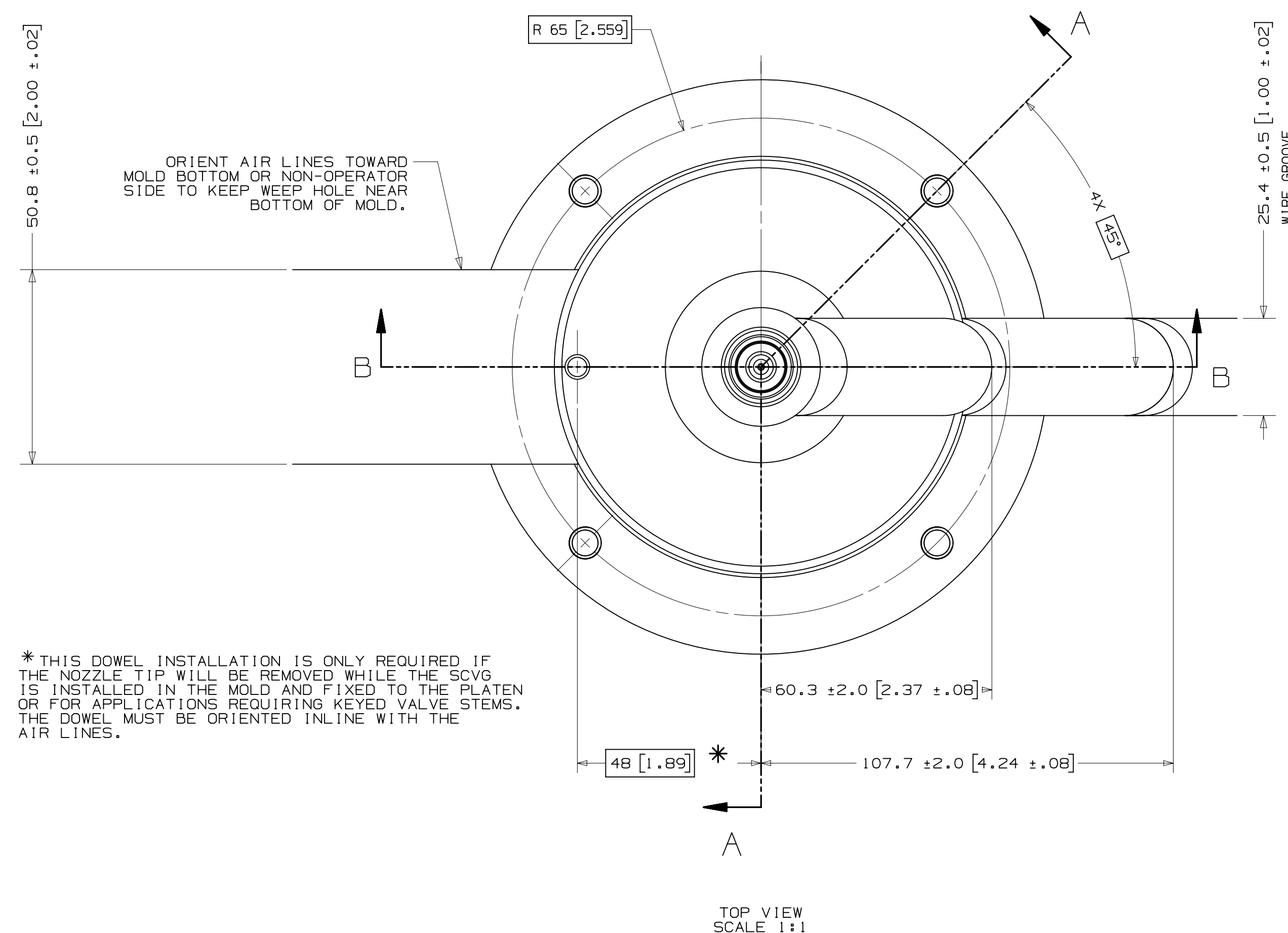


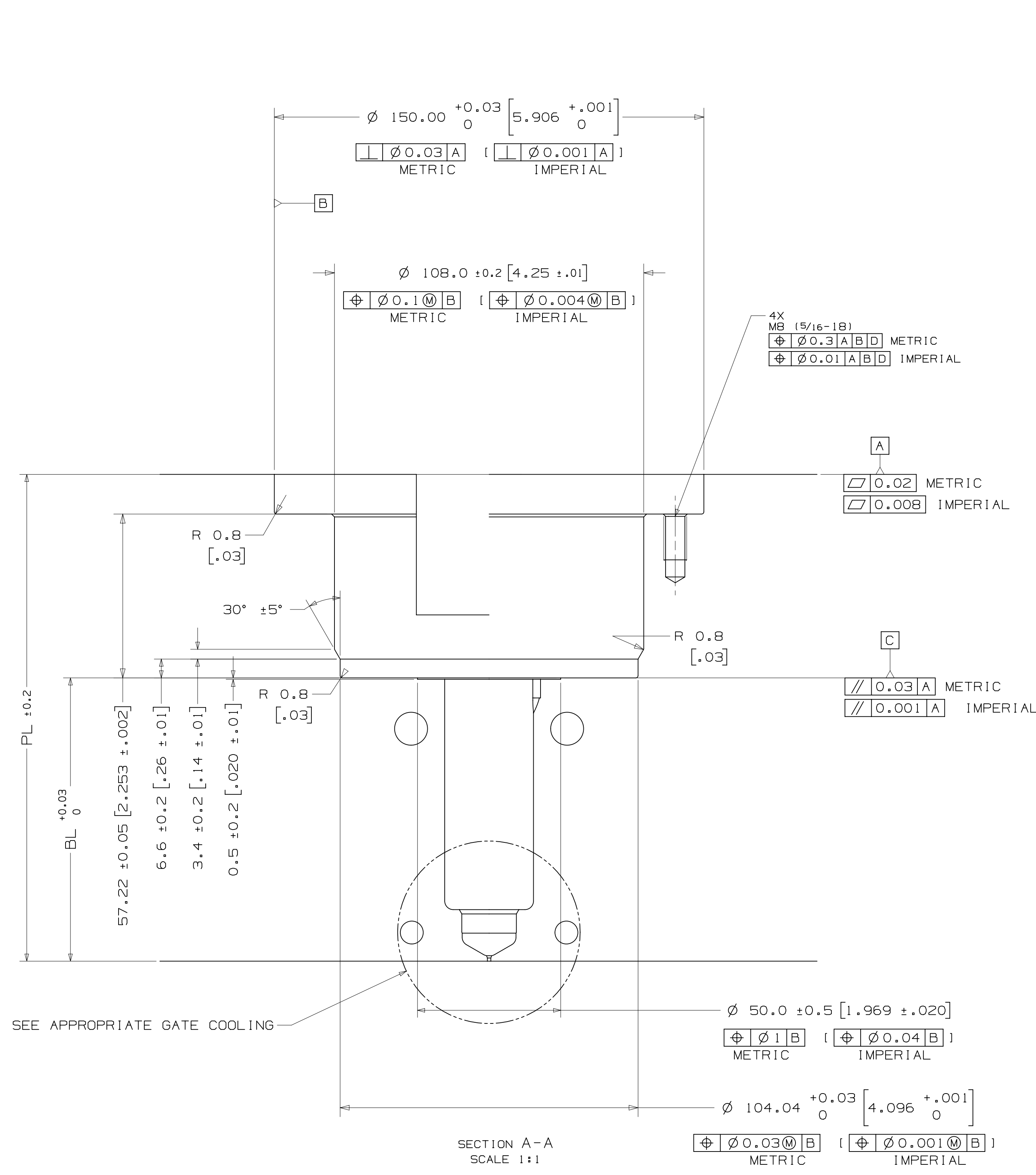
INSTALLATION DRAWING

REV: 0
STATUS: 8333283

