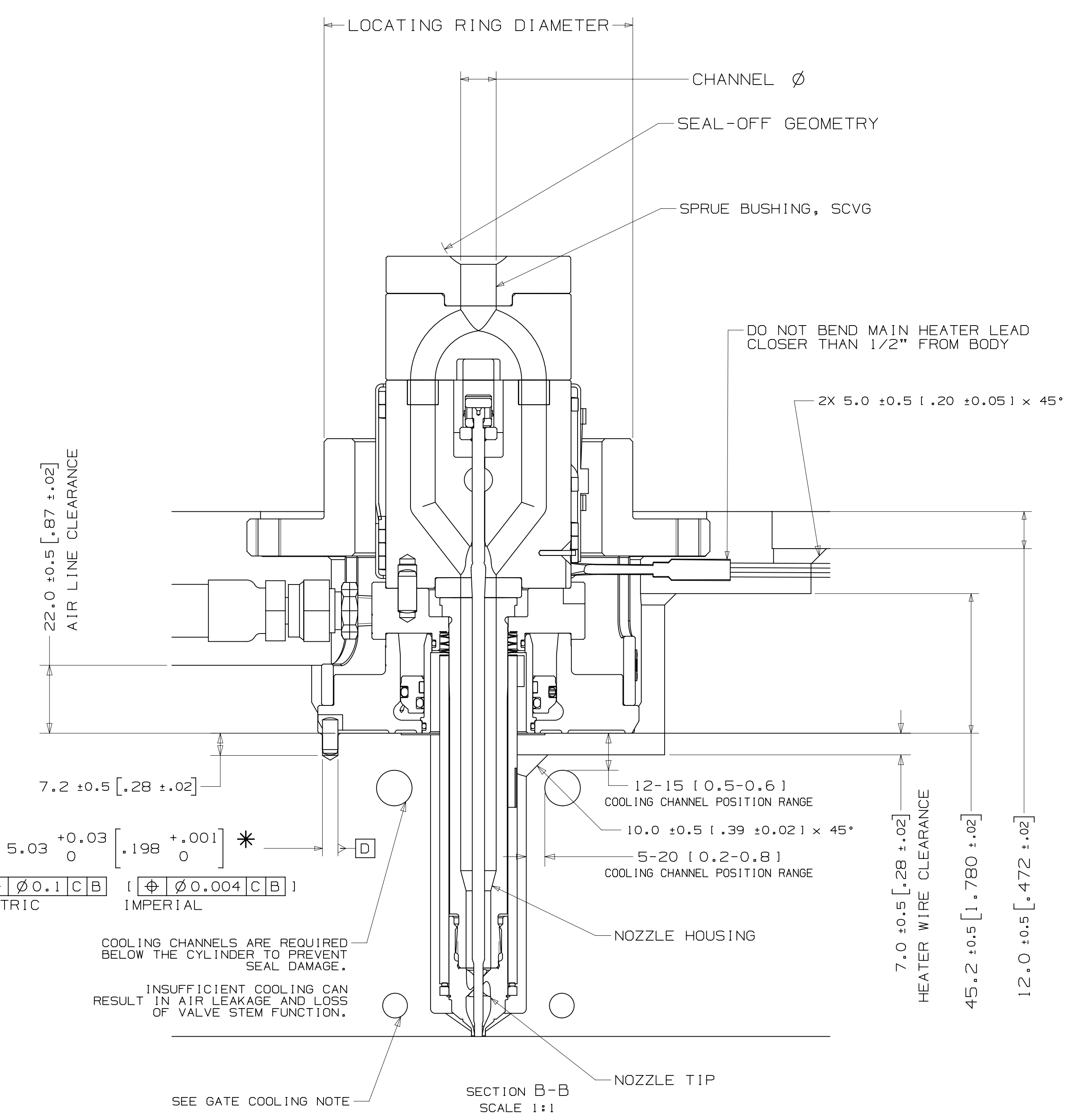
