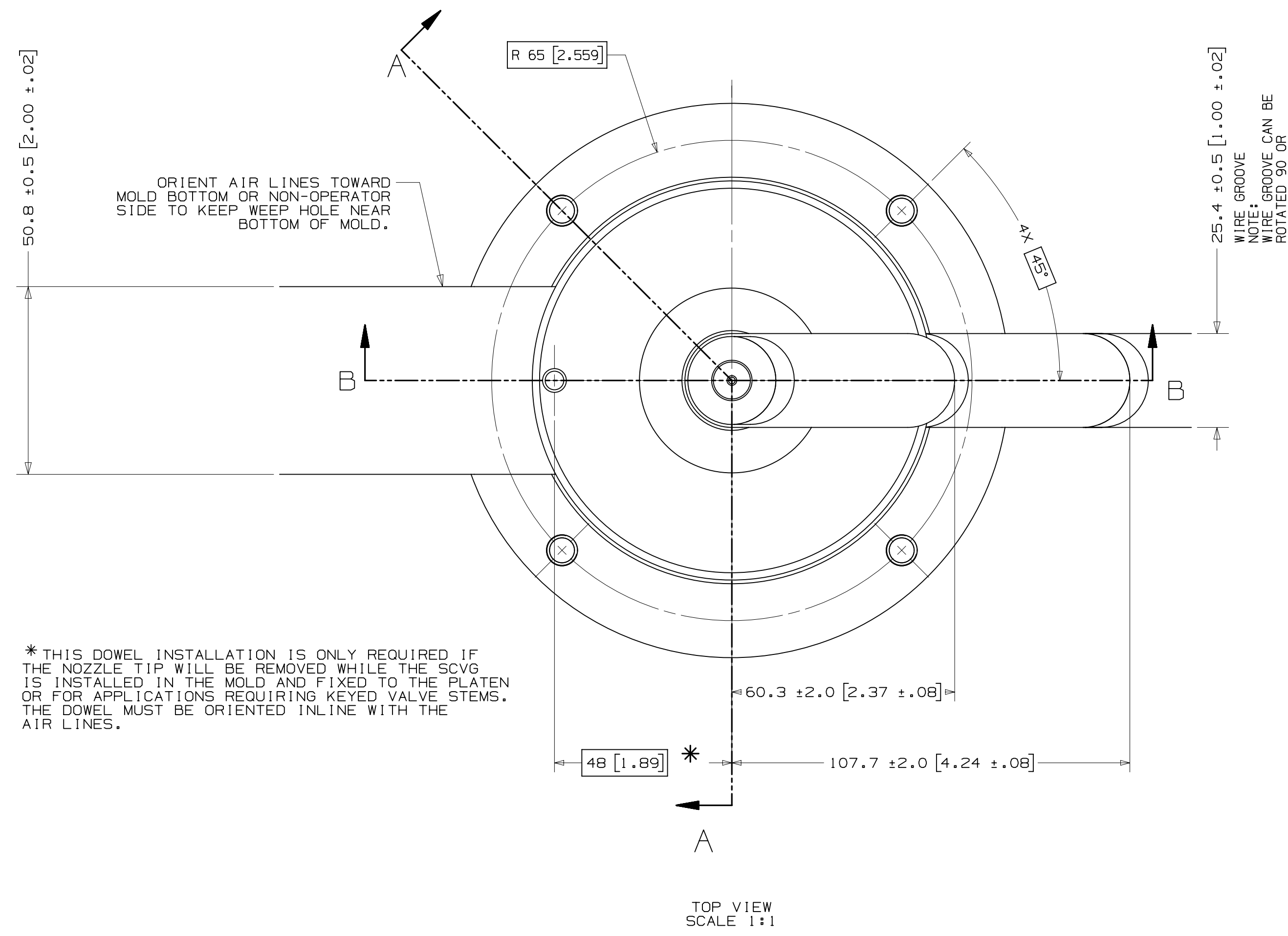
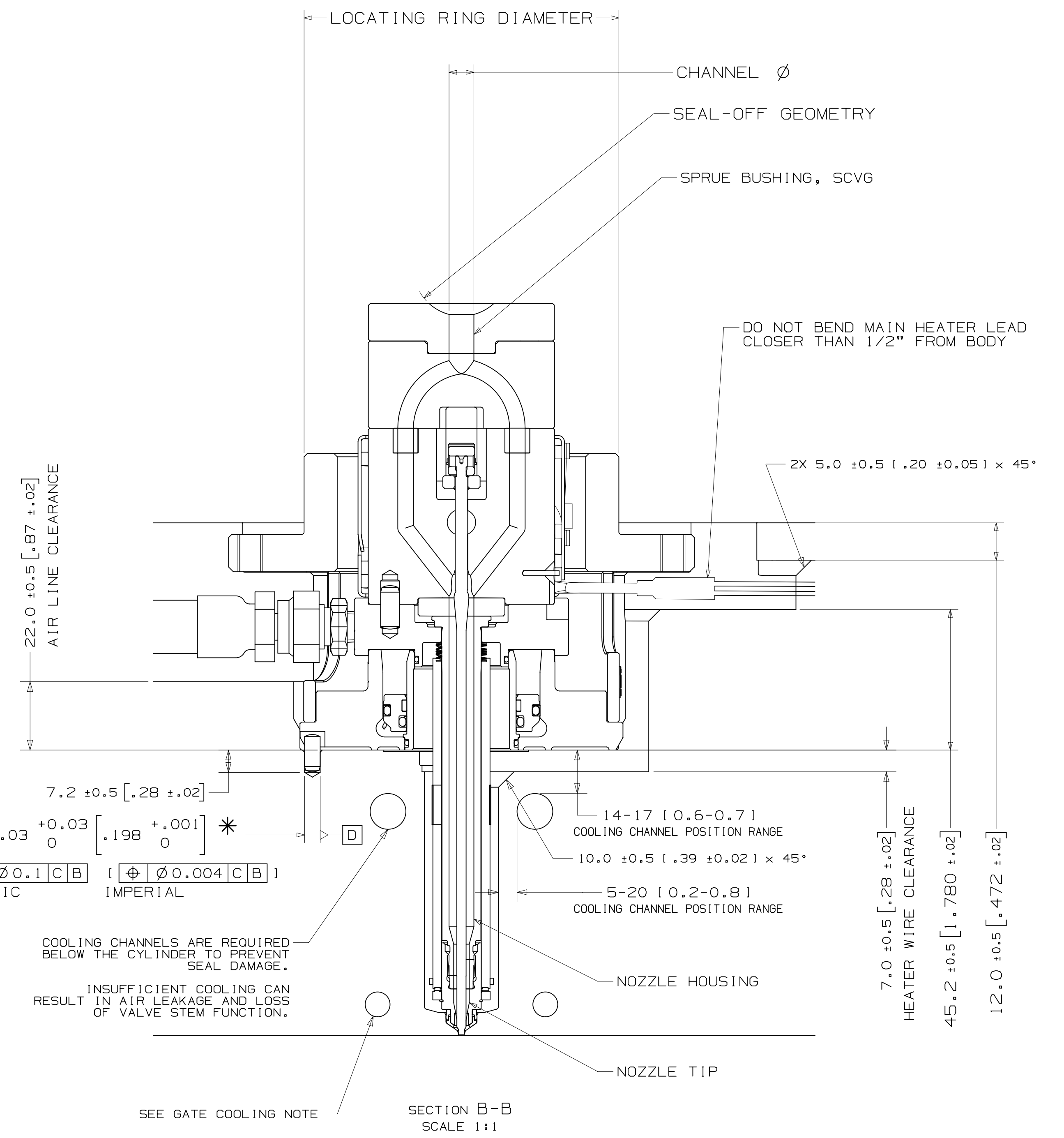
