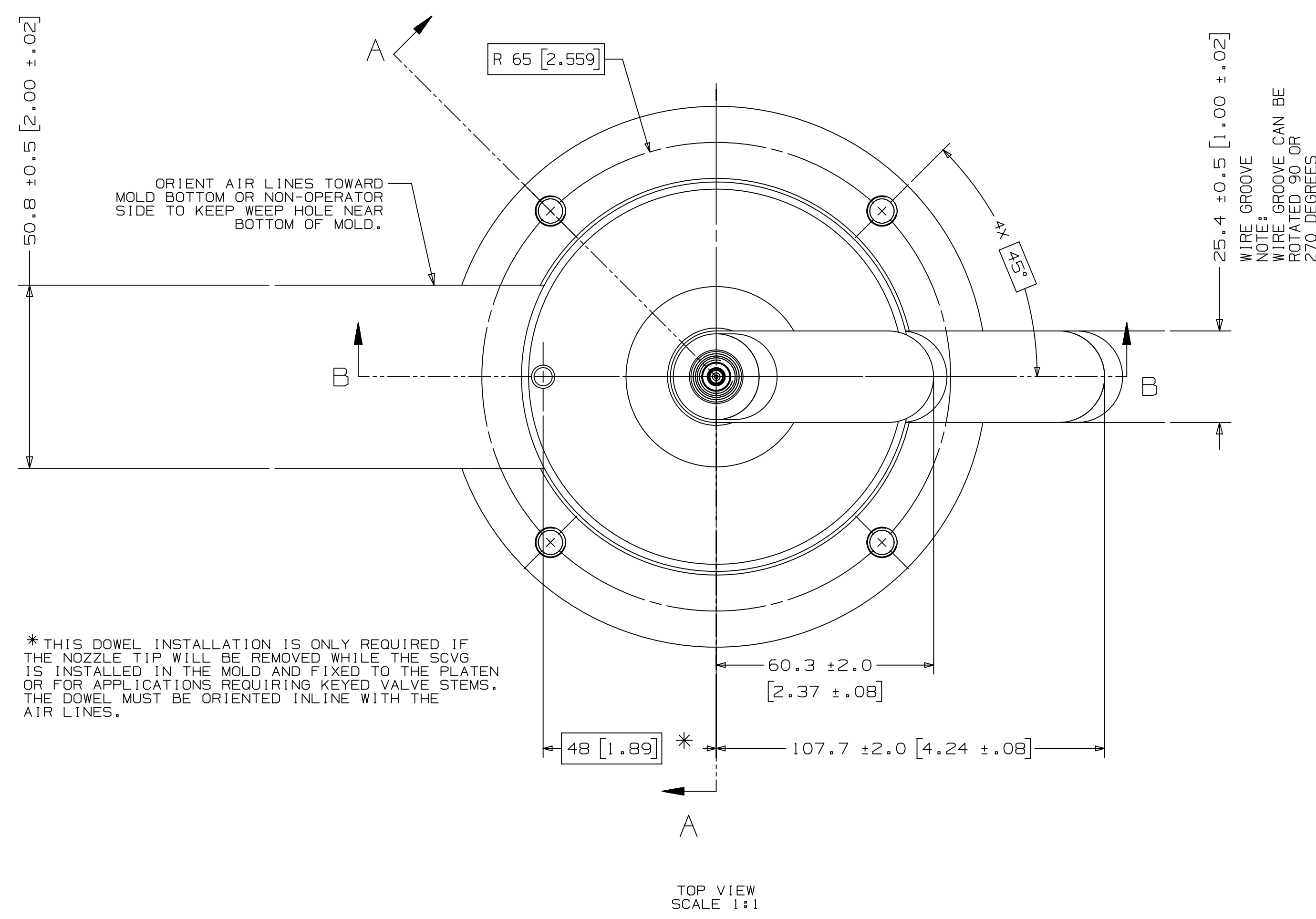


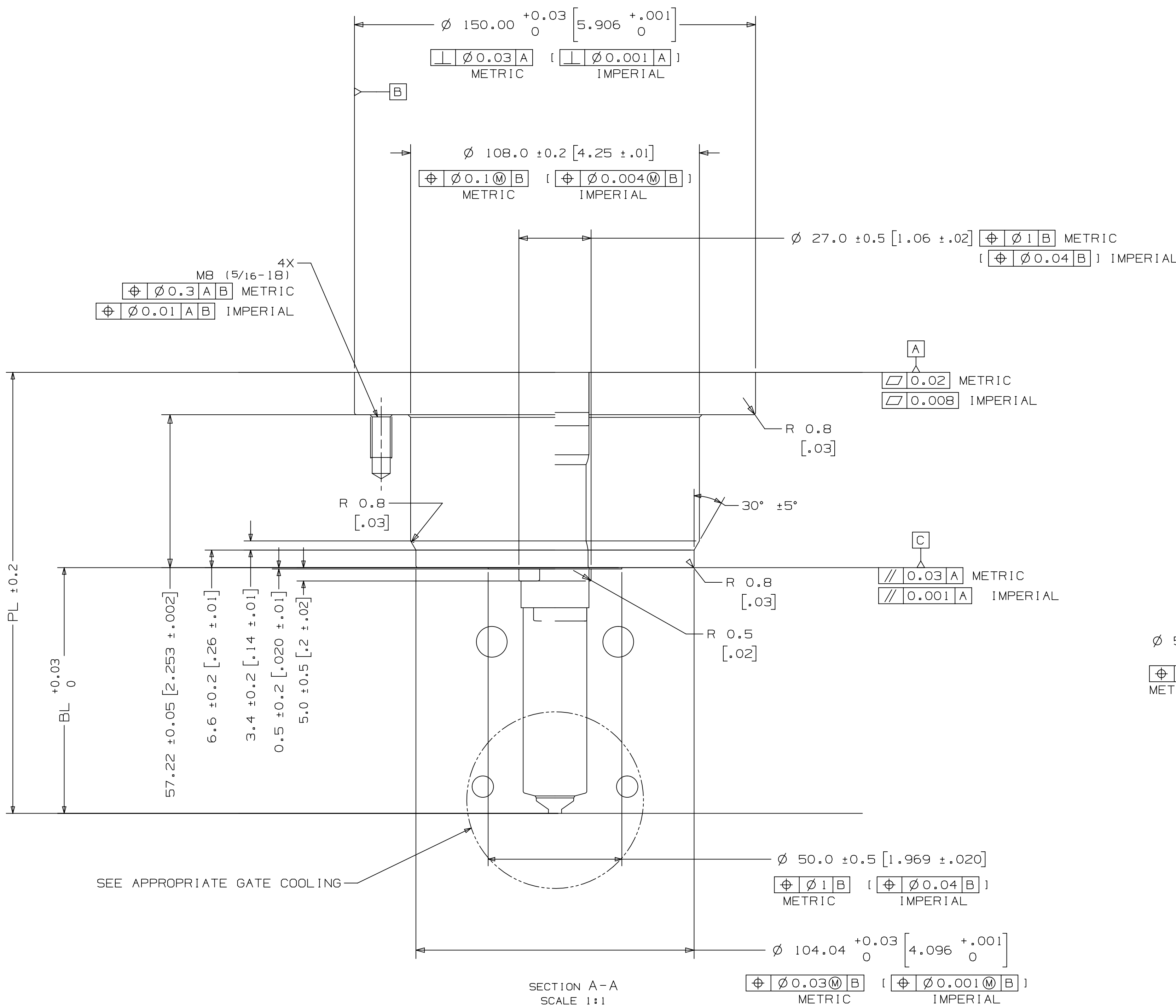
# INSTALLATION DRAWING

DRAWING NO. 8143261

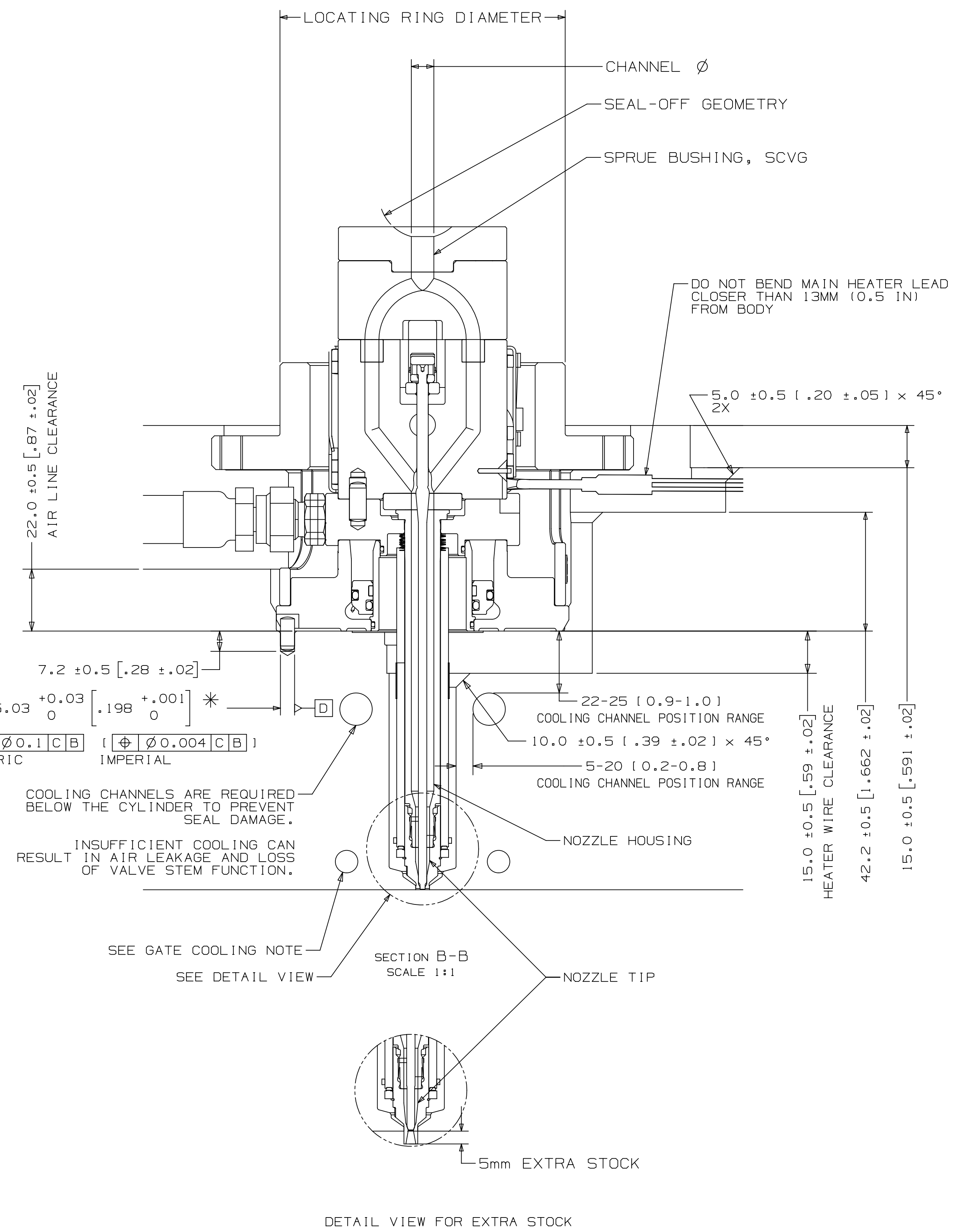


\* THIS DOWEL INSTALLATION IS ONLY REQUIRED IF THE NOZZLE TIP WILL BE REMOVED WHILE THE SCVG IS INSTALLED IN THE MOLD AND FIXED TO THE PLATEN OR FOR APPLICATIONS REQUIRING KEYS VALVE STEMS. THE DOWEL MUST BE ORIENTED IN LINE WITH THE AIR LINES.

TOP VIEW  
SCALE 1:1



SECTION A-A  
SCALE 1:1



SECTION B-B  
SCALE 1:1

DETAIL VIEW FOR EXTRA STOCK

NOZZLE SERIES	NOZZLE TIP	PL RANGE	Approx. BL*
U500	VX	91.24 [3.592] - 251.6 [9.905]	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.

U500	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	

U500	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 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 [48-51 Rc]  
AISI 420 [48-51 Rc]

