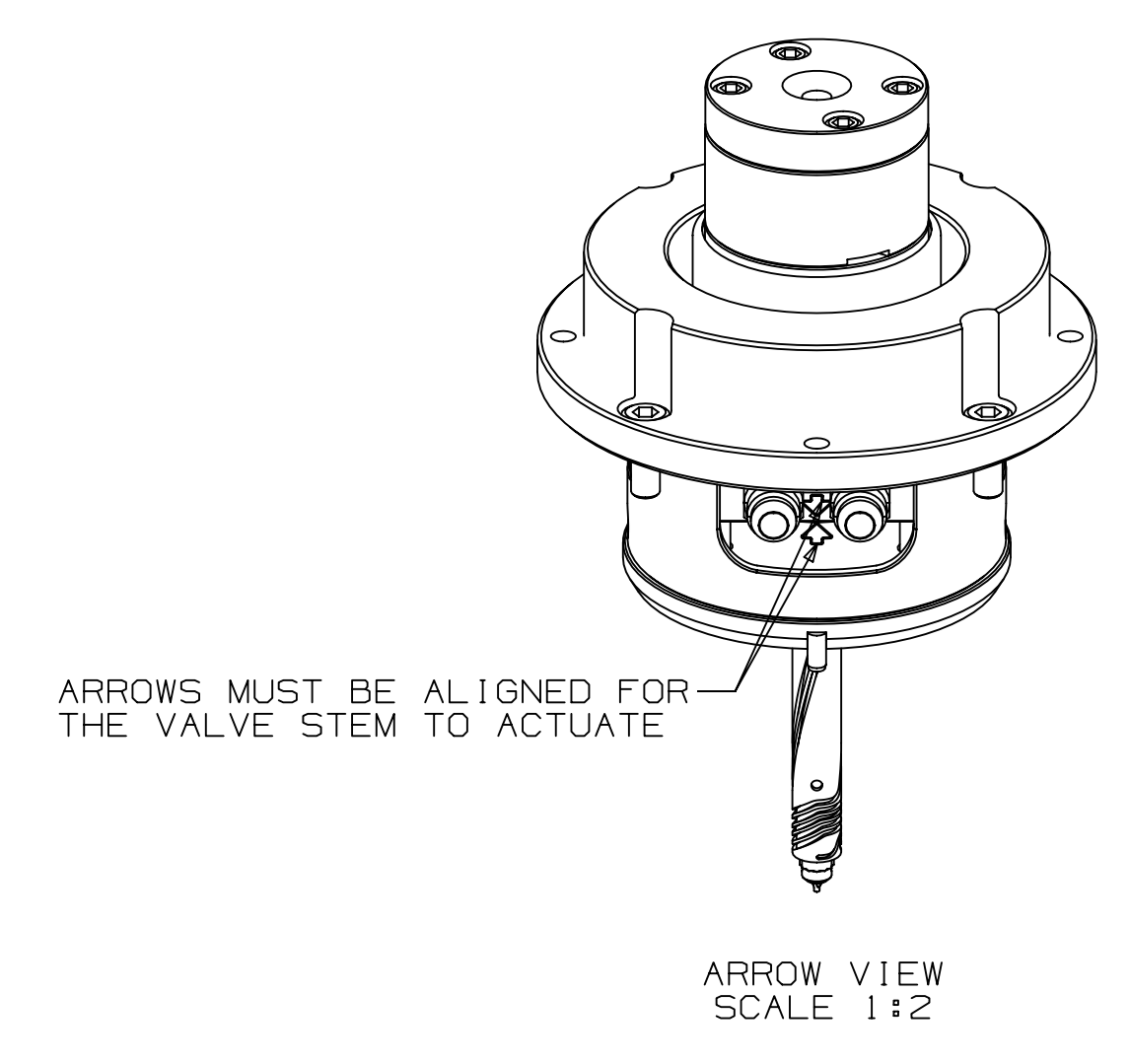
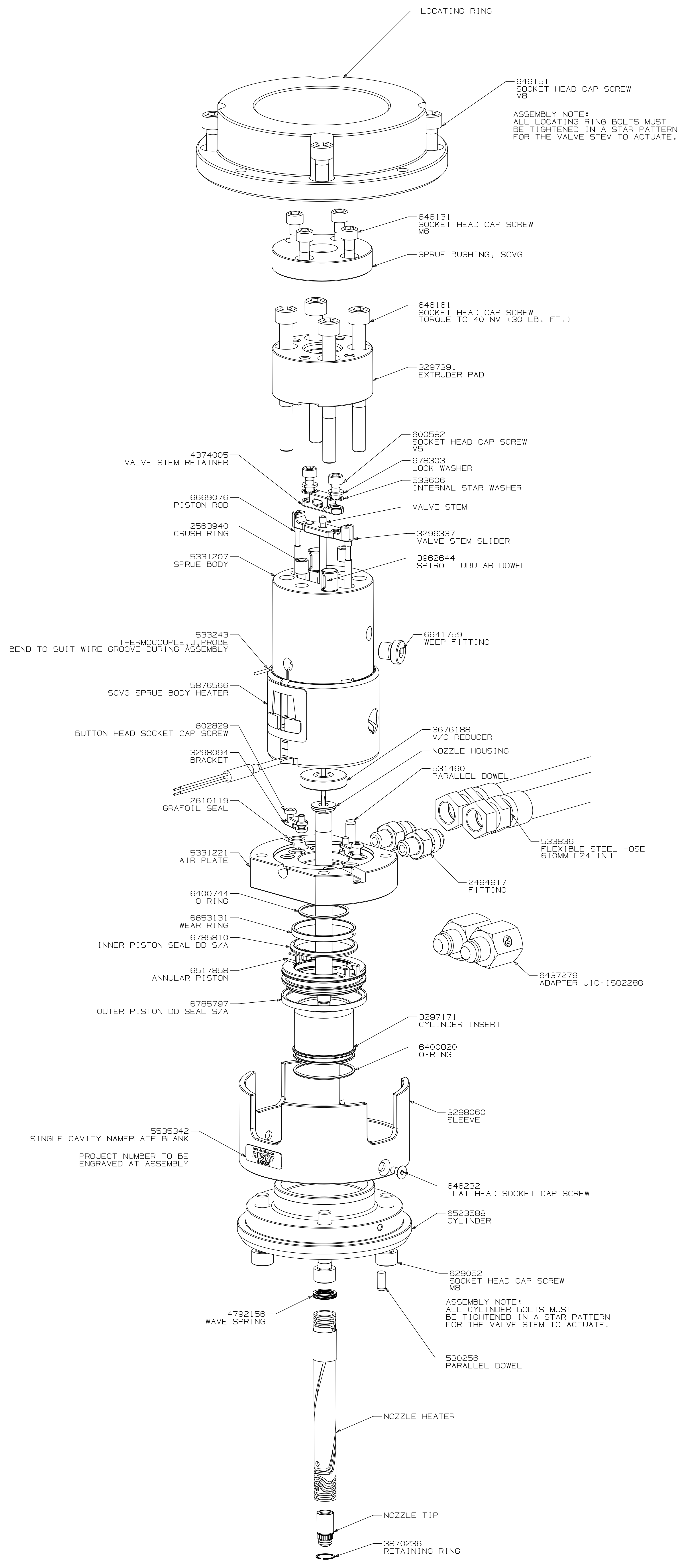


