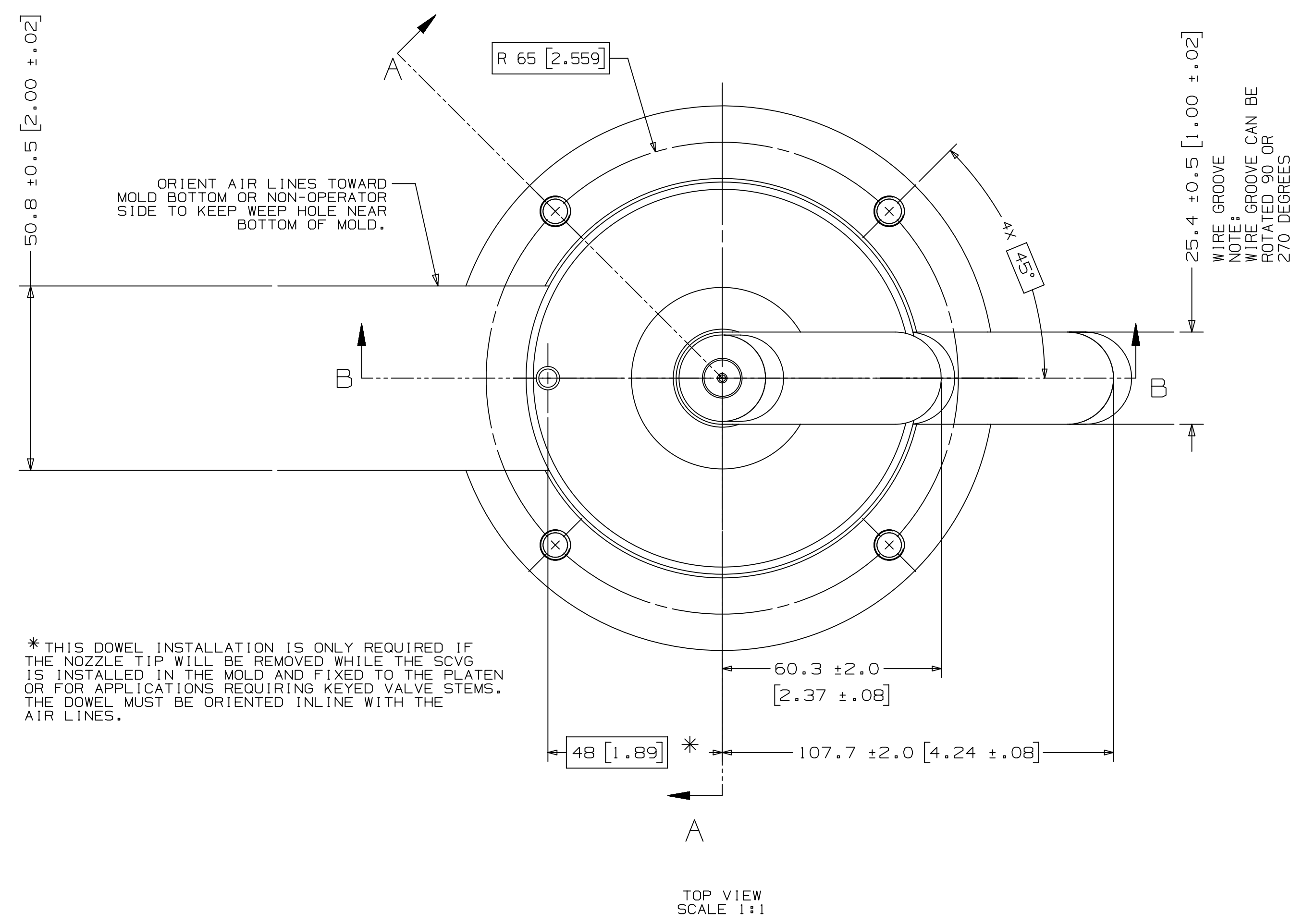
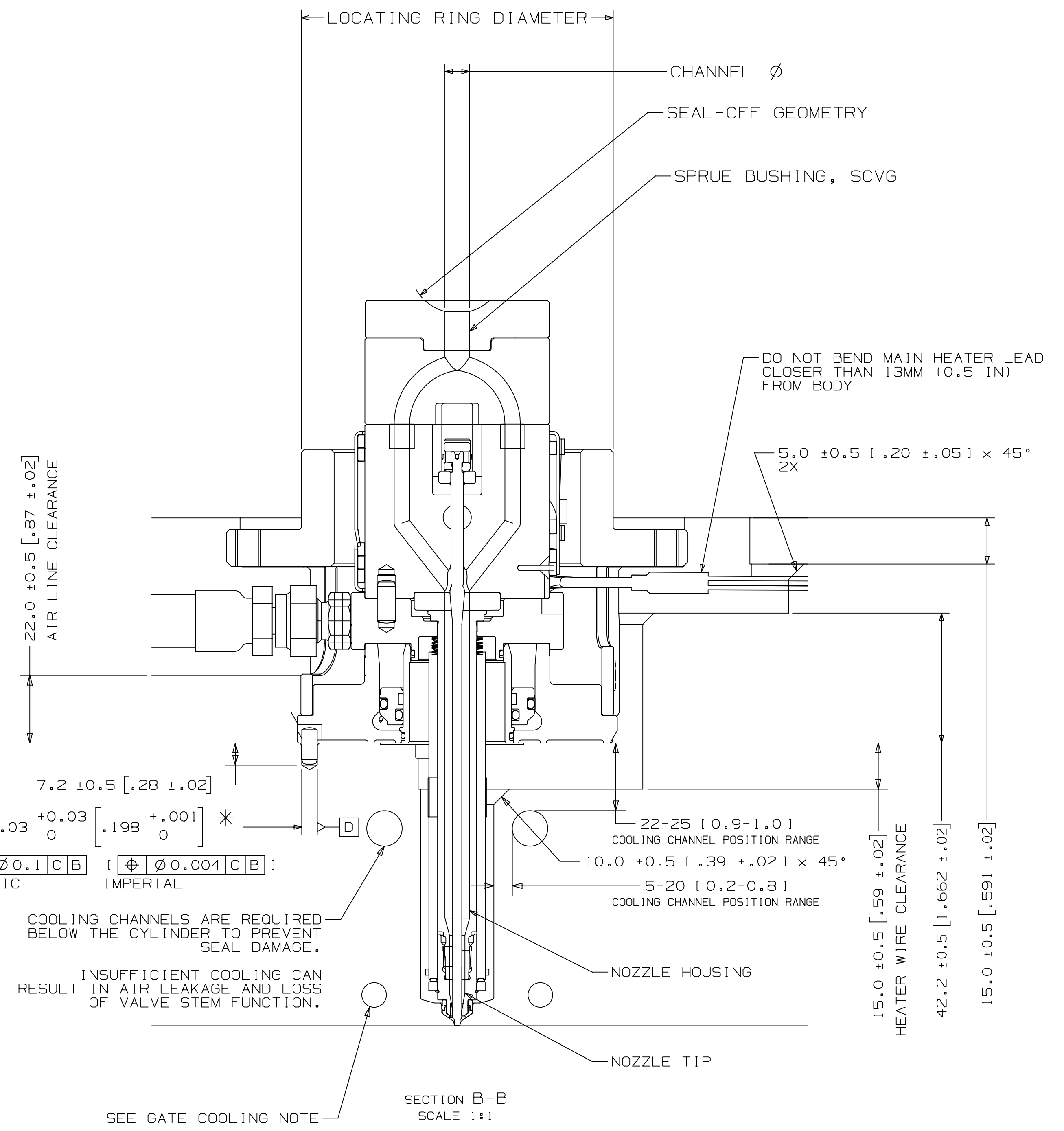
