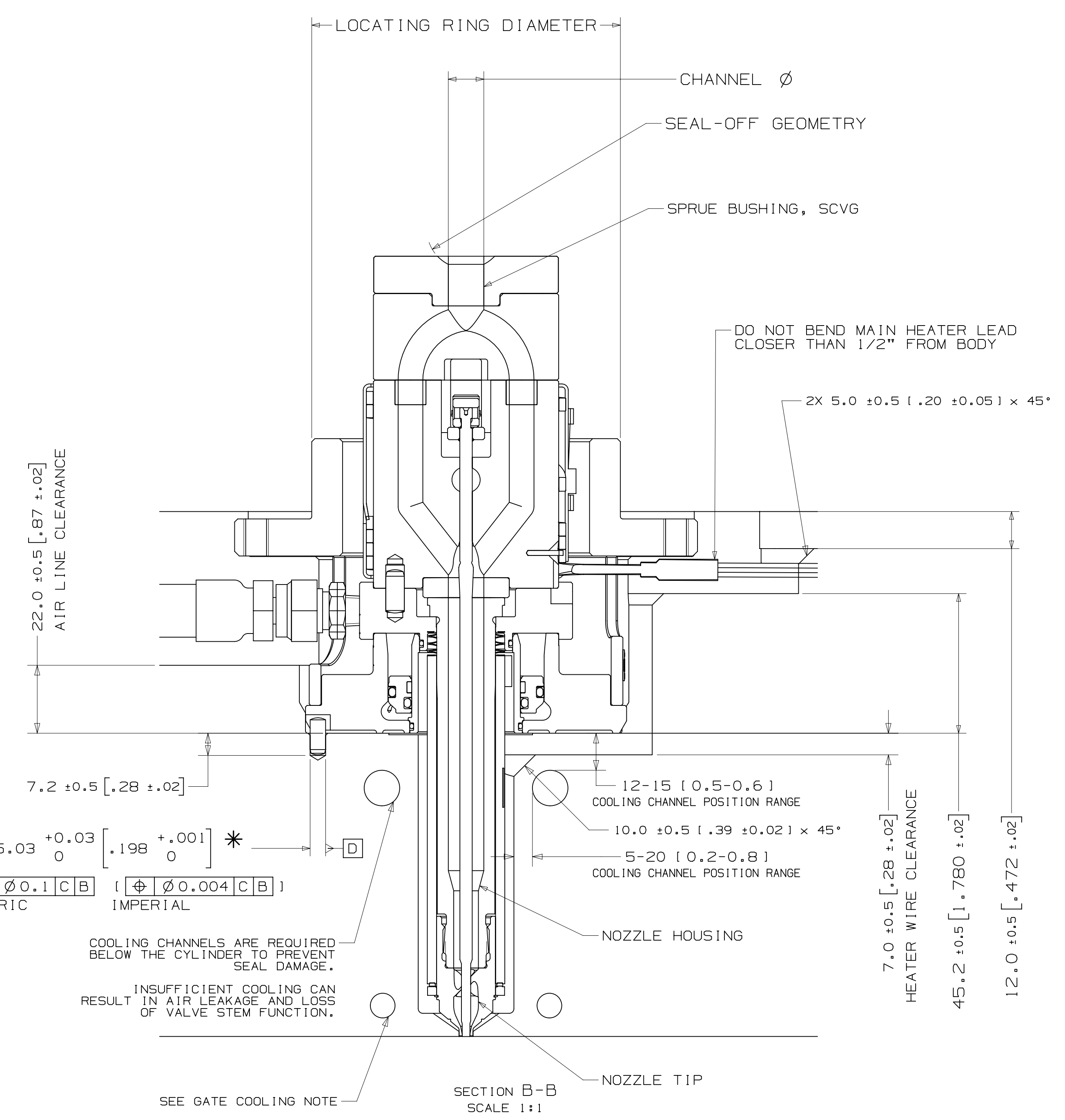
