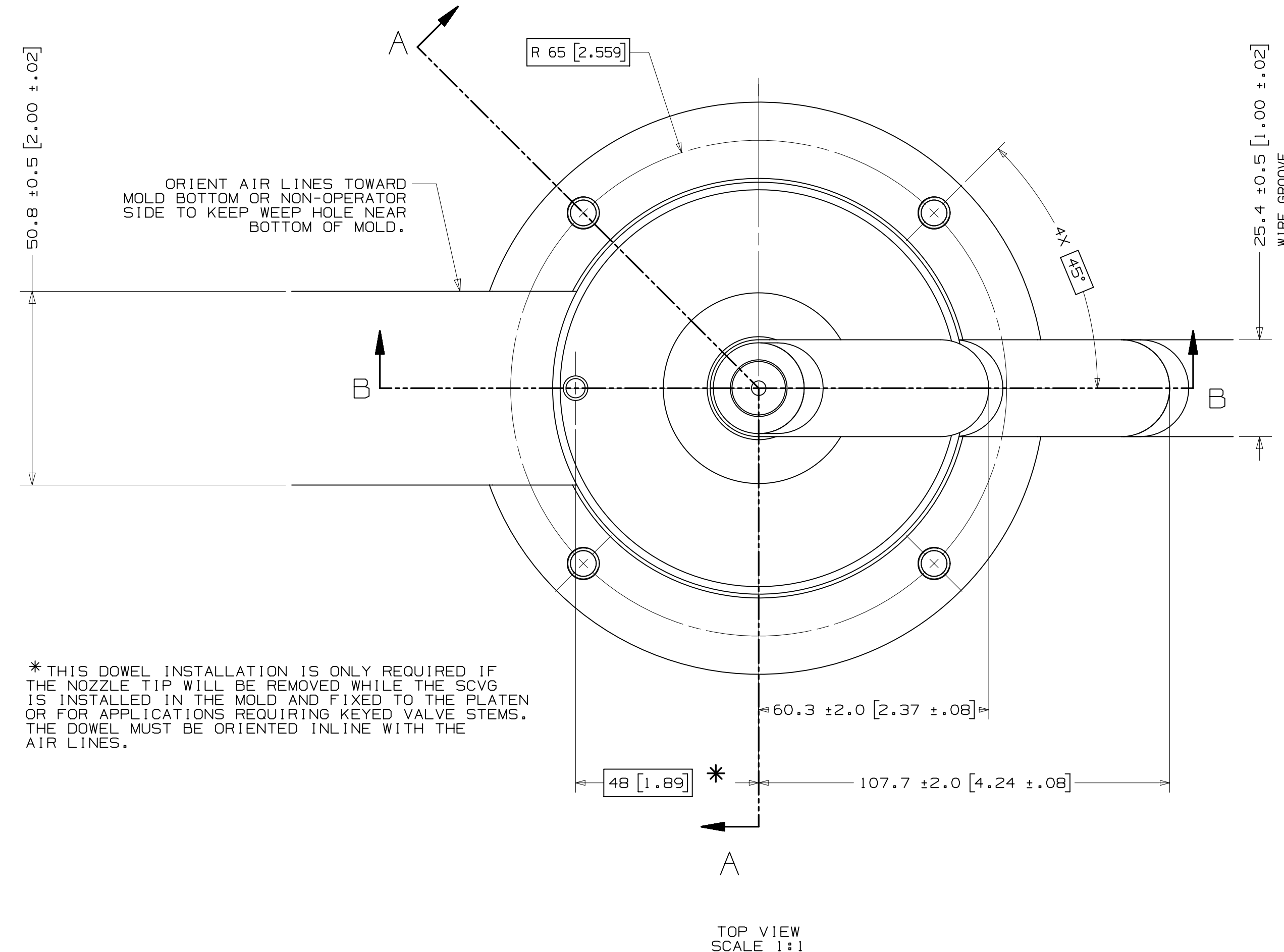
