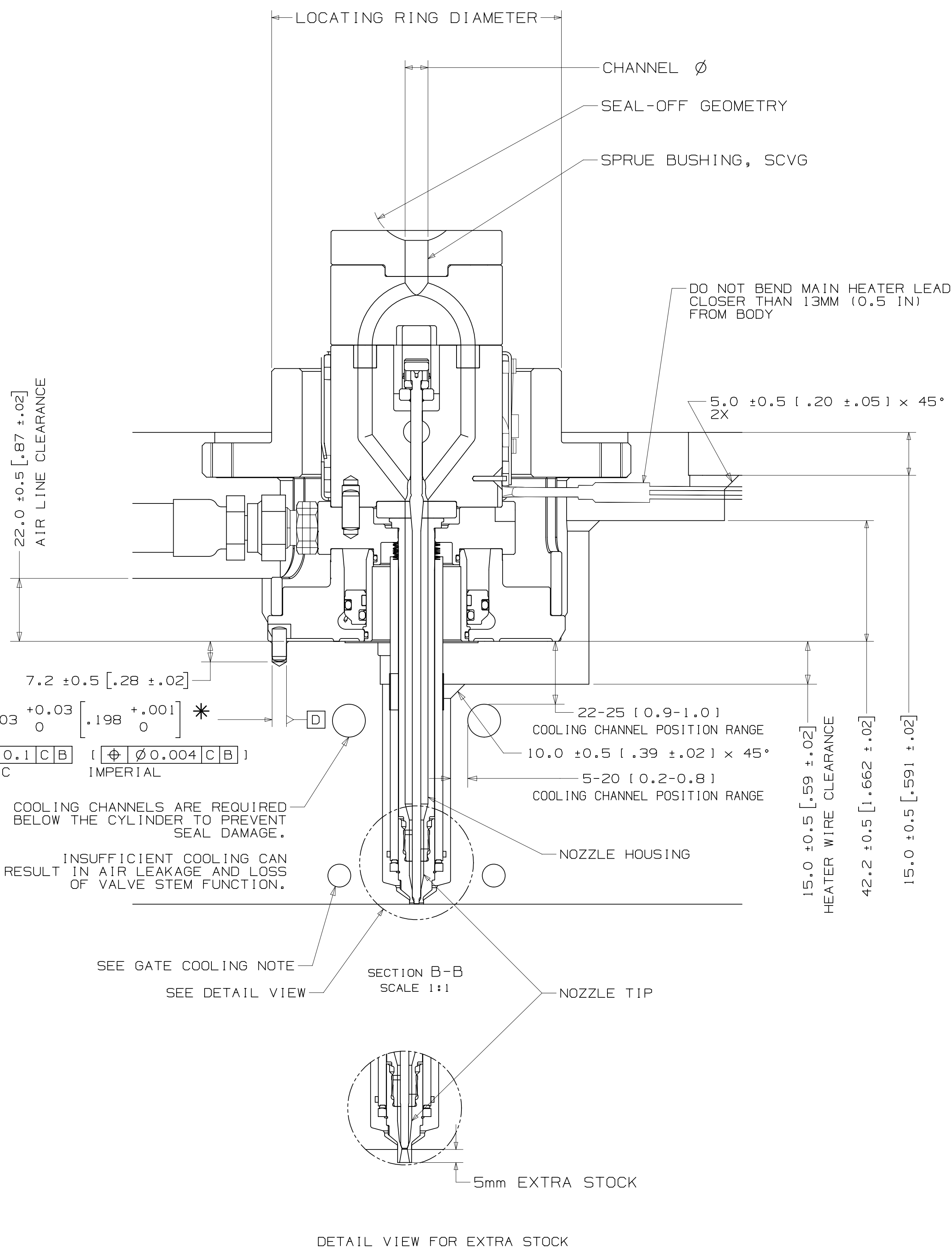
