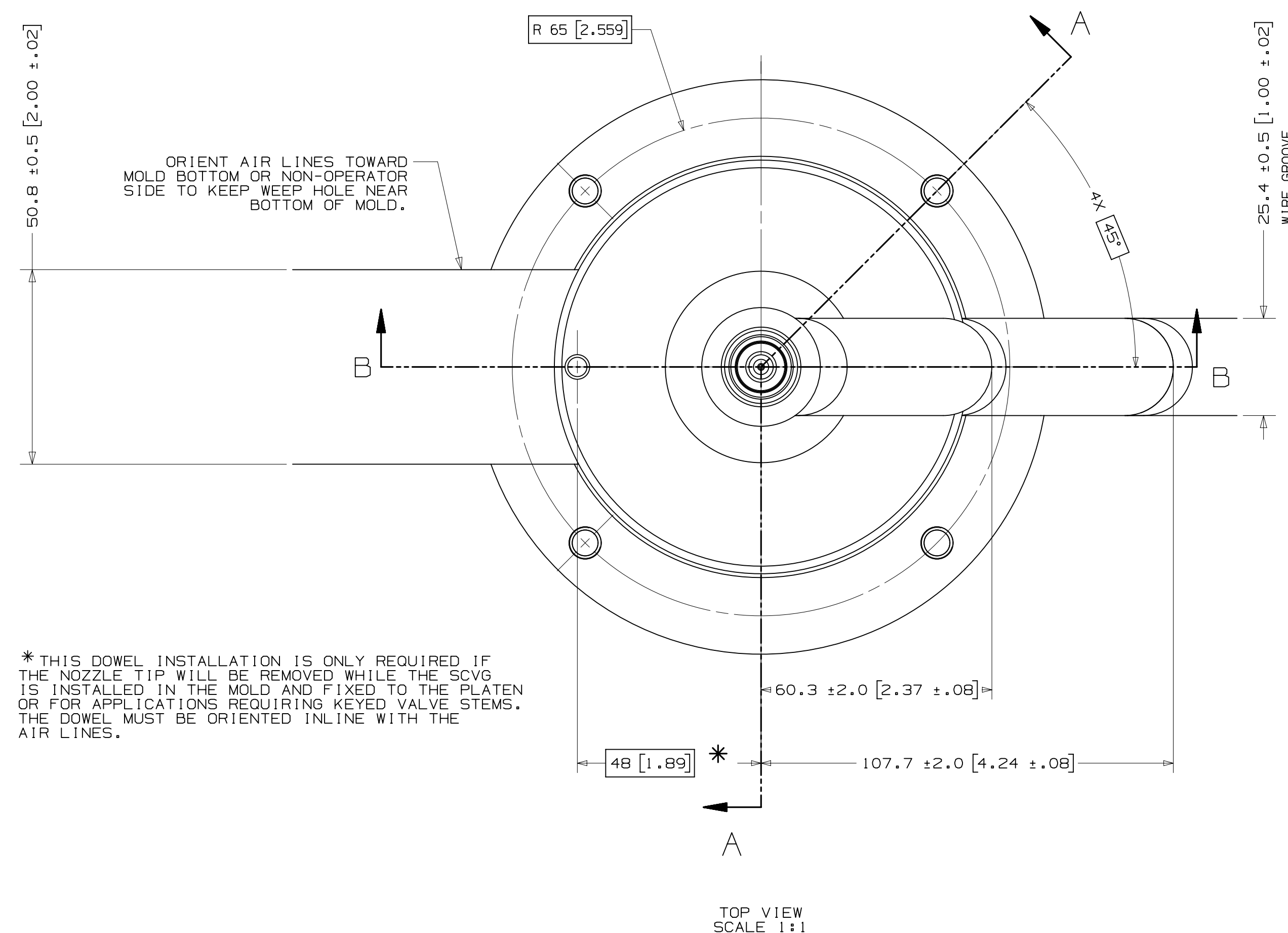
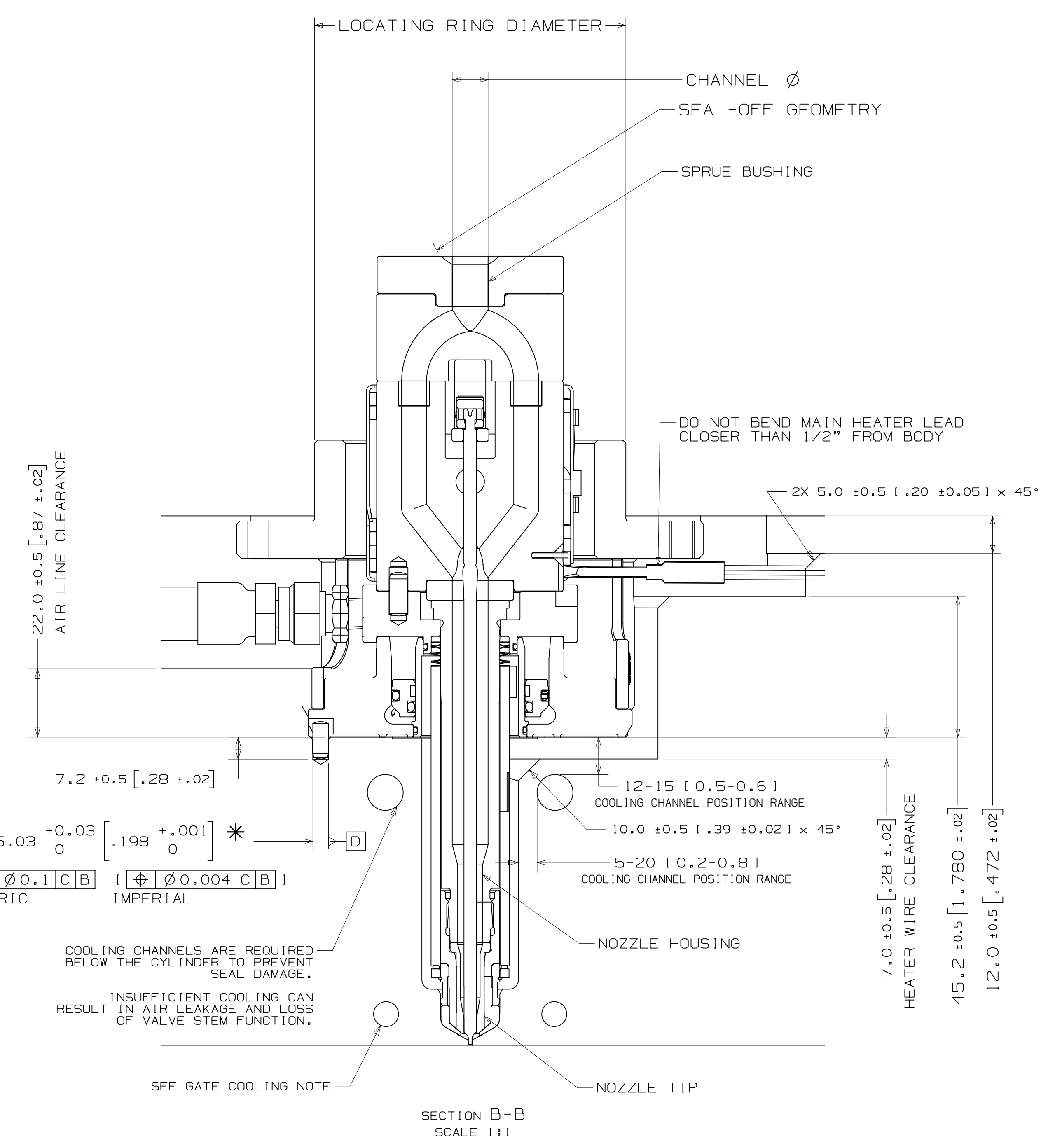