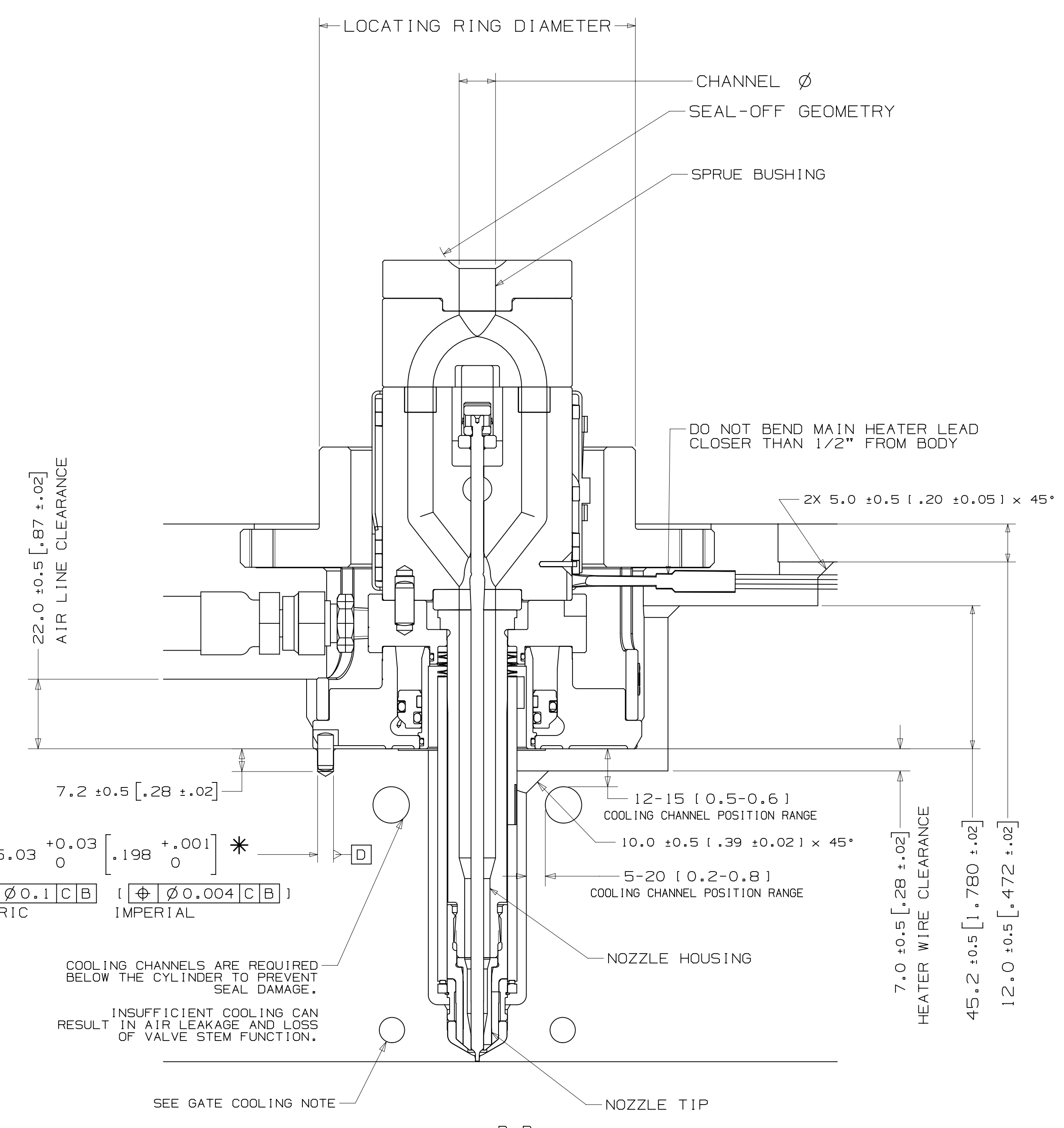


* THIS DOWEL INSTALLATION IS ONLY REQUIRED IF THE NOZZLE TIP WILL BE REMOVED WHILE THE SCVGS IS INSTALLED IN THE MOLD AND FIXED TO THE PLATEN OR FOR APPLICATIONS REQUIRING KEYS VALVE STEMS. THE DOWEL MUST BE ORIENTED IN LINE WITH THE AIR LINES.

