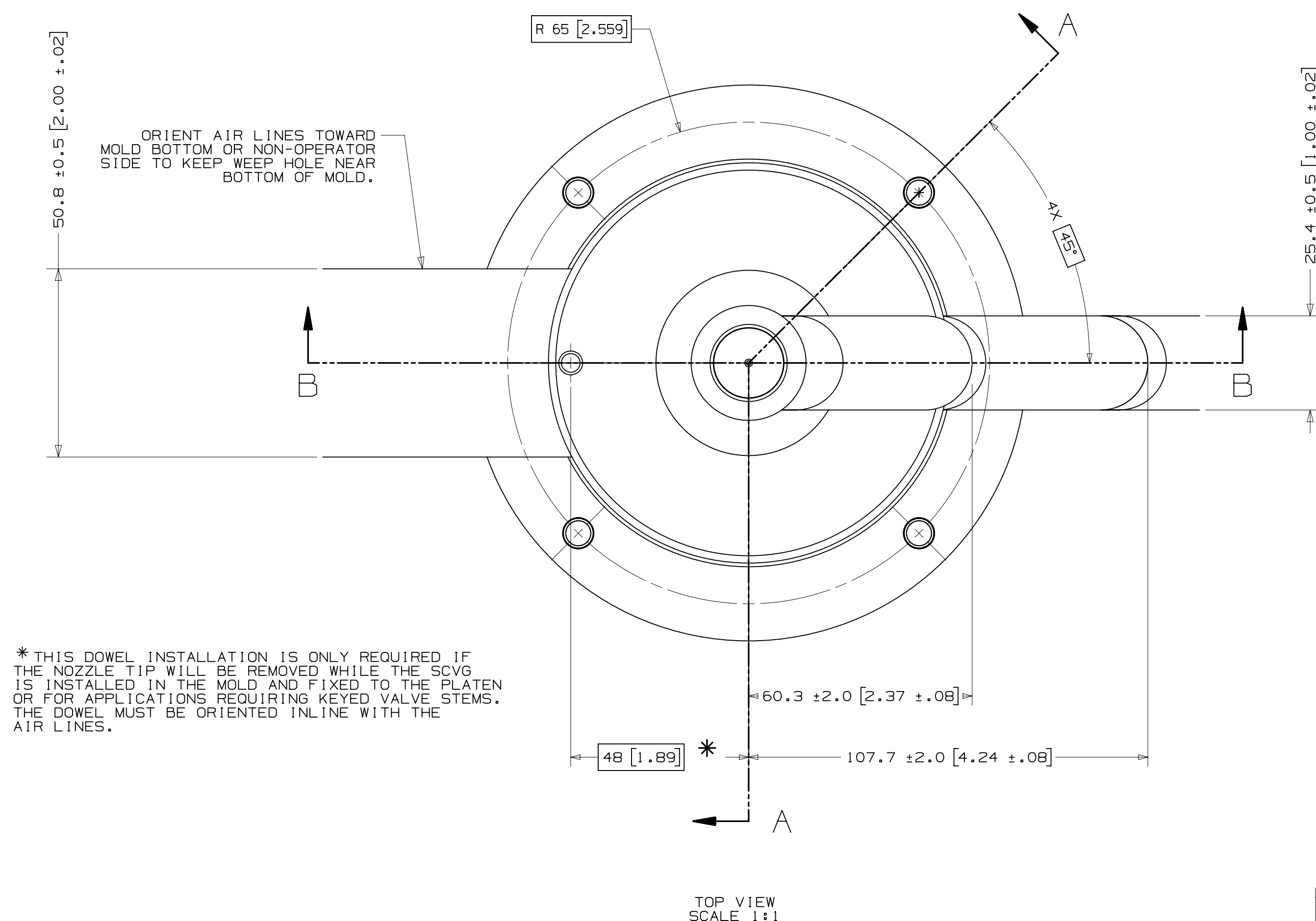


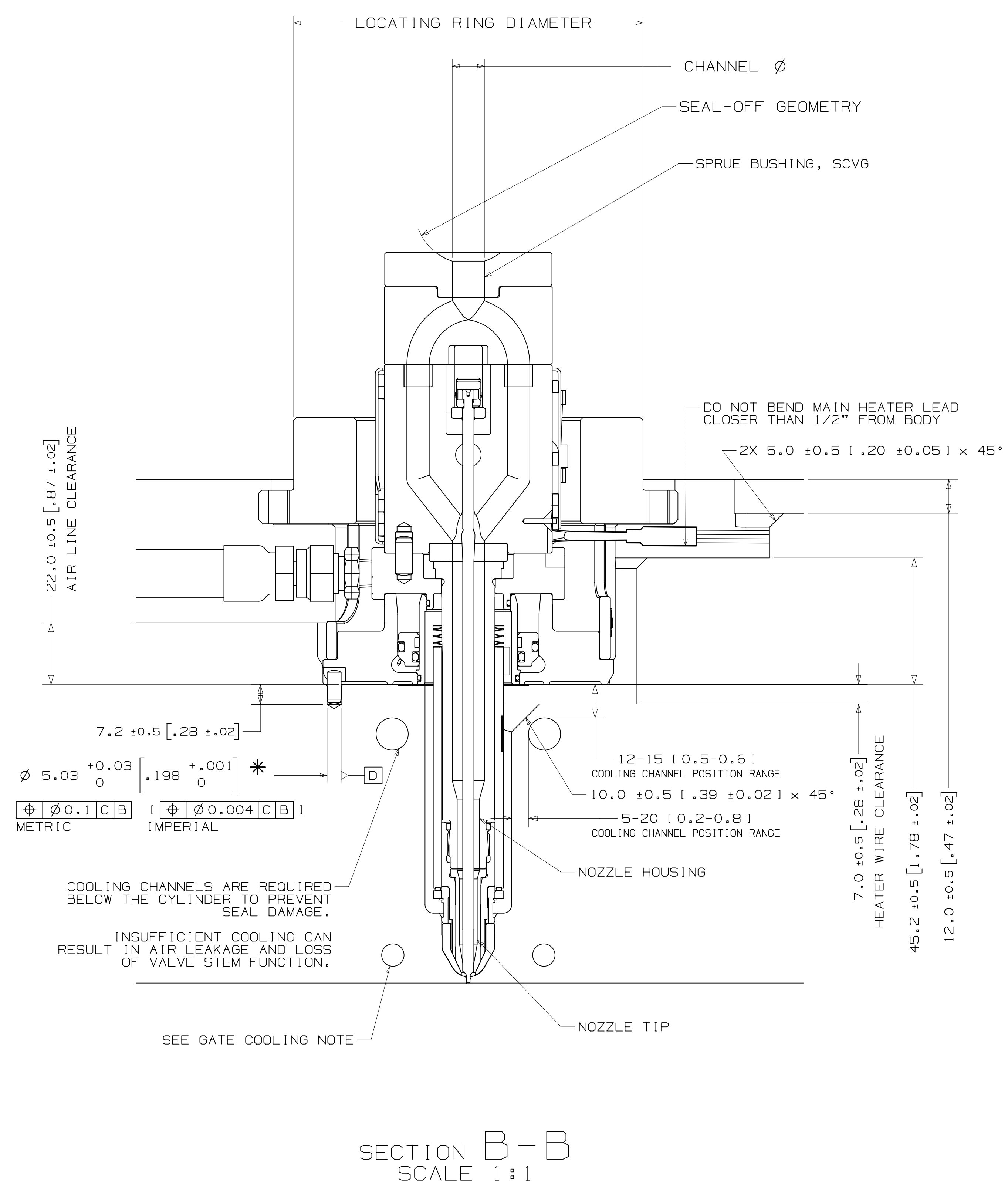
INSTALLATION DRAWING

REV 0
STATUS 8333407