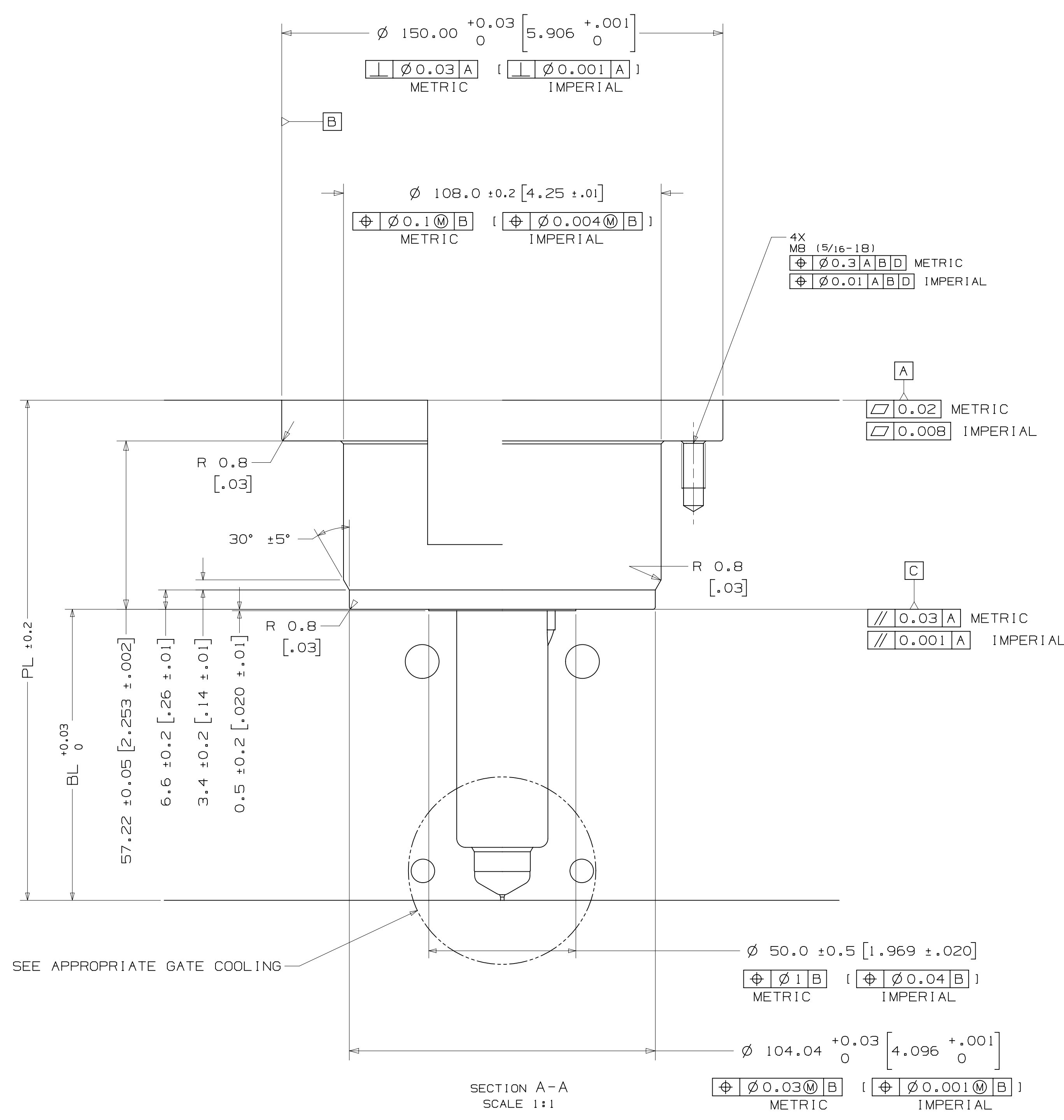


