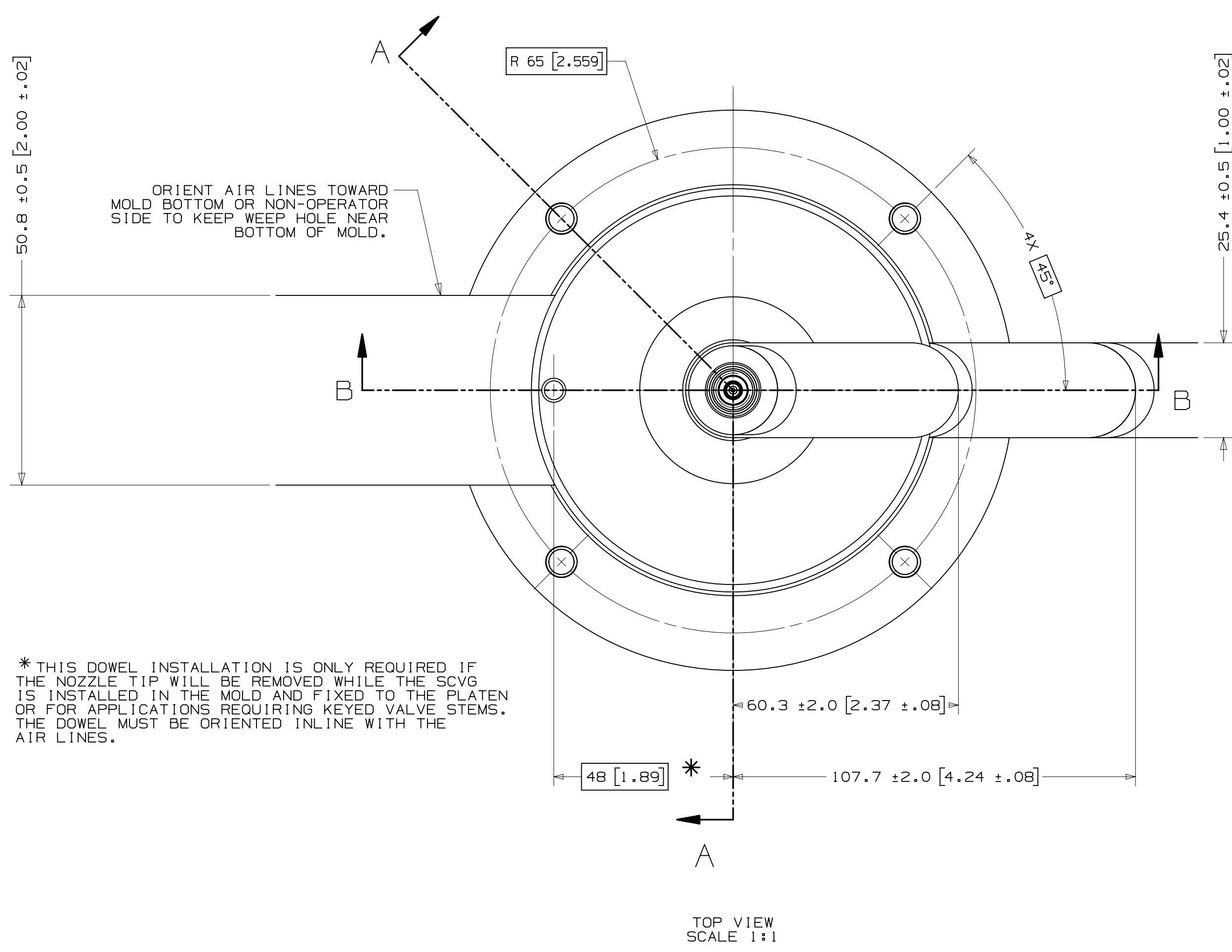


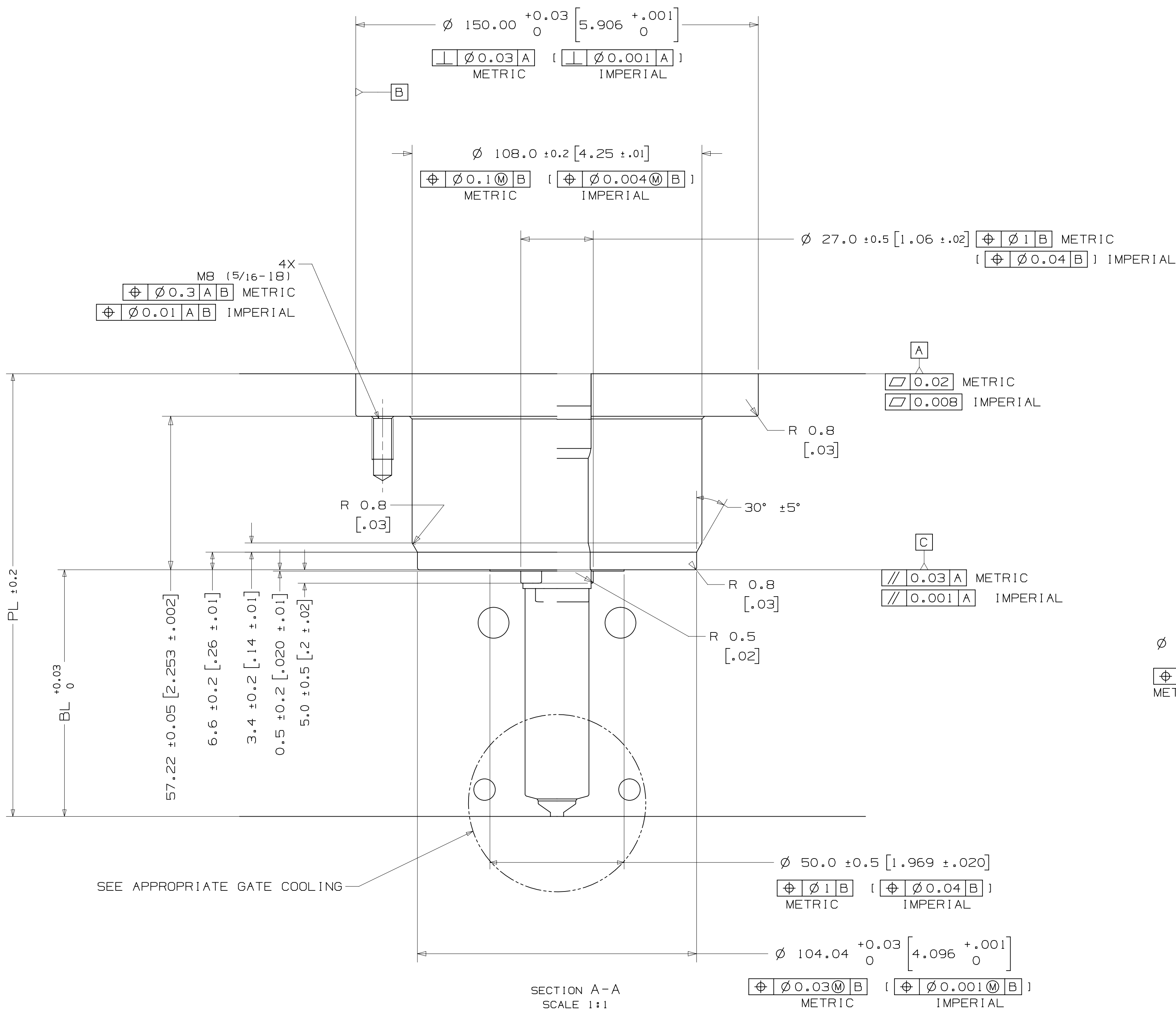
# INSTALLATION DRAWING

STATUS: 8143261\_0