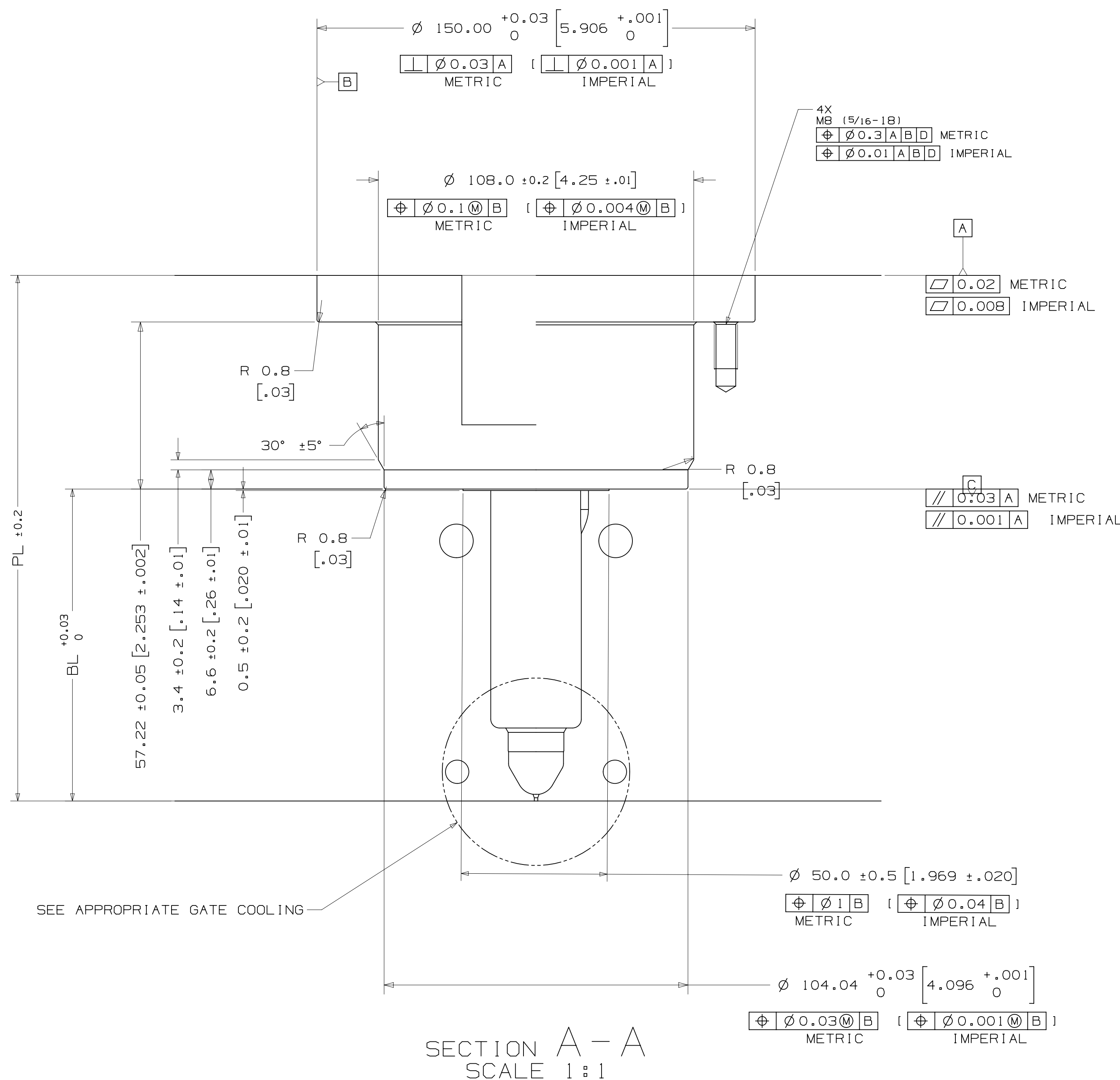


* THIS DOWEL INSTALLATION IS ONLY REQUIRED IF THE NOZZLE TIP WILL BE REMOVED WHILE THE SCVGS IS INSTALLED IN THE MOLD AND FIXED TO THE PLATEN OR FOR APPLICATIONS REQUIRING KEYED VALVE STEMS. THE DOWEL MUST BE ORIENTED IN LINE WITH THE AIR LINES.

