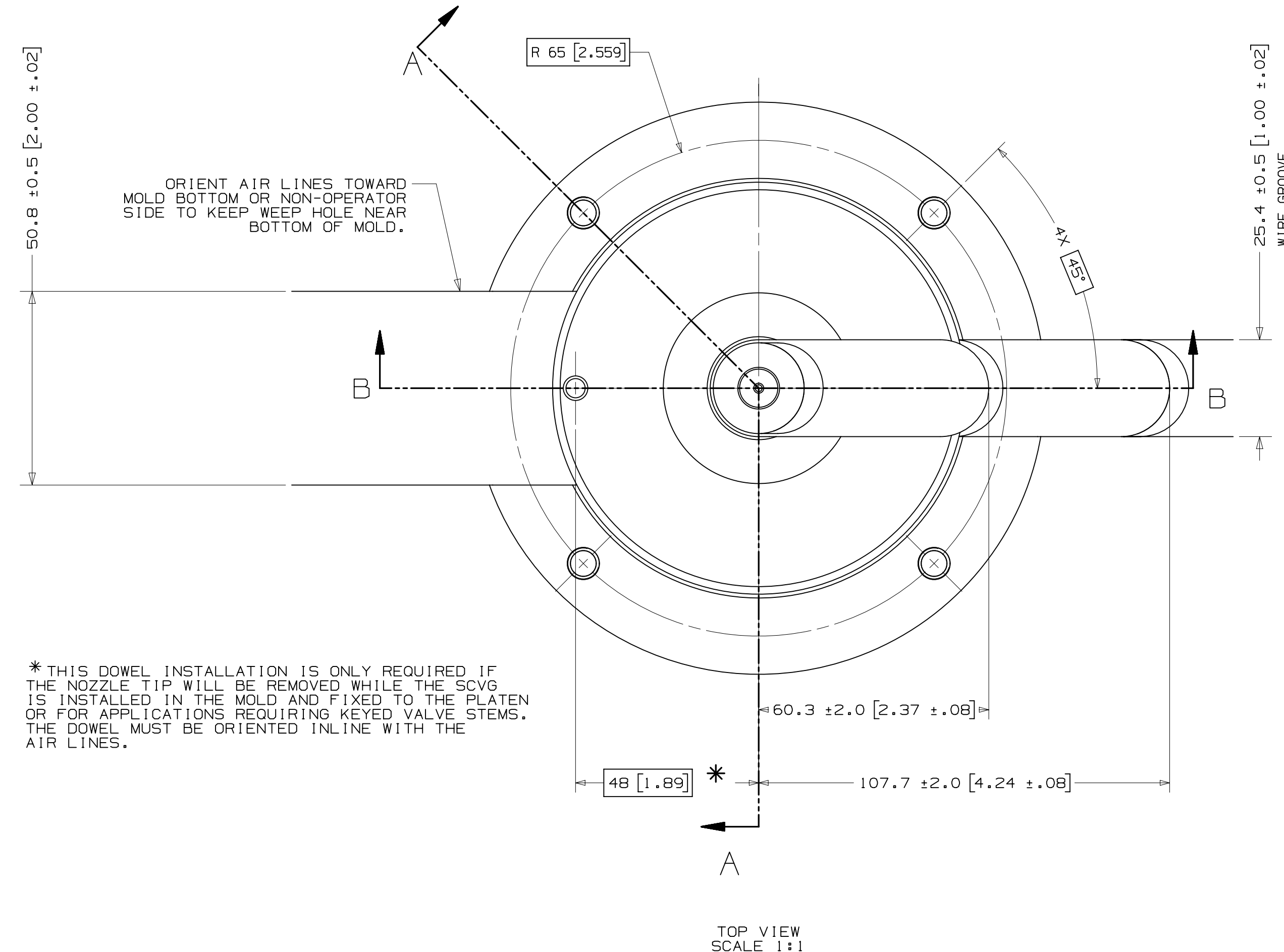
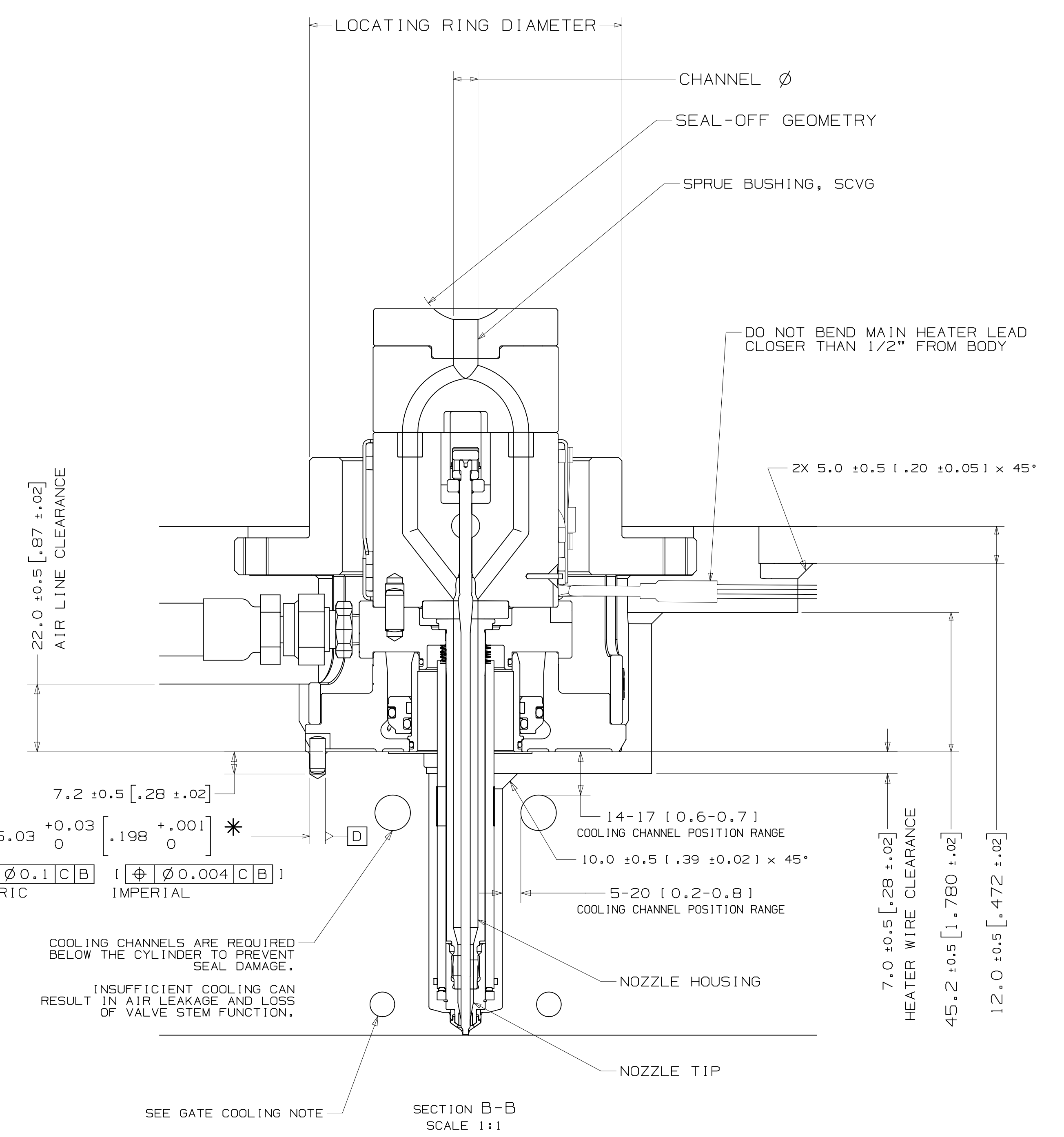
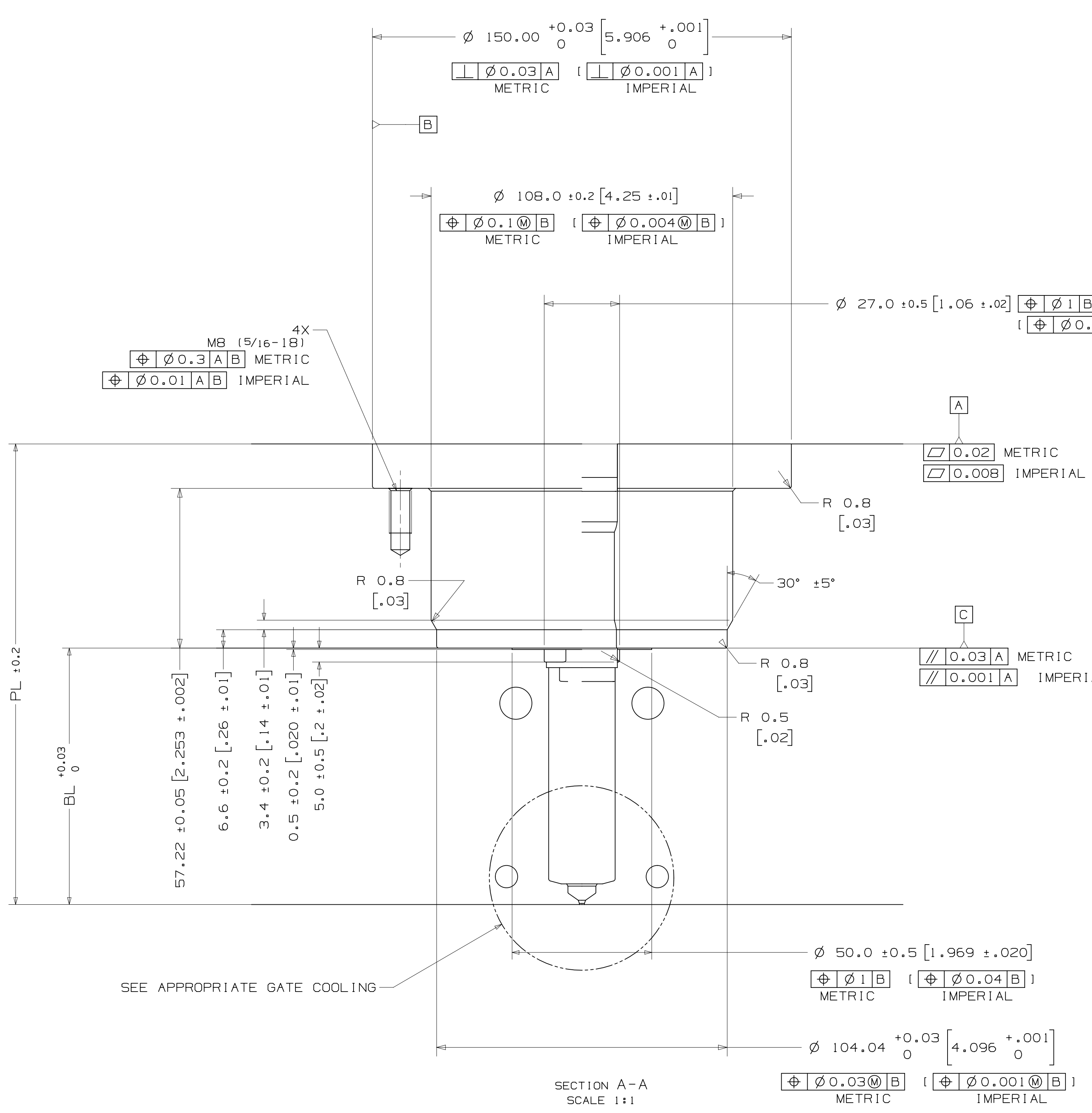


# INSTALLATION DRAWING

REV 0  
8094793



\* THIS DOWEL INSTALLATION IS ONLY REQUIRED IF THE NOZZLE TIP WILL BE REMOVED WHILE THE SCVGS 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]	60° C-79° C [140° F-174° F]	80° C-99° C [176° F-210° F]	100° C-119° C [212° F-248° F]	120° C-139° C [248° F-282° F]	140° C-159° C [284° F-318° F]	160° C-179° C [320° F-354° F]	180° C-199° C [356° F-390° F]	200° C-219° C [392° F-428° F]	220° C-239° C [428° F-462° F]	240° C-259° C [464° F-498° F]	260° C-279° C [500° F-534° F]	280° C-300° C [536° F-572° F]					
U500	VG	50	91 [3.583]	100 [3.937]	21.58 [0.850]	21.59 [0.850]	21.61 [0.851]	21.62 [0.851]	21.63 [0.852]	21.64 [0.852]	21.66 [0.853]	21.67 [0.853]	21.68 [0.854]	21.70 [0.854]	21.71 [0.855]	21.73 [0.856]					