INSTALLATION DRAWING

REV 0
8333283



* 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 KEYS VALVE STEMS. THE DOWEL MUST BE ORIENTED IN LINE WITH THE AIR LINES.



NOZZLE SERIES	NOZZLE TIP	PL RANGE	Approx. BL *
U750	VG-PKG	107.57(4.235) - 267.93(10.548)	39(1.54) - 188(7.40)

*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.

U750	SPRUE BUSHING	
	SEAL-OFF GEOMETRY	CHANNEL Ø 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	

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)

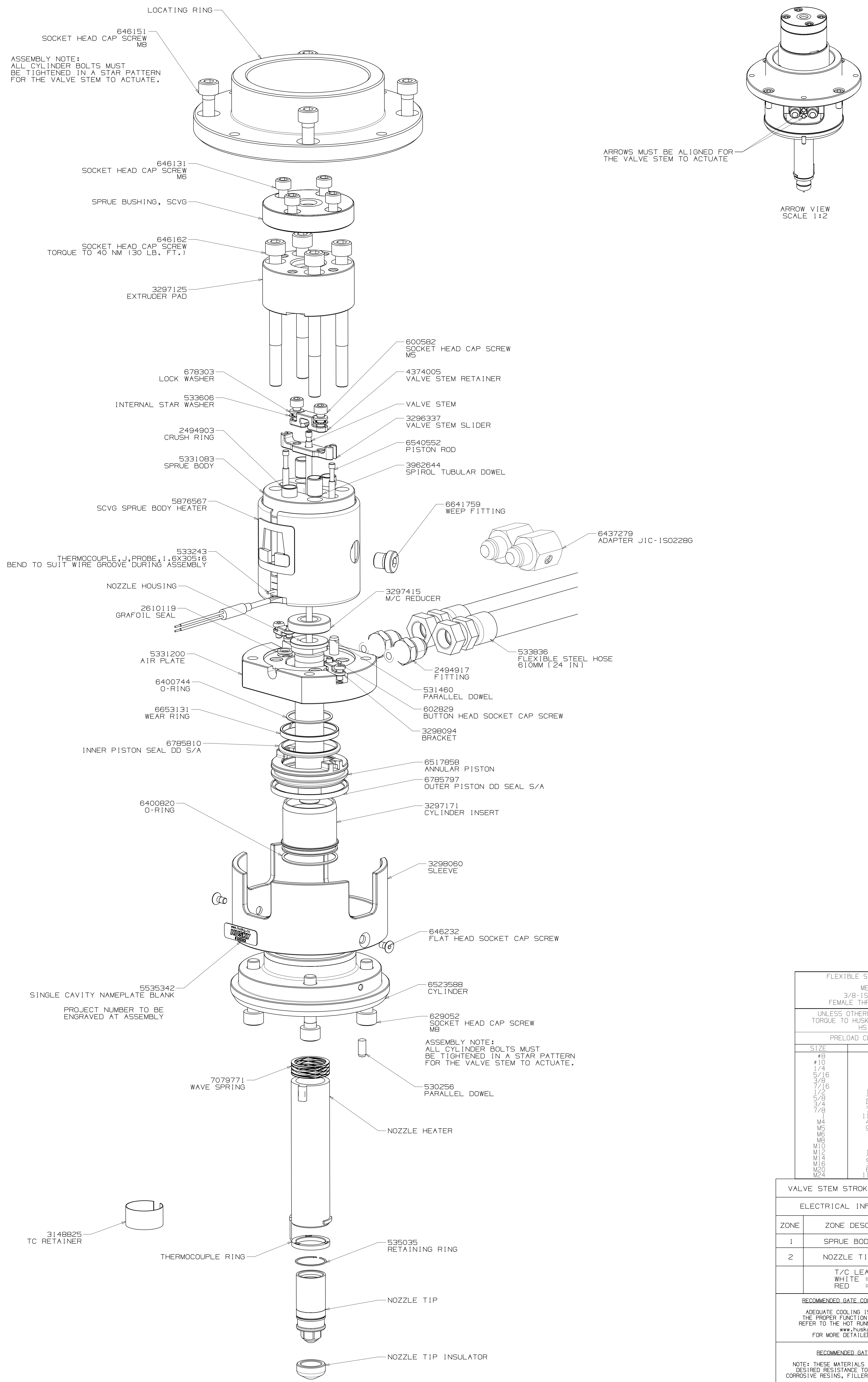
RECOMMENDED GATE MANUFACTURING GUIDELINES
- HARDENED GATE INSERTS (49-51) ARE RECOMMENDED WHEN USING SOFTER CAVITY STEELS. SOFTER CAVITIES MAY BE ACCEPTABLE FOR CERTAIN APPLICATIONS. CONTACT YOUR HUSKY REPRESENTATIVE WITH QUESTIONS.
- EDM'ING THE GATE AREA CAUSES MICRO CRACKS WHICH LEAD TO BRITTLE GATE 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
4	2020-05-29	TABLE UPDATED PER LATEST CALCULATION	DRWNG DEEBAN N T	CHKD
3	2019-07-09	TEMPLATE VALUES UPDATED AS PER SOL 2.0	DRWNG MURALIDHARAN	CHKD
2	2018-04-06	DRAWING NAME CHANGED	DRWNG ANUSHAL	CHKD
1	2018-01-12	BL NOTE UPDATED	DRWNG DHANANLEYAN	CHKD
0	2017-12-19	ORIGINAL ISSUE - DESIGNED BY: DHANANLEYAN	DRWNG DHANANLEYAN	CHKD