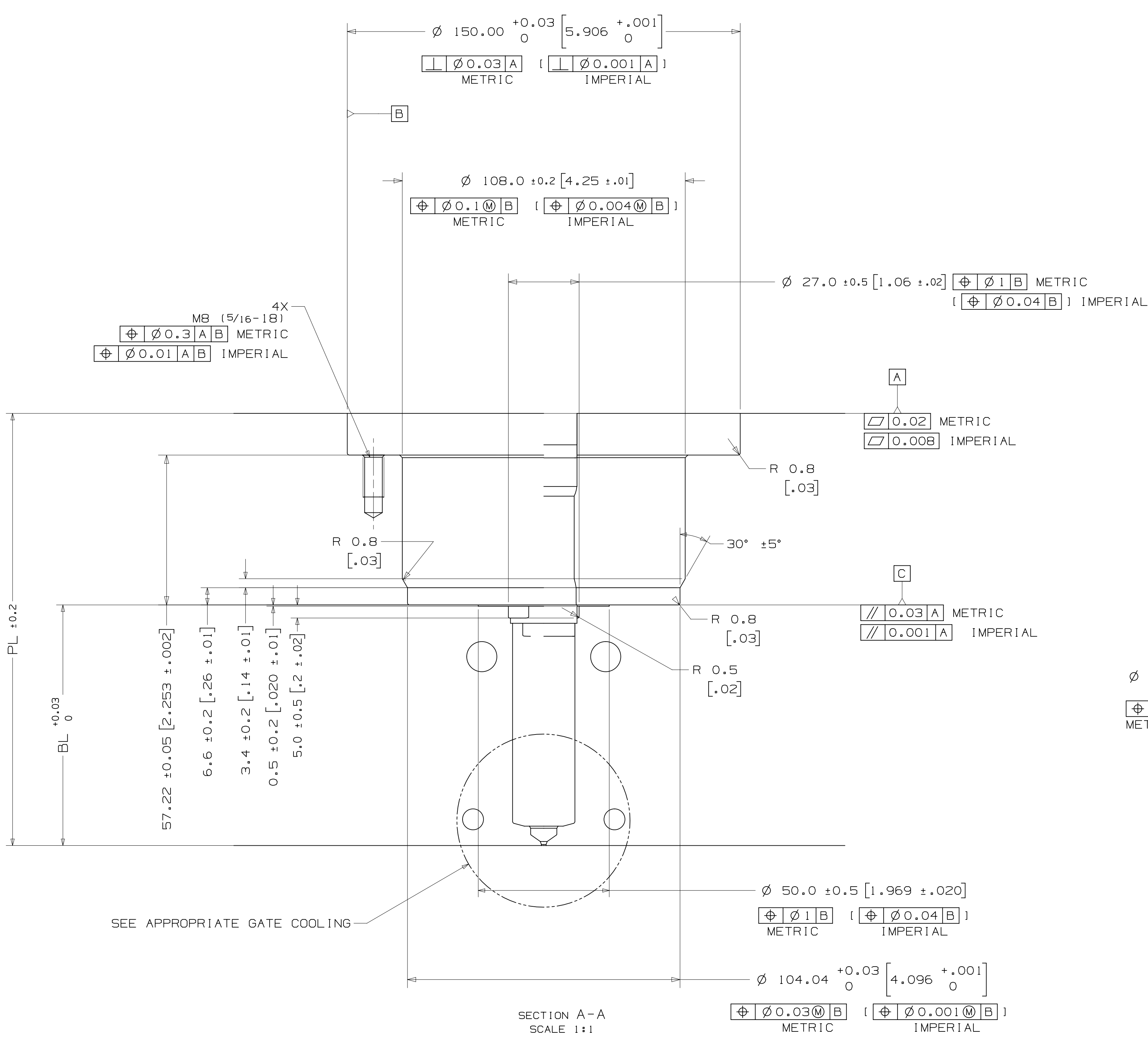


