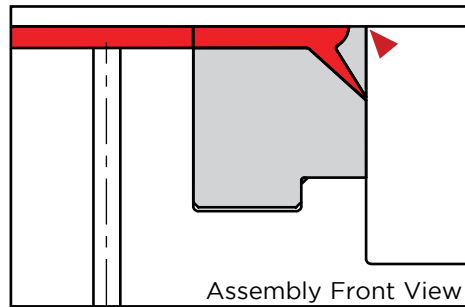
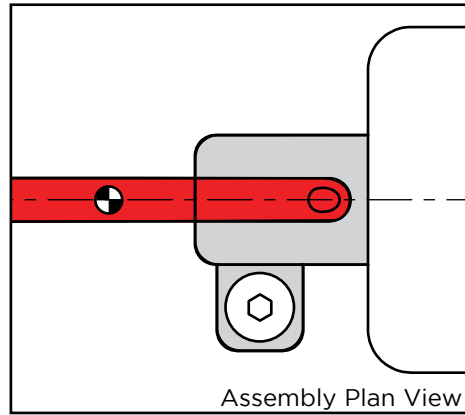
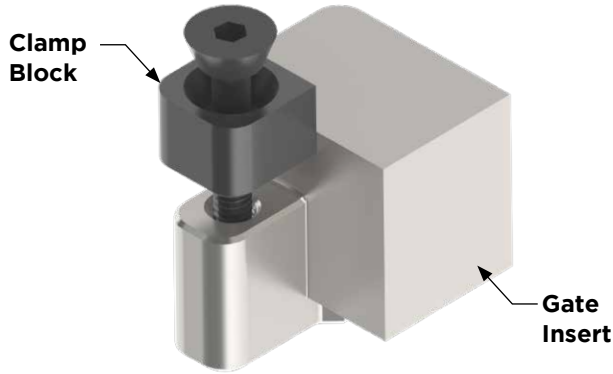


GATE INSERTS



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

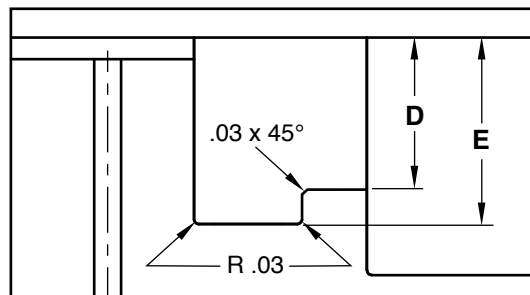
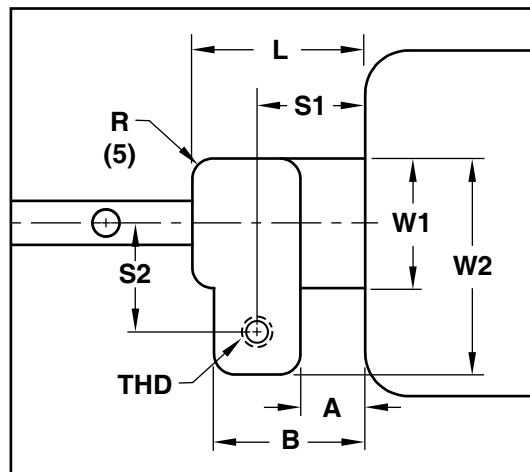
▶ CAD insertion point

CATALOG NUMBER	W1	W2	L	A	B	R	D	E	S1	S2	THD
GT75	.750	1.250	1.000	.375	.875	.130	.875	1.063	.625	.625	#8-32

Assembly includes Gate Insert, Clamp Block, and Screw.

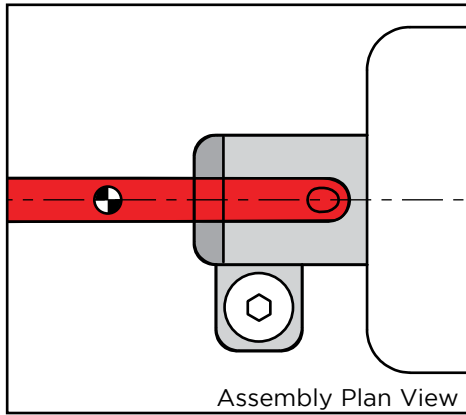
APPLICATION GUIDELINES

- Gate Inserts are designed for performance when running abrasive materials.
- Serviceable from parting line.
- The GT75 is designed for use when gate size is known. If unknown and adjustments are likely, consider the GT75-S 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"/+.012"
 - D = +.005"/+.007"

