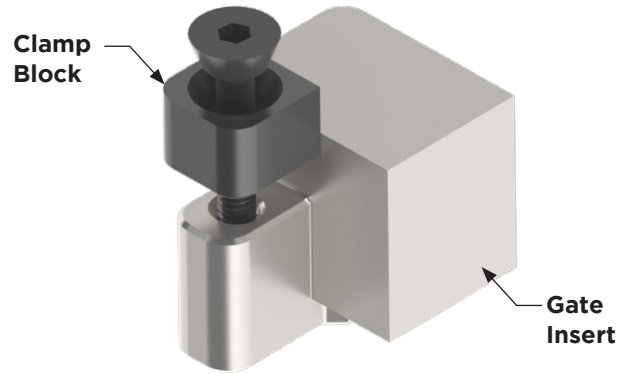
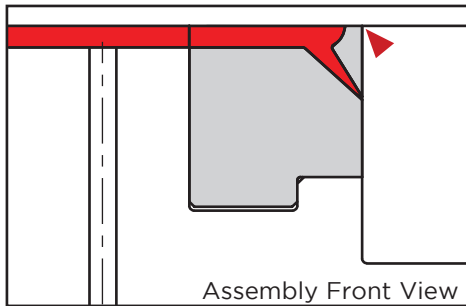
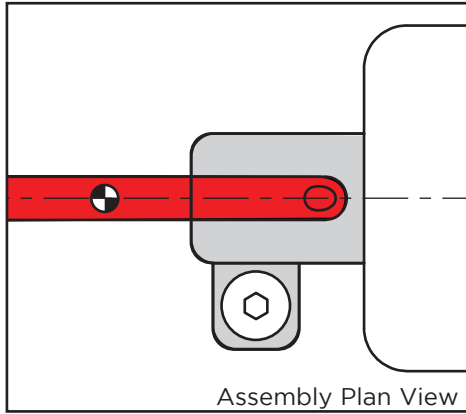




# GATE INSERTS

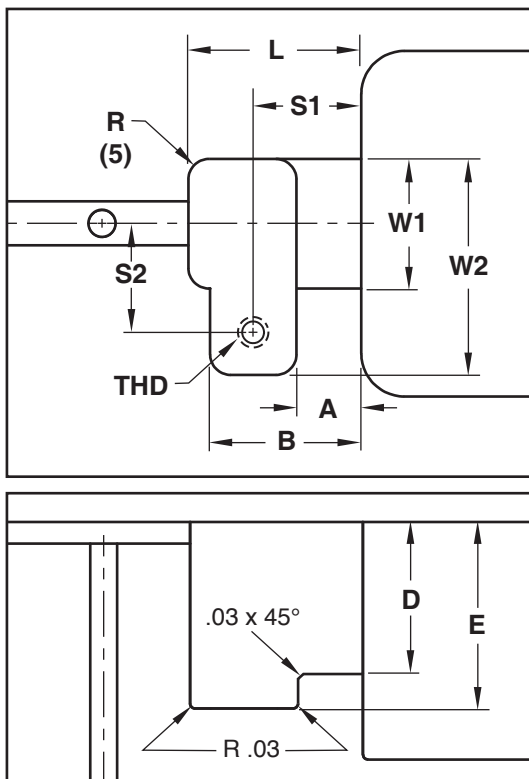


PART NAME	MATERIAL/TREATMENT
Gate Insert	Uddeholm Caldie®, 56-60 HRC
Clamp Block	4140, 28-32 HRC, Black Oxide

▶ CAD insertion point

W1	W2	L	A	B	R	D	E	S1	S2	THD
.750	1.250	1.000	.375	.875	.130	.875	1.063	.625	.625	#8-32

Assembly includes Gate Insert, Clamp Block, and Screw.

