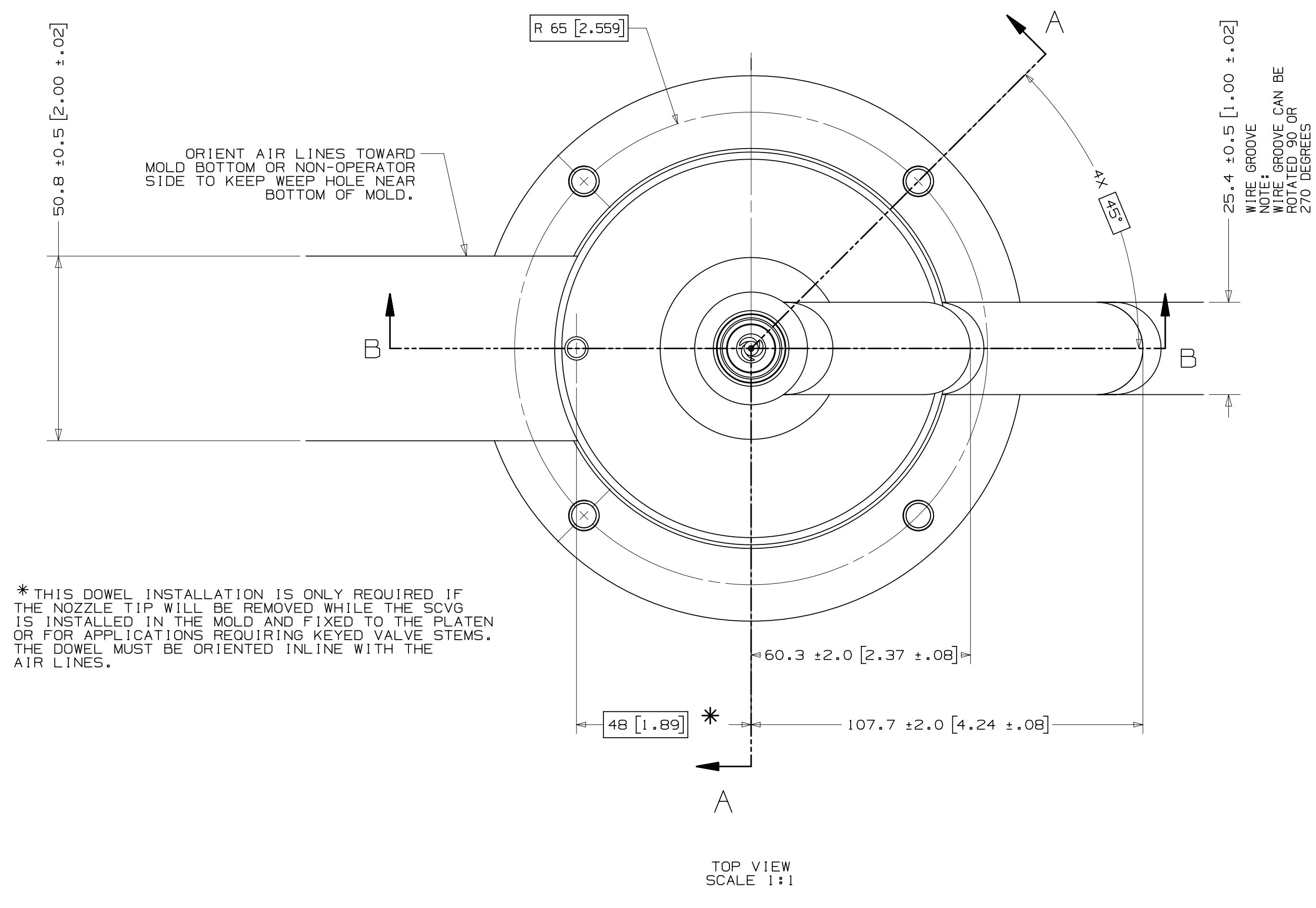
