

D-M-E ME-0719-PS-053-A

GATE INSERTS INSTALLATION DATA FOR FINLESS AND INTEGRAL HEATER PROBES

Please read carefully before installing components

REFER TO DATA SHEET #1315
AND MINI-PRINT NOS. 1300, 1400, 1500,
1600 AND 1700

AFGI-03N, AFGI-04N, AFGI-10N, AFGI-20N Gate Inserts are supplied with the appropriate internal configuration already finish machined to suit the style of Auto-Fixed Integral Heater Probe and Auto-Fixed Finless Probe being used. Both external faces of the insert are supplied square to the ground O.D. surface. This provides for quick set-up and easy machining of gate and cavity details to suit the application.

IMPORTANT:

- 1) Layout all gate dimensions from the finished spherical radius (See Figure #1).
- 2) If a higher Insert hardness is desired, anneal and harden by heat treatment.

GATE INSERT

MATERIAL: AISI 5-7 STEEL
(pre-hard)

HARDNESS: 30-34 RC

Hardness can be increased
by heat treatment.

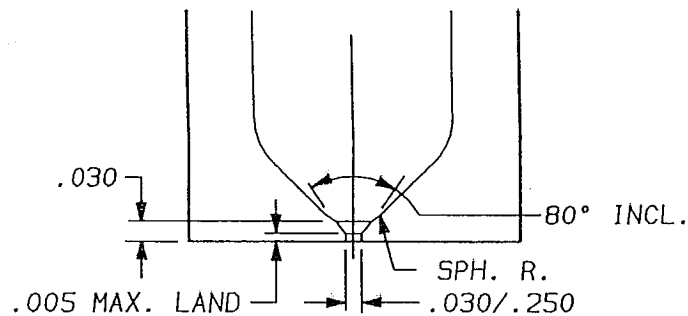
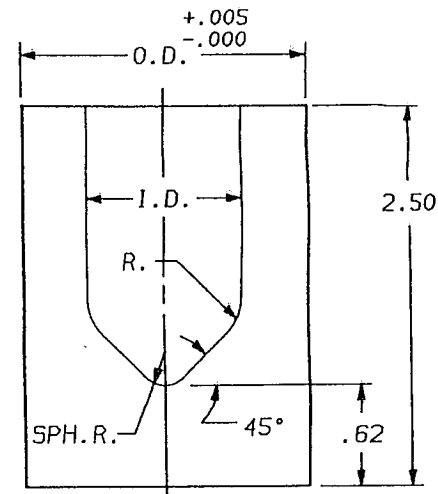
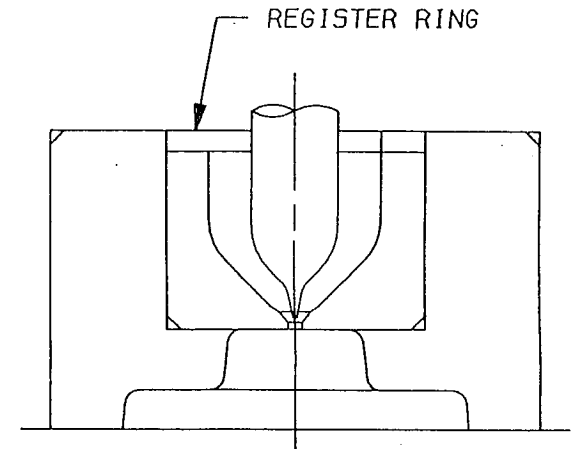
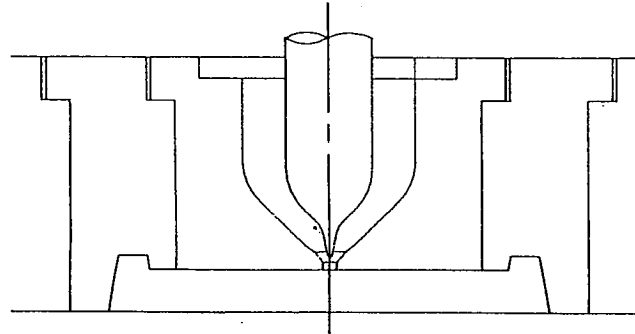
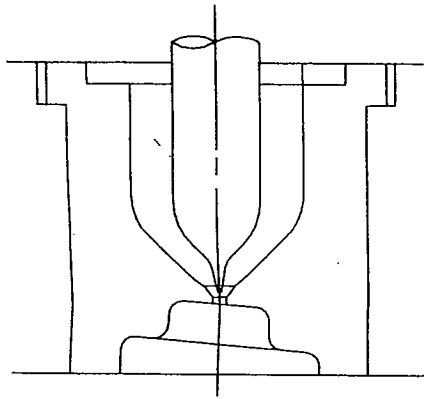
GATE MACHINING DIMENSIONS

Figure 1



| CAT. NO. | O.D. | I.D. | SPH. R. | R. | USED WITH |
|----------|-------|-------|---------|------|---------------------------------------|
| AFGI-03N | 1.625 | .812 | .187 | .375 | AFIP3 SERIES |
| AFGI-04N | 1.625 | .875 | .187 | .375 | AFIP4 SERIES |
| AFGI-10N | 1.750 | 1.000 | .187 | .375 | AFPN-310 THRU 610 AND AFIP5 SERIES |
| AFGI-20N | 2.000 | 1.125 | .250 | .500 | AFPN-720 THRU 1020 |

GATE INSERT APPLICATIONS



29111 STEPHENSON HIGHWAY
MADISON HEIGHTS,
MICHIGAN 48071 U.S.A.
(800) 626-6653