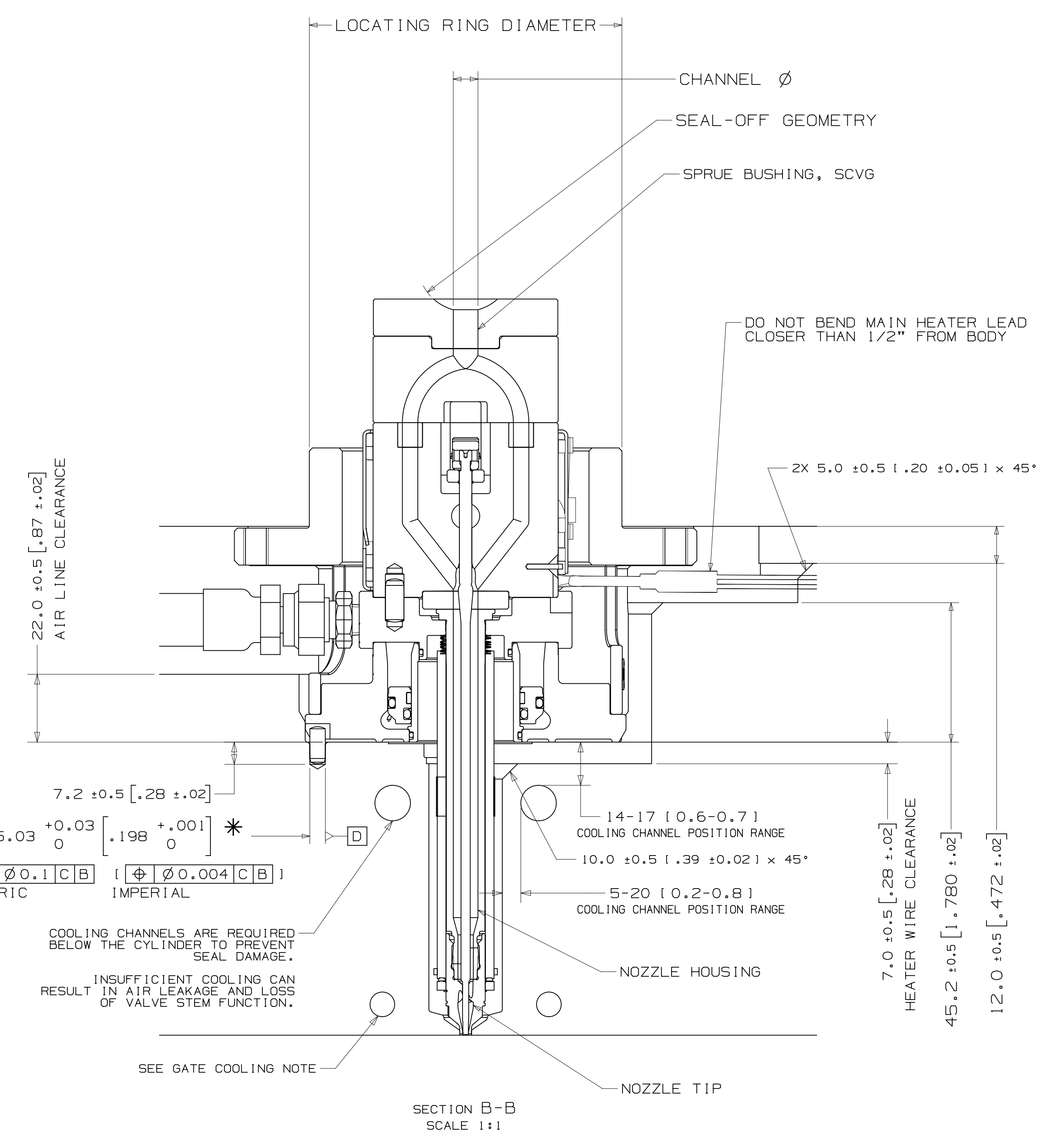