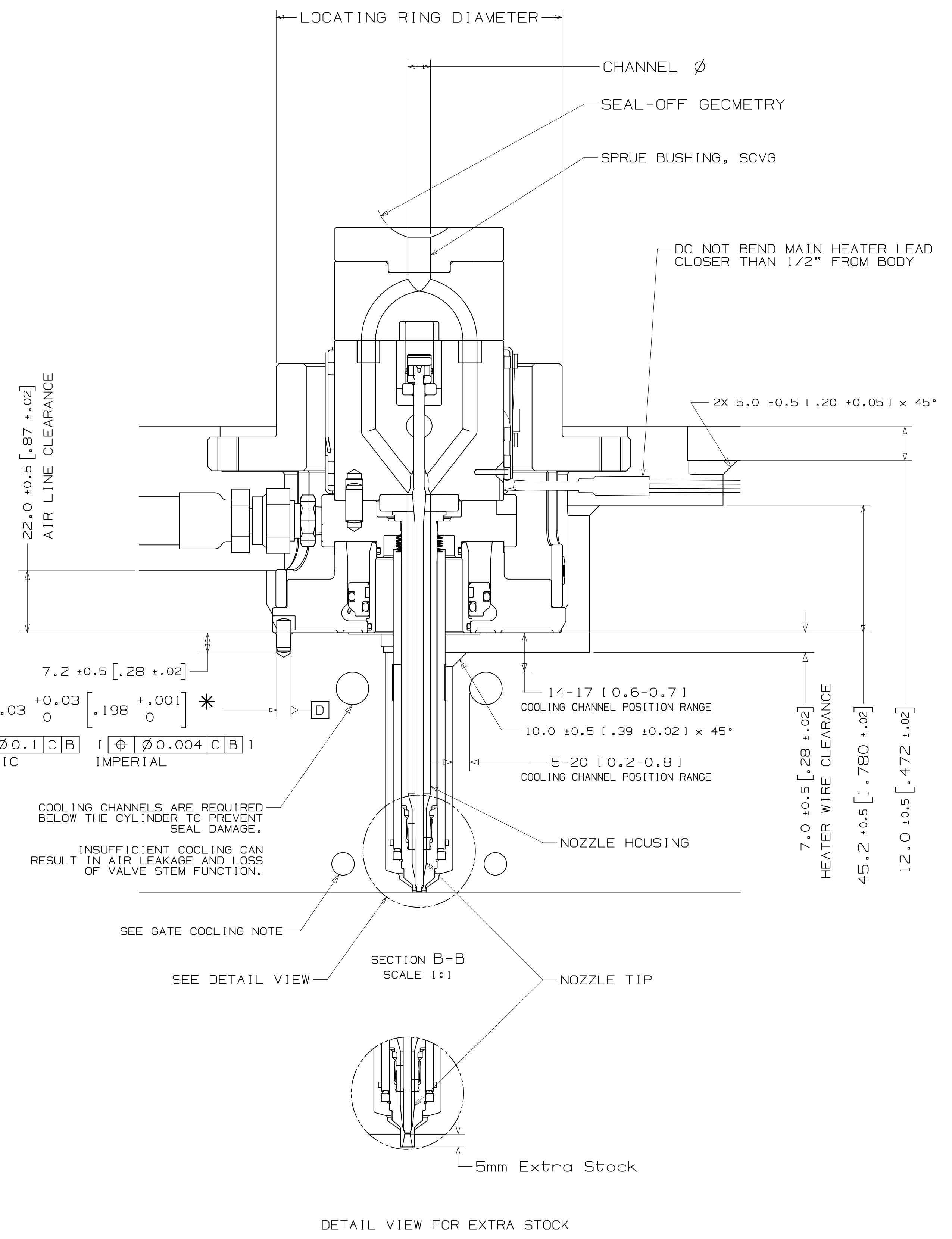


\* THIS DOWEL INSTALLATION IS ONLY REQUIRED IF THE NOZZLE TIP WILL BE REMOVED WHILE THE SCVG IS INSTALLED IN THE MOLD AND FIXED TO THE PLATEN OR FOR APPLICATIONS REQUIRING KEYS VALVE STEMS. THE DOWEL MUST BE ORIENTED IN LINE WITH THE AIR LINES.