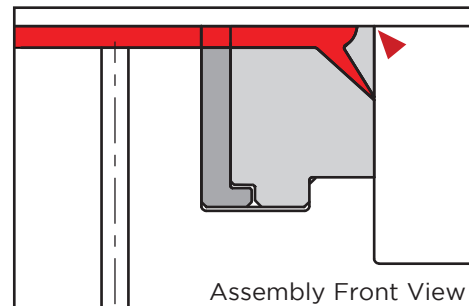
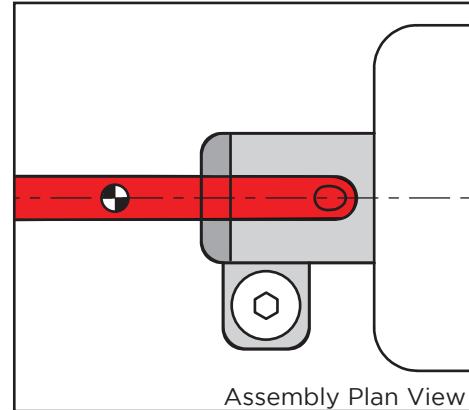
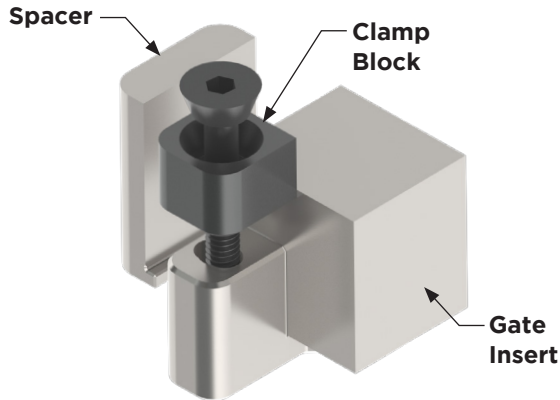


## APPLICATION GUIDELINES

- Gate Inserts are designed for performance when running abrasive materials.
- Serviceable from parting line.
- This Insert is designed for use when gate size is known. If unknown and adjustments are likely, consider the Gate Insert on the opposite page for modifications without requiring re-EDM'ing of the gate.
- Fitting stock is included on both this insert and the insert on the next page:  
 $L = +.010''/+0.012''$   
 $D = +.005''/+0.007''$

# GATE INSERTS

## ADJUSTABLE SPACER DESIGN

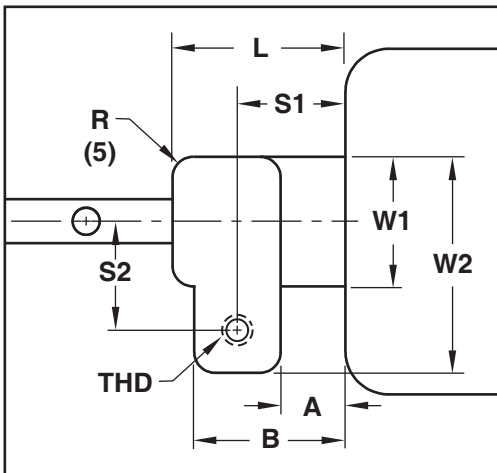


PART NAME	MATERIAL/TREATMENT
Gate Insert	Uddeholm Caldie®, 56-60 HRC
Clamp Block	4140, 28-32 HRC, Black Oxide
Spacer	DH2F, 37-41 HRC

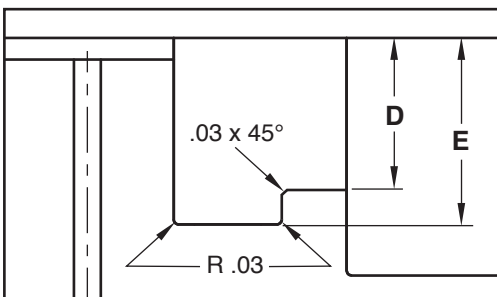
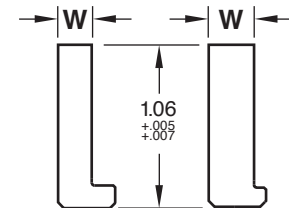
▶ CAD insertion point

W1	W2	L	A	B	R	D	E	S1	S2	THD
.750	1.250	1.000	.375	.875	.130	.875	1.063	.625	.625	#8-32

Assembly includes Gate Insert, Clamp Block, and Screw.



SPACER REFERENCE	W
MIN	.175
MAX	.235



### APPLICATION GUIDELINES

- This Gate Insert is designed for use in applications where the gate size is unknown and adjustments are likely.
- Rather than re-EDM'ing the gate to open the diameter, material can be removed from the front/cavity face of the Gate Insert.
- Spacers are sold separately and are required when using this version:
  - The MIN offers no stock for adjustment and would be utilized when gate modifications are not yet known.
  - The MAX includes .060" stock for modification when up to .060" of stock is removed from the Gate Insert.
- Remove stock from the front face and the front heel (shown below). Then subtract .060" from what was removed from those two surfaces, and remove that result from the Spacer. Then re-sample the mold.

Example: First, the mold was sampled with the MIN Spacer. After deciding to open the gate, .020" was removed from the front face and heel of the Gate Insert. Then, .040" was removed from the MAX Spacer face (.060"-.020"=.040") to fit within the original pocket.