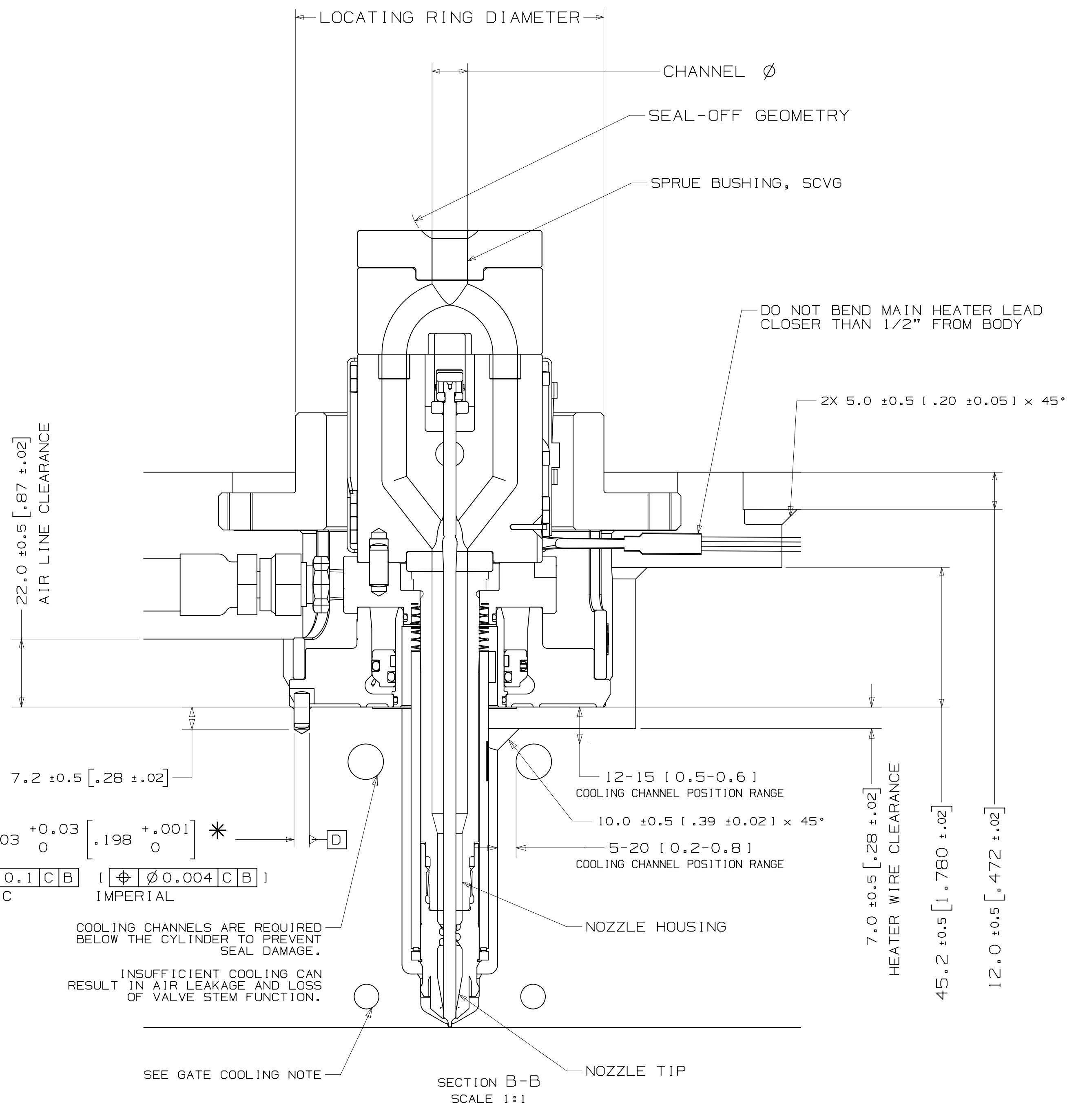