		60	101 [3.976]	110 [4.331]	31.59 [1.244]	31.60 [1.244]	31.62 [1.245]	31.63 [1.245]	31.65 [1.246]	31.66 [1.246]	31.68 [1.247]	31.69 [1.248]	31.71 [1.248]	31.73 [1.249]	31.74 [1.250]	31.76 [1.250]					
		70	111 [4.370]	120 [4.724]	41.60 [1.638]	41.61 [1.638]	41.63 [1.639]	41.65 [1.640]	41.67 [1.641]	41.68 [1.641]	41.70 [1.642]	41.72 [1.643]	41.74 [1.643]	41.76 [1.644]	41.78 [1.645]	41.80 [1.646]					
		80	121 [4.764]	130 [5.118]	51.61 [2.032]	51.62 [2.032]	51.64 [2.033]	51.66 [2.034]	51.68 [2.035]	51.70 [2.035]	51.72 [2.036]	51.74 [2.037]	51.76 [2.038]	51.79 [2.039]	51.81 [2.040]	51.83 [2.041]					
		90	131 [5.157]	140 [5.512]	61.61 [2.426]	61.63 [2.426]	61.66 [2.428]	61.68 [2.428]	61.70 [2.429]	61.72 [2.430]	61.74 [2.431]	61.77 [2.432]	61.79 [2.433]	61.81 [2.433]	61.84 [2.435]	61.87 [2.436]					
