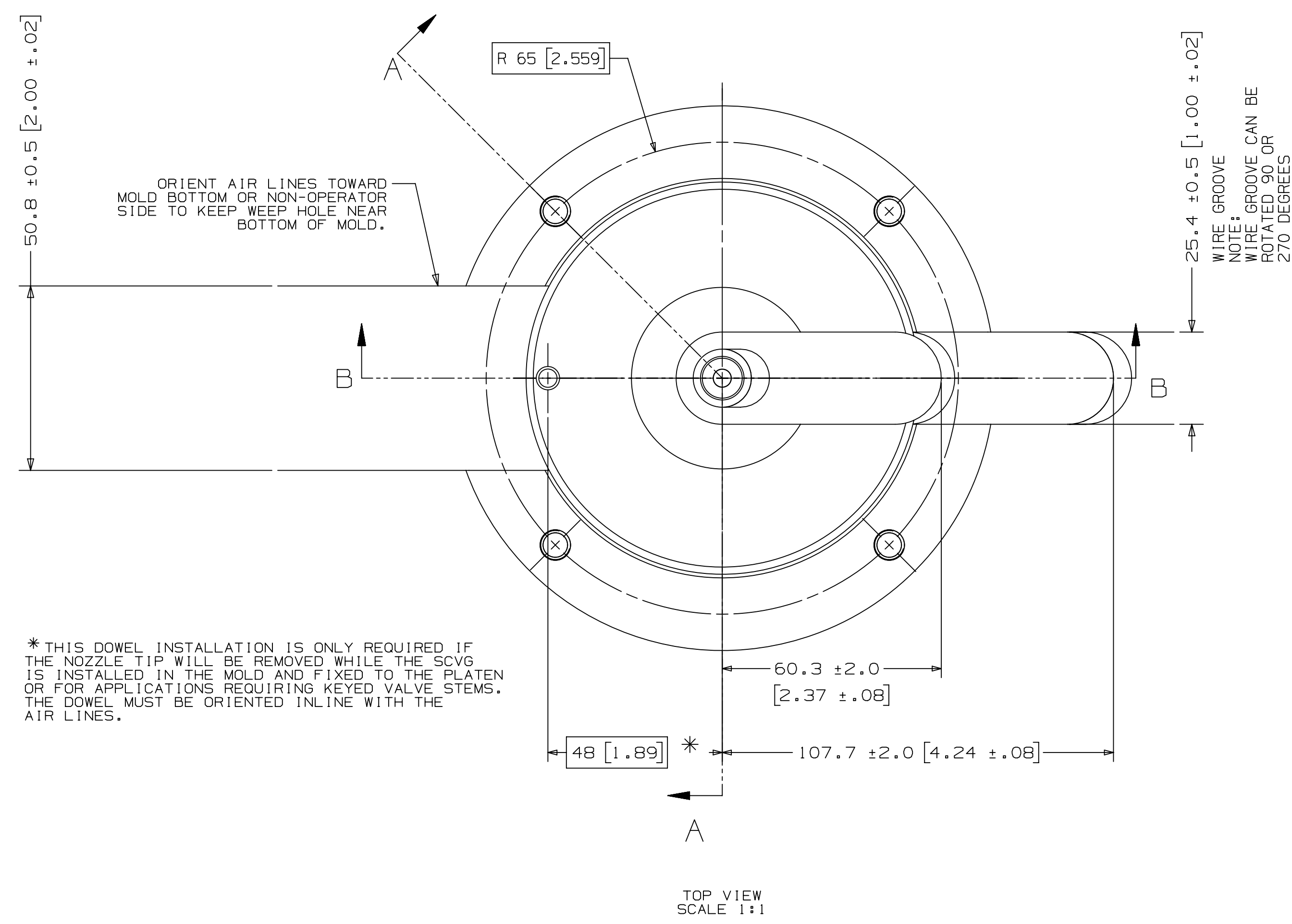


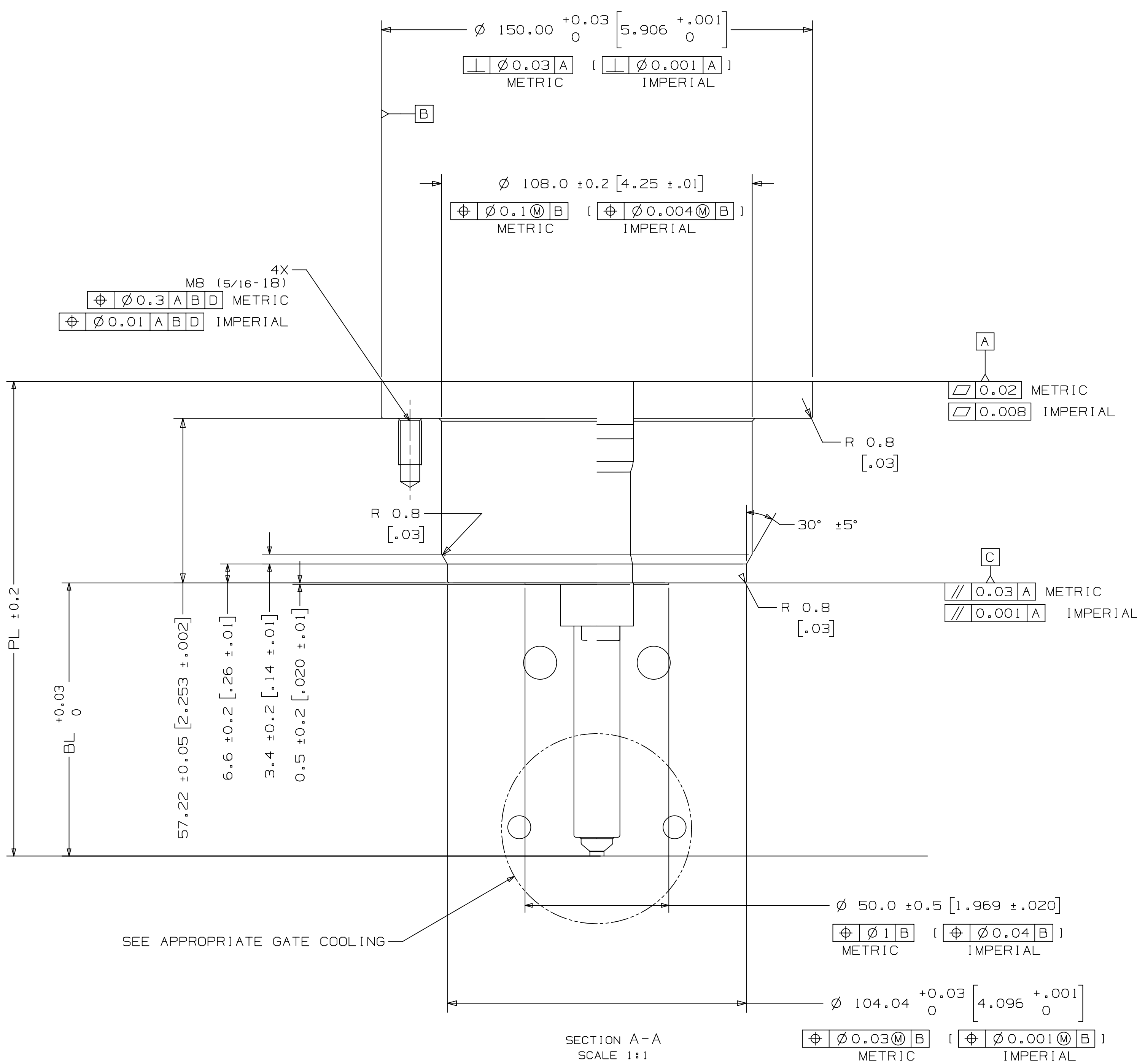
# INSTALLATION DRAWING

REV 1  
8147452

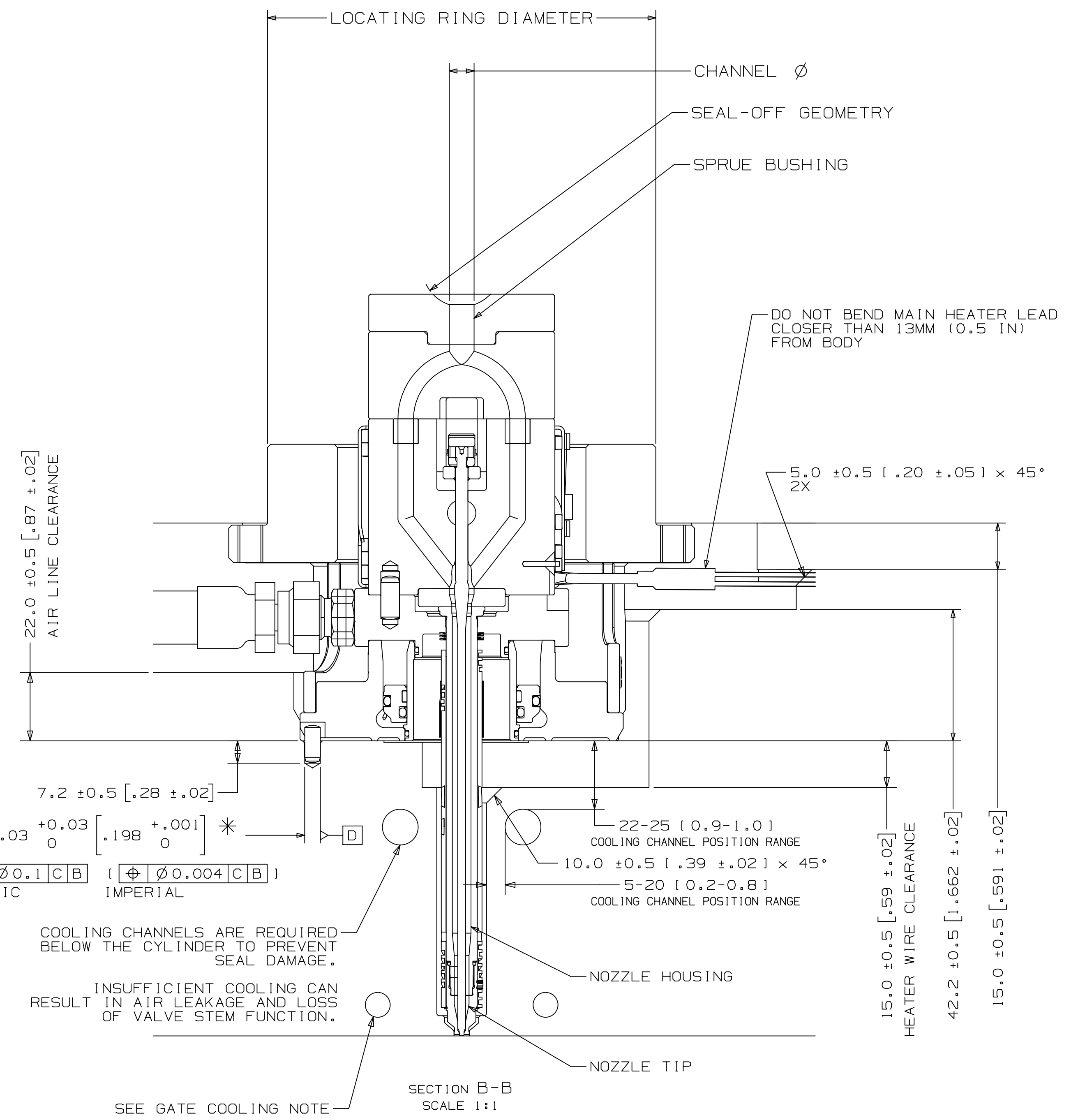


\* THIS DOWEL INSTALLATION IS ONLY REQUIRED IF THE NOZZLE TIP WILL BE REMOVED WHILE THE SCVG IS INSTALLED IN THE MOLD AND FIXED TO THE PLATEN OR FOR APPLICATIONS REQUIRING KEVED VALVE STEMS. THE DOWEL MUST BE ORIENTED IN LINE WITH THE AIR LINES.

TOP VIEW SCALE 1:1



SECTION A-A SCALE 1:1



SECTION B-B SCALE 1:1

NOZZLE SERIES	NOZZLE TIP	PL RANGE	Approx. BL*
U350	VX	94.23 [3.710] - 244.58 [9.629]	25 [0.98] - 165 [6.50]

\*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	SPRUE BUSHING	
	SEAL-OFF GEOMETRY SPHERICAL RADIUS	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	

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 FOR CERTAIN APPLICATIONS. CONTACT YOUR HUSKY REPRESENTATIVE WITH QUESTIONS.