TOP VIEW SCALE 1:1



SECTION A-A SCALE 1:1



DETAIL VIEW FOR EXTRA STOCK

NOZZLE SERIES	NOZZLE TIP	NOZZLE HOUSING LENGTH	PL		"BL" AT DELTA TEMP (DELTA TEMP = TEMP OF MELT - TEMP OF MOLD) *															
			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-246° F	120° C-139° C 248° F-282° F	140° C-159° C 288° 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-426° 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	VX / VX with 5mm Extra Stock	50	91 (3.583)	100 (3.937)	21.66 (0.853)	21.67 (0.853)	21.68 (0.854)	21.69 (0.854)	21.70 (0.854)	21.71 (0.855)	21.73 (0.856)	21.75 (0.856)	21.76 (0.857)	21.78 (0.857)	21.79 (0.858)	21.81 (0.859)				
		60	101 (3.976)	110 (4.331)	31.66 (1.246)	31.68 (1.247)	31.69 (1.248)	31.70 (1.248)	31.72 (1.249)	31.73 (1.249)	31.75 (1.250)	31.76 (1.250)	31.78 (1.251)	31.79 (1.252)	31.81 (1.252)	31.82 (1.253)				
		70	111 (4.370)	120 (4.724)	41.67 (1.641)	41.69 (1.641)	41.70 (1.642)	41.72 (1.643)	41.74 (1.643)	41.75 (1.644)	41.77 (1.644)	41.79 (1.645)	41.80 (1.646)	41.82 (1.646)	41.84 (1.647)	41.86 (1.648)				
		80	121 (4.764)	130 (5.118)	51.68 (2.035)	51.70 (2.035)	51.72 (2.036)	51.73 (2.037)	51.75 (2.037)	51.77 (2.038)	51.79 (2.039)	51.81 (2.040)	51.83 (2.041)	51.85 (2.041)	51.87 (2.042)	51.89 (2.043)				
		90	131 (5.157)	140 (5.512)	61.69 (2.429)	61.71 (2.430)	61.73 (2.430)	61.75 (2.431)	61.77 (2.432)	61.79 (2.433)	61.81 (2.433)	61.84 (2.435)	61.86 (2.435)	61.88 (2.436)	61.91 (2.437)	61.93 (2.438)				
		100	141 (5.551)	150 (5.906)	71.70 (2.823)	71.72 (2.824)	71.74 (2.824)	71.76 (2.825)	71.79 (2.826)	71.81 (2.827)	71.84 (2.828)	71.86 (2.829)	71.88 (2.830)	71.91 (2.831)	71.94 (2.832)	71.96 (2.833)				
		110	151 (5.945)	160 (6.299)	81.70 (3.217)	81.73 (3.218)	81.75 (3.219)	81.78 (3.220)	81.80 (3.220)	81.83 (3.222)	81.86 (3.223)	81.88 (3.224)	81.91 (3.225)	81.94 (3.226)	81.97 (3.227)	82.00 (3.228)				
		120	161 (6.339)	170 (6.693)	91.71 (3.611)	91.74 (3.612)	91.77 (3.613)	91.79 (3.614)	91.82 (3.615)	91.85 (3.616)	91.88 (3.617)	91.91 (3.619)	91.94 (3.620)	91.97 (3.621)	92.00 (3.622)	92.03 (3.623)				
		130	171 (6.732)	180 (7.087)	101.72 (4.005)	101.75 (4.006)	101.78 (4.007)	101.81 (4.008)	101.84 (4.009)	101.87 (4.011)	101.90 (4.012)	101.93 (4.013)	101.97 (4.015)	102.00 (4.016)	102.04 (4.017)	102.07 (4.019)				
		140	181 (7.126)	190 (7.480)	111.73 (4.399)	111.76 (4.400)	111.79 (4.401)	111.82 (4.402)	111.86 (4.404)	111.89 (4.405)	111.92 (4.406)	111.96 (4.408)	111.99 (4.409)	112.03 (4.411)	112.07 (4.412)	112.10 (4.413)				
		150	191 (7.520)	200 (7.874)	121.73 (4.793)	121.77 (4.794)	121.80 (4.795)	121.84 (4.797)	121.87 (4.798)	121.91 (4.800)	121.95 (4.801)	121.98 (4.802)	122.02 (4.804)	122.06 (4.806)	122.10 (4.807)	122.14 (4.809)				
		160	201 (7.913)	210 (8.268)	131.74 (5.187)	131.78 (5.188)	131.81 (5.189)	131.85 (5.191)	131.89 (5.193)	131.93 (5.194)	131.97 (5.196)	132.01 (5.197)	132.05 (5.199)	132.09 (5.200)	132.13 (5.202)	132.17 (5.204)				
		170	211 (8.307)	220 (8.661)	141.75 (5.581)	141.79 (5.582)	141.83 (5.584)	141.87 (5.585)	141.91 (5.587)	141.95 (5.589)	141.99 (5.590)	142.03 (5.592)	142.07 (5.593)	142.12 (5.595)	142.17 (5.597)	142.21 (5.599)				
		180	221 (8.701)	231 (9.094)	151.76 (5.975)	151.80 (5.976)	151.84 (5.978)	151.88 (5.980)	151.92 (5.981)	151.97 (5.983)	152.01 (5.985)	152.06 (5.987)	152.10 (5.988)	152.15 (5.990)	152.20 (5.992)	152.24 (5.994)				
		190	232 (9.134)	241 (9.488)	161.77 (6.369)	161.81 (6.370)	161.85 (6.372)	161.90 (6.374)	161.94 (6.376)	161.99 (6.378)	162.03 (6.379)	162.08 (6.381)	162.13 (6.383)	162.18 (6.385)	162.23 (6.387)	162.28 (6.389)				
		200	242 (9.528)	253 (9.961)	171.77 (6.763)	171.82 (6.765)	171.86 (6.766)	171.91 (6.768)	171.96 (6.770)	172.01 (6.772)	172.06 (6.774)	172.11 (6.776)	172.15 (6.778)	172.20 (6.780)	172.26 (6.782)	172.31 (6.784)				

\* BL VALUES IN THE TABLE ARE REFERENCES WHICH CAN DEVIATE BY +/-0.03mm FINAL BL VALUE CAN BE FIND ON GATE DETAIL DRAWING AND 3D AFTER FINISHED DESIGN.