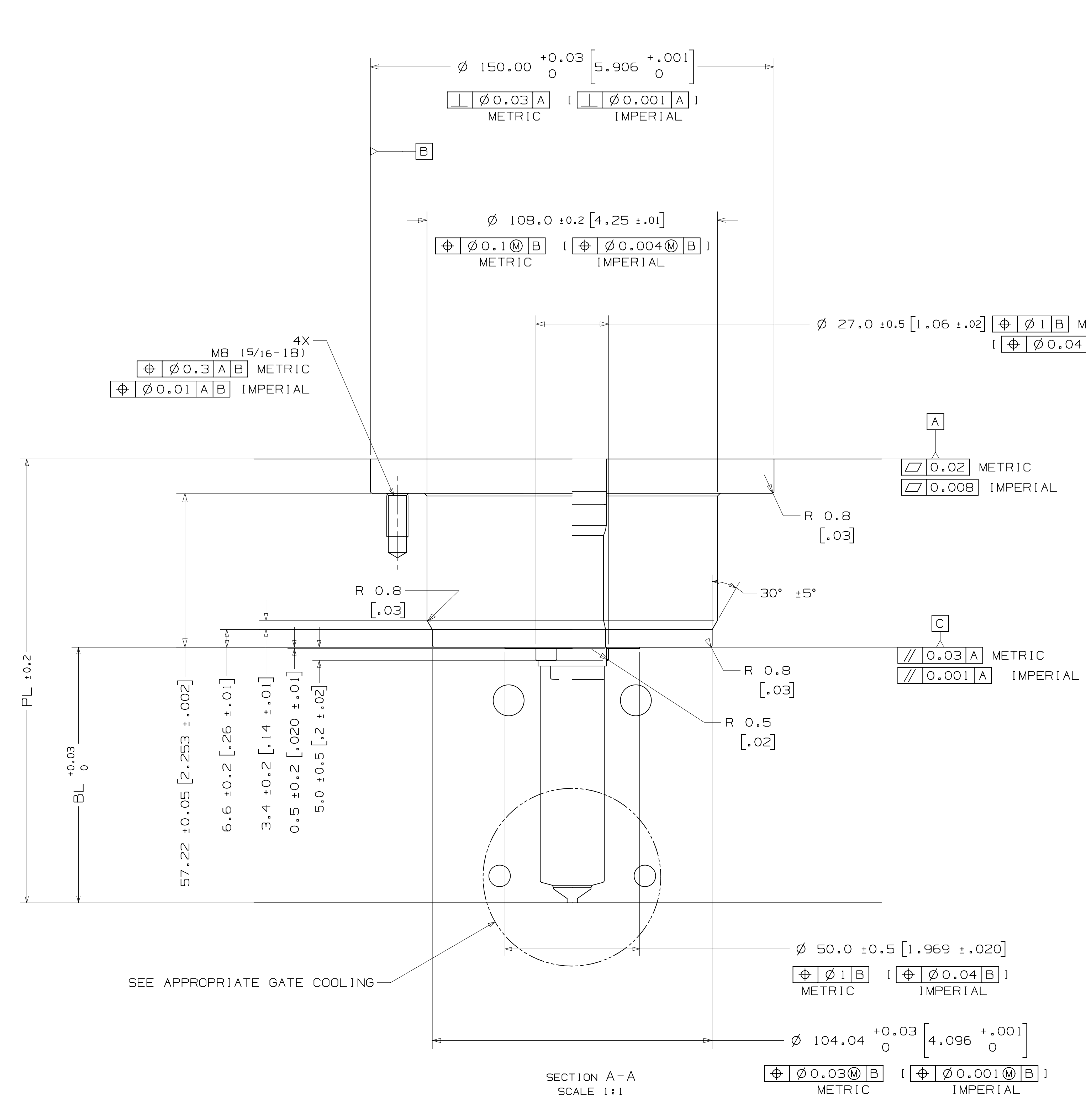