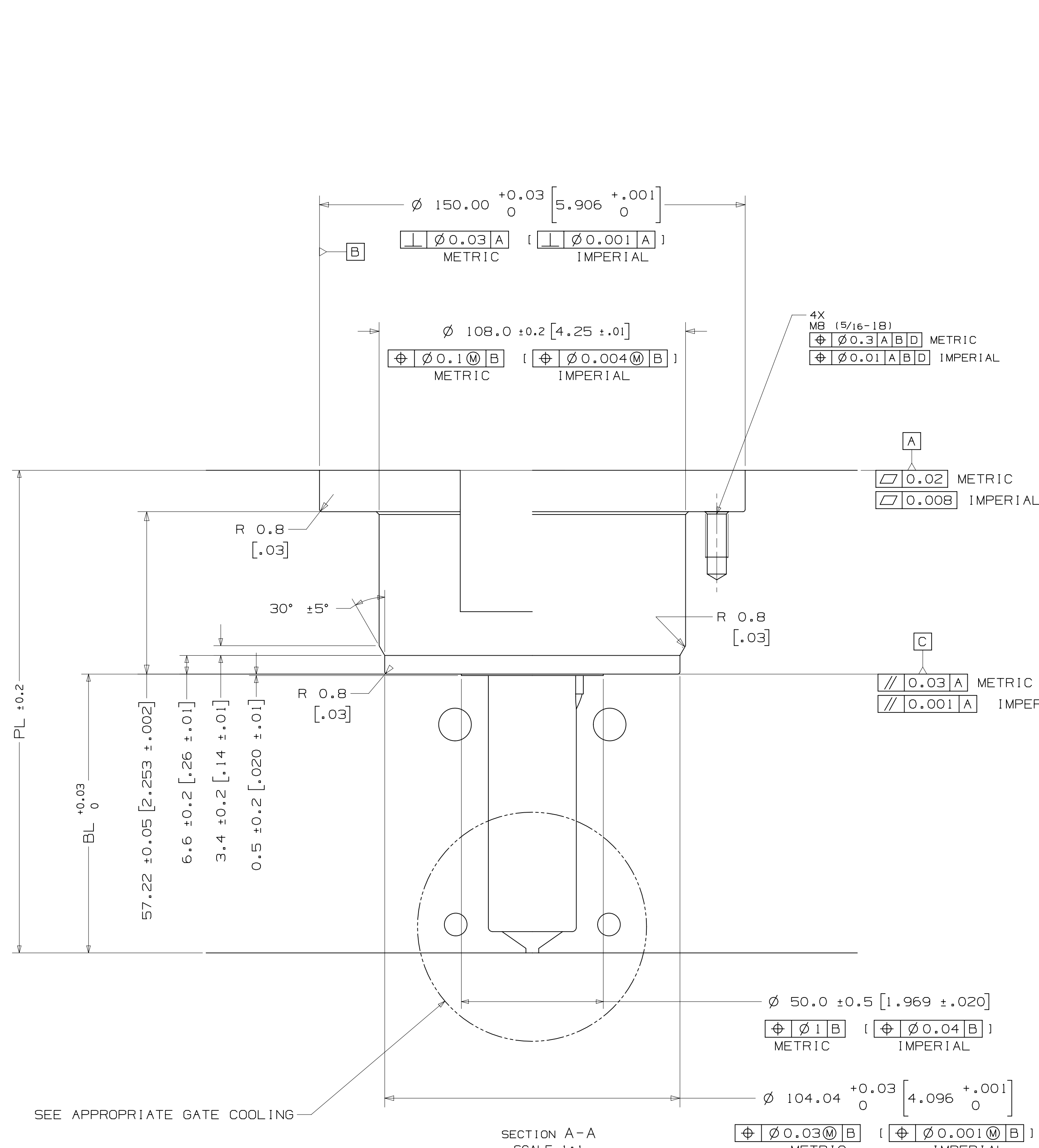