NOZZLE SERIES	LOCATING RING DIAMETER	SPRUE BUSHING	
		SEAL-OFF GEOMETRY SPHERICAL RADIUS	CHANNEL Ø IN - OUT
U500	100mm	FLAT	4 - 8
	101.3mm (3.99")	FLAT	8 - THRU
	125mm	SEAL-OFF 12.7 (1/2")	
SEAL-OFF 15.5			
		SEAL-OFF 19.05 (3/4")	
		SEAL-OFF 20	
		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)

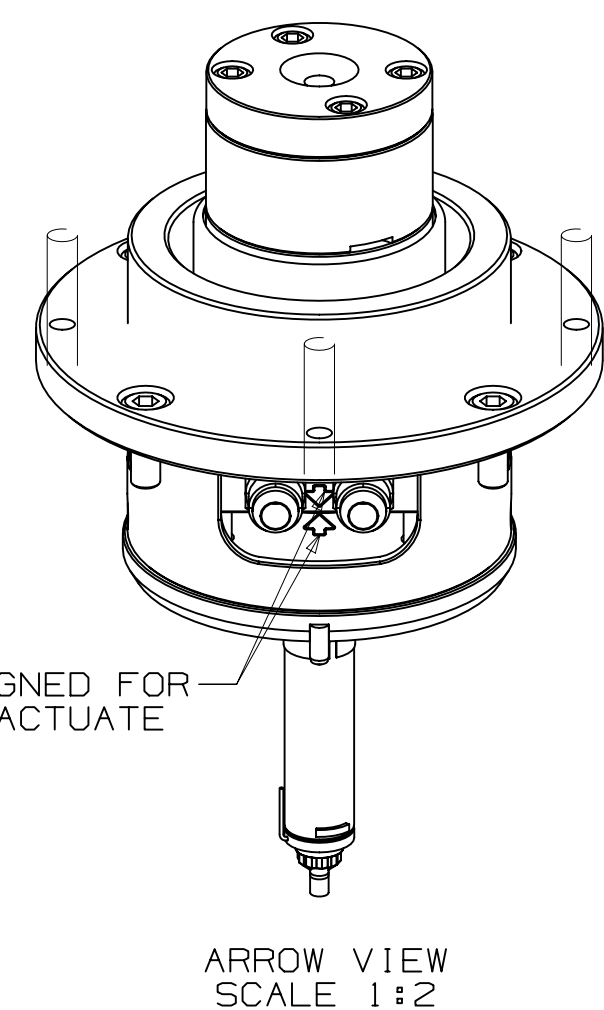
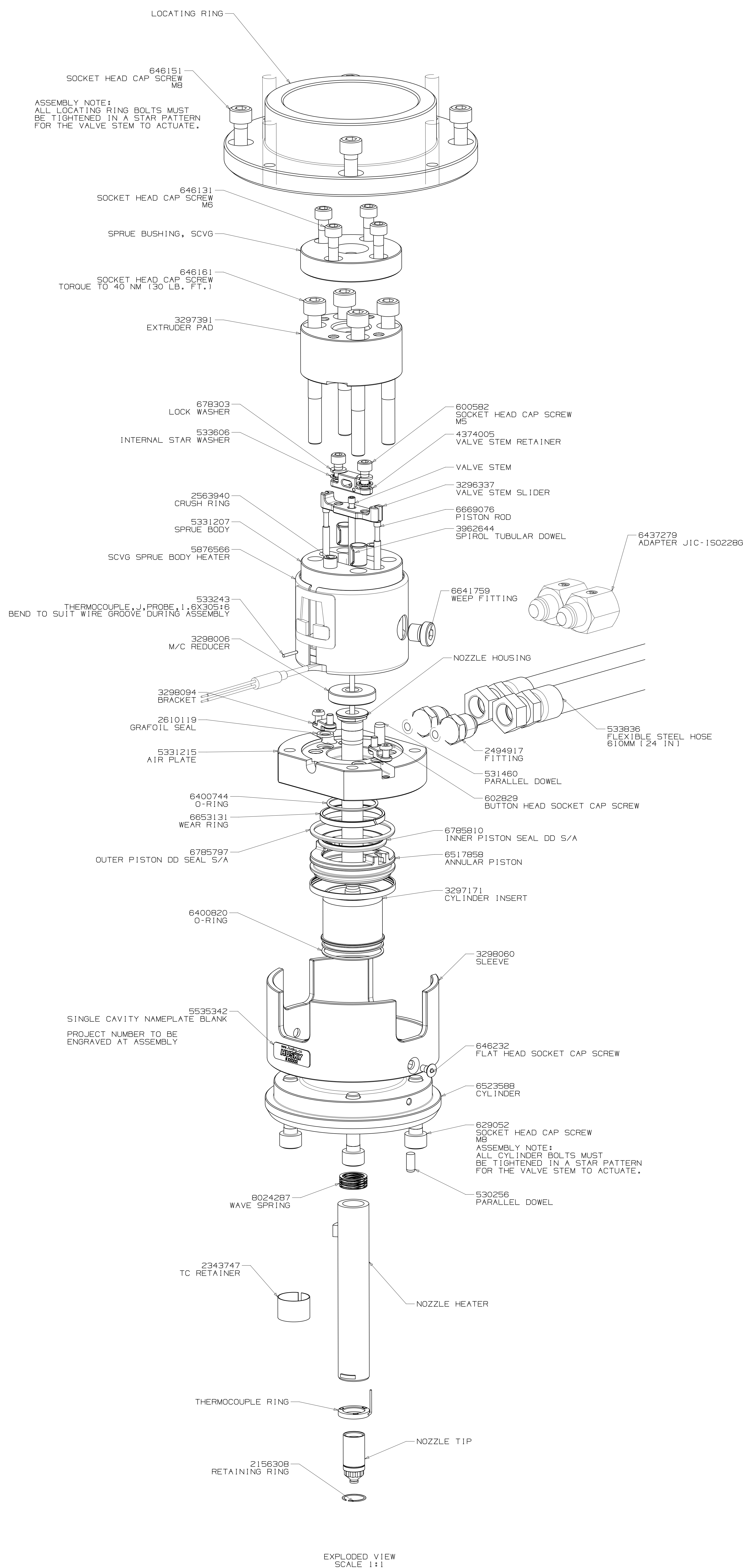
**RECOMMENDED GATE MANUFACTURING GUIDELINES**  
- HARDENED GATE INSERTS (49-51) ARE RECOMMENDED WHEN USING SOFTER CAVITY STEELS. SOFTER CAVITIES MAY BE ACCEPTABLE FOR CERTAIN APPLICATIONS. CONTACT YOUR HUSKY REPRESENTATIVE WITH QUESTIONS.  
- EDM'ING THE GATE AREA CAUSES MICRO CRACKS WHICH LEAD TO BRITTLE 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. SORTENS THE AREA AROUND THE WELD AND CAN CAUSE GATE FAILURES.