TOP VIEW SCALE 1:1



SECTION A-A SCALE 1:1



SECTION B-B SCALE 1:1

NOZZLE SERIES	NOZZLE TIP	NOZZLE HOUSING		PL		*BL" AT DELTA TEMP (DELTA TEMP = TEMP OF MELT - TEMP OF MOLD) *															
		LENGTH	MIN [INCH]	MAX [INCH]	60° C-79° C [140° F-171° 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-319° F]	160° C-179° C [320° F-354° F]	180° C-199° C [356° F-390° F]	200° C-219° C [392° F-426° F]	220° C-239° C [428° F-462° F]	240° C-259° C [464° F-498° F]	260° C-279° C [500° F-534° F]	280° C-300° C [536° F-572° F]					
U750	VG-PKG	50	108 [4.252]	117 [4.606]	38.66 [1.522]	38.68 [1.523]	38.7 [1.524]	38.72 [1.524]	38.73 [1.524]	38.75 [1.526]	38.76 [1.526]	38.78 [1.527]	38.79 [1.527]	38.81 [1.528]	38.83 [1.529]	38.83 [1.529]					
		60	118 [4.646]	127 [5.000]	48.67 [1.916]	48.69 [1.917]	48.7 [1.917]	48.72 [1.918]	48.74 [1.919]	48.75 [1.919]	48.77 [1.920]	48.79 [1.921]	48.8 [1.921]	48.82 [1.922]	48.84 [1.923]	48.86 [1.924]					
		70	128 [5.039]	137 [5.394]	58.68 [2.310]	58.7 [2.311]	58.72 [2.312]	58.73 [2.312]	58.75 [2.313]	58.77 [2.314]	58.79 [2.315]	58.81 [2.315]	58.83 [2.316]	58.85 [2.317]	58.88 [2.318]	58.9 [2.319]					
		80	138 [5.433]	147 [5.787]	68.69 [2.704]	68.71 [2.705]	68.73 [2.706]	68.75 [2.707]	68.77 [2.707]	68.79 [2.708]	68.81 [2.709]	68.84 [2.710]	68.86 [2.711]	68.88 [2.712]	68.91 [2.713]	68.93 [2.714]					
		90	148 [5.827]	157 [6.181]	78.69 [3.098]	78.72 [3.099]	78.74 [3.100]	78.76 [3.101]	78.79 [3.102]	78.81 [3.103]	78.84 [3.104]	78.86 [3.105]	78.89 [3.106]	78.91 [3.107]	78.94 [3.108]	78.97 [3.109]					
		100	158 [6.220]	167 [6.575]	88.7 [3.492]	88.73 [3.493]	88.75 [3.494]	88.78 [3.495]	88.8 [3.496]	88.83 [3.497]	88.86 [3.498]	88.89 [3.500]	88.91 [3.500]	88.94 [3.502]	88.97 [3.503]	89 [3.504]					
		110	168 [6.614]	177 [6.969]	98.71 [3.886]	98.74 [3.887]	98.76 [3.888]	98.79 [3.889]	98.82 [3.891]	98.85 [3.892]	98.88 [3.893]	98.91 [3.894]	98.94 [3.895]	98.97 [3.896]	99.01 [3.898]	99.04 [3.899]					
		120	178 [7.008]	187 [7.362]	108.72 [4.280]	108.75 [4.281]	108.78 [4.283]	108.81 [4.284]	108.84 [4.285]	108.87 [4.286]	108.9 [4.287]	108.93 [4.289]	108.97 [4.290]	109 [4.291]	109.04 [4.293]	109.07 [4.294]					
		130	188 [7.402]	197 [7.756]	118.73 [4.674]	118.76 [4.676]	118.79 [4.677]	118.82 [4.679]	118.86 [4.680]	118.89 [4.681]	118.92 [4.682]	118.96 [4.685]	118.99 [4.686]	119.03 [4.688]	119.07 [4.689]	119.11 [4.689]					
		140	198 [7.795]	207 [8.150]	128.73 [5.068]	128.77 [5.070]	128.8 [5.071]	128.84 [5.072]	128.87 [5.074]	128.91 [5.075]	128.95 [5.077]	128.98 [5.078]	129.02 [5.080]	129.06 [5.081]	129.1 [5.083]	129.14 [5.084]					
		150	208 [8.189]	217 [8.543]	138.74 [5.462]	138.78 [5.464]	138.81 [5.465]	138.85 [5.467]	138.89 [5.468]	138.93 [5.470]	138.97 [5.471]	139.01 [5.473]	139.05 [5.474]	139.09 [5.476]	139.14 [5.478]	139.18 [5.480]					
		160	218 [8.583]	227 [8.937]	148.75 [5.856]	148.79 [5.858]	148.83 [5.859]	148.87 [5.861]	148.91 [5.863]	148.95 [5.864]	148.99 [5.866]	149.03 [5.867]	149.07 [5.869]	149.12 [5.871]	149.17 [5.873]	149.21 [5.874]					
		170	228 [8.976]	237 [9.331]	158.76 [6.250]	158.8 [6.252]	158.84 [6.254]	158.88 [6.255]	158.92 [6.257]	158.97 [6.259]	159.01 [6.260]	159.06 [6.262]	159.1 [6.264]	159.15 [6.266]	159.2 [6.268]	159.25 [6.270]					
180	238 [9.370]	247 [9.724]	168.76 [6.644]	168.81 [6.646]	168.85 [6.648]	168.9 [6.650]	168.94 [6.651]	168.99 [6.653]	169.03 [6.655]	169.08 [6.657]	169.13 [6.659]	169.18 [6.661]	169.23 [6.663]	169.28 [6.665]							
190	248 [9.764]	257 [10.118]	178.77 [7.038]	178.82 [7.040]	178.86 [7.042]	178.91 [7.044]	178.96 [7.046]	179.01 [7.048]	179.06 [7.050]	179.11 [7.052]	179.16 [7.054]	179.21 [7.056]	179.27 [7.058]	179.32 [7.060]							
200	258 [10.157]	268 [10.551]	188.78 [7.432]	188.83 [7.434]	188.88 [7.436]	188.93 [7.438]	188.98 [7.440]	189.03 [7.442]	189.08 [7.444]	189.13 [7.446]	189.18 [7.448]	189.24 [7.450]	189.3 [7.453]	189.35 [7.455]							