		100	141 [5.551]	150 [5.906]	71.62 [2.820]	71.64 [2.820]	71.67 [2.822]	71.69 [2.822]	71.72 [2.824]	71.74 [2.824]	71.77 [2.826]	71.79 [2.826]	71.82 [2.828]	71.84 [2.828]	71.87 [2.830]	71.90 [2.831]					
		110	151 [5.945]	160 [6.299]	81.63 [3.214]	81.65 [3.215]	81.68 [3.216]	81.71 [3.217]	81.73 [3.218]	81.76 [3.219]	81.79 [3.220]	81.82 [3.221]	81.85 [3.222]	81.87 [3.223]	81.91 [3.225]	81.94 [3.226]					
		120	161 [6.339]	170 [6.693]	91.64 [3.608]	91.67 [3.609]	91.69 [3.610]	91.72 [3.611]	91.75 [3.612]	91.78 [3.613]	91.81 [3.615]	91.84 [3.616]	91.87 [3.617]	91.90 [3.618]	91.94 [3.620]	91.97 [3.621]					
		130	171 [6.732]	180 [7.087]	101.64 [4.002]	101.68 [4.003]	101.71 [4.004]	101.74 [4.006]	101.77 [4.007]	101.80 [4.008]	101.83 [4.009]	101.87 [4.011]	101.90 [4.012]	101.93 [4.013]	101.97 [4.015]	102.01 [4.016]					