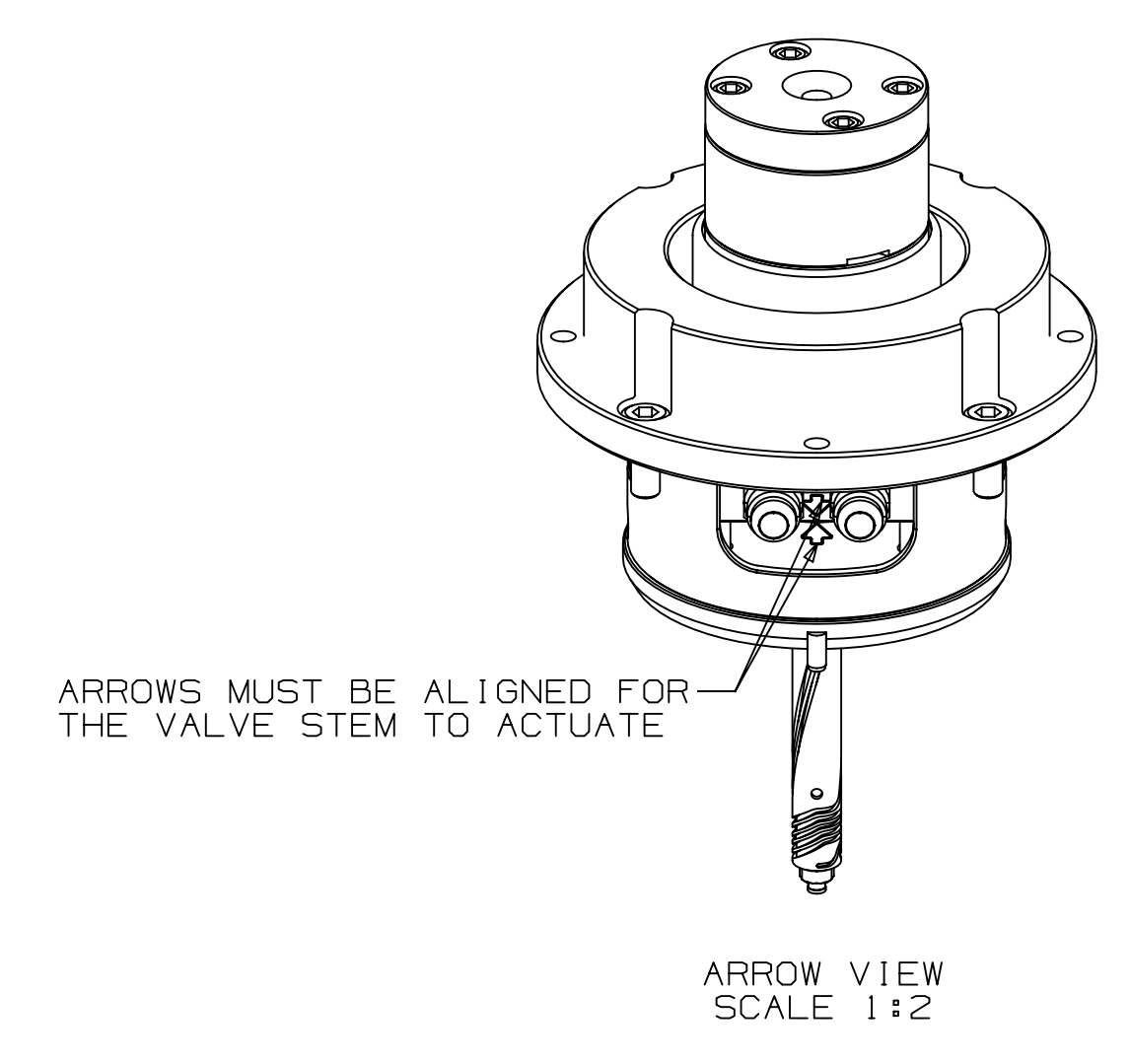
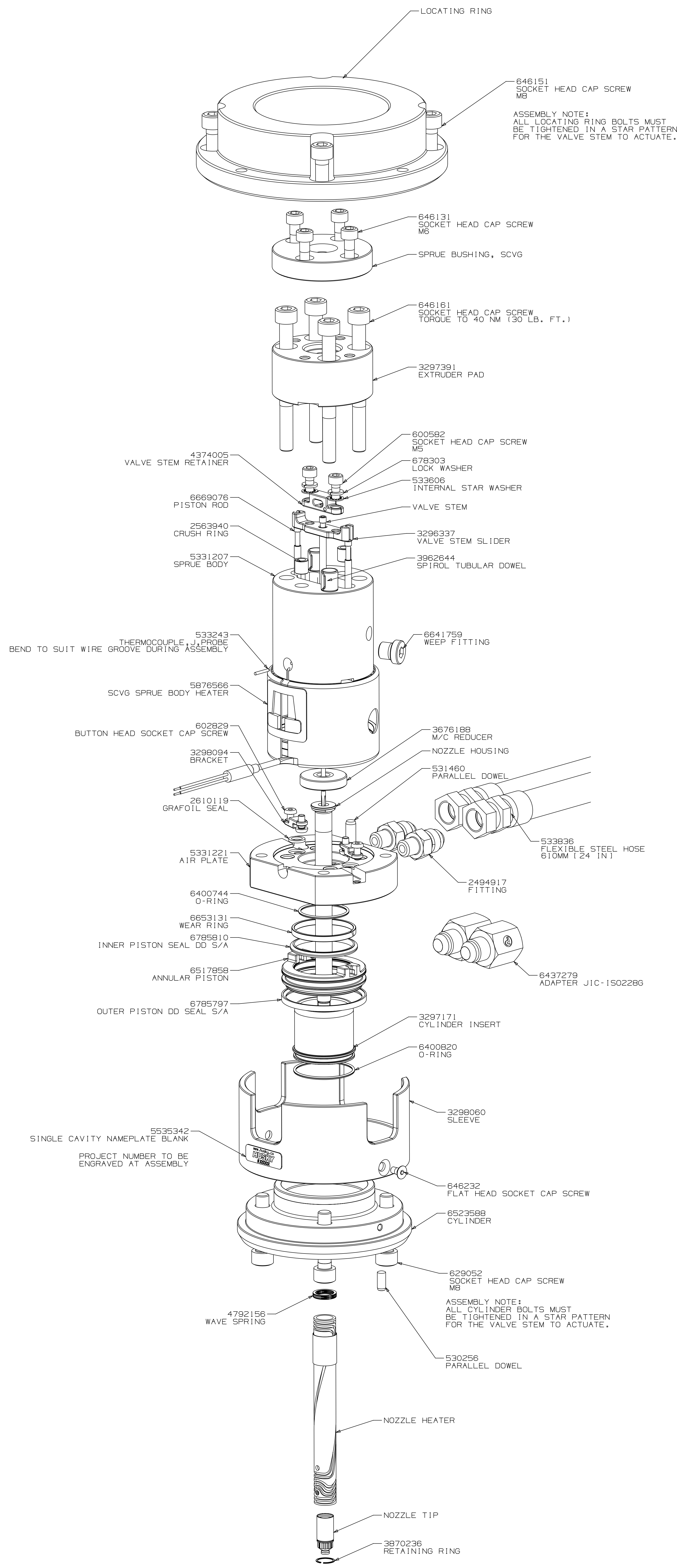
**RECOMMENDED GATE MATERIAL**  
 NOTE: THESE MATERIALS MAY NOT OFFER THE DESIRED RESISTANCE TO ABRASIVE AND/OR CORROSIVE RESINS, FILLERS AND/OR ADDITIVES.  
 A1S1 H13 [48-51 Rc]  
 A1S1 420 [48-51 Rc]