* 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.

U750	LOCATING RING DIAMETER	SPRUE BUSHING	
		SEAL-OFF GEOMETRY SPHERICAL RADIUS	CHANNEL Ø IN - OUT
100mm	101.3mm [3.99"]	FLAT	6.35 - 11.5
		FLAT	11.5-THRU
125mm		SEAL-OFF 12.7 [1/2"]	11.5-THRU
		SEAL-OFF 15.5	
		SEAL-OFF 19.05 [3/4"]	
		SEAL-OFF 20	

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]

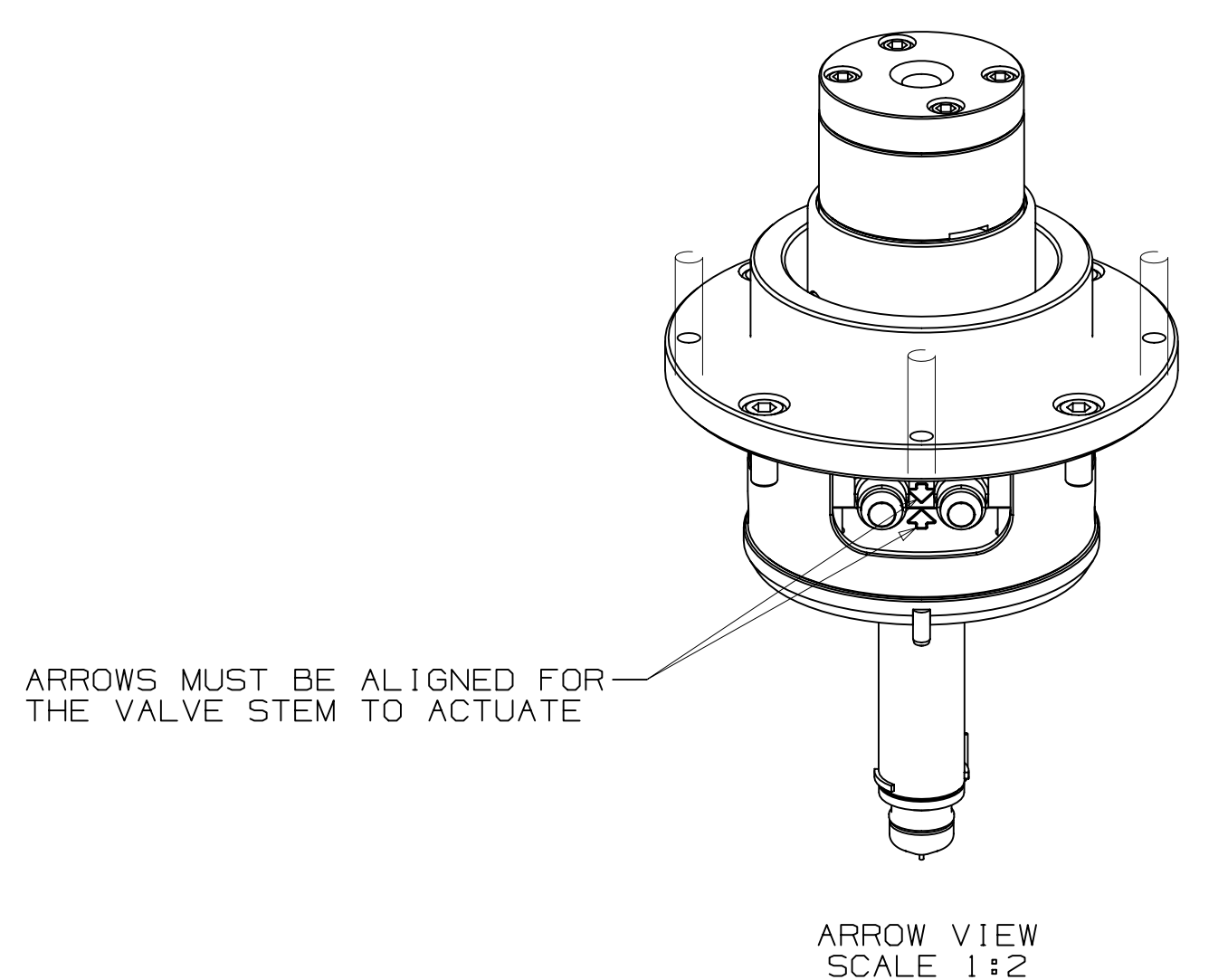
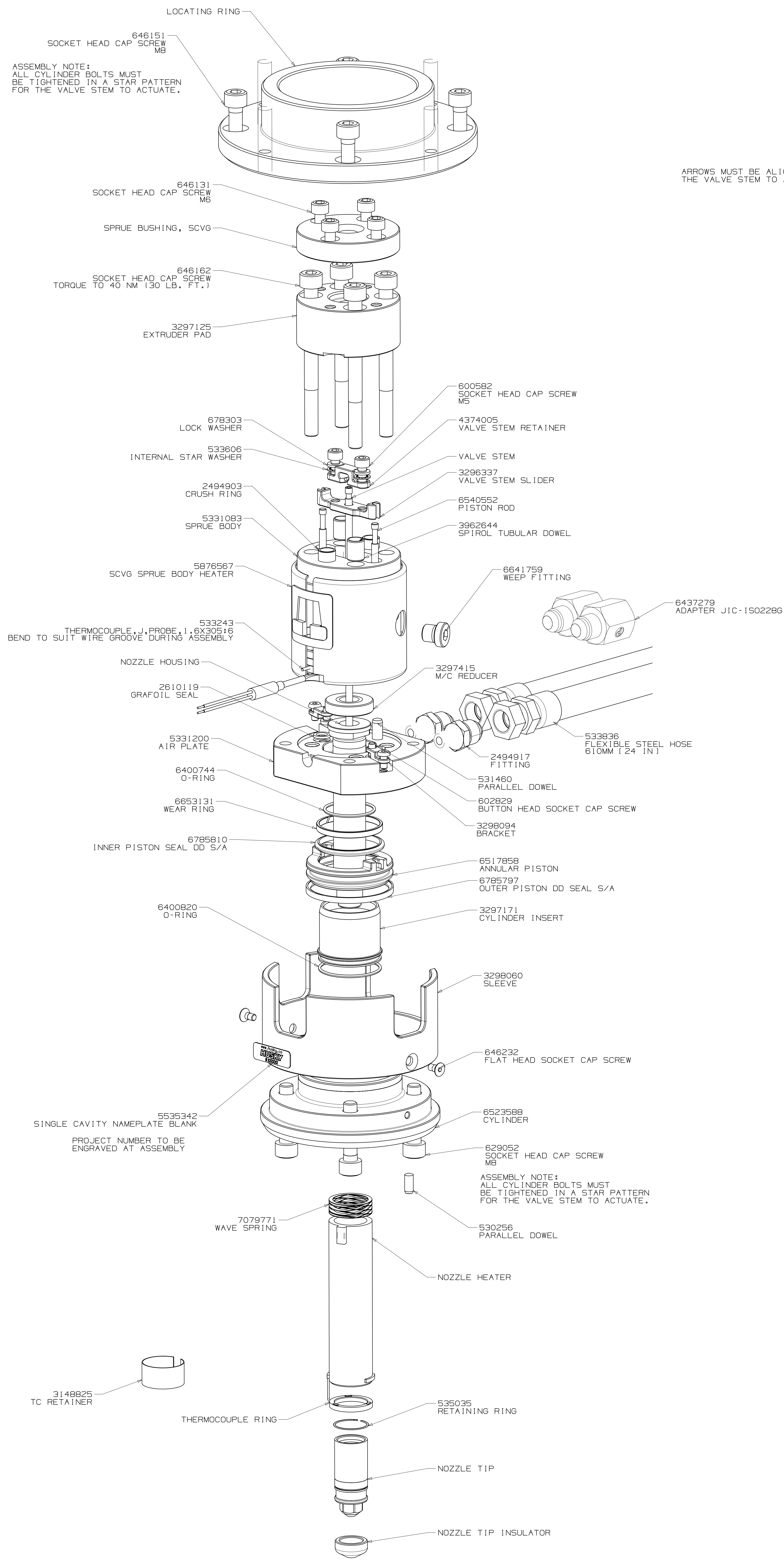
RECOMMENDED GATE MANUFACTURING GUIDELINES
- HARDENED GATE INSERTS (49-51) ARE RECOMMENDED WHEN USING SOFTER CAVITY STEELS. SOFTER CAVITIES MAY BE ACCEPTABLE FOR CERTAIN APPLICATIONS. CONTACT YOUR HUSKY REPRESENTATIVE WITH QUESTIONS.
- EDM'ING THE GATE HOLE CAUSES MICRO CRACKS WHICH LEAD TO BRITTLE GATE 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
0	2017-12-19	ORIGINAL ISSUE - DESIGNED BY: DHANANLEYAN