INSTALLATION DRAWING



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



| NOZZLE SERIES | NOZZLE TIP | PL RANGE | Approx. BL |
|---------------|------------|-----------------------------|----------------------|
| U500 | VG | 91.17(3.589) - 251.4(9.898) | 22(0.86) - 172(6.77) |

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

| U500 | SPRUE BUSHING | |
|------|-----------------------|--------------------|
| | SEAL-OFF GEOMETRY | CHANNEL Ø IN - OUT |
| | FLAT | 4 - 8 |
| | SEAL-OFF 12.7 (1/2") | 8 - THRU |
| | SEAL-OFF 15.5 | |
| | SEAL-OFF 19.05 (3/4") | |
| | SEAL-OFF 20 | |
| | SEAL-OFF 40 | |

| U500 | LOCATING RING DIAMETER |
|------|------------------------|
| | 100mm |
| | 101.3mm (3.99") |
| | 125mm |

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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.

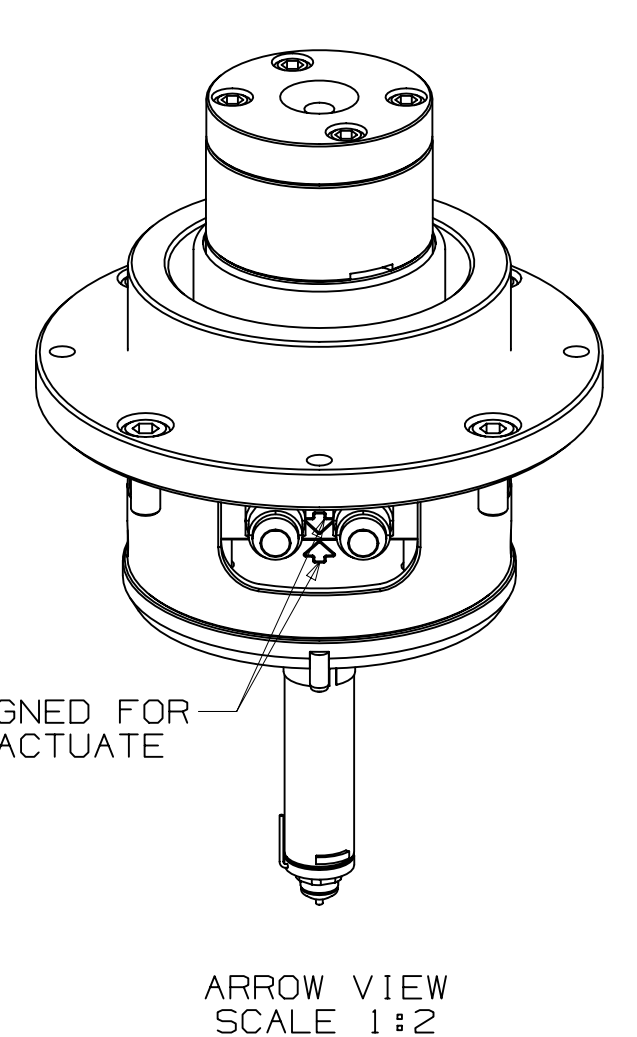
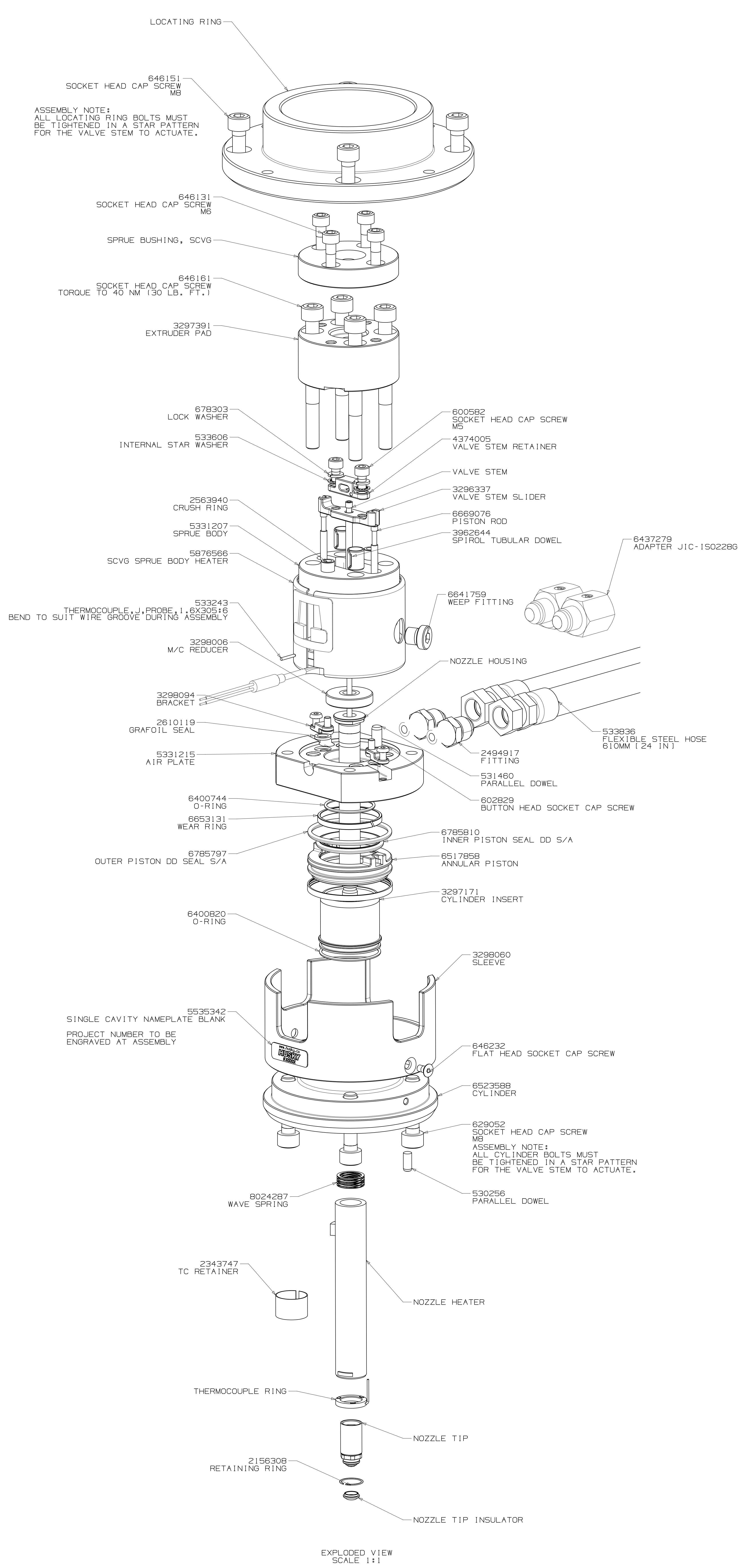
| REV | DATE | DESCRIPTION | DESIGNED BY | CHECKED BY |
|-----|------------|--|---------------------|------------|
| 4 | 2020-05-28 | TABLE UPDATED PER LATEST CALCULATION | DRWINI DEEBAN N T | CHKD1 |
| 3 | 2019-07-09 | TEMPLATE VALUES UPDATED AS PER SOL 2.0 | DRWINI MURALIDHARAN | CHKD1 |
| 2 | 2018-04-06 | DRAWING NAME CHANGED | DRWINI ANUSHAL | CHKD1 |
| 1 | 2018-01-12 | BL NOTE UPDATED | DRWINI DHANALEYAN | CHKD1 |
| 0 | 2017-09-09 | ORIGINAL ISSUE - DESIGNED BY: DHANALEYAN | DRWINI DHANALEYAN | CHKD1 |