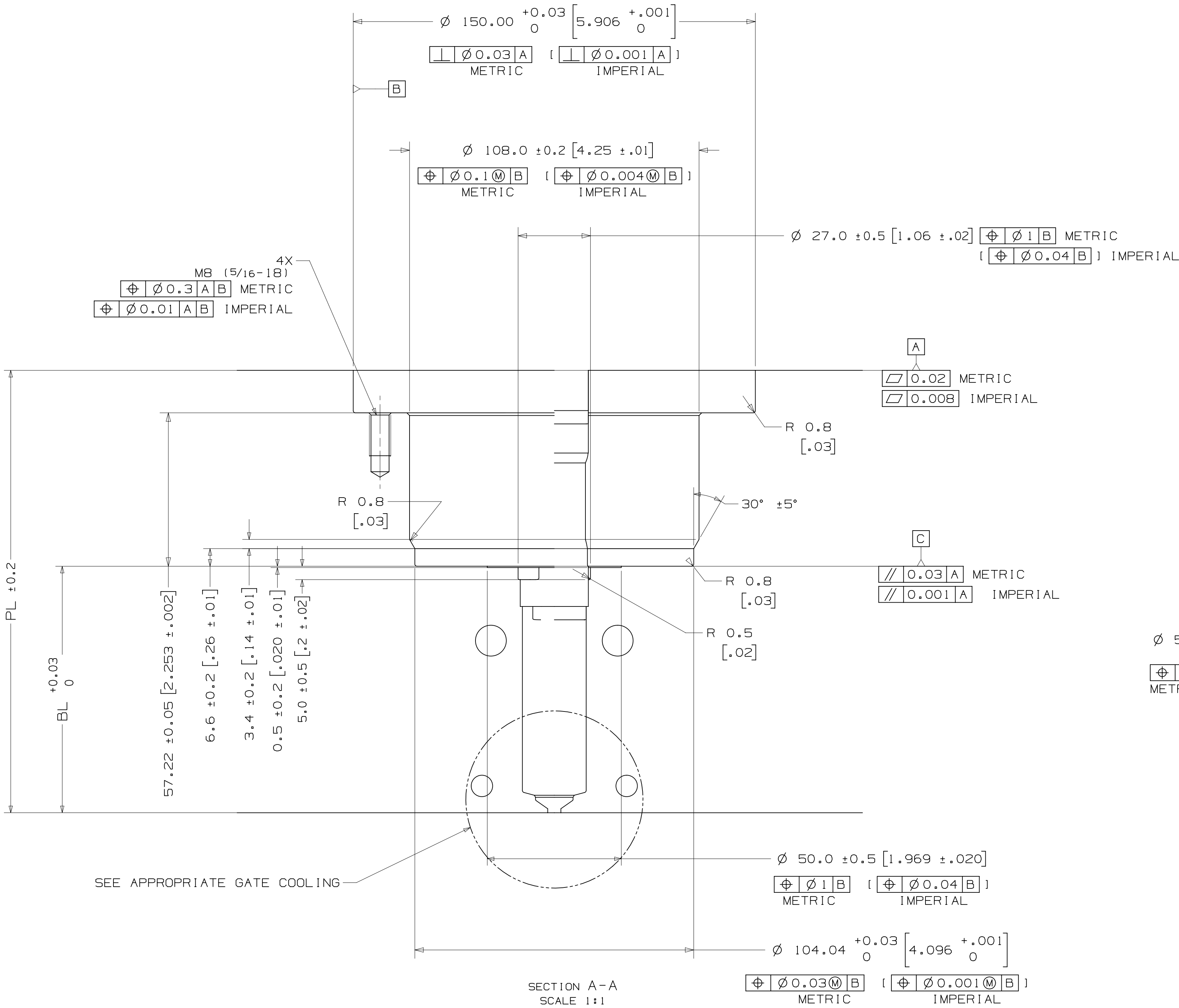