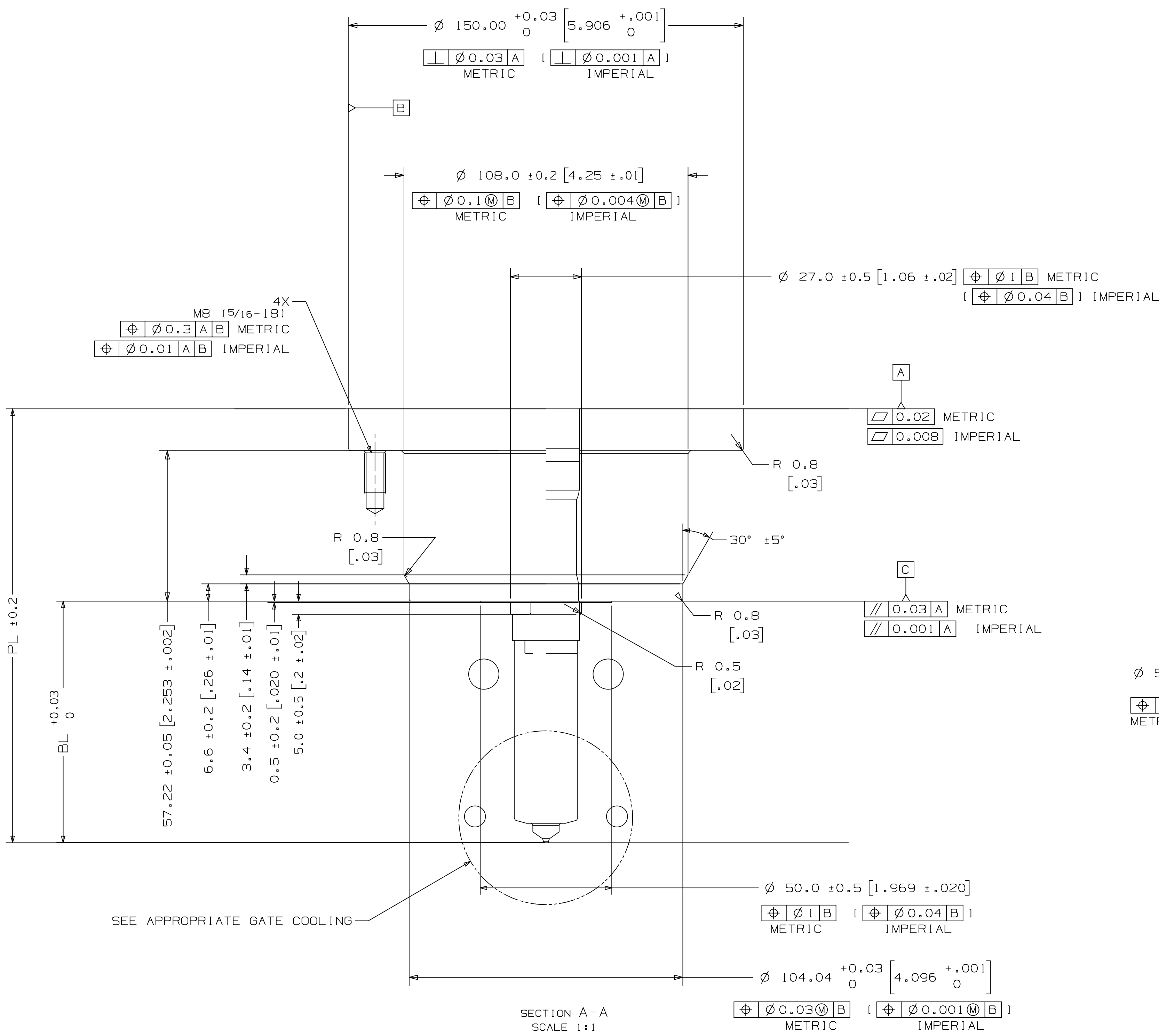