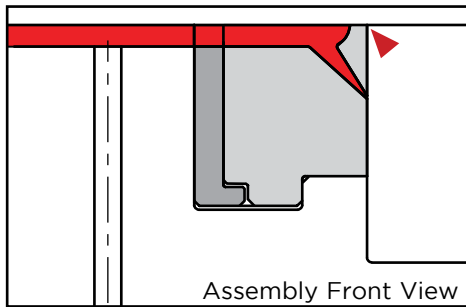




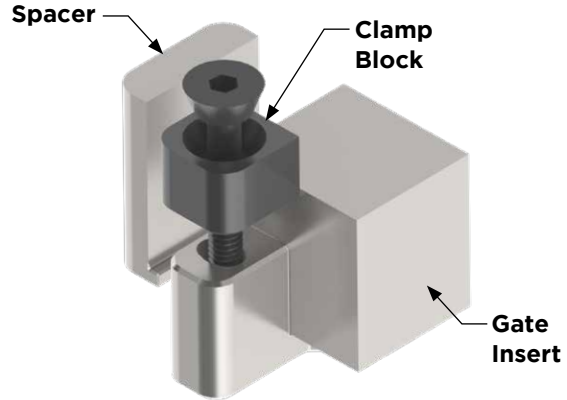
GATE INSERTS ADJUSTABLE SPACER DESIGN



Assembly Plan View



Assembly Front View

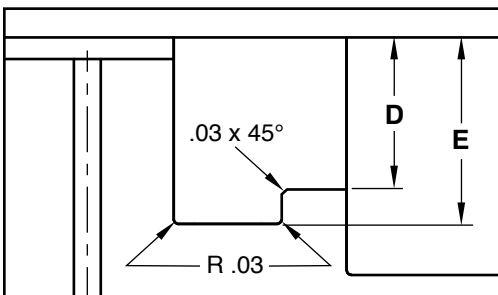
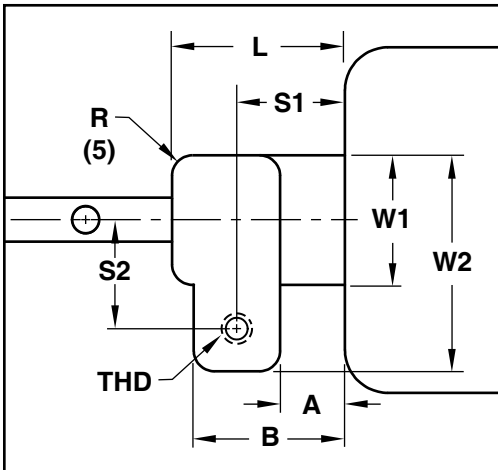


PART NAME	MATERIAL/TREATMENT
Gate Insert	Uddeholm Caldie®, 56-60 HRC
Clamp Block	4140, 28-32 HRC, Black Oxide
Spacer	DH2F, 37-41 HRC

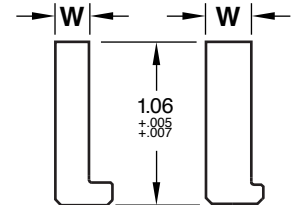
CAD insertion point

CATALOG NUMBER	W1	W2	L	A	B	R	D	E	S1	S2	THD
GT75-S	.750	1.250	1.000	.375	.875	.130	.875	1.063	.625	.625	#8-32

Assembly includes Gate Insert, Clamp Block, and Screw.



SPACER CATALOG NUMBER	W
GTS75-MIN	.175
GTS75-MAX	.235



APPLICATION GUIDELINES

- The GT75-S 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 the GT75-S:
 - The GTS75-MIN offers no stock for adjustment and would be utilized when gate modifications are not yet known.
 - The GTS75-MAX includes .060" stock for modification when up to .060" of stock is removed from the Gate Insert GT75-S.
- 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 GT75-MIN Spacer. After deciding to open the gate, .020" was removed from the front face and heel of the Gate Insert GT75-S. Then, .040" was removed from the GTS75-MAX Spacer face (.060"-.020"=.040") to fit within the original pocket.

