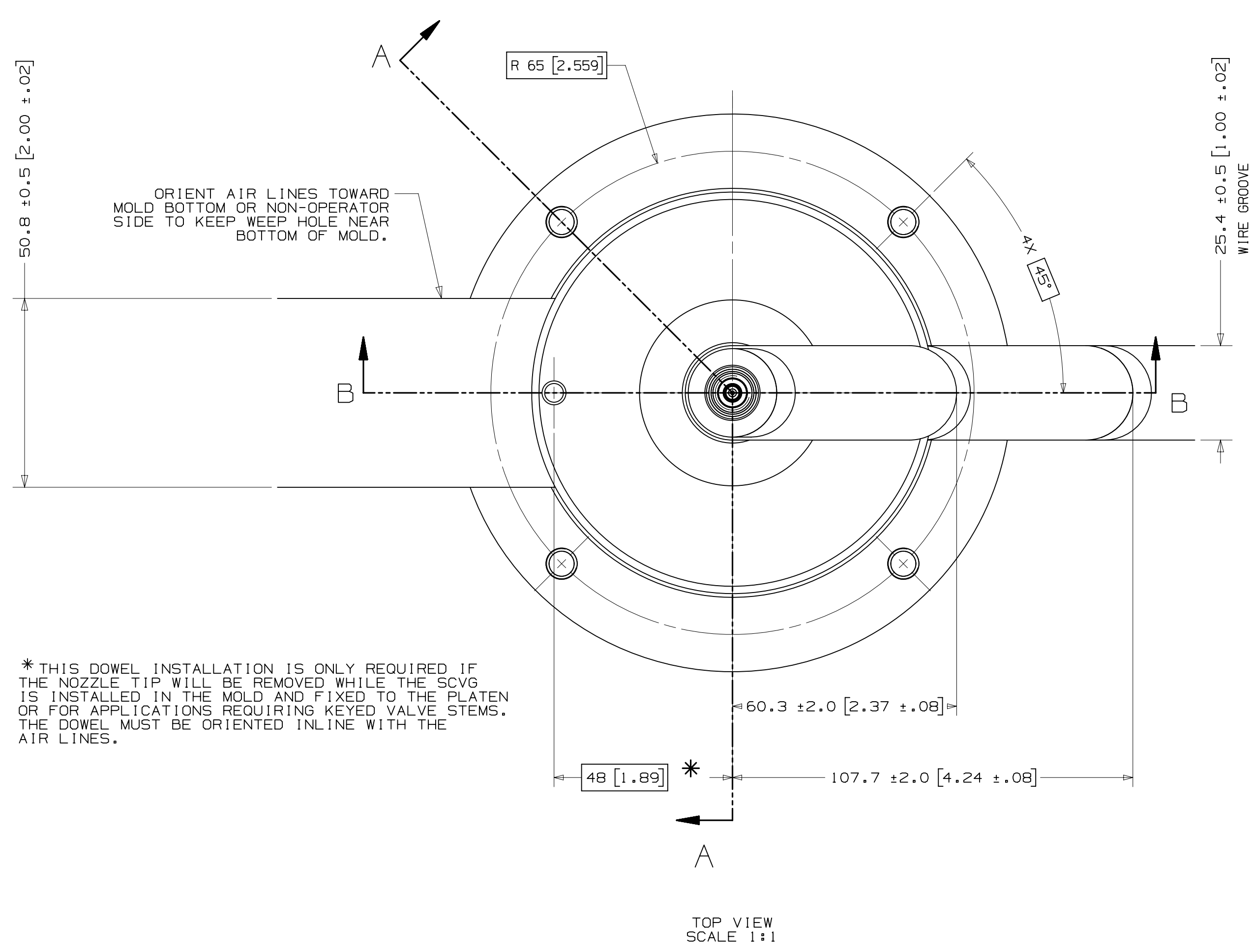


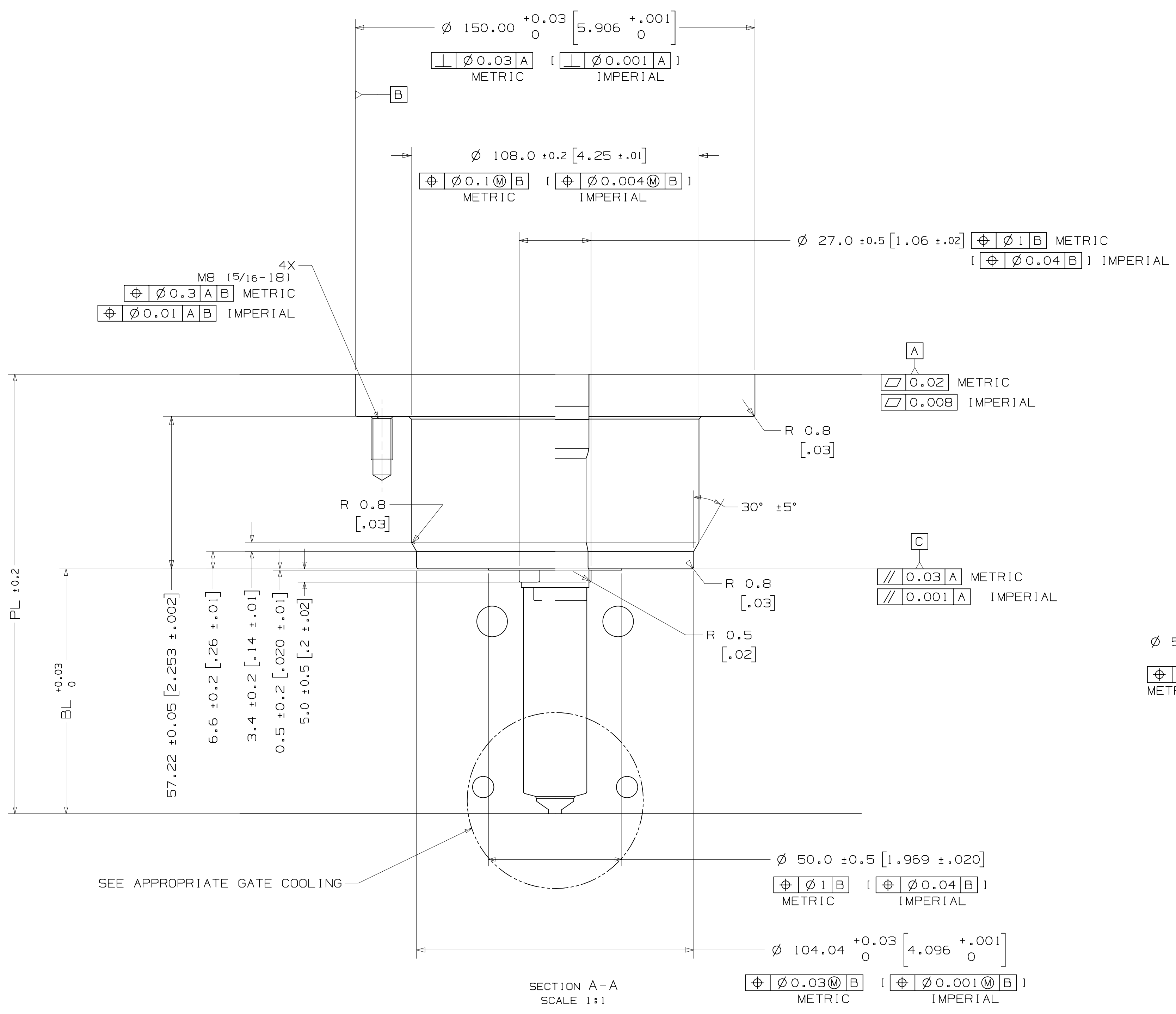
INSTALLATION DRAWING

STATUS: 8143261 0

