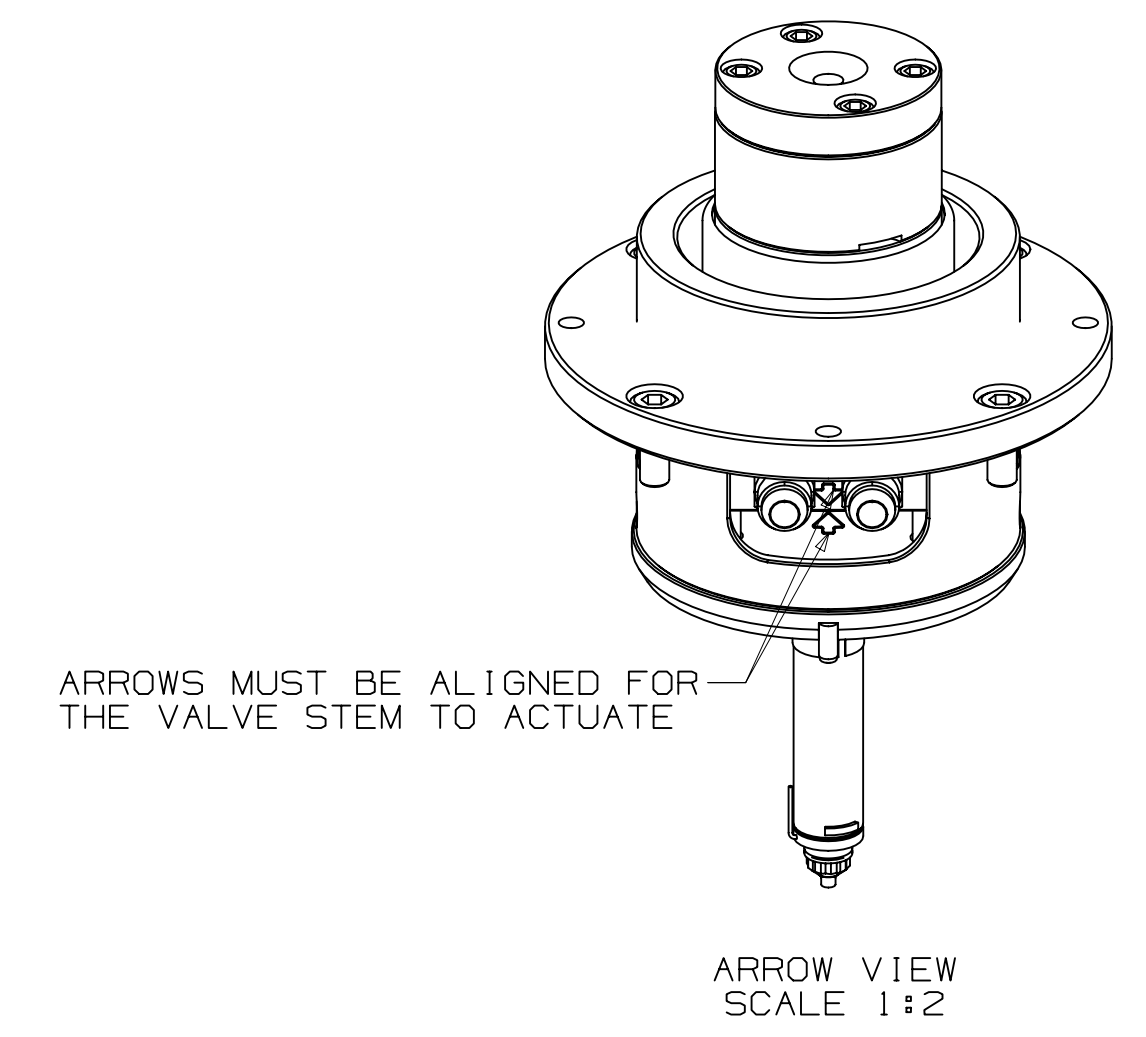
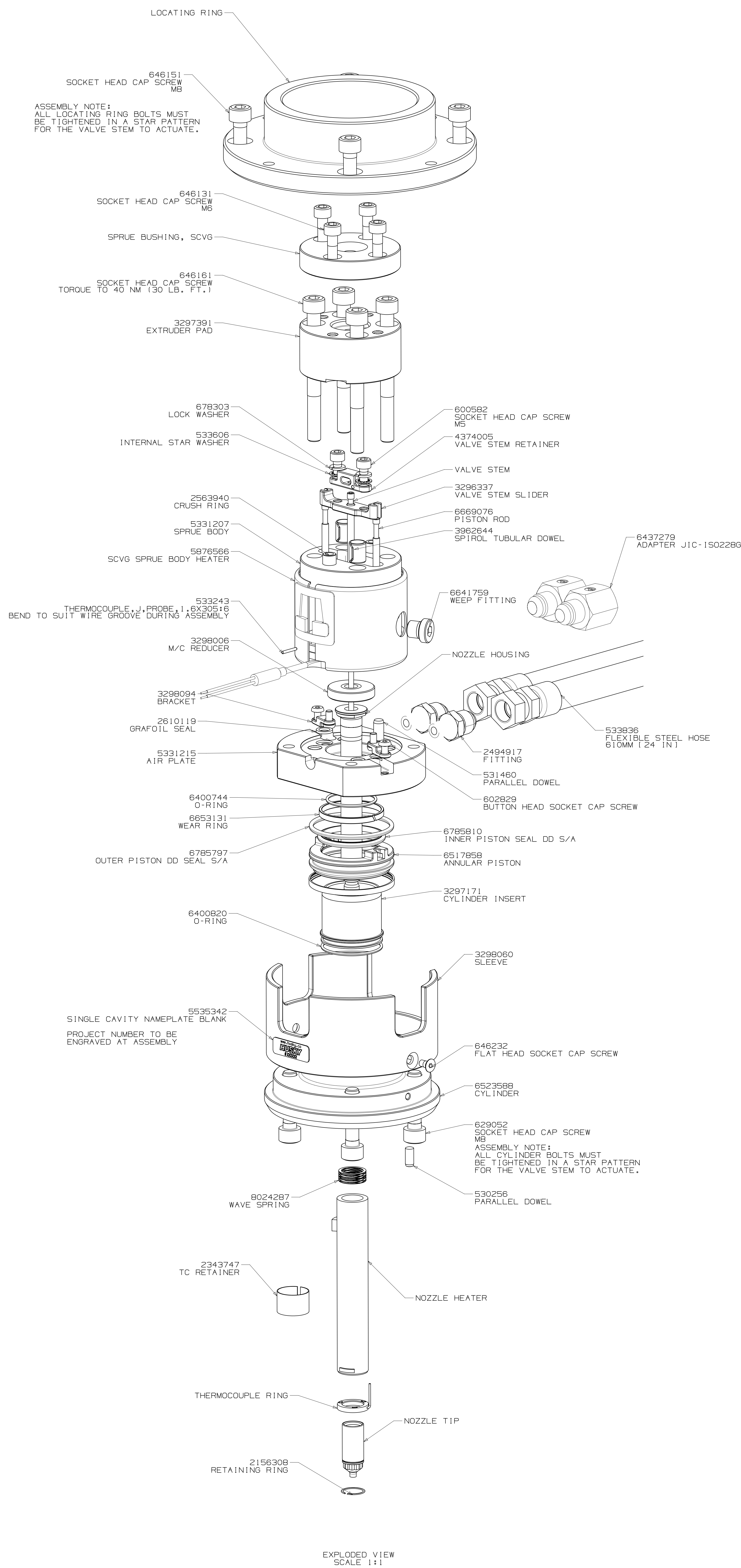