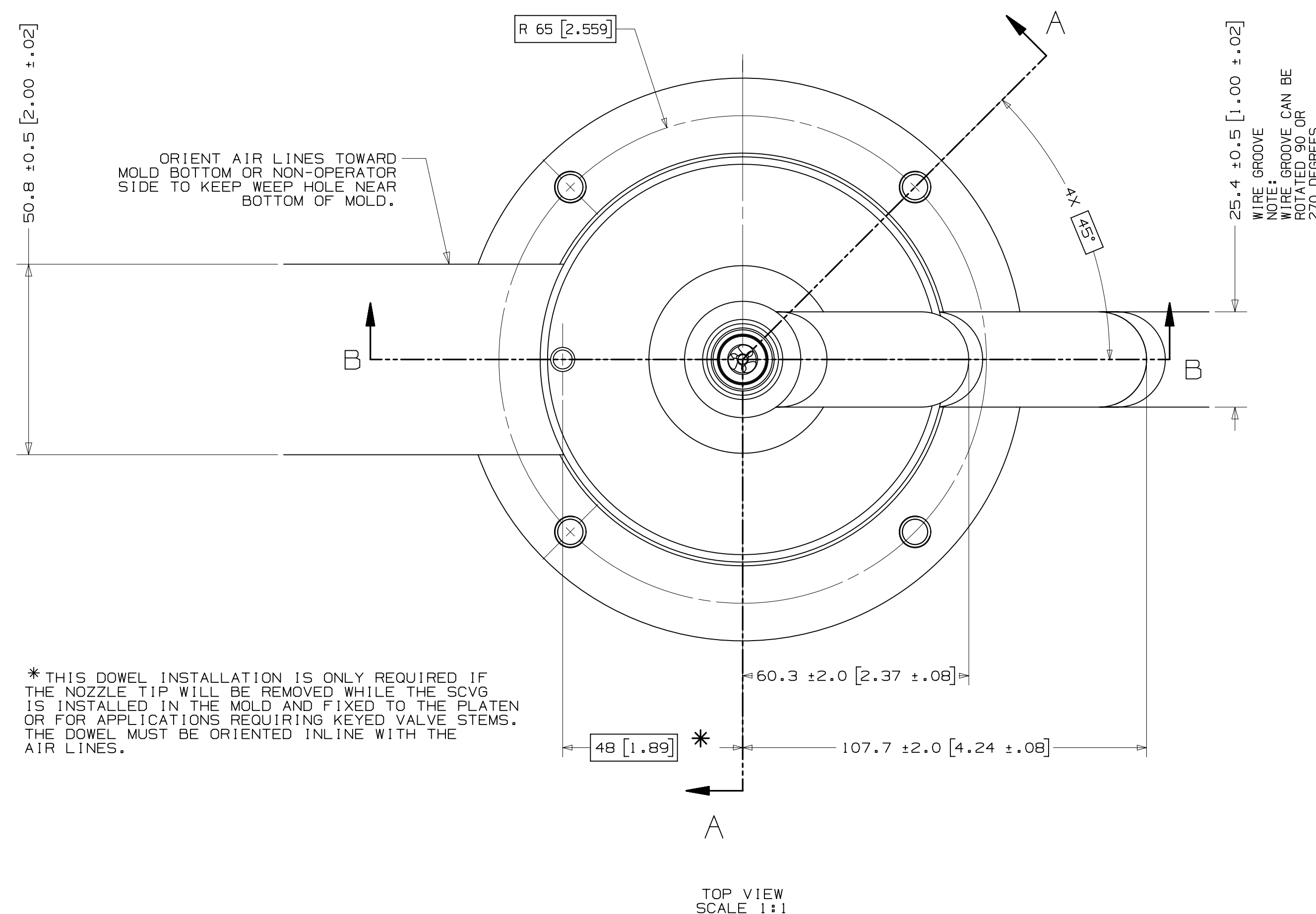