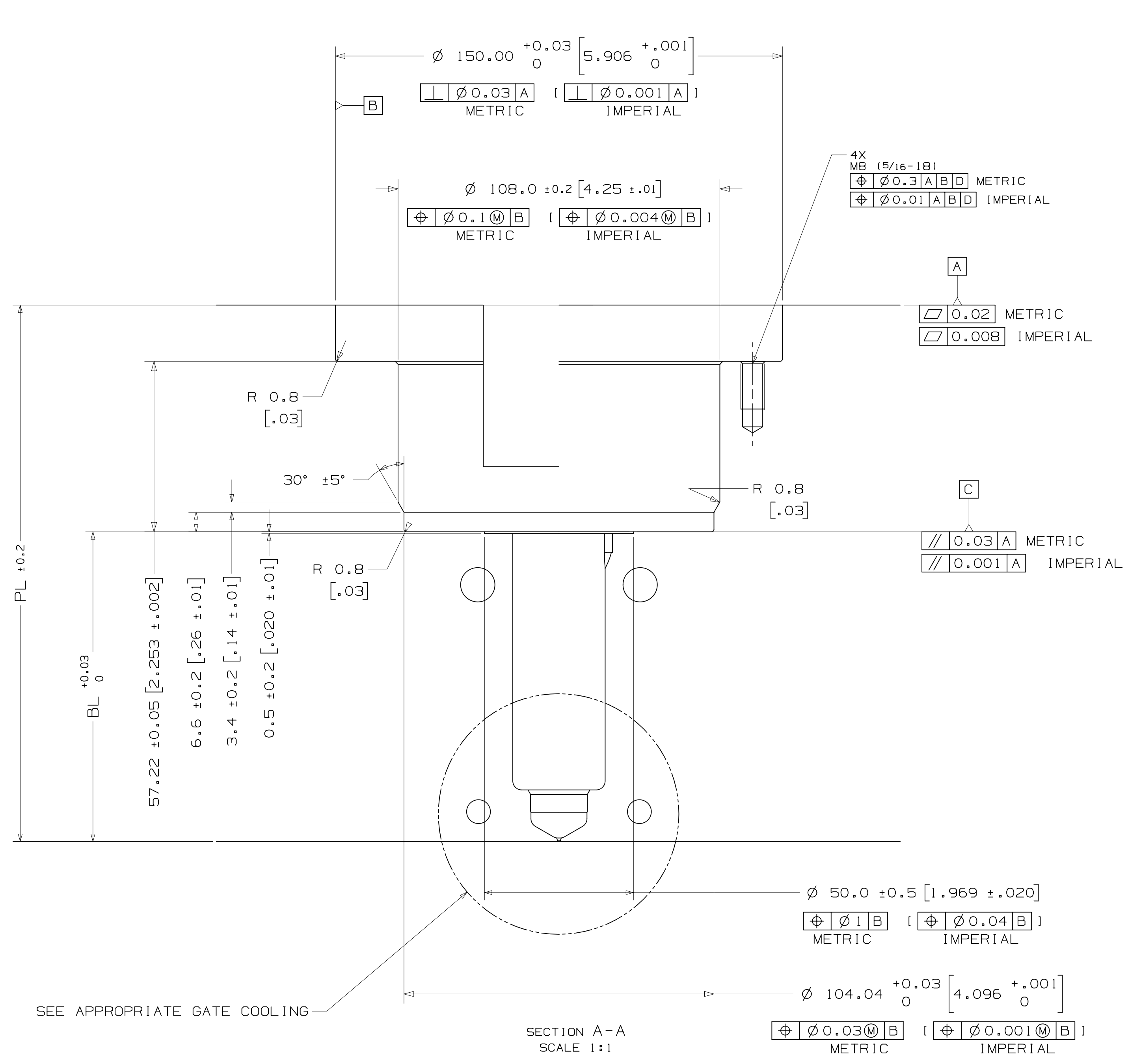