		140	181 [7.126]	190 [7.480]	111.65 [4.396]	111.69 [4.397]	111.72 [4.398]	111.75 [4.400]	111.79 [4.401]	111.82 [4.402]	111.85 [4.404]	111.89 [4.405]	111.93 [4.407]	111.96 [4.408]	112.00 [4.409]	112.04 [4.411]					
		150	191 [7.520]	200 [7.874]	121.66 [4.790]	121.70 [4.791]	121.73 [4.793]	121.77 [4.794]	121.80 [4.795]	121.84 [4.797]	121.88 [4.798]	121.92 [4.800]	121.95 [4.801]	121.99 [4.803]	122.04 [4.805]	122.08 [4.806]					
		160	201 [7.913]	210 [8.268]	131.67 [5.184]	131.71 [5.185]	131.74 [5.187]	131.78 [5.188]	131.82 [5.190]	131.86 [5.191]	131.90 [5.193]	131.94 [5.194]	131.98 [5.196]	132.02 [5.198]	132.07 [5.200]	132.11 [5.201]					
		170	211 [8.307]	220 [8.661]	141.68 [5.578]	141.72 [5.580]	141.76 [5.581]	141.80 [5.583]	141.84 [5.584]	141.88 [5.586]	141.92 [5.587]	141.96 [5.589]	142.01 [5.591]	142.05 [5.593]	142.10 [5.594]	142.15 [5.596]					