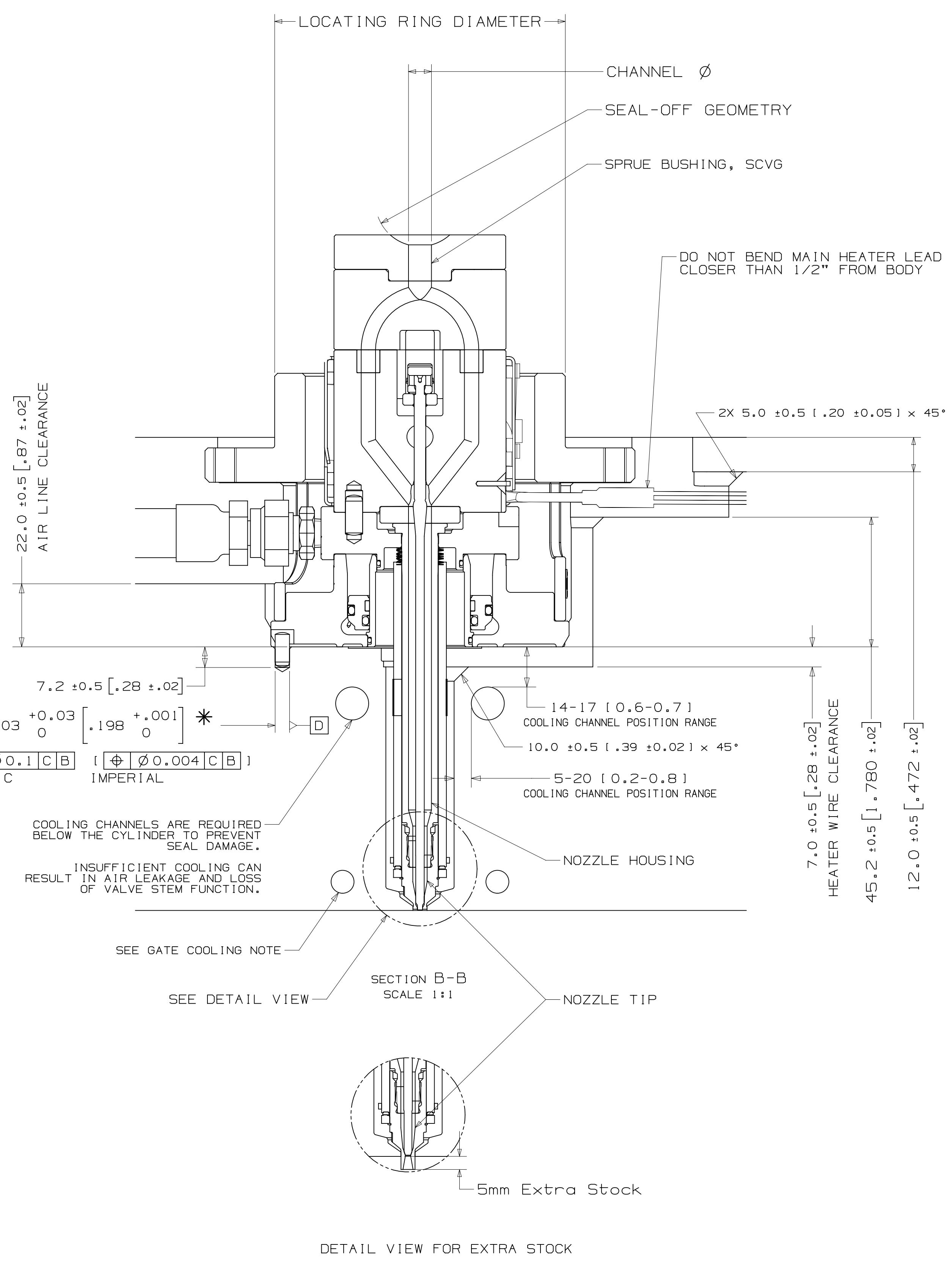


* THIS DOWEL INSTALLATION IS ONLY REQUIRED IF THE NOZZLE TIP WILL BE REMOVED WHILE THE SCVG IS INSTALLED IN THE MOLD AND FIXED TO THE PLATEN OR FOR APPLICATIONS REQUIRING KEYS VALVE STEMS. THE DOWEL MUST BE ORIENTED IN LINE WITH THE AIR LINES.