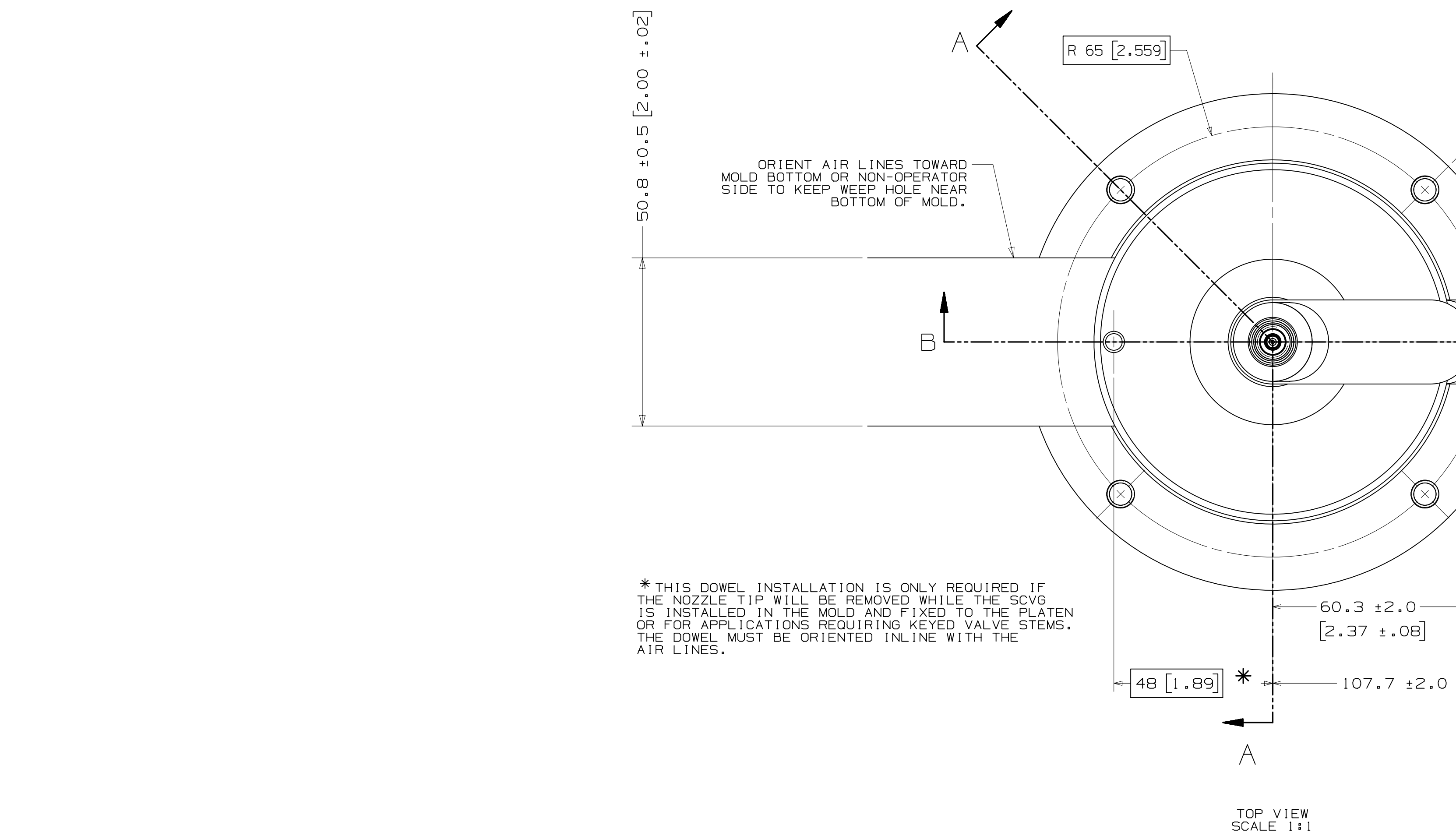