INSTALLATION DRAWING

REV 0
8090120



| NOZZLE SERIES | NOZZLE TIP | NOZZLE HOUSING | PL | | "BL" AT DELTA TEMP (DELTA TEMP = TEMP OF MELT - TEMP OF MOLD) * | | | | | | | | | | | | | | | | | | | |
|---------------|------------|----------------|----------------|-----------------|---|-----------------------------|-------------------------------|-------------------------------|-------------------------------|-------------------------------|-------------------------------|-------------------------------|-------------------------------|-------------------------------|-------------------------------|-------------------------------|--|--|--|--|--|--|--|--|
| | | | MIN INCH | MAX INCH | 60° C-79° C 140° F-174° F | 80° C-99° C 176° F-210° F | 100° C-119° C 212° F-246° F | 120° C-139° C 248° F-282° F | 140° C-159° C 284° F-318° F | 160° C-179° C 320° F-354° F | 180° C-199° C 356° F-390° F | 200° C-219° C 382° F-422° F | 220° C-239° C 422° F-462° F | 240° C-259° C 464° F-498° F | 260° C-279° C 500° F-534° F | 280° C-300° C 538° F-572° F | | | | | | | | |
| U750 | UH-VG | 50 | 97.73 3.848 | 106.75 4.203 | 27.96 1.101 | 27.97 1.101 | 27.98 1.102 | 28.00 1.102 | 28.01 1.103 | 28.02 1.103 | 28.04 1.104 | 28.05 1.104 | 28.06 1.105 | 28.08 1.106 | 28.09 1.106 | 28.11 1.107 | | | | | | | | |
| | | 60 | 107.75 4.242 | 116.77 4.597 | 37.97 1.495 | 37.98 1.495 | 38.00 1.496 | 38.01 1.496 | 38.03 1.497 | 38.04 1.498 | 38.06 1.498 | 38.07 1.499 | 38.09 1.500 | 38.11 1.501 | 38.13 1.502 | 38.14 1.502 | | | | | | | | |
| | | 70 | 117.77 4.637 | 126.79 4.992 | 47.98 1.889 | 47.99 1.889 | 48.01 1.890 | 48.03 1.891 | 48.04 1.891 | 48.06 1.892 | 48.08 1.893 | 48.10 1.894 | 48.12 1.894 | 48.14 1.895 | 48.16 1.896 | 48.18 1.897 | | | | | | | | |
| | | 80 | 127.79 5.031 | 136.82 5.387 | 57.98 2.283 | 58.00 2.283 | 58.02 2.284 | 58.04 2.285 | 58.06 2.286 | 58.08 2.287 | 58.10 2.287 | 58.12 2.288 | 58.14 2.289 | 58.17 2.290 | 58.19 2.291 | 58.21 2.292 | | | | | | | | |
| | | 90 | 137.82 5.426 | 146.84 5.781 | 67.99 2.677 | 68.01 2.678 | 68.03 2.678 | 68.06 2.680 | 68.08 2.680 | 68.10 2.681 | 68.12 2.682 | 68.15 2.683 | 68.17 2.684 | 68.20 2.685 | 68.22 2.686 | 68.25 2.687 | | | | | | | | |
| | | 100 | 147.84 5.820 | 156.86 6.176 | 78.00 3.071 | 78.02 3.072 | 78.05 3.073 | 78.07 3.074 | 78.10 3.075 | 78.12 3.076 | 78.15 3.077 | 78.17 3.078 | 78.20 3.079 | 78.22 3.080 | 78.26 3.081 | 78.28 3.082 | | | | | | | | |
| | | 110 | 157.86 6.215 | 166.88 6.570 | 88.01 3.465 | 88.03 3.466 | 88.06 3.467 | 88.09 3.468 | 88.11 3.469 | 88.14 3.470 | 88.17 3.471 | 88.20 3.472 | 88.23 3.474 | 88.25 3.474 | 88.29 3.476 | 88.32 3.477 | | | | | | | | |
| | | 120 | 167.88 6.609 | 176.90 6.965 | 98.01 3.859 | 98.04 3.860 | 98.07 3.861 | 98.10 3.862 | 98.13 3.863 | 98.16 3.865 | 98.19 3.866 | 98.22 3.867 | 98.25 3.868 | 98.28 3.869 | 98.32 3.871 | 98.35 3.872 | | | | | | | | |
| | | 130 | 177.90 7.004 | 186.92 7.359 | 108.02 4.253 | 108.05 4.254 | 108.08 4.255 | 108.12 4.257 | 108.15 4.258 | 108.18 4.259 | 108.21 4.260 | 108.25 4.262 | 108.28 4.263 | 108.31 4.264 | 108.35 4.266 | 108.39 4.267 | | | | | | | | |
| | | 140 | 187.92 7.398 | 196.94 7.754 | 118.03 4.647 | 118.06 4.648 | 118.10 4.650 | 118.13 4.651 | 118.16 4.652 | 118.20 4.654 | 118.23 4.655 | 118.27 4.656 | 118.31 4.658 | 118.34 4.659 | 118.38 4.661 | 118.42 4.662 | | | | | | | | |
| | | 150 | 197.94 7.793 | 206.96 8.148 | 128.04 5.041 | 128.07 5.042 | 128.11 5.044 | 128.14 5.045 | 128.18 5.046 | 128.22 5.048 | 128.26 5.050 | 128.30 5.051 | 128.33 5.052 | 128.37 5.054 | 128.42 5.056 | 128.46 5.057 | | | | | | | | |
| | | 160 | 207.96 8.187 | 216.98 8.543 | 138.05 5.435 | 138.08 5.436 | 138.12 5.438 | 138.16 5.439 | 138.20 5.441 | 138.24 5.443 | 138.28 5.444 | 138.32 5.446 | 138.36 5.447 | 138.40 5.449 | 138.45 5.451 | 138.49 5.452 | | | | | | | | |
| | | 170 | 217.98 8.582 | 227.00 8.937 | 148.05 5.829 | 148.09 5.830 | 148.13 5.832 | 148.17 5.833 | 148.22 5.835 | 148.26 5.837 | 148.30 5.839 | 148.34 5.840 | 148.39 5.842 | 148.43 5.844 | 148.48 5.846 | 148.53 5.848 | | | | | | | | |
| | | 180 | 228.00 8.976 | 237.03 9.332 | 158.06 6.223 | 158.10 6.224 | 158.15 6.226 | 158.19 6.228 | 158.23 6.230 | 158.28 6.231 | 158.32 6.233 | 158.37 6.235 | 158.41 6.237 | 158.46 6.239 | 158.51 6.241 | 158.56 6.243 | | | | | | | | |
| | | 190 | 238.03 9.371 | 247.05 9.726 | 168.07 6.617 | 168.11 6.619 | 168.16 6.620 | 168.20 6.622 | 168.25 6.624 | 168.30 6.626 | 168.34 6.628 | 168.39 6.630 | 168.44 6.631 | 168.49 6.633 | 168.55 6.636 | 168.60 6.638 | | | | | | | | |
| | | 200 | 248.05 9.766 | 258.08 10.121 | 178.08 7.011 | 178.12 7.013 | 178.17 7.015 | 178.22 7.017 | 178.27 7.019 | 178.32 7.020 | 178.37 7.022 | 178.42 7.024 | 178.47 7.026 | 178.52 7.028 | 178.58 7.031 | 178.63 7.033 | | | | | | | | |