TOP VIEW
SCALE 1:1



SECTION A-A
SCALE 1:1



SECTION B-B
SCALE 1:1

DETAIL VIEW FOR EXTRA STOCK

NOZZLE SERIES	NOZZLE TIP	PL RANGE	Approx. BL
U500	VX	91.24(3.592) - 251.619(9.905)	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 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	

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

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

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)

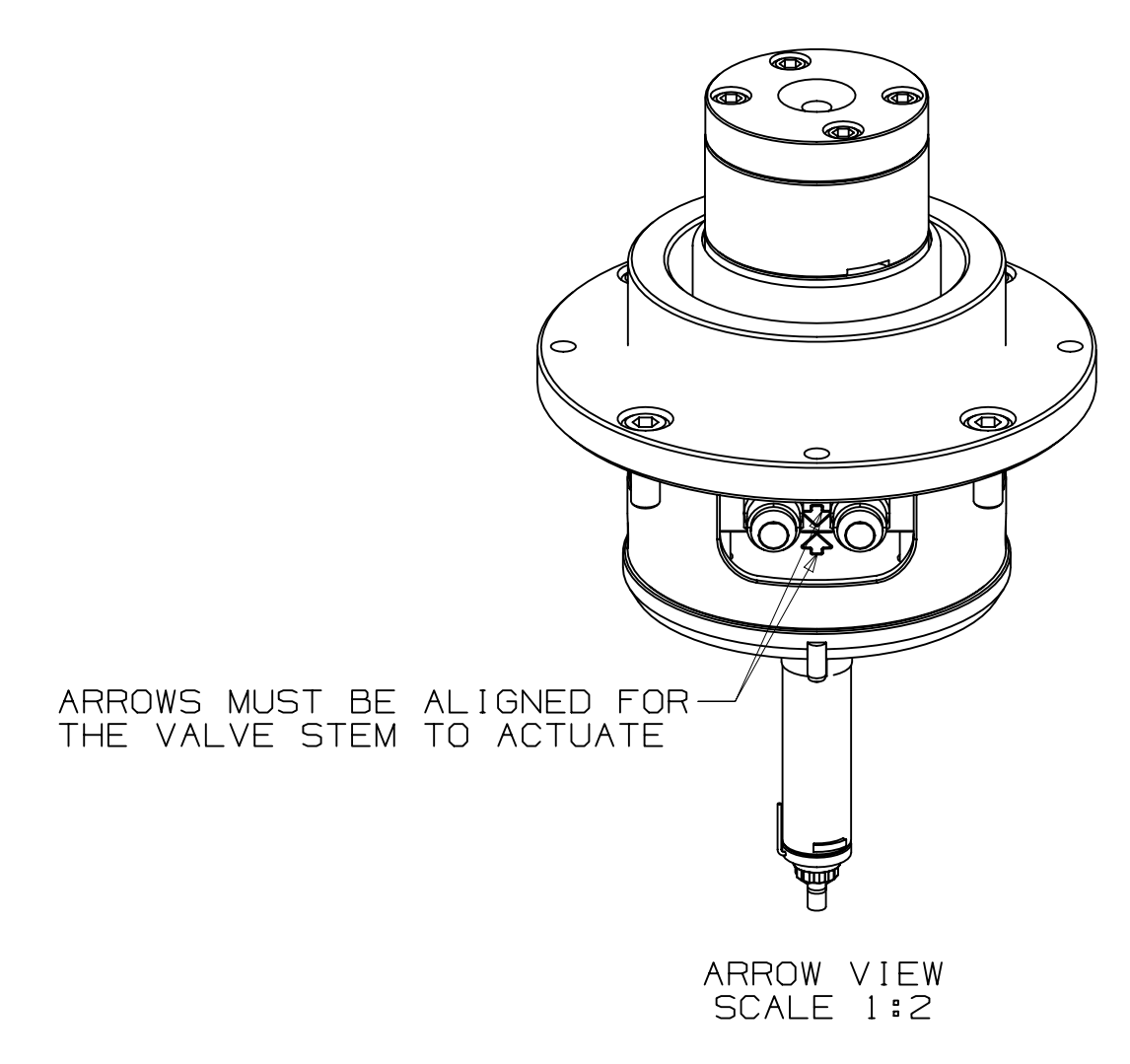
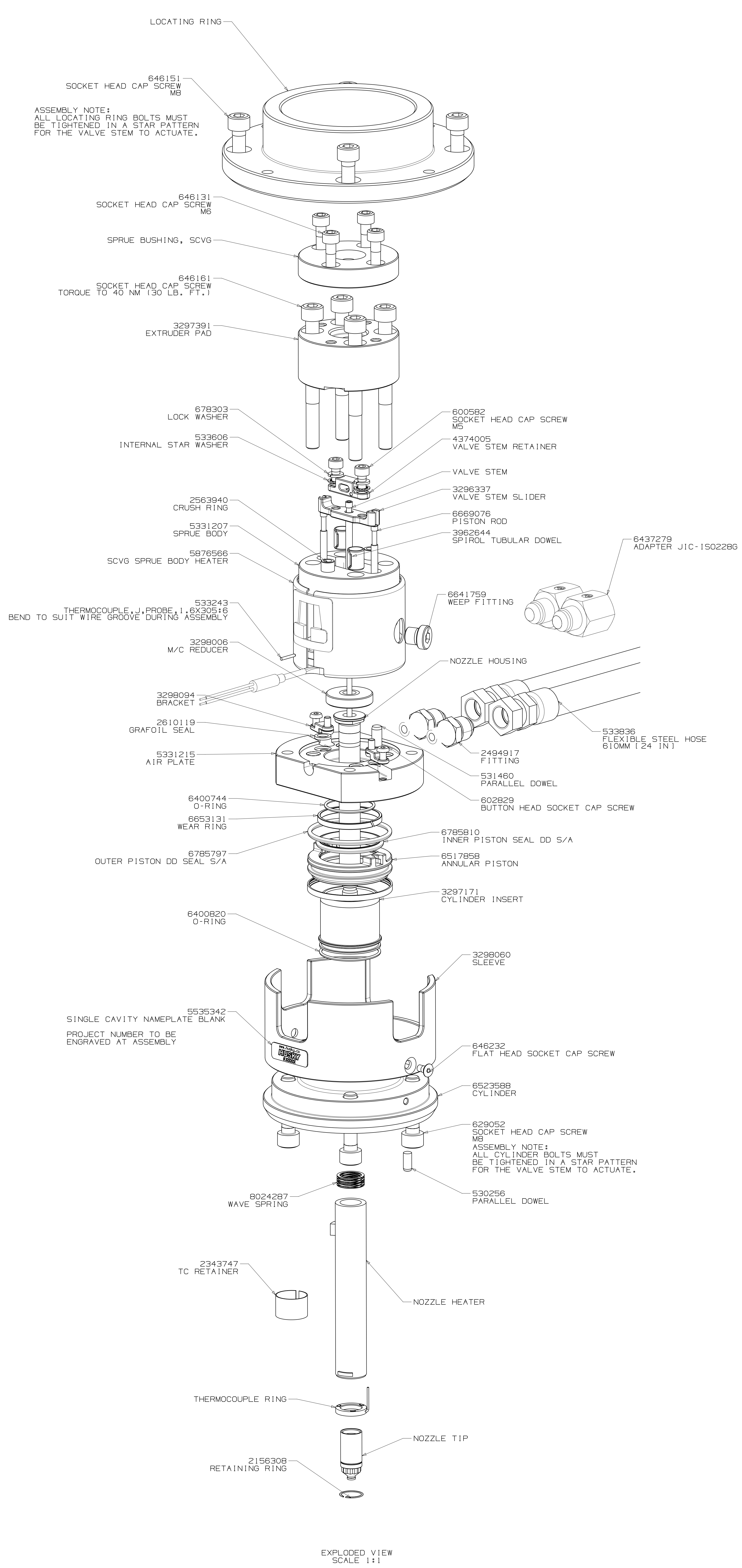
RECOMMENDED GATE MANUFACTURING GUIDELINES
- HARDENED GATE INSERTS (49-51) ARE RECOMMENDED WHEN USING SOFTER CAVITY STEELS. SOFTER CAVITIES MAY BE ACCEPTABLE FOR CERTAIN APPLICATIONS. CONTACT YOUR HUSKY REPRESENTATIVE WITH QUESTIONS.
- EDM'ING THE GATE AREA CAUSES MICRO CRACKS WHICH LEAD TO BRITTLE GATE 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	DRWNG	CHKD
4	2020-05-28	TABLE UPDATED PER LATEST CALCULATION	DRWNG DEEBAN N T	CHKD
3	2019-07-09	TEMPLATE VALUES UPDATED AS PER SOL 2.0	DRWNG MURALIDHARAN	CHKD
2	2018-04-06	DRAWING NAME CHANGED	DRWNG ANUSHAL	CHKD
1	2018-01-12	BL NOTE UPDATED	DRWNG DHANALEYAN	CHKD
0	2017-09-11	ORIGINAL ISSUE - DESIGNED BY: DHANALEYAN	DRWNG DHANALEYAN	CHKD
			DRWNG PICHLER KLAUS	CHKD