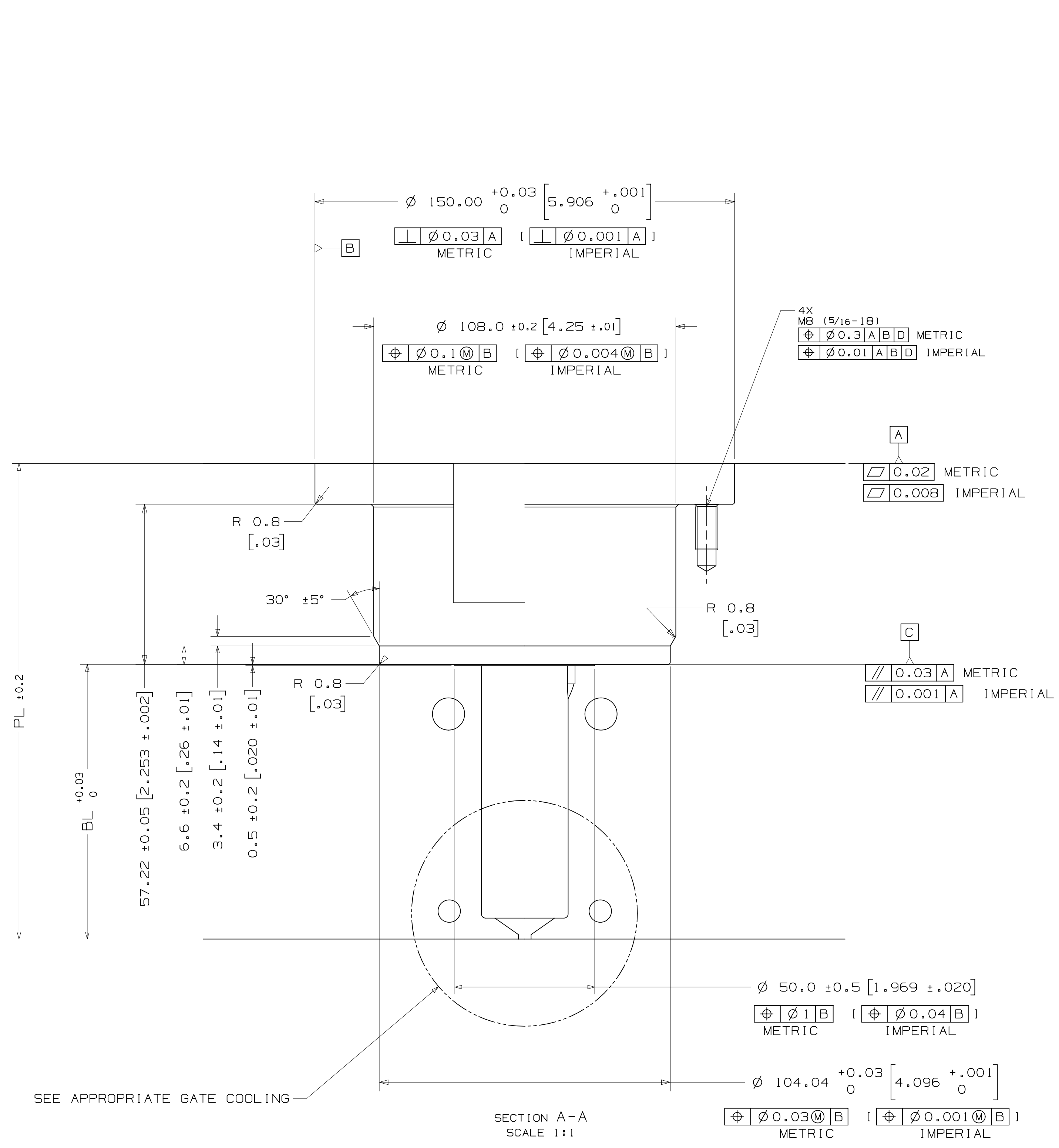