DWT PER ASME Y14.5M-1994 AND HEAVY ADDENDUM - H254 UNLESS OTHERWISE SPECIFIED: DIMENSIONS UNLESS OTHERWISE SPECIFIED ARE IN MILLIMETERS. DIMENSIONS IN PARENTHESES ARE IN INCHES. DIMENSIONS IN BRACKETS ARE IN MILLIMETERS. DIMENSIONS IN SQUARE BRACKETS ARE IN INCHES. DIMENSIONS IN CIRCLES ARE IN MILLIMETERS. DIMENSIONS IN DIAMETERS ARE IN MILLIMETERS. DIMENSIONS IN SQUARE BRACKETS ARE IN INCHES. DIMENSIONS IN CIRCLES ARE IN MILLIMETERS. DIMENSIONS IN DIAMETERS ARE IN MILLIMETERS.	FINISH/TREATMENT R0.8 ± 0.2 R0.03 ± 0.01 SURFACE FINISH: R0.8 ± 0.2 R0.03 ± 0.01	METRIC HUSKY TITLE: SCVG Single Cavity Valve Gate U750_SCVG_V6_PKG SCALE: 1:1 SHEET: 1 OF 2 AOR: 8333283 REV: 0
--	--	---

ASSEMBLY DRAWING

REV 0
8333283



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	26
7/16	50	37
1/2	70	52
5/8	100	74
3/4	150	110
7/8	200	148
1	250	184
1 1/8	350	257
1 1/4	450	331
M4	4.6	3.4
M5	8.1	6.0
M6	11.6	8.5
M8	20.4	15.1
M10	39	28.7
M12	58	42.8
M14	87	64.1
M16	135	100
M20	215	159
M25	350	257
M30	500	368
M36	770	565
M42	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 FOR MORE DETAILED GUIDELINES.
www.husky.ca

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	2017-12-19	ORIGINAL ISSUE - DESIGNED BY DHANALEYAN	DHANI DHANALEYAN
			DRWNG: DHANALEYAN
			CHKD: PICHLER KLAUS

DEFINING DRAWING FEATURES	METRIC	HUSKY
MATERIAL: N/A	SCALE: 1:1	TITLE: SCVG
FINISH/TREATMENT	SIZE: AOR	Single Cavity Valve Gate
WEIGHT: - kg	SHEET 2 OF 2	UT50_SCVG_V6_PKG
		8333283
		0