# INSTALLATION DRAWING

REV 0  
STATUS 8143933



\* 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		PL		*BL" AT DELTA TEMP (DELTA TEMP = TEMP OF MELT - TEMP OF MOLD) *																								
		LENGTH	MIN (INCH)	MAX (INCH)	MIN (INCH)	MAX (INCH)	60° C-79° F	114° F-174° F	180° C-354° F	118° F-210° F	100° C-119° F	121° F-210° F	120° C-139° F	128° F-218° F	140° C-159° F	128° F-218° F	160° C-179° F	132° F-250° F	180° C-199° F	156° F-300° F	200° C-219° F	162° F-422° F	220° C-239° F	142° F-462° F	240° C-259° F	148° F-488° F	260° C-279° F	153° F-534° F	280° C-300° F	158° F-532° F
U500	UH-VG	50	94.32	13.713	103.34	14.069	24.55	0.967	24.56	0.967	24.57	0.967	24.58	0.968	24.60	0.969	24.61	0.969	24.62	0.969	24.63	0.970	24.65	0.970	24.66	0.971	24.68	0.972	24.69	0.972
		60	104.34	14.108	113.36	14.463	34.56	1.361	34.57	1.361	34.58	1.361	34.60	1.362	34.61	1.363	34.63	1.363	34.64	1.364	34.66	1.365	34.67	1.365	34.68	1.366	34.71	1.367	34.72	1.367
		70	114.36	14.502	123.38	14.857	44.56	1.754	44.58	1.755	44.60	1.756	44.61	1.756	44.63	1.757	44.65	1.758	44.67	1.759	44.68	1.759	44.70	1.760	44.72	1.761	44.74	1.761	44.76	1.762
		80	124.38	14.897	133.40	15.252	54.57	2.148	54.59	2.149	54.61	2.150	54.63	2.151	54.65	2.152	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
		90	134.40	15.291	143.42	15.646	64.58	2.543	64.60	2.543	64.62	2.544	64.64	2.545	64.67	2.546	64.69	2.547	64.71	2.548	64.73	2.548	64.76	2.550	64.78	2.550	64.81	2.552	64.83	2.552
		100	144.42	15.686	153.44	16.041	74.59	2.937	74.61	2.937	74.63	2.938	74.66	2.939	74.68	2.940	74.71	2.941	74.73	2.942	74.76	2.943	74.78	2.944	74.81	2.945	74.84	2.946	74.86	2.947
		110	154.44	16.080	163.46	16.435	84.60	3.331	84.62	3.331	84.65	3.333	84.67	3.333	84.70	3.335	84.73	3.336	84.75	3.337	84.78	3.338	84.81	3.339	84.84	3.340	84.87	3.341	84.90	3.343
		120	164.46	16.475	173.48	16.830	94.60	3.724	94.63	3.726	94.66	3.727	94.69	3.728	94.72	3.729	94.75	3.730	94.78	3.731	94.81	3.733	94.84	3.734	94.87	3.735	94.90	3.736	94.93	3.737
		130	174.48	16.869	183.51	17.225	104.61	4.119	104.64	4.120	104.67	4.121	104.70	4.122	104.73	4.123	104.77	4.125	104.80	4.126	104.83	4.127	104.86	4.128	104.90	4.130	104.94	4.131	104.97	4.133
		140	184.51	17.264	193.53	17.619	114.62	4.513	114.65	4.514	114.68	4.515	114.72	4.517	114.75	4.518	114.78	4.519	114.82	4.520	114.86	4.522	114.89	4.523	114.93	4.525	114.97	4.526	115.00	4.528
		150	194.53	17.659	203.55	18.014	124.63	4.907	124.66	4.908	124.70	4.909	124.73	4.911	124.77	4.912	124.80	4.913	124.84	4.915	124.88	4.917	124.92	4.918	124.96	4.920	125.00	4.921	125.04	4.923
		160	204.55	18.053	213.57	18.408	134.63	5.300	134.67	5.302	134.71	5.304	134.75	5.305	134.79	5.307	134.82	5.308	134.86	5.309	134.90	5.311	134.94	5.313	134.98	5.314	135.03	5.316	135.07	5.318
		170	214.57	18.448	223.59	18.803	144.64	5.694	144.68	5.696	144.72	5.698	144.76	5.699	144.80	5.701	144.84	5.702	144.89	5.704	144.93	5.706	144.97	5.707	145.01	5.709	145.06	5.711	145.11	5.713
		180	224.59	18.842	233.61	19.197	154.65	6.089	154.69	6.090	154.73	6.092	154.78	6.094	154.82	6.095	154.86	6.097	154.91	6.099	154.95	6.100	155.00	6.102	155.04	6.104	155.10	6.106	155.14	6.108
		190	234.61	19.237	243.63	19.592	164.66	6.483	164.70	6.484	164.75	6.486	164.79	6.488	164.84	6.490	164.88	6.491	164.93	6.493	164.98	6.495	165.03	6.497	165.07	6.499	165.13	6.501	165.18	6.503
		200	244.63	19.631	253.65	19.987	174.67	6.877	174.71	6.878	174.76	6.880	174.80	6.882	174.85	6.884	174.90	6.886	174.95	6.888	175.00	6.890	175.05	6.892	175.10	6.894	175.16	6.896	175.21	6.898

\* 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.

NOTE:  
TIP PROTRUSION INTO CAVITY IN HOT CONDITION 0.2 mm

LOCATING RING DIAMETER	SPRUE BUSHING	
	SEAL-OFF GEOMETRY	CHANNEL Ø
U500	FLAT	4 - B
	SEAL-OFF 12.7 [1/2"]	B - THRU
SEAL-OFF 15.5		
SEAL-OFF 19.05 [3/4"]		
SEAL-OFF 20		
125mm	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](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	2017-09-11	ORIGINAL ISSUE - DESIGNED BY: DHANALEKIAN	DRWN: DHANALEKIAN	CHKD: PICHLER KLAUS

UNIT PER ASME Y14.5M-1994 AND HEAVY ADDENDUM - H25.4	UNLESS OTHERWISE SPECIFIED	NO UNFINISHED DIMENSIONS ARE BASIC	NO HOLLOWED DIMENSIONS ARE BASIC	NO UNLESS OTHERWISE SPECIFIED	NO UNLESS OTHERWISE SPECIFIED	NO UNLESS OTHERWISE SPECIFIED	NO UNLESS OTHERWISE SPECIFIED	NO UNLESS OTHERWISE SPECIFIED	NO UNLESS OTHERWISE SPECIFIED
0.25	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001	0.001