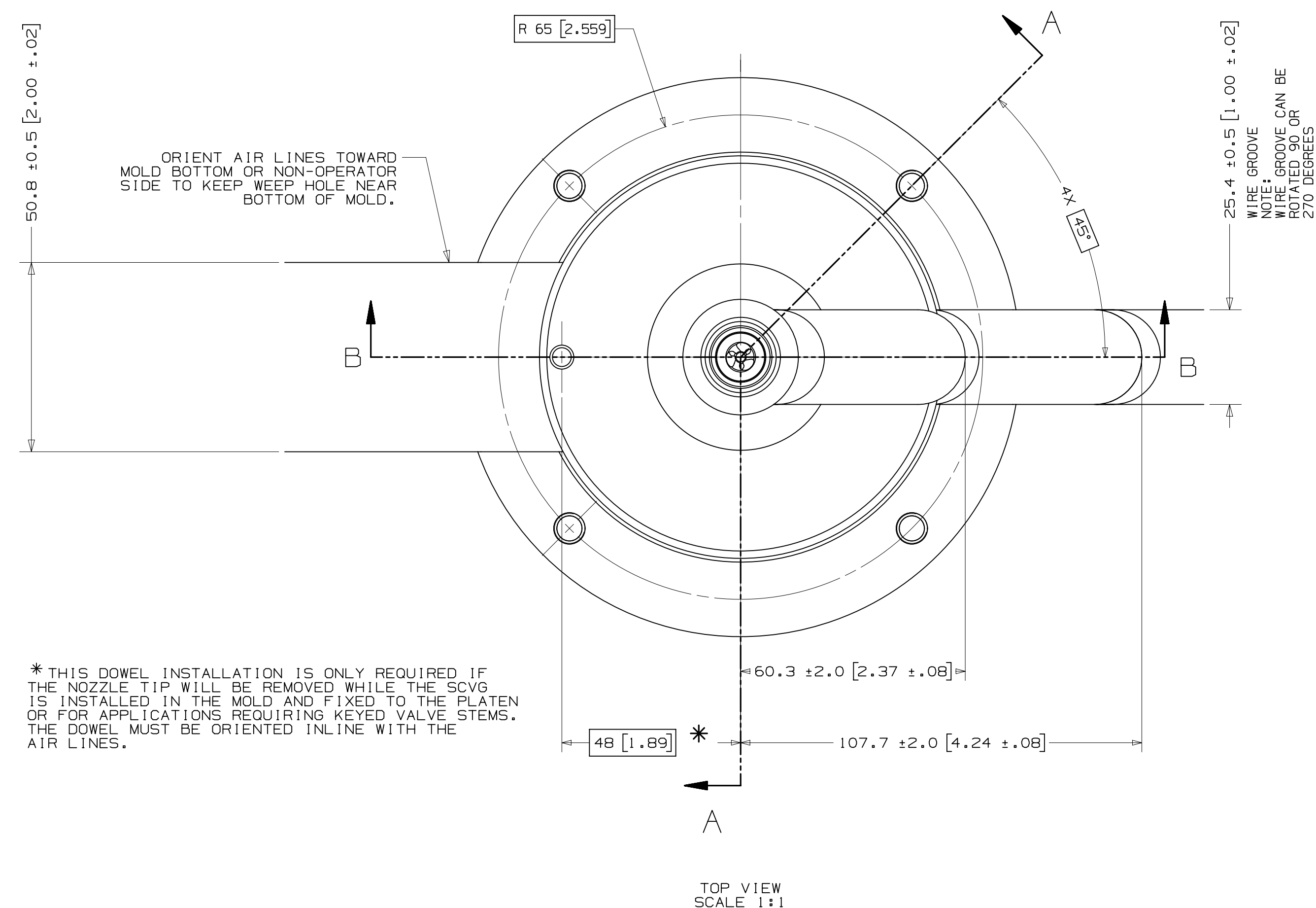