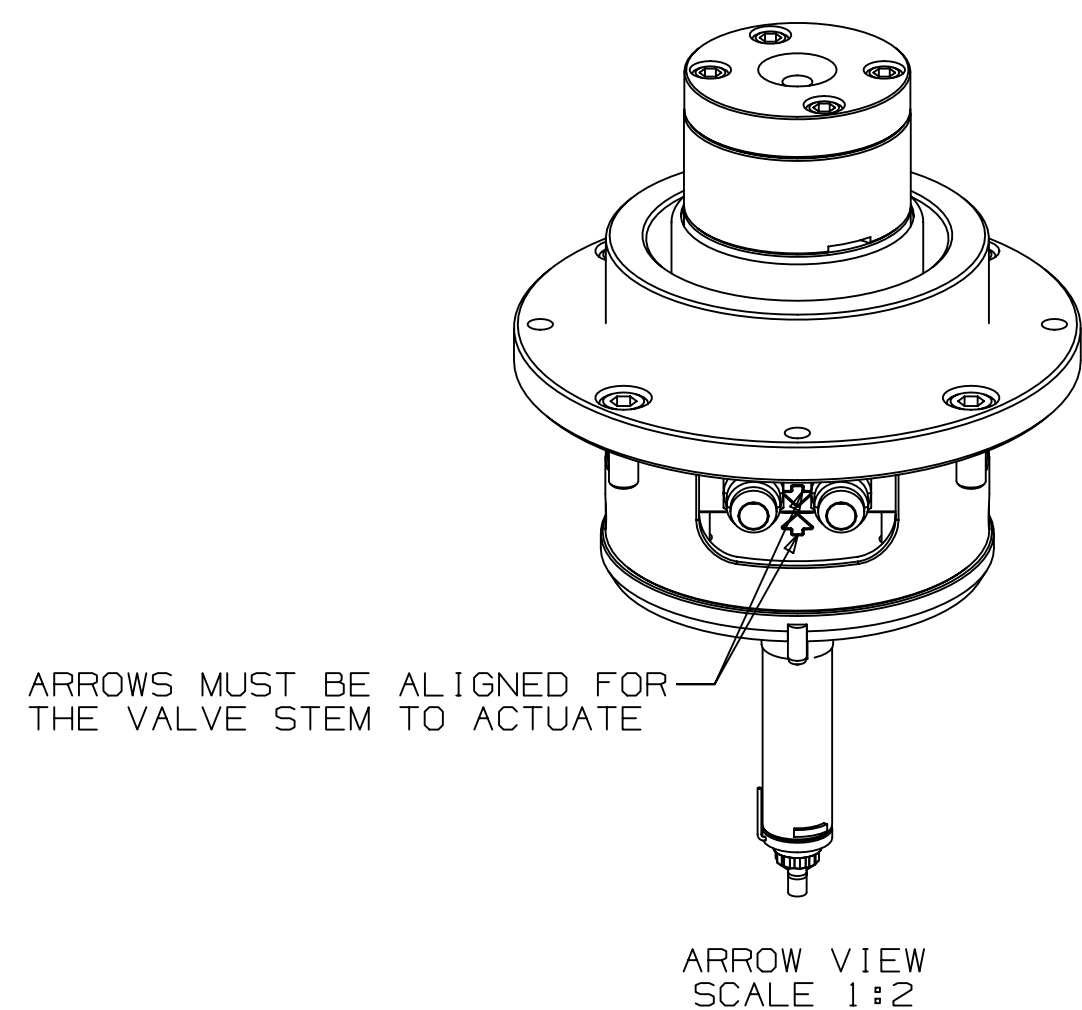
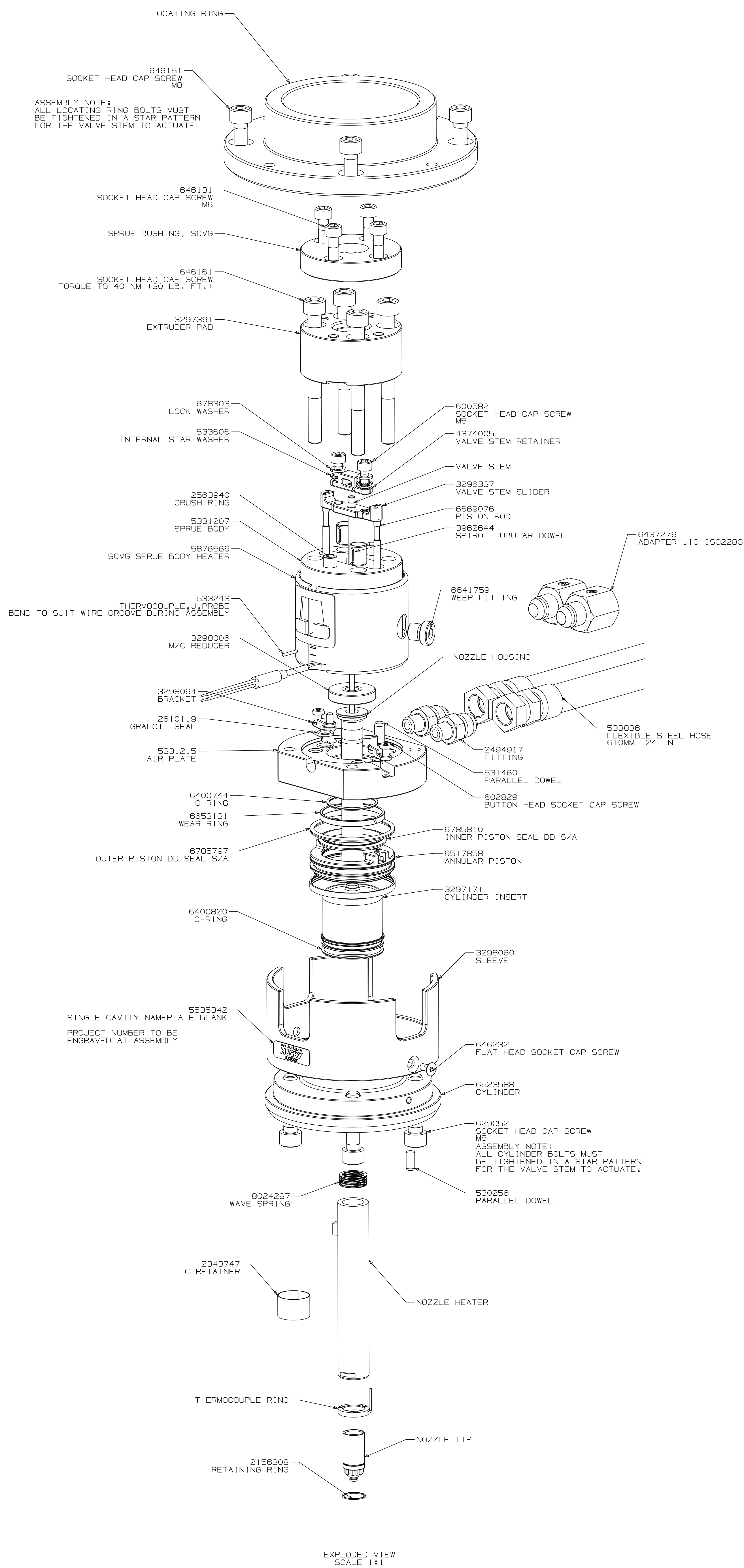
**RECOMMENDED GATE MANUFACTURING GUIDELINES**