DWT PER ASME Y14.5M-1994 AND HEAVY ADDENDUM - H254		UNFINISHED DRAWING FEATURES		MATERIAL		FINISH/TREATMENT		WEIGHT	
GENERAL TOLERANCE:	ASME Y14.5M-1994	FINISH/TREATMENT:	ASME Y14.5M-1994	MATERIAL:	N/A	WEIGHT:	- kg	SCALE 1:1	
BROKEN EDGES/CHAMFER:	1 ± 0.2 X 45°	FINISH/TREATMENT:	ASME Y14.5M-1994	TITLE		SHEET 1 OF 2		REV	
FILLET/RADIUS:	R0.8 ± 0.2	FINISH/TREATMENT:	ASME Y14.5M-1994	Single Cavity Valve Gate		AOR		8143261 0	
SURFACE FINISH:	6.3	FINISH/TREATMENT:	ASME Y14.5M-1994	U500-SCVG-VX		DRAWING		8143261 0	

ASSEMBLY DRAWING

DRAWING NO. 8143261 0



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	65	48
1/2	150	110
5/8	250	180
3/4	500	360
1	750	540
1 1/8	1180	860
M4	4.6	3.4
M5	9.1	6.7
M6	13.7	10.0
M8	27.4	20.1
M10	39.2	28.7
M12	58.8	43.1
M14	78.4	57.5
M16	118.0	86.0
M20	236.0	172.0
M25	472.0	344.0

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 = (-)	
RECOMMENDED GATE COOLING GUIDELINES ADEQUATE COOLING IS ESSENTIAL FOR THE PROPER FUNCTION OF THIS SYSTEM. REFER TO THE HOT RUNNER PRODUCT GUIDE FOR CERTAIN APPLICATIONS. CONTACT YOUR HUSKY REPRESENTATIVE WITH QUESTIONS. 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
4	2020-05-28	TABLE UPDATED PER LATEST CALCULATION	DRWIN DEEBAN N T
3	2019-07-09	TEMPLATE VALUES UPDATED AS PER SOL 2.0	DRWIN MURALIDHARAN
2	2018-04-06	DRAWING NAME CHANGED	DRWIN ANUSHAL
1	2018-01-12	BL NOTE UPDATED	DRWIN DHANALEYAN
0	2017-09-11	ORIGINAL ISSUE - DESIGNED BY: DHANALEYAN	DRWIN DHANALEYAN
			DRWIN PICHLER KLAUS

DEFINING DRAWING FEATURES	METRIC	HUSKY
MATERIAL	N/A	TITLE
FINISH/TREATMENT		Single Cavity Valve Gate
WEIGHT	- kg	U500-SCVG-VX
		SCALE 1:1
		SIZE AOR
		DRAWING NO. 8143261
		REV 0
		SHEET 2 OF 2