* BL VALUES IN THE TABLE ARE REFERENCES WHICH CAN DEVIATE BY +/-0.03mm
FINAL BL VALUE CAN BE FOUND ON GATE DETAIL DRAWING AND 3D AFTER FINISHED DESIGN.

NOTE:
TIP PROTRUSION INTO CAVITY IN HOT CONDITION 0.2 mm

| LOCATING RING DIAMETER | | SPRUE BUSHING | |
|------------------------|------------------------|------------------------------------|--------------------|
| U750 | LOCATING RING DIAMETER | SEAL-OFF GEOMETRY SPHERICAL RADIUS | CHANNEL Ø IN - OUT |
| U750 | 100mm | FLAT | 6.35 - 11.5 |
| | 101.3mm 3.99" | FLAT | |
| | 125mm | 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
A1S1 H13 | 49-51 Rc1
A1S1 420 | 49-51 Rc1

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. SORTENS THE AREA AROUND THE WELD AND CAN CAUSE GATE FAILURES.

| | | | | |
|----|------------|--|--|------------------|
| 0 | 2017-09-09 | ORIGINAL ISSUE - DESIGNED BY DHANALEKIAN | DRWN: DHANALEKIAN CHKD: DHANALEKIAN | DATE: 09-09-2017 |
| 1 | | | | |
| 2 | | | | |
| 3 | | | | |
| 4 | | | | |
| 5 | | | | |
| 6 | | | | |
| 7 | | | | |
| 8 | | | | |
| 9 | | | | |
| 10 | | | | |
| 11 | | | | |
| 12 | | | | |

UNFINISHED DRAWING FEATURES
NO FINISH SPECIFIED UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN MILLIMETERS UNLESS OTHERWISE SPECIFIED
GENERAL TOLERANCES: METRIC: 0.15-0.30 | IMPERIAL: 0.004-0.012

