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**GATE INSERT INSTALLATION DATA  
FOR FINLESS & INTEGRAL HEATER PROBES**  
Please read carefully before installing components

Refer to Data Sheet: #1315 & Mini-Prints No.: 1300, 1400, 1500, 1600, 1700

AFGI-03N, AFGI-04N, 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.

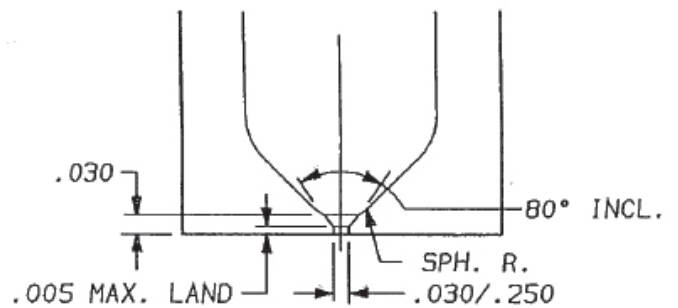
Both external faces of the insert are supplied square to the ground O.D. Surface. This provides for quick set-up and easy machining of gate and cavity details to suit the application.

**IMPORTANT:**

Layout all gate dimensions from the finished spherical radius. (See Figure #1).

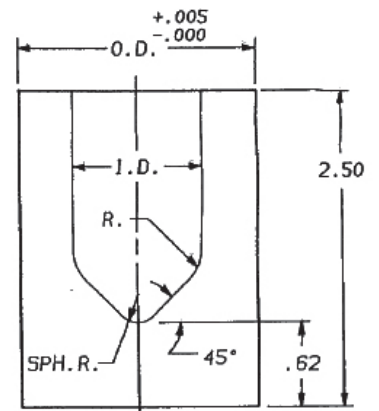
If a higher insert hardness is desired, anneal and harden by heat treatment.

**GATE MACHINING DIMENSIONS**

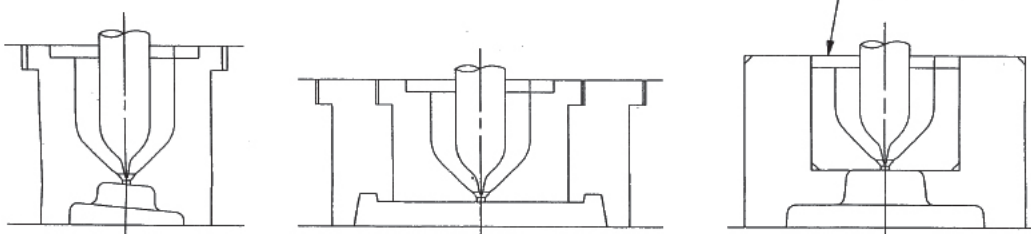


**FIGURE 1**

Catalog #	O.D.	I.D.	SPH. R.	R.	Used With
AFGI-03N	1.625	.812	.187	.375	AFIP3
AFGI-04N	1.625	.875	.187	.375	AFIP4
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**



Material: AISI S-7 Steel  
(pre-hardened)

Hardness: 30-34 RC  
Hardness can be increased  
by heat treatment.