INSTALLATION DRAWING

REV 0
8090120



NOZZLE SERIES	NOZZLE TIP	PL RANGE	Approx. BL
U750	UH-V6	97.65 (3.844) - 258.01 (10.158)	29 (1.14) - 178 (7.03)

*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.

NOTE:
TIP PROTRUSION INTO CAVITY IN HOT CONDITION 0.1 mm

U750	SPRUE BUSHING	
	SEAL-OFF GEOMETRY SPHERICAL RADIUS	CHANNEL Ø IN - OUT
	FLAT	6.35 - 11.5
	FLAT	11.5-THRU
	SEAL-OFF 12.7 (1/2")	
	SEAL-OFF 15.5	
	SEAL-OFF 19.05 (3/4")	
	SEAL-OFF 20	
	SEAL-OFF 40	

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

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)

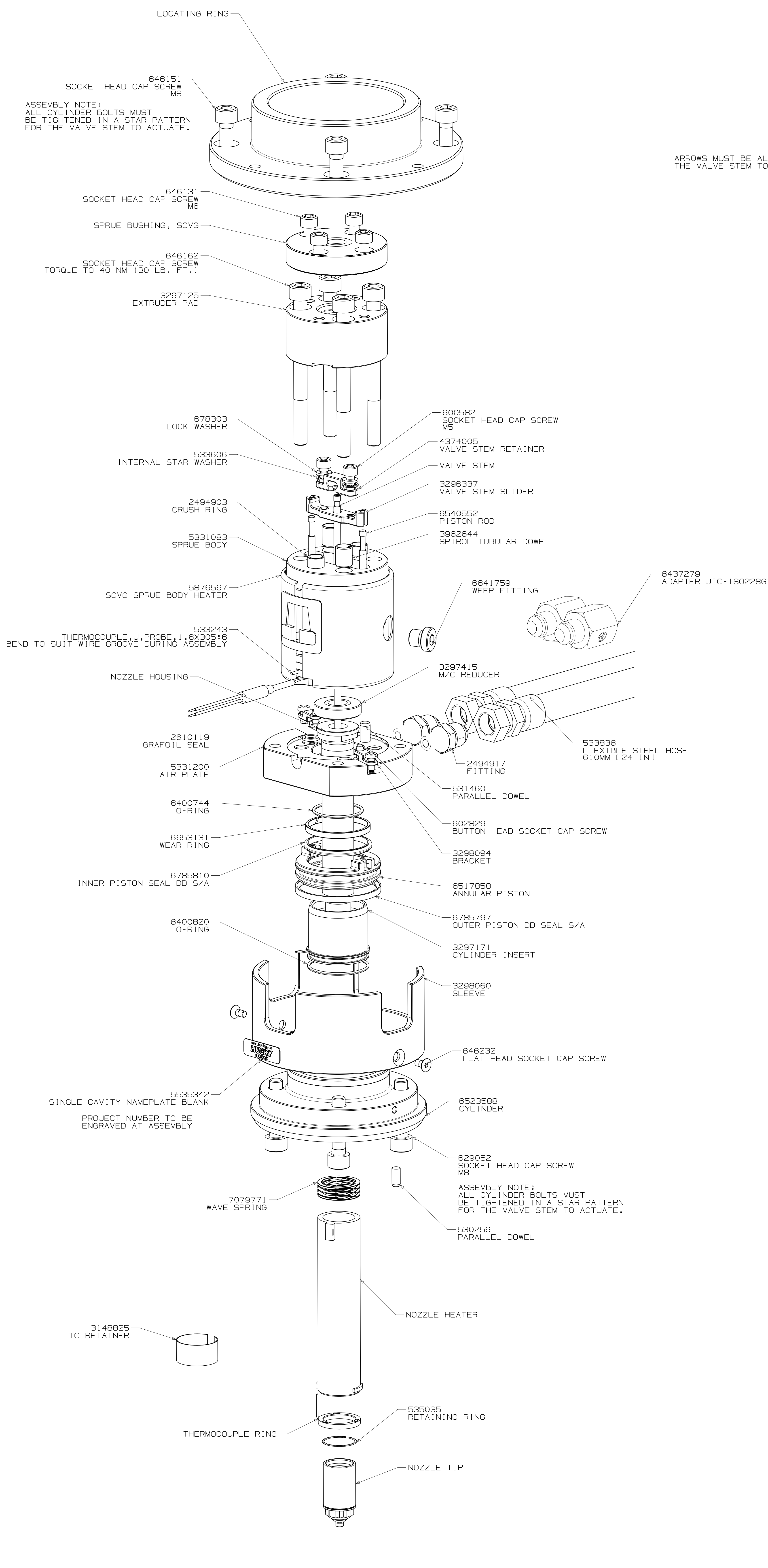
RECOMMENDED GATE MANUFACTURING GUIDELINES
- HARDENED GATE INSERTS (49-51) ARE RECOMMENDED WHEN USING SOFTER CAVITY STEELS. SOFTER CAVITIES MAY BE ACCEPTABLE FOR CERTAIN APPLICATIONS. CONTACT YOUR HUSKY REPRESENTATIVE WITH QUESTIONS.
- EDM'ING THE GATE AREA CAUSES MICRO CRACKS WHICH LEAD TO BRITTLE GATE 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	DRWNG	CHKD
5	2020-05-29	TABLE UPDATED PER LATEST CALCULATION	DRWNG DEEBAN N T	CHKD
4	2019-07-29	TIP PROTRUSION AND BL DIMENSIONS UPDATED	DRWNG DEEBAN N T	CHKD
3	2019-07-09	TEMPLATE VALUES UPDATED AS PER SOL 2.0	DRWNG MURALIDHARAN	CHKD
2	2018-04-05	DRAWING NAME CHANGE	DRWNG ANUSHAL	CHKD
0	2017-09-09	ORIGINAL ISSUE - DESIGNED BY: DHANANLEYAN	DRWNG DHANANLEYAN	CHKD: PICHLER KLAUS