		180	221 [8.701]	230 [9.055]	151.68 [5.972]	151.73 [5.974]	151.77 [5.975]	151.81 [5.977]	151.85 [5.978]	151.90 [5.980]	151.94 [5.982]	151.99 [5.984]	152.03 [5.985]	152.08 [5.987]	152.13 [5.989]	152.18 [5.991]					
		190	231 [9.094]	240 [9.449]	161.69 [6.366]	161.74 [6.368]	161.78 [6.369]	161.82 [6.371]	161.87 [6.373]	161.92 [6.375]	161.96 [6.376]	162.01 [6.378]	162.06 [6.380]	162.11 [6.382]	162.17 [6.385]	162.22 [6.387]					
		200	241 [9.488]	250 [9.843]	171.70 [6.760]	171.75 [6.762]	171.79 [6.763]	171.84 [6.765]	171.89 [6.767]	171.94 [6.769]	171.99 [6.771]	172.04 [6.773]	172.09 [6.775]	172.14 [6.777]	172.20 [6.780]	172.25 [6.781]					

\* 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.

NOZZLE TIP	LOCATING RING DIAMETER	SPRUE BUSHING	
		SEAL-OFF GEOMETRY	CHANNEL Ø
U500	100mm	FLAT	4 - B
	101.3mm [3.99"]	FLAT	8 - THRU
U500	125mm	SEAL-OFF 12.7 [1/2"]	8 - THRU
		SEAL-OFF 15.5	
		SEAL-OFF 19.05 [3/4"]	
U500	125mm	SEAL-OFF 20	8 - THRU