INSTALLATION DRAWING

REV 1
8094793



*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.



NOZZLE SERIES	NOZZLE TIP	PL RANGE	Approx. BL
U500	VG	91.17 (3.589) - 251.4 (9.898)	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.

	SPRUE BUSHING	
	SEAL-OFF GEOMETRY	CHANNEL Ø
U500	FLAT	4 - 8
	FLAT	B - THRU
	SEAL-OFF 12.7 (1/2)	
	SEAL-OFF 15.5	
	SEAL-OFF 19.05 (3/4)	
	SEAL-OFF 20	
	SEAL-OFF 40	

	LOCATING RING DIAMETER
U500	100
	101.3 (3.991)
	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 MORE DETAILED GUIDELINES.
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.
 A1S1 H13 (48-51 Rc)
 A1S1 420 (48-51 Rc)

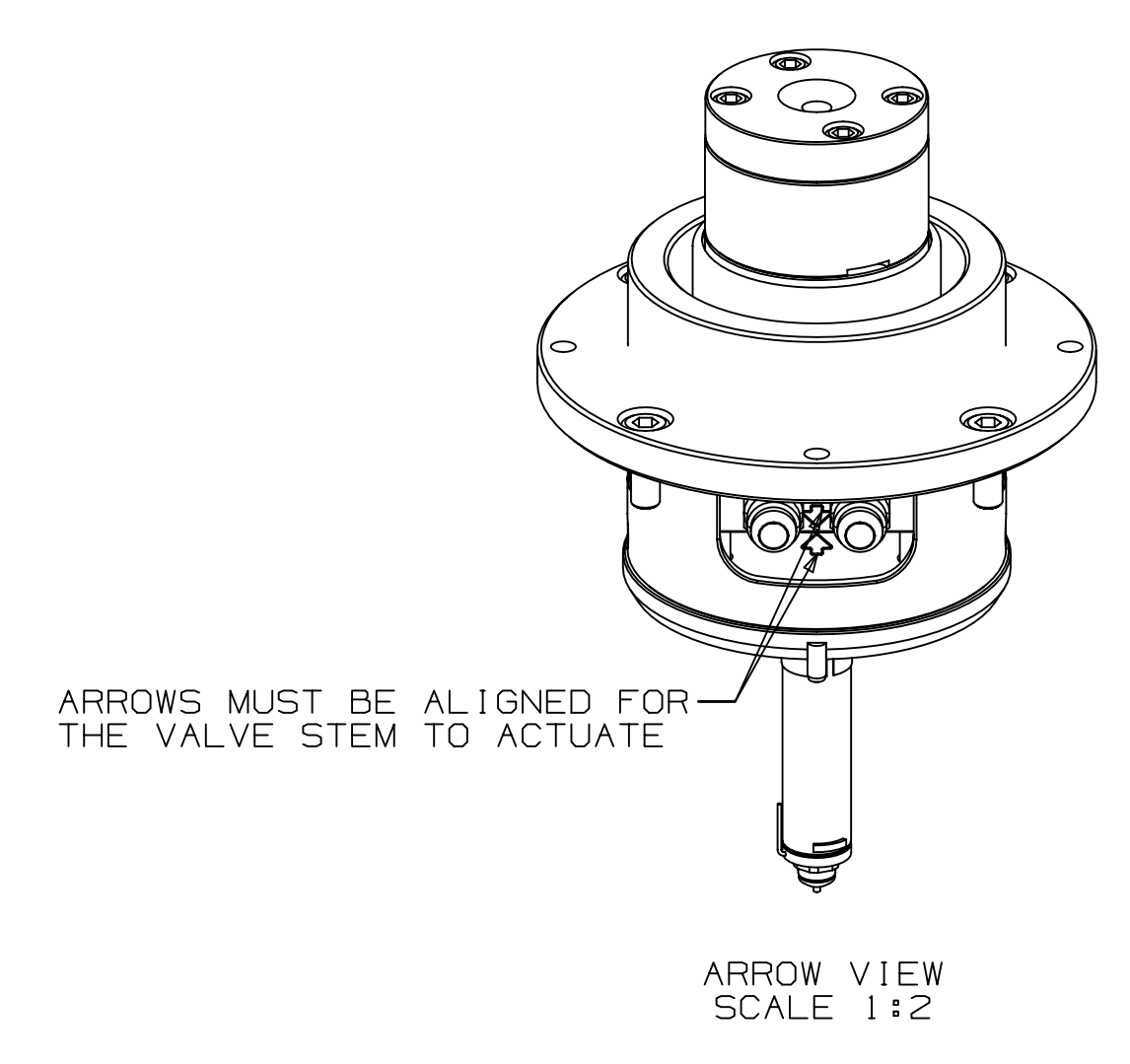
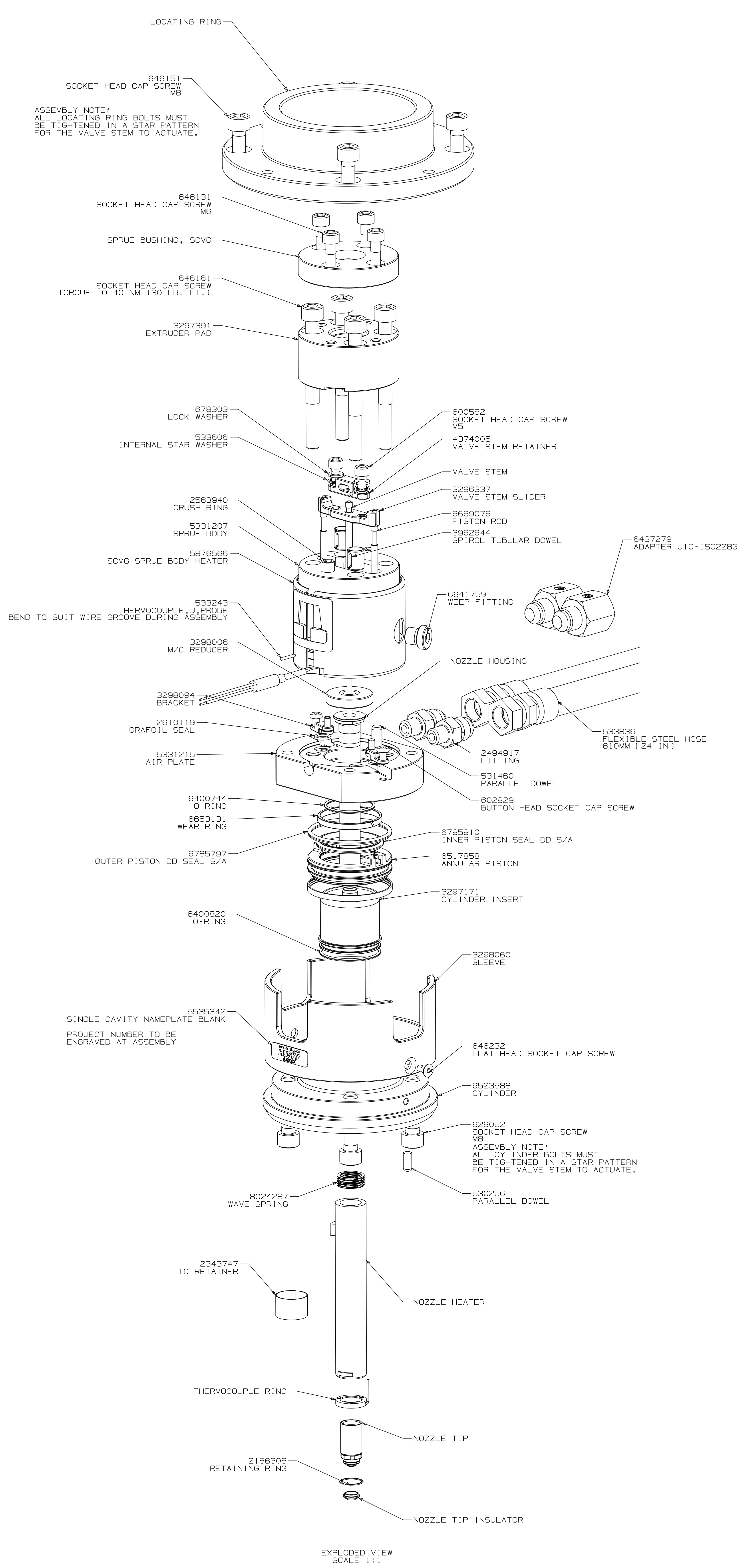
RECOMMENDED GATE MANUFACTURING GUIDELINES