INSTALLATION DRAWING

REV 0
9618683



* THIS DOWEL INSTALLATION IS ONLY REQUIRED IF THE NOZZLE TIP WILL BE REMOVED WHILE THE SCVG IS INSTALLED IN THE MOLD AND FIXED TO THE PLATEN OR FOR APPLICATIONS REQUIRING KEVED VALVE STEMS. THE DOWEL MUST BE ORIENTED IN LINE WITH THE AIR LINES.



NOZZLE SERIES	NOZZLE TIP	PL RANGE	Approx. BL
U750	UH-T2	113.27(4.459) - 273.64(10.773)	44(1.73) - 194(7.64)

*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.

LOCATING RING DIAMETER
U750 100mm
101.3mm [3.99"]
125mm

SPRUE BUSHING	
SEAL-OFF GEOMETRY	CHANNEL Ø
SPHERICAL RADIUS	IN - OUT
FLAT	6.35 - 11.5
FLAT	
SEAL-OFF 12.7 [1/2"]	11.5-THRU
SEAL-OFF 15.5	
SEAL-OFF 19.05 [3/4"]	
SEAL-OFF 20	
SEAL-OFF 40	

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.
www.husky.co

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)

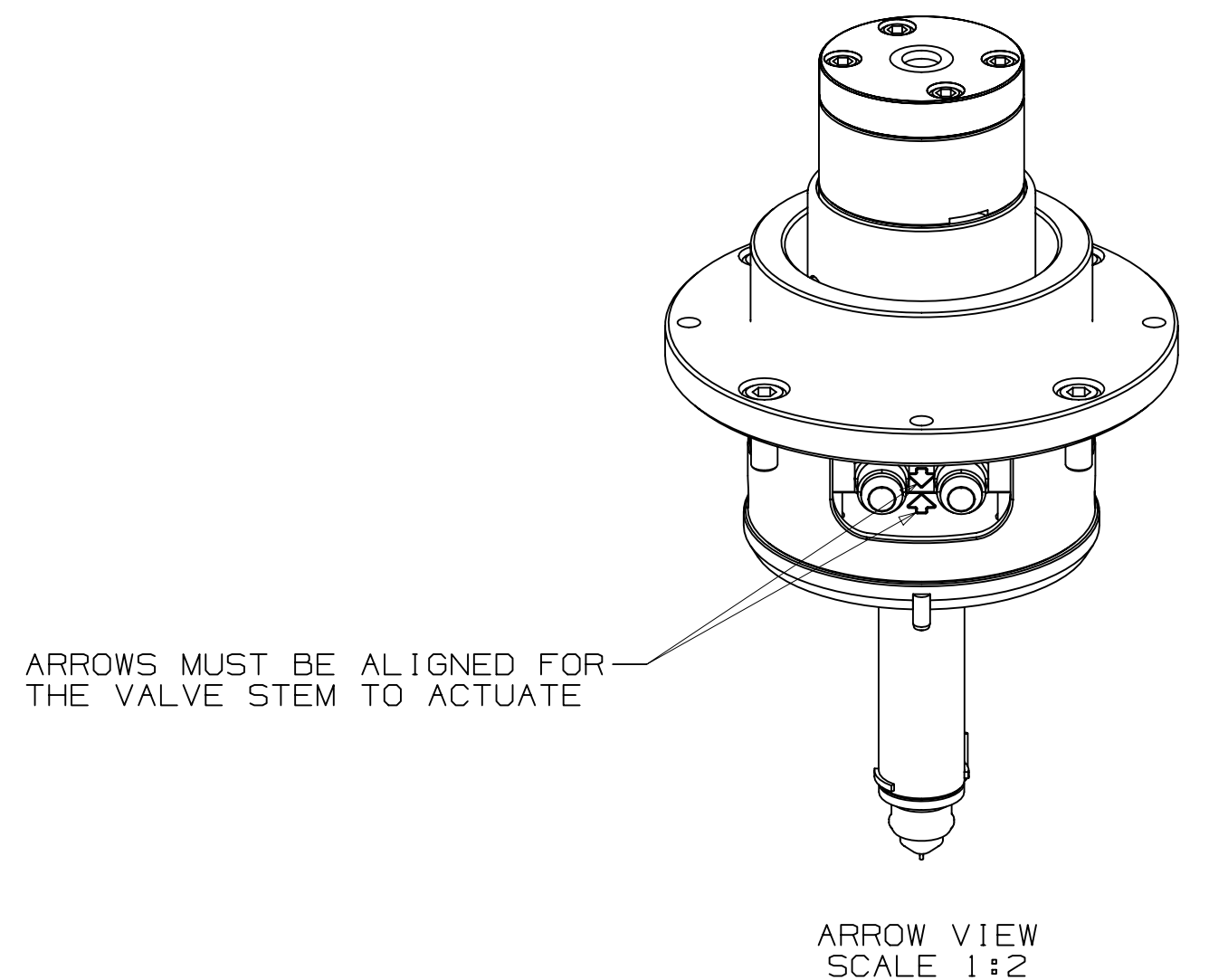
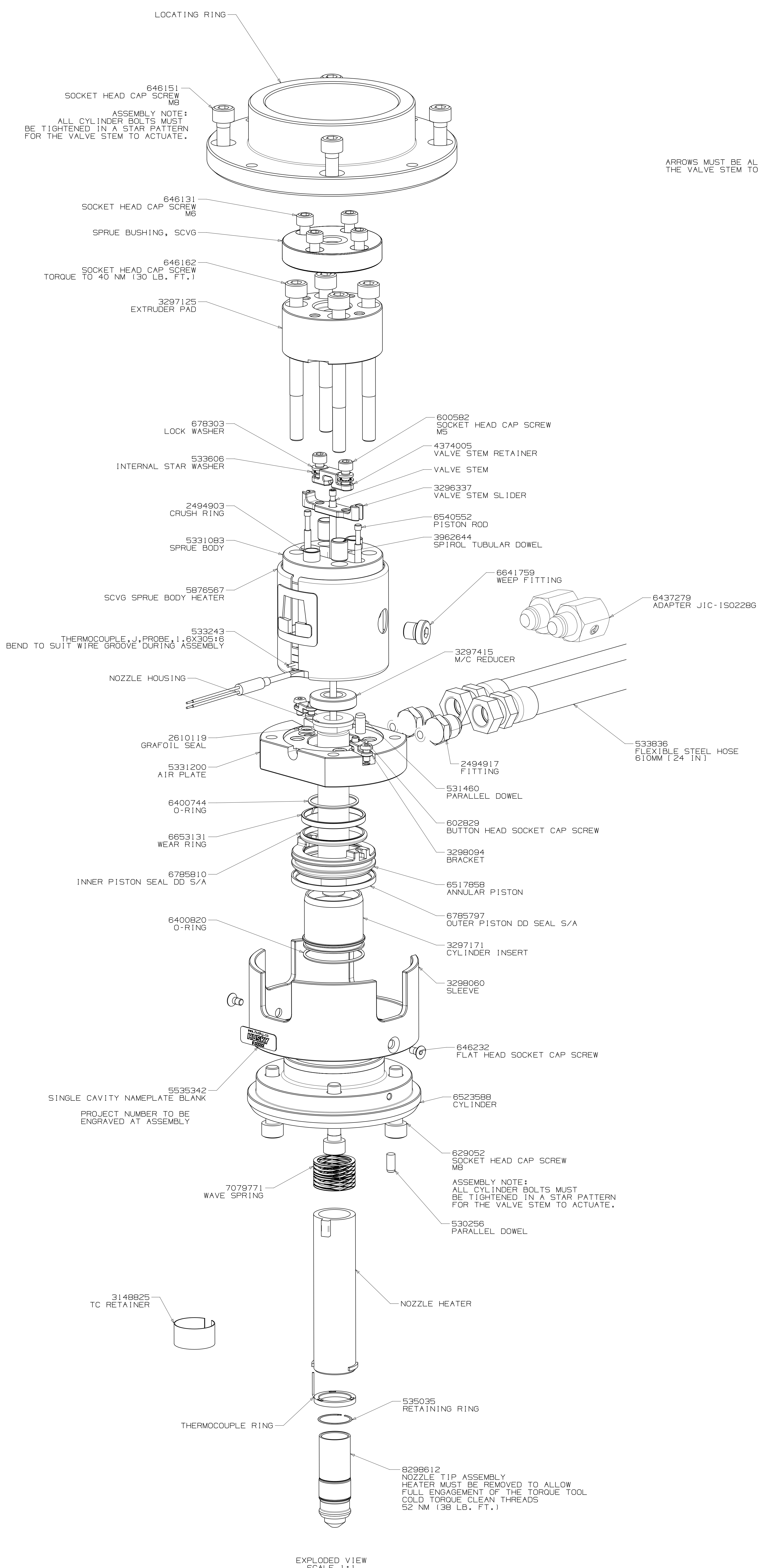
RECOMMENDED GATE MANUFACTURING GUIDELINES
- HARDENED GATE INSERTS (49-51) ARE RECOMMENDED WHEN USING SOFTER CAVITY STEELS. SOFTER CAVITIES MAY BE ACCEPTABLE FOR CERTAIN APPLICATIONS. CONTACT YOUR HUSKY REPRESENTATIVE WITH QUESTIONS.
- EDM'ING THE GATE AREA CAUSES MICRO CRACKS WHICH LEAD TO BRITTLE GATE 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.