INSTALLATION DRAWING



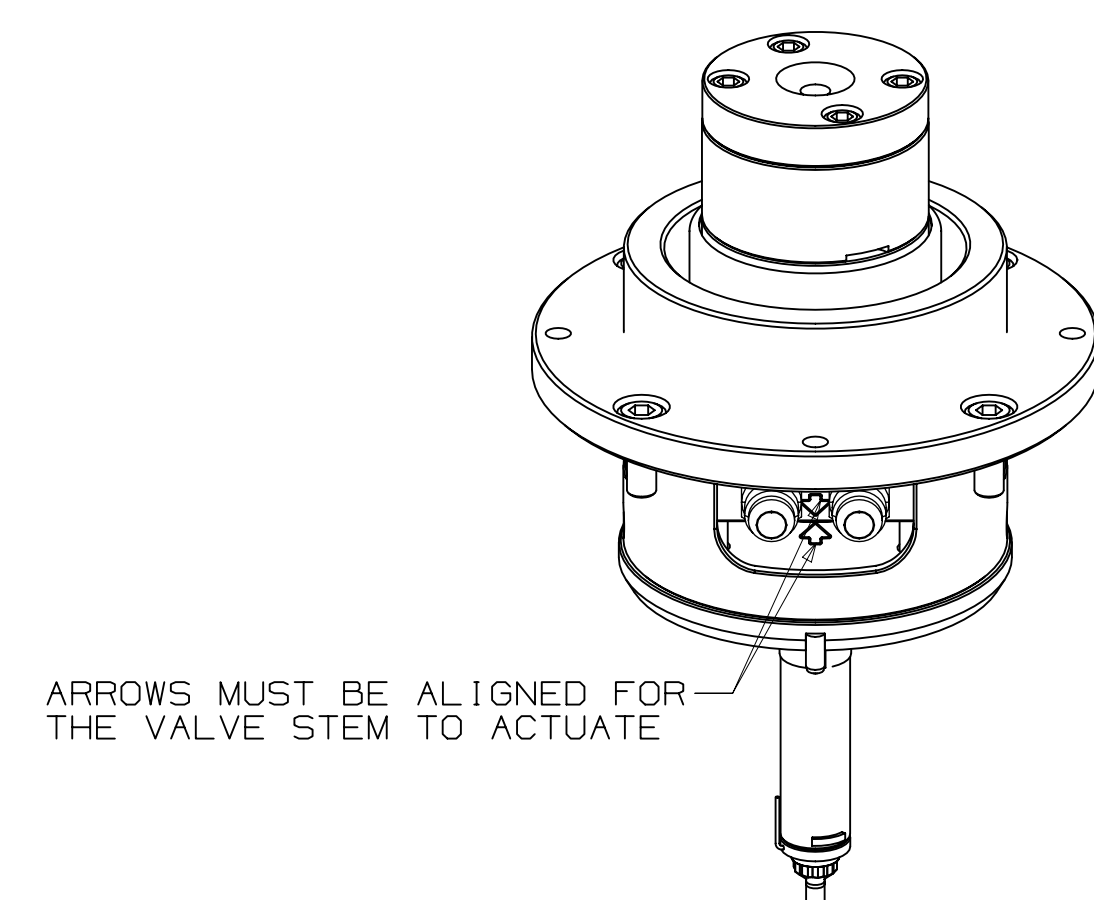
NOZZLE SERIES	NOZZLE TIP	PL RANGE	Approx. BL*
U500	VX	91.24 (3.592) - 251.6 (9.905)	22 (0.86) - 172 (6.77)

*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 - B
	FLAT	
	SEAL-OFF 12.7 (1/2)	B - THRU
	SEAL-OFF 15.5	
	SEAL-OFF 19.05 (3/4)	
	SEAL-OFF 20	
	SEAL-OFF 40	

U500	LOCATING RING DIAMETER	
	Ø	
	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 (49-51 Rc) AISI 420 (49-51 Rc)	
		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.	
		HUSKY	
		TITLE: Single Cavity Valve Gate	
		U500-SCVG-VX	
		SCALE: 1:1	
		SHEET 1 OF 2	
		DRAWING: 8143261	
		REV: 2	



FLEXIBLE STEEL HOSE HAS:		
METRIC		
3/8-150 228 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"	50	35
5/8"	70	50
3/4"	90	65
1"	110	80
M4	1180	865
M6	13	9
M8	9.8	7
M10	13	10
M12	29	21
M16	107	78
M20	135	100
M24	215	158
M28	280	205
M32	350	255
M36	480	350
M42	650	480
M48	850	625

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 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

AlSi H13 149-51 Rc1
AlSi 420 149-51 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 STEEL 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 TREATING.
- 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 IN THE GATE. SOFTER GATE MATERIALS IN THE WELD CAN CAUSE GATE FAILURES.

UNDESIGNED DRAWINGS FEATURES TO COMPLY WITH ASTM "SUPERIOR QUALITY REFERENCE"		METRIC 			
MATERIAL: N/A		THIS DRAWING AND INFORMATION CONTAINED HEREIN IS CONFIDENTIAL AND NOT BE LOANED, REPRODUCED, COPIED, OR IN ANY MANNER DISCLOSED TO ANY OTHER PERSONS OR SYSTEMS. IT IS THE PROPERTY OF HUSKY TOOL COMPANY AND MAY NOT BE COPIED, REPRODUCED, OR IN ANY MANNER DISCLOSED TO ANY OTHER PERSONS OR SYSTEMS WITHOUT THE WRITTEN CONSENT OF HUSKY.		TITLE: SCV6 Single Cavity Valve Gate	
FINISH/TREATMENT:		NO INTELLECTUAL PROPERTY RIGHTS ARE GRANTED INCLUDING ANY LICENSE IMPLIED OR OTHERWISE.		1/1 SCALE: 1:1 SIZE: AOR DRAWING: 8143261 REV: 2	
WEIGHT: - kg		ALL RIGHTS RESERVED. COPYRIGHT © 2010 HUSKY TOOL COMPANY		SHEET 2 OF 2	