BRKWN EDGE/CHAMFER: R0.5 x 45° | 0.04 x 0.01 x 45°
FILLET/RADIUS: R0.8 ± 0.2 | R0.03 ± 0.01
SURFACE FINISH: Ra 3.2

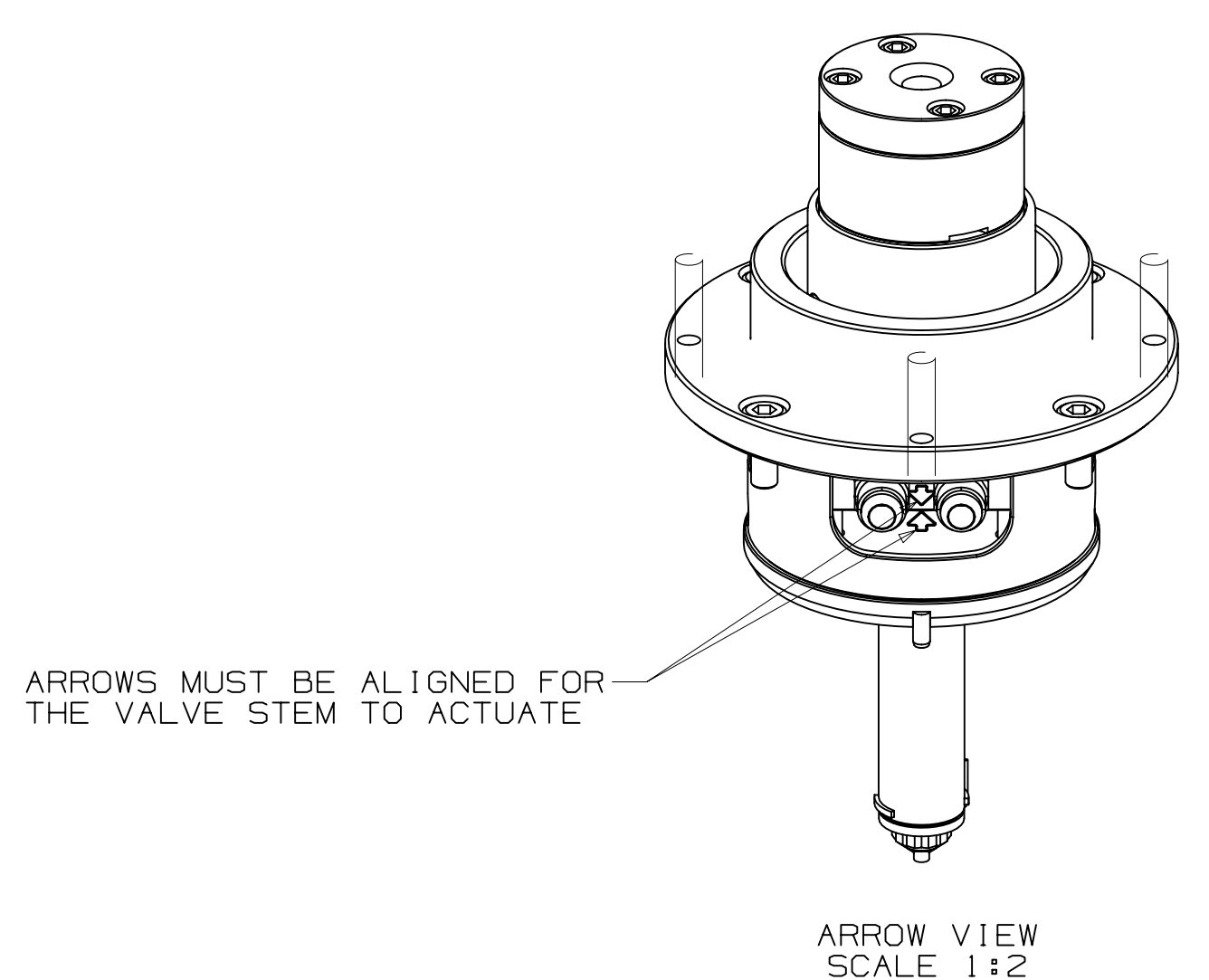
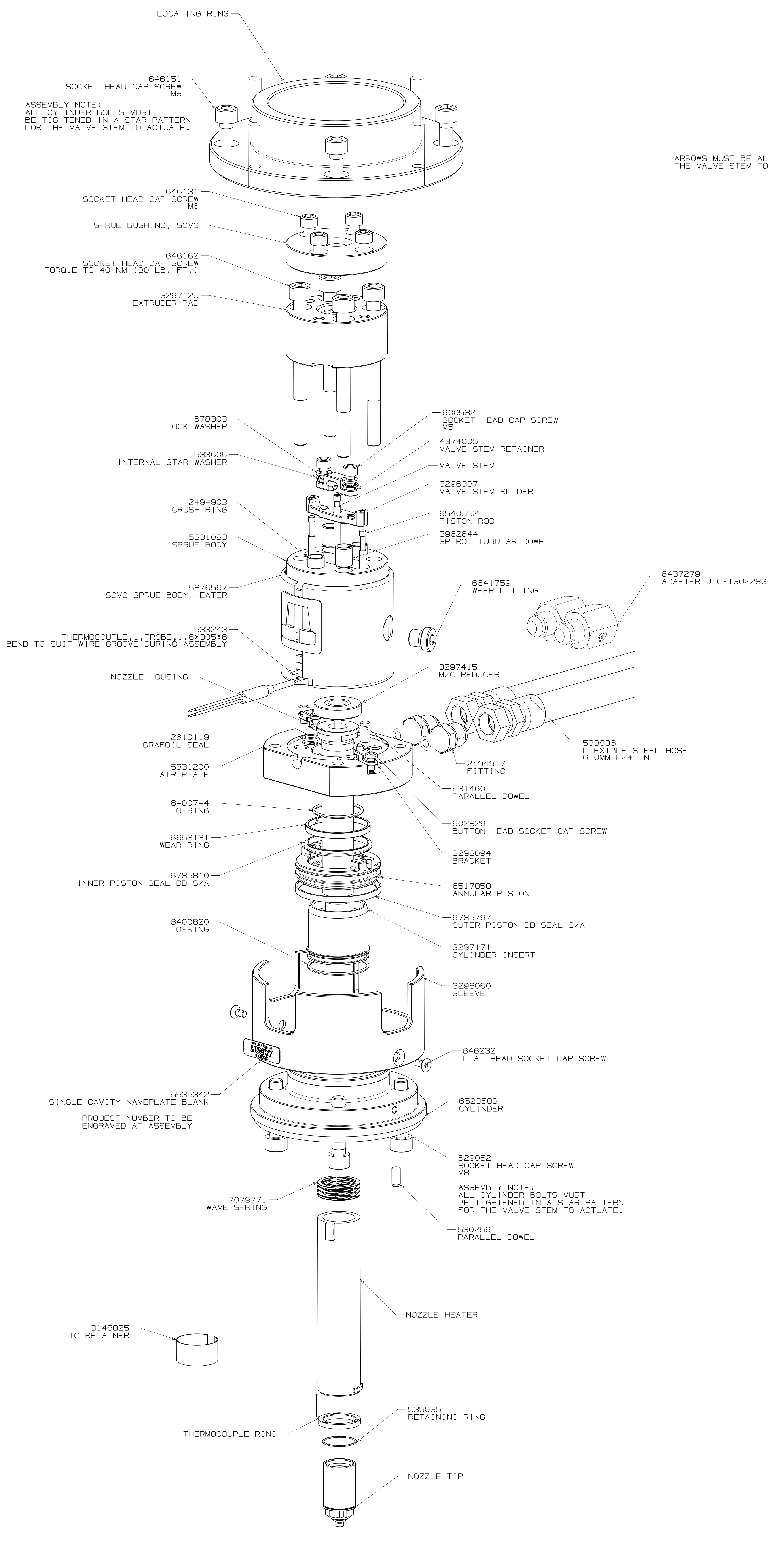
WEIGHT: - kg