- 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 Y14.1M-1994 AND HUSKY ADDENDUM - HIGH PRESSURE OPERATING SPECIFIED DIM MODEL IS BASIC UNLESS OTHERWISE SPECIFIED DIMENSIONS UNLESS OTHERWISE SPECIFIED ARE BASIC GENERAL TOLERANCES: METRIC: (M) ± 0.17 IMPERIAL: (I) ± 0.017 BROKEN EDGE/CHAMFER: 1 ± 0.2 X 45° 0.04 ± 0.01 X 45° FILLET/RADIUS: R0.8 ± 0.2 R0.03 ± 0.01 SURFACE FINISH: 6.3	UNFINISHED DRAWING FEATURES TO DIMS: #100 (HOLE) #125 (SLIT) #150 (SLOT) #175 (SHAFT) #200 (RIB) #225 (RIB) #250 (RIB) #275 (RIB) #300 (RIB) #325 (RIB) #350 (RIB) #375 (RIB) #400 (RIB) #425 (RIB) #450 (RIB) #475 (RIB) #500 (RIB)	METRIC IMPERIAL FINISH/TREATMENT SCALE: 1:1 SIZE: AOR SHEET: 1 OF 2 WEIGHT: - kg	HUSKY TITLE: SCVG Single Cavity Valve Gate U500-SCVG-VG DRAWING: 8094793 REV: 1
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ASSEMBLY DRAWING

REV 1
8094793



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	25
1/2	65	48
5/8	95	70
3/4	150	110
7/8	250	180
1	350	250
M4	70	50
M5	110	80
M6	160	115
M8	250	180
M10	350	250
M12	500	360
M14	700	510
M16	1000	730
M20	1600	1170
M24	2500	1830

VALVE STEM STROKE IS 7.3 (1.29)

ELECTRICAL INFO (240 VAC)

ZONE	ZONE DESCRIPTION
1	SPRUE BODY
2	NOZZLE TIP

T/C LEADS:
WHITE = (+)
RED = (-)

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RECOMMENDED GATE MATERIAL
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AISI H13 148-51 Rc1
AISI 420 148-51 Rc1

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DEFINED DRAWING FEATURES		MATERIAL		FINISH/TREATMENT		WEIGHT	
100% DIMENSIONAL ACCURACY	100% DIMENSIONAL ACCURACY	N/A	N/A	N/A	N/A	-	-
100% DIMENSIONAL ACCURACY	100% DIMENSIONAL ACCURACY	HUSKY		TITLE		SCALE 1:1	
DRAWING		REV		DRAWING		REV	
SHEET 2 OF 2		AOR		8094793		1	