ASSEMBLY DRAWING

REV 0
8143933



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	50	35
1/2	70	50
5/8	100	70
3/4	150	110
7/8	200	150
1	250	180
M4	4.6	3.4
M5	7.7	5.7
M6	11.6	8.5
M8	20	15
M10	30	22
M12	45	33
M14	70	50
M16	100	70
M20	180	130
M25	300	220
M30	450	330
M36	700	500

VALVE STEM STROKE IS 7.3 (1.29)

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 FOR MORE DETAILED GUIDELINES.
www.husky.ca

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
5	2020-05-28	TABLE UPDATED PER LATEST CALCULATION	DRWIN DEEBAN N T
4	2019-07-29	TIP PROTRUSION AND BL DIMENSIONS UPDATED	DRWIN DEEBAN N T
3	2019-07-09	TEMPLATE VALUES UPDATED AS PER SOL 2.0	DRWIN MURALIDHARAN
2	2018-04-05	DRAWING NAME CHANGE	DRWIN ANUSHAL
0	2017-09-11	ORIGINAL ISSUE - DESIGNED BY: DHANALEYAN	DRWIN DHANALEYAN
			CHKD: PICHLER KLAUS

MATERIAL	FINISH/TREATMENT	WEIGHT	SCALE	SIZE	REV
N/A		- kg	1:1	AOR	0

TITLE	SCALE	SIZE	REV
Single Cavity Valve Gate US00-SCVG-UH-VG	1:1	AOR	0