DATE: 09-09-2017
DRAWING: 8090120
SHEET: 1 OF 2

HUSKY
TITLE: SCVG
Single Cavity Valve Gate
U750-SCVG-UH-VG

ASSEMBLY DRAWING

REV 0
8090120



| 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 | 16 | 12 |
| 5/16 | 25 | 18 |
| 3/8 | 35 | 26 |
| 7/16 | 50 | 37 |
| 1/2 | 70 | 52 |
| 5/8 | 100 | 74 |
| 3/4 | 150 | 110 |
| 7/8 | 200 | 148 |
| 1 | 250 | 184 |
| M4 | 4.6 | 3.4 |
| M5 | 9.1 | 7.1 |
| M6 | 16 | 12 |
| M8 | 39 | 29 |
| M10 | 77 | 57 |
| M12 | 135 | 100 |
| M14 | 215 | 160 |
| M16 | 350 | 258 |
| M20 | 650 | 480 |
| M25 | 1100 | 810 |

| 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 = (-) | |

RECOMMENDED GATE COOLING GUIDELINES
ADEQUATE COOLING IS ESSENTIAL FOR THE PROPER FUNCTION OF THIS SYSTEM. REFER TO THE HOT RUNNER PRODUCT GUIDE www.husky.ca FOR MORE DETAILED GUIDELINES.

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 | NAME |
|-----|------------|---|---------------------|
| 0 | 2017-09-09 | ORIGINAL ISSUE - DESIGNED BY DHANALEYAN | DHANI DHANALEYAN |
| | | | DIWIK PICHLER KLAUS |

| | | |
|---------------------------|------------------|--------------------------------------|
| DEFINING DRAWING FEATURES | METRIC | HUSKY |
| MATERIAL: N/A | FINISH/TREATMENT | TITLE: Single Cavity SCVG Valve Gate |
| WEIGHT: - kg | SCALE: 1:1 | SIZE: AOR |
| | SHEET 2 OF 2 | REV: 0 |