**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.

DAT PER ASME Y14.2M-1994 AND HUSKY ADDENDUM - HIGH PRESSURE DIECASTING SPECIFICATIONS DIMENSIONS UNLESS OTHERWISE SPECIFIED ARE METRIC DIMENSIONS UNLESS OTHERWISE SPECIFIED ARE IMPERIAL GENERAL TOLERANCES: FRACTIONS: ±0.2 X 45° DECIMALS: ±0.04 ±0.01 X 45° HOLE POSITION: ±0.03 ±0.01 SURFACE FINISH: 6.3	UNFINISHED DRAWING FEATURES: MATERIAL: N/A FINISH/TREATMENT:	HUSKY TITLE: SCVG Single Cavity Valve Gate U350-SCVG-VX SCALE: 1:1 SHEET: 1 OF 2 DATE: AOR 8147452 REV: 1
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# ASSEMBLY DRAWING

REV 1  
8147452



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	19	14
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
M4	70	50
M5	110	80
M6	160	110
M8	210	150
M10	290	210
M12	390	280
M14	500	360
M16	650	480
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

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UNDEFINED DRAWING FEATURES (SHEET 1 OF 2) (SEE DRAWING FOR DIMENSIONS)	METRIC	HUSKY	TITLE
MATERIAL	FINISH/TREATMENT	WEIGHT	SCALE 1:1
N/A		- kg	DRWING
			REV
			1

SCALE 1:1	DRWING	REV
1:1	8147452	1
SHEET 2 OF 2	ADR	