REV	DATE	DESCRIPTION	DRW	CHKD
0	2017-09-11	ORIGINAL ISSUE - DESIGNED BY DHANALEKIAN	DRW	CHKD
			DRW	CHKD
			DRW	CHKD
			DRW	CHKD
			DRW	CHKD
			DRW	CHKD

GENERAL TOLERANCES	METRIC	IMPERIAL	FINISH/TREATMENT	WEIGHT
	±0.17	±0.007		- kg
BROKEN EDGES/CHAMFER	±0.2 X 45°	0.04 ±0.01 X 45°		
FILLET ROUNDS	R0.8 ±0.2	R0.03 ±0.01		
SURFACE FINISH	Ra 3.2			

# 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	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	7.0
M10	15	10
M12	20	14
M14	25	18
M16	35	25
M20	60	45
M25	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 = (-)	
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. <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	2017-09-11	ORIGINAL ISSUE - DESIGNED BY DHANALEYAN	DRWN1	CHKD1
			DRWN2	CHKD2
			DRWN3	CHKD3
			DRWN4	CHKD4
			DRWN5	CHKD5
			DRWN6	CHKD6
			DRWN7	CHKD7
			DRWN8	CHKD8
			DRWN9	CHKD9
			DRWN10	CHKD10

DEFINING DRAWING FEATURES	METRIC		TITLE
MATERIAL	N/A		Single Cavity Valve Gate
FINISH/TREATMENT			U500-SCVG-VX
WEIGHT	- kg	SCALE 1:1	DRAWING
		AOR	8143261 0
		SHEET 2 OF 2	REV