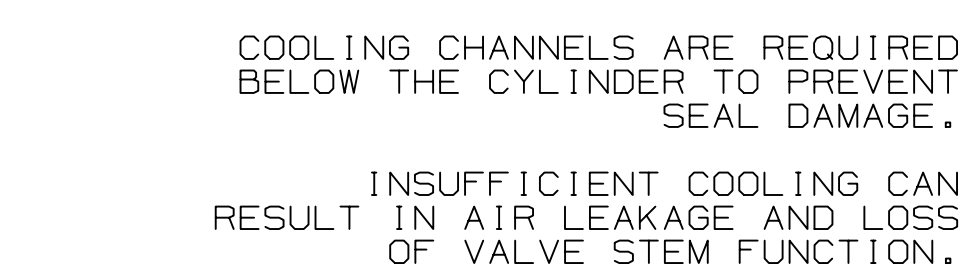
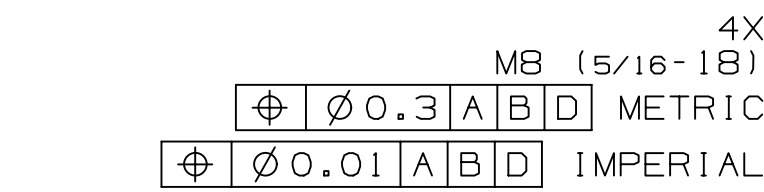
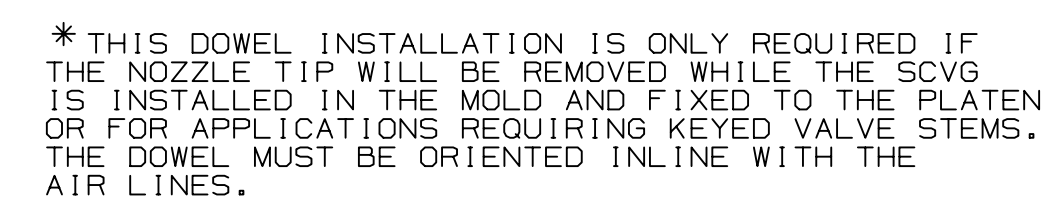


DRAWING	REV
8147452	2



\*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.

U350	LOCATING RING DIAMETER
	100
	101.3 ( 3.99 )
	125

DIMENSIONS SHOWN AS: millimeters (inches)

RECOMMENDED GATE COOLING GUIDELINES

ADEQUATE COOLING IS ESSENTIAL FOR  
THE PROPER FUNCTION OF THIS SYSTEM.  
REFER TO THE HOT RUNNER PRODUCT GUIDE  
[www.husky.ca](http://www.husky.ca)  
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 149-51 Rc1



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.

UDAT PER ASME Y14.5M-1994 AND HUSKY ADDENDUM - H252A UNLESS OTHERWISE SPECIFIED: CAD MODEL IS BASIC. NON-TOLERANCED DIMENSIONS ARE BASIC.		
GENERAL TOLERANCE:	METRIC	IMPERIAL
	 0.4 ?	 0.02 ?
BROKEN EDGE/CHAMFER:	$1 \pm 0.2 \times 45^\circ$	$0.04 \pm 0.01 \times 45^\circ$
FILLET/ROUND:	$R0.8 \pm 0.2$	$R0.03 \pm 0.01$
SURFACE FINISH:	$6.3/\sqrt{\text{in}}$	

UNDEFINED DRAWING FEATURE TO COMPLY WITH H5534 *SUPPLIER QUICK REFERENCE	
MATERIAL	N/A
FINISH/TREATMENT	
WEIGHT	- kg

METRIC   **HUSKY**

TITLE	SCVG Single Cavity Value Gate
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U350-SCVG-VX

SCALE 1:1	SIZE	DRAWING
SHEET 1 OF 2	AOR	8147452

2	1
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