- 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.

<p>DATE PER ASME Y14.2M-1994 AND HUSKY ADDENDUM - HIGH PRESSURE DIECASTING SPECIFICATIONS</p> <p>DESIGN MODEL TO DATE: N/A</p> <p>GENERAL TOLERANCES ARE BASIC: METRIC: (M) IMPERIAL: (S)</p> <p>BROKEN EDGES/CHAMFER: 1 ± 0.2 X 45° 0.04 ± 0.01 X 45°</p> <p>FILLET/RADIUS: R0.8 ± 0.2 R0.03 ± 0.01</p> <p>SURFACE FINISH: 6.3</p>	<p>DEFINING DRAWING FEATURES: METRIC</p> <p>MATERIAL: N/A</p> <p>FINISH/TREATMENT: N/A</p> <p>NO INTELLECTUAL PROPERTY RIGHTS ARE CLAIMED UNLESS OTHERWISE INDICATED OR OTHERWISE APPLICABLE.</p> <p>ALL RIGHTS RESERVED. COPYRIGHT © 2014 HUSKY</p>	<p>TITLE: SCVG</p> <p>Single Cavity Valve Gate</p> <p>U500-SCVG-VX</p> <p>SCALE: 1:1</p> <p>SHEET: 1 OF 2</p> <p>DRAWING NO.: 8143261</p> <p>REV: 1</p>
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# ASSEMBLY DRAWING

DRAWING NO. 8143261



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	20
3/8	35	28
1/2	65	50
5/8	95	70
3/4	150	110
7/8	250	210
1	350	280
M4	75	55
M5	110	80
M6	160	120
M8	250	180
M10	390	290
M12	580	430
M14	870	640
M16	1350	1000
M20	2500	1850
M24	4100	3000

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 = (-)

**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.
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- WELDING THE GATE AREA INCREASES STRESSES AT THE GATE. SOFTENS THE AREA AROUND THE WELD AND CAN CAUSE GATE FAILURES.

UNDEFINED DRAWING FEATURES (SHEET 2 OF 2)	METRIC	<b>HUSKY</b>	TITLE
MATERIAL: N/A	FINISH/TREATMENT	SCALE: 1:1	Single Cavity Valve Gate
WEIGHT: - kg	NO INTELLECTUAL PROPERTY RIGHTS IMPLIED OR OTHERWISE	SIZE: AOR	U500-SCVG-VX
	ALL RIGHTS RESERVED. COPYRIGHT	DRAWING NO.	8143261
		REV	1