| GENERAL TOLERANCES | METRIC | IMPERIAL |
|----------------------|---------------|-------------------|
| GENERAL TOLERANCES | CS [0.17] | CS [0.017] |
| BROKEN EDGES/CHAMFER | 1 ± 0.2 X 45° | 0.04 ± 0.01 X 45° |
| FILLET ROUNDS | R0.8 ± 0.2 | R0.03 ± 0.01 |
| SURFACE FINISH | 6.3 | |

| FINISH/TREATMENT | SCALE | SIZE | DRAWING | REV |
|------------------|-------|------|---------|-----|
| | 1:1 | AOR | 8094793 | 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 | 7 | 5 |
| 1/16 | 16 | 12 |
| 5/16 | 25 | 18 |
| 3/8 | 35 | 25 |
| 1/2 | 50 | 35 |
| 5/8 | 75 | 55 |
| 3/4 | 100 | 75 |
| 7/8 | 150 | 110 |
| 1 | 200 | 150 |
| M4 | 7 | 5 |
| M5 | 8 | 6 |
| M6 | 10 | 7 |
| M8 | 15 | 11 |
| M10 | 20 | 15 |
| M12 | 25 | 18 |
| M14 | 35 | 25 |
| M16 | 50 | 35 |
| M20 | 75 | 55 |
| M24 | 110 | 80 |

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 = (-)

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| REV | DATE | DESCRIPTION | NAME |
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| 4 | 2020-05-28 | TABLE UPDATED PER LATEST CALCULATION | DRWNI DEEBAN N T |
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| 1 | 2018-01-12 | BL NOTE UPDATED | DRWNI DHANALEYAN |
| 0 | 2017-09-09 | ORIGINAL ISSUE - DESIGNED BY: DHANALEYAN | DRWNI DHANALEYAN |
| | | | CHKDI PICHLER KLAUS |

| MATERIAL | FINISH/TREATMENT | WEIGHT | SCALE | SIZE | DRAWING | REV |
|----------|------------------|--------|-------|------|---------|-----|
| N/A | | - kg | 1:1 | AOR | 8094793 | 0 |