			DRWNG PICHLER KLAUS	CHKD

DWT PER ASME Y14.5M-1994 AND HEAVY ADDENDUM - H254 UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN MILLIMETERS UNLESS OTHERWISE SPECIFIED ARE BASIC GENERAL TOLERANCES: METRIC: [M-17] IMPERIAL: [G-0.17] FINISH/TREATMENT: [F-0.017] SURFACE FINISH: 3.2 WEIGHT: - kg	UNFINISHED DRAWING FEATURES: MATERIAL: N/A FINISH/TREATMENT: [F-0.017] NO INTELLECTUAL PROPERTY RIGHTS CLAIMED OR GRANTED. HUSKY RESERVES COPYRIGHT.	HUSKY TITLE: SCVG Single Cavity Valve Gate U750_SCVG_V6_PKG SCALE: 1:1 SHEET: 1 OF 2 AOR: 8333283 REV: 0
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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	5.2
5/16	16	12
3/8	25	18
1/2	50	37
5/8	85	63
3/4	150	110
7/8	250	183
1	350	258
1 1/8	500	367
1 1/2	750	550
M4	4.6	3.4
M5	6.8	5.0
M6	9.8	7.2
M8	19	14
M10	29	21
M12	39	29
M14	59	43
M16	78	58
M20	135	100
M25	215	159
M30	350	258
M40	650	480
M50	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 = (-)	

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			CHKDI: PICHLER KLAUS

DEFINING DRAWING FEATURES	METRIC	HUSKY
MATERIAL	N/A	TITLE
FINISH/TREATMENT		Single Cavity Valve Gate
WEIGHT	- kg	SCALE 1:1
		SIZE
		SCALE 1:1
		DRWING
		REV
		8333283
		0