		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]

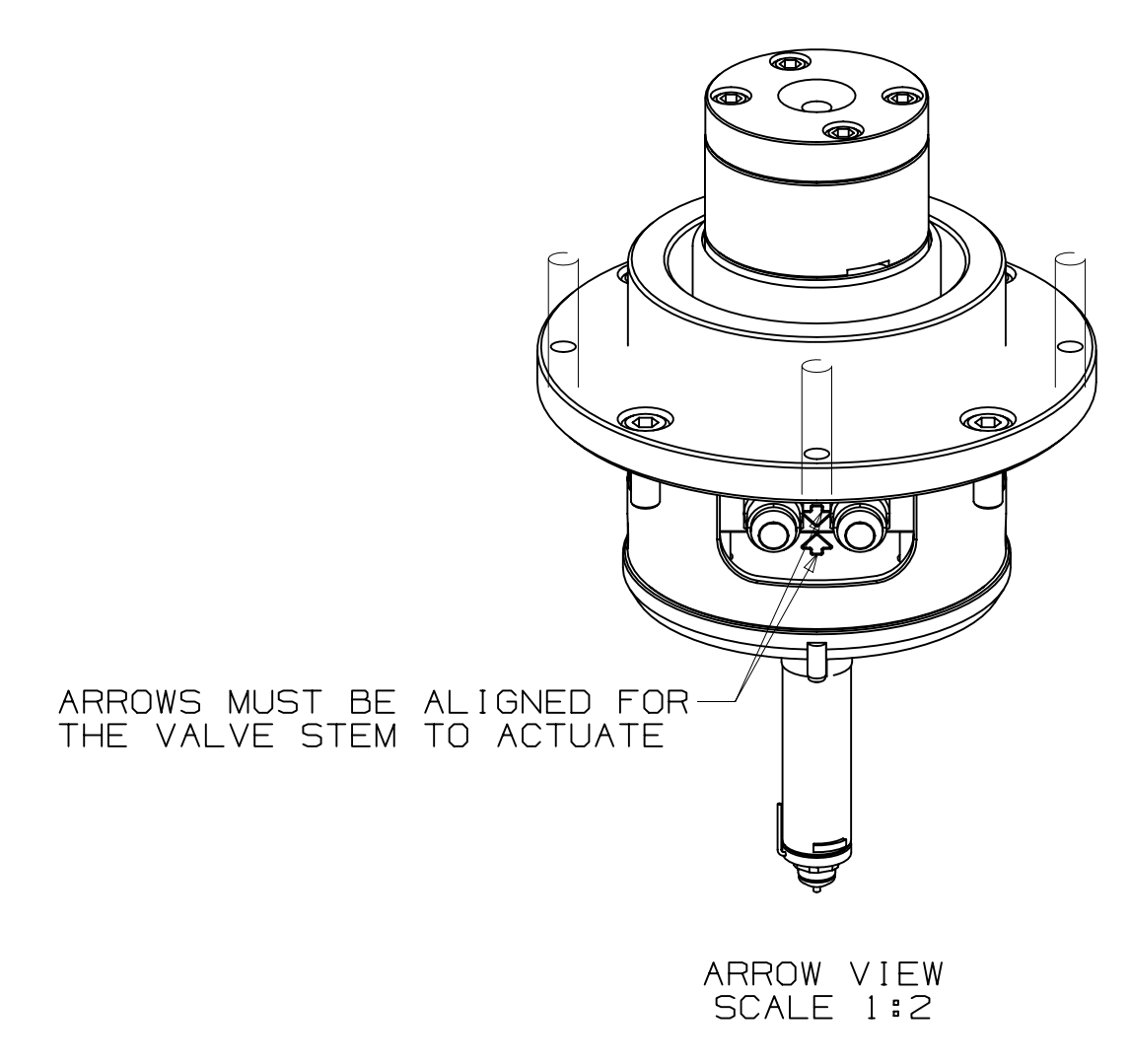
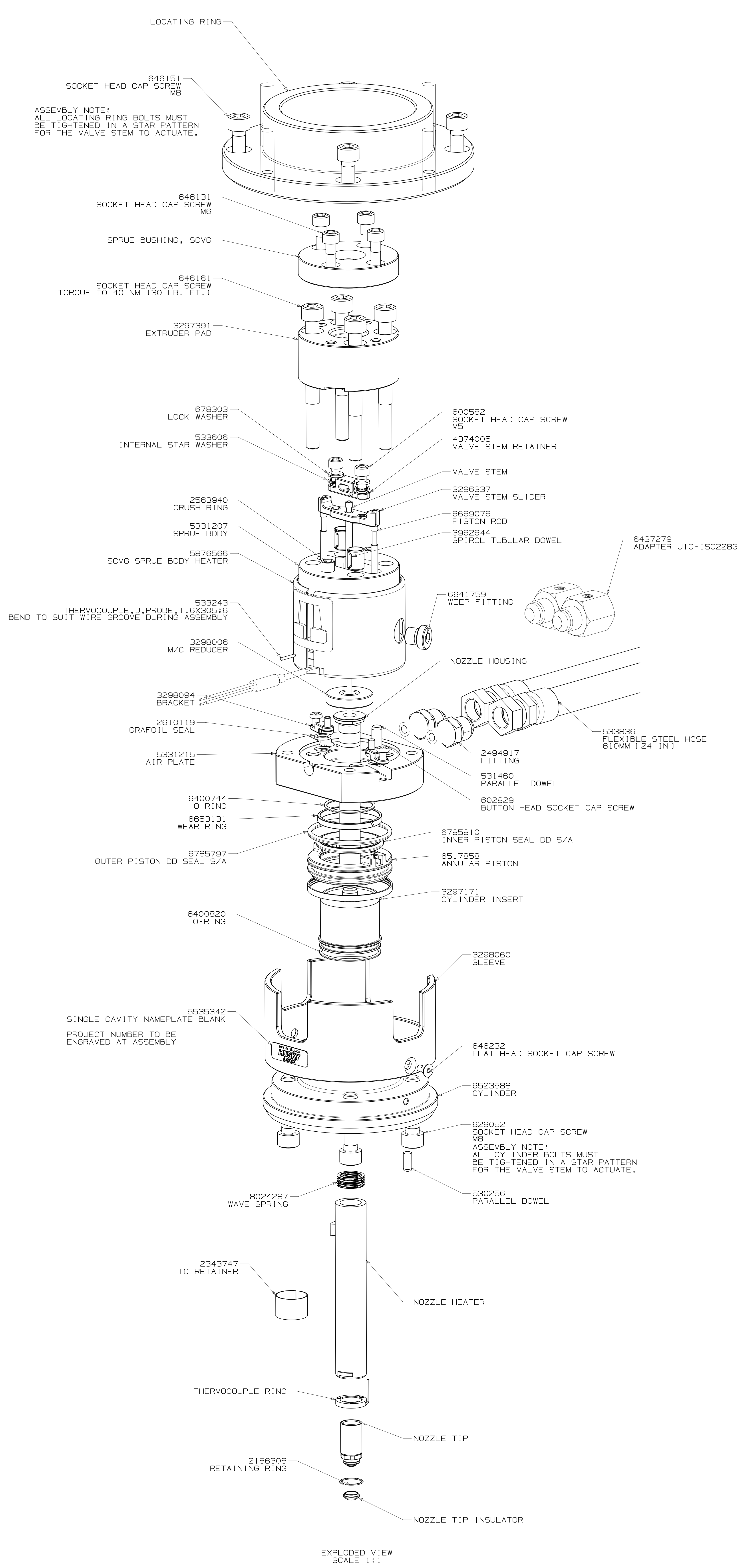
**RECOMMENDED GATE MANUFACTURING GUIDELINES**  
- HARDENED GATE INSERTS (49-51) ARE RECOMMENDED WHEN USING SOFTER CAVITY STEELS. SOFTER CAVITIES MAY BE ACCEPTABLE FOR CERTAIN APPLICATIONS. CONTACT YOUR HUSKY REPRESENTATIVE WITH QUESTIONS.  
- EDM'ING THE GATE AREA CAUSES MICRO CRACKS WHICH LEAD TO BRITTLE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

DWT PER ASM 114-1994 AND HEAVY ASSEMBLY - H254 BASIS: CHINA SPECIFIED DTD MODEL IS BASIC NO. TOLERANCES DIMENSIONS ARE BASIC GENERAL TOLERANCE: METRIC: $\pm 0.17$ IMPERIAL: $\pm 0.017$ BREAK EDGES/CHAMFER: $1 \times 0.2 \times 45^\circ$ $0.04 \pm 0.01 \times 45^\circ$ FILLET/RADIUS: $R0.8 \pm 0.2$ $R0.03 \pm 0.01$ SURFACE FINISH: $Rz$	UNFINISHED DRAWING FEATURES TO 300% AT THE MOLD SUPPLIER