REV	DATE	DESCRIPTION	DRWN	CHKD
1	2020-05-30	TABLE UPDATED PER LATEST CALCULATION	DRWN: DEEBAN N T	CHKD: DEEBAN N T
0	2019-10-19	ORIGINAL ISSUE - DESIGNED BY: DEEBAN N T	DRWN: DEEBAN N T	CHKD: ANUSHAL S

DWT PER ASME Y14.5M-1994 AND HDXV ADDENDUM - HDXV BASIS: DIMENSIONS SPECIFIED UNLESS OTHERWISE SPECIFIED DIM MODEL IS BASIC UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE BASIC. GENERAL TOLERANCES: METRIC: [0.13] IMPERIAL: [0.005] BROKEN EDGES/CORNERS: 1 ± 0.2 X 45° 0.04 ± 0.01 X 45° FILLET ROUNDS: R0.8 ± 0.2 R0.03 ± 0.01 SURFACE FINISH: Ra 3.2	UNFINISHED DRAWING FEATURES: METRIC [0.13] IMPERIAL [0.005] MATERIAL: N/A FINISH/TREATMENT: [0.005]	HUSKY TITLE: SCVG Single Cavity Valve Gate U750_SCVG-UH-T2 SCALE: 1:1 SIZE: AOR SHEET: 1 OF 2 REV: 0
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ASSEMBLY DRAWING

DRAWING NO. 9618683 0



FLEXIBLE STEEL HOSE HAS:		
METRIC		
3/8-ISO 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
7/16	50	37
1/2	70	52
5/8	100	74
3/4	150	110
7/8	200	148
1	280	207
M4	4.6	3.4
M5	6.8	5.0
M6	9.8	7.2
M8	19	14
M10	29	21
M12	42	31
M14	61	45
M16	88	65
M20	150	110
M25	280	207

VALVE STEM STROKE IS 7.3 (.29)	
ELECTRICAL INFO (240 VAC)	
ZONE	ZONE DESCRIPTION
1	SPRUE BODY
2	NOZZLE TIP
T/C LEADS: WHITE = (+) RED = (-)	

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DEFINED DRAWING FEATURES	METRIC	HUSKY
MATERIAL: N/A	FINISH/TREATMENT	TITLE: Single Cavity Valve Gate
WEIGHT: - kg	SCALE: 1:1	SIZE: U750_SCVG-UH-T2
	SHEET 2 OF 2	DRAWING NO: 9618683
		REV: 0