ASSEMBLY DRAWING

REV 1
8146855



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
1/4	16	12
5/16	25	18
3/8	35	26
1/2	65	48
5/8	95	70
3/4	150	110
7/8	250	180
1	500	360
M2	70	50
M3	110	80
M4	160	120
M5	210	150
M6	270	200
M8	390	290
M10	510	370
M12	630	460
M14	750	550
M16	870	640
M20	1100	810

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 MORE DETAILED GUIDELINES.

RECOMMENDED GATE MATERIAL
NOTE: THESE MATERIALS MAY NOT OFFER THE DESIRED RESISTANCE TO ABRASIVE AND/OR CORROSIVE RESINS, FILLERS AND/OR ADDITIVES

AISI H13 148-51 Rc1
AISI 420 148-51 Rc1

RECOMMENDED GATE MANUFACTURING GUIDELINES

- HARDENED GATE INSERTS (48-51) 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. SOFTEN THE AREA AROUND THE WELD AND CAN CAUSE GATE FAILURES.

DEFINED DRAWING FEATURES		METRIC		HUSKY	
MATERIAL	N/A	DATE DRAWN AND INFORMATION	DATE	TITLE	SCALE
FINISH/TREATMENT		DESIGNED BY: J. J. HUSKY	10/20/18	Single Cavity Valve Gate	1:1
WEIGHT	- kg	CHECKED BY: J. J. HUSKY	10/20/18	U350-SCVG-VG	DRWING
		APPROVED BY: J. J. HUSKY	10/20/18	8146855	REV
					1