QUALITY REFERENCE MATERIAL: N/A FINISH/TREATMENT:	HUSKY TITLE: SCVG Single Cavity Valve Gate U500-SCVG-VG SCALE: 1:1 SHEET: 1 OF 2 AOR: 8094793 REV: 0
---	--	---

# ASSEMBLY DRAWING

REV: 0  
STATUS: 8094793



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	250	180
1	350	250
M4	4.0	3.0
M5	5.0	3.5
M6	6.0	4.0
M8	10.0	7.0
M10	15.0	10.0
M12	20.0	14.0
M14	25.0	18.0
M16	35.0	25.0
M20	60.0	45.0
M24	110.0	80.0

VALVE STEM STROKE IS 7.3 (.291)	
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. <a href="http://www.husky.ca">www.husky.ca</a>	
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	2017-09-09	ORIGINAL ISSUE - DESIGNED BY DHANALEYAN	DRWN: DHANALEYAN	CHKD: PICHLER KLAUS

DEFINING DRAWING FEATURES	METRIC	<b>HUSKY</b>
MATERIAL: N/A	SCALE: 1:1	TITLE: Single Cavity Valve Gate
FINISH/TREATMENT	SIZE: AOR	DRAWING: 8094793
WEIGHT: - kg	SHEET 2 OF 2	REV: 0