<p>LAST PER ASME Y14.5M-1994 AND HEAVY ADDENDUM - H2004</p> <p>BASED ON THE SPEC OF THE MODEL IS BASIC</p> <p>NO TOLERANCED DIMENSIONS ARE BASIC</p> <p>GENERAL TOLERANCES: METRIC: [0.17] IMPERIAL: [0.027]</p> <p>BROKEN EDGE/CHAMFER: 1 ± 0.2 X 45° 0.04 ± 0.01 X 45°</p> <p>FILLET/RADIUS: R0.8 ± 0.2 R0.03 ± 0.01</p> <p>SURFACE FINISH: Ra 3.2</p>	<p>DEFINING DRAWING FEATURES</p> <p>MATERIAL: N/A</p> <p>FINISH/TREATMENT: [0.027]</p> <p>NO INTELLECTUAL PROPERTY RIGHTS ARE CLAIMED FOR THIS DRAWING. ALL RIGHTS RESERVED. COPYRIGHT © 2020 HUSKY</p>	<p>HUSKY</p> <p>TITLE: Single Cavity SCVG</p> <p>U750-SCVG-UH-V6</p> <p>SCALE: 1:1</p> <p>SHEET: 1 OF 2</p> <p>REV: 0</p>
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ASSEMBLY DRAWING

REV 0
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ARROWS MUST BE ALIGNED FOR THE VALVE STEM TO ACTUATE

ARROW VIEW
SCALE 1:2

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
#12	10	7
5/16	16	12
3/8	25	18
7/16	35	26
1/2	50	37
5/8	70	52
3/4	100	74
7/8	150	110
1	200	148
M4	4.6	3.4
M5	7.7	5.7
M6	11.6	8.5
M8	20	15
M10	30	22
M12	45	33
M14	70	52
M16	100	74
M20	180	133
M25	300	221

VALVE STEM STROKE IS 7.3 (.291)	
ELECTRICAL INFO (240 VAC)	
ZONE	ZONE DESCRIPTION
1	SPRUE BODY
2	NOZZLE TIP
T/C LEADS: WHITE = (+) RED = (-)	

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			CHKDI PICHLER KLAUS

DEFINED DRAWING FEATURES	METRIC	HUSKY
MATERIAL: N/A	SCALE: 1:1	TITLE: Single Cavity Valve Gate
FINISH/TREATMENT	SCALE: 1:1	SIZE: U750-SCVG-UH-VG
WEIGHT: - kg	SCALE: 2 OF 2	REV: 0
		8090120