TOP VIEW
SCALE 1:1



SECTION B-B
SCALE 1:1



SECTION A-A
SCALE 1:1

NOZZLE SERIES	NOZZLE TIP	NOZZLE HOUSING LENGTH	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 [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	V6-R-PKG	50	115 [4.528]	124 [4.882]	46.56 [1.833]	46.57 [1.833]	46.59 [1.834]	46.61 [1.835]	46.62 [1.835]	46.64 [1.837]	46.66 [1.837]	46.67 [1.837]	46.69 [1.839]	46.71 [1.839]	46.73 [1.840]	46.75 [1.841]								
		60	125 [4.921]	134 [5.276]	56.57 [2.227]	56.58 [2.228]	56.60 [2.228]	56.62 [2.229]	56.64 [2.230]	56.66 [2.231]	56.68 [2.231]	56.70 [2.232]	56.72 [2.233]	56.74 [2.234]	56.76 [2.235]	56.78 [2.235]								
		70	135 [5.315]	145 [5.709]	66.57 [2.621]	66.59 [2.622]	66.62 [2.623]	66.64 [2.624]	66.66 [2.624]	66.68 [2.625]	66.70 [2.626]	66.72 [2.627]	66.74 [2.628]	66.77 [2.629]	66.79 [2.630]	66.82 [2.631]	66.84 [2.631]							
		80	146 [5.748]	155 [6.102]	76.58 [3.015]	76.60 [3.016]	76.63 [3.017]	76.65 [3.018]	76.67 [3.019]	76.70 [3.020]	76.72 [3.021]	76.75 [3.022]	76.77 [3.022]	76.80 [3.024]	76.82 [3.024]	76.85 [3.026]	76.87 [3.026]							
		90	158 [6.142]	165 [6.496]	86.59 [3.409]	86.61 [3.410]	86.64 [3.411]	86.67 [3.412]	86.69 [3.413]	86.72 [3.414]	86.74 [3.415]	86.77 [3.416]	86.80 [3.417]	86.83 [3.419]	86.86 [3.420]	86.89 [3.421]	86.91 [3.421]							
		100	168 [6.635]	175 [6.890]	96.60 [3.803]	96.62 [3.804]	96.65 [3.805]	96.68 [3.806]	96.71 [3.807]	96.74 [3.809]	96.77 [3.810]	96.80 [3.811]	96.83 [3.812]	96.86 [3.813]	96.89 [3.815]	96.92 [3.816]	96.94 [3.816]							
		110	178 [6.929]	185 [7.283]	106.61 [4.197]	106.64 [4.198]	106.66 [4.199]	106.69 [4.200]	106.73 [4.202]	106.76 [4.203]	106.79 [4.204]	106.82 [4.206]	106.85 [4.207]	106.88 [4.208]	106.92 [4.209]	106.96 [4.211]	106.98 [4.211]							
		120	188 [7.323]	195 [7.677]	116.61 [4.591]	116.65 [4.593]	116.68 [4.594]	116.71 [4.595]	116.74 [4.596]	116.78 [4.598]	116.81 [4.599]	116.85 [4.600]	116.88 [4.602]	116.91 [4.603]	116.95 [4.604]	116.99 [4.606]	117.01 [4.606]							
		130	198 [7.717]	205 [8.071]	126.62 [4.985]	126.66 [4.987]	126.69 [4.989]	126.72 [4.990]	126.76 [4.991]	126.80 [4.992]	126.83 [4.993]	126.87 [4.995]	126.91 [4.996]	126.94 [4.999]	126.99 [5.000]	127.03 [5.001]	127.05 [5.001]							
		140	208 [8.110]	215 [8.465]	136.63 [5.379]	136.67 [5.381]	136.70 [5.382]	136.74 [5.383]	136.78 [5.385]	136.82 [5.387]	136.85 [5.388]	136.89 [5.389]	136.93 [5.391]	136.97 [5.393]	137.02 [5.394]	137.06 [5.396]	137.08 [5.396]							
		150	218 [8.504]	225 [8.858]	146.64 [5.773]	146.68 [5.775]	146.71 [5.776]	146.75 [5.778]	146.79 [5.779]	146.84 [5.781]	146.88 [5.783]	146.92 [5.784]	146.96 [5.786]	147.00 [5.787]	147.05 [5.789]	147.10 [5.791]	147.12 [5.791]							
		160	228 [8.998]	235 [9.252]	156.64 [6.167]	156.69 [6.169]	156.73 [6.170]	156.77 [6.172]	156.81 [6.174]	156.85 [6.175]	156.90 [6.177]	156.94 [6.179]	156.99 [6.181]	157.03 [6.182]	157.08 [6.184]	157.13 [6.186]	157.15 [6.186]							
		170	238 [9.291]	245 [9.646]	166.65 [6.561]	166.70 [6.563]	166.74 [6.565]	166.78 [6.566]	166.83 [6.568]	166.87 [6.570]	166.92 [6.572]	166.97 [6.574]	167.01 [6.575]	167.06 [6.577]	167.12 [6.580]	167.17 [6.581]	167.19 [6.581]							
180	248 [9.685]	255 [10.039]	176.66 [6.955]	176.71 [6.957]	176.75 [6.959]	176.80 [6.961]	176.85 [6.963]	176.89 [6.964]	176.94 [6.966]	176.99 [6.968]	177.04 [6.970]	177.09 [6.972]	177.15 [6.974]	177.20 [6.976]	177.22 [6.976]									
190	258 [10.079]	265 [10.433]	186.67 [7.349]	186.72 [7.351]	186.76 [7.353]	186.81 [7.355]	186.86 [7.357]	186.91 [7.359]	186.96 [7.361]	187.02 [7.363]	187.07 [7.365]	187.12 [7.367]	187.18 [7.369]	187.24 [7.372]	187.26 [7.372]									
200	268 [10.472]	276 [10.866]	196.68 [7.743]	196.73 [7.745]	196.78 [7.747]	196.83 [7.749]	196.88 [7.751]	196.93 [7.753]	196.99 [7.756]	197.04 [7.757]	197.10 [7.760]	197.15 [7.762]	197.21 [7.764]	197.27 [7.767]	197.29 [7.767]									

* 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.

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

SPRUE BUSHING	
U750	SEAL-OFF SPHERICAL RADIUS
	FLAT
U750	SEAL-OFF 12.7 [1/2"]
	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. SOFTEN THE AREA AROUND THE WELD AND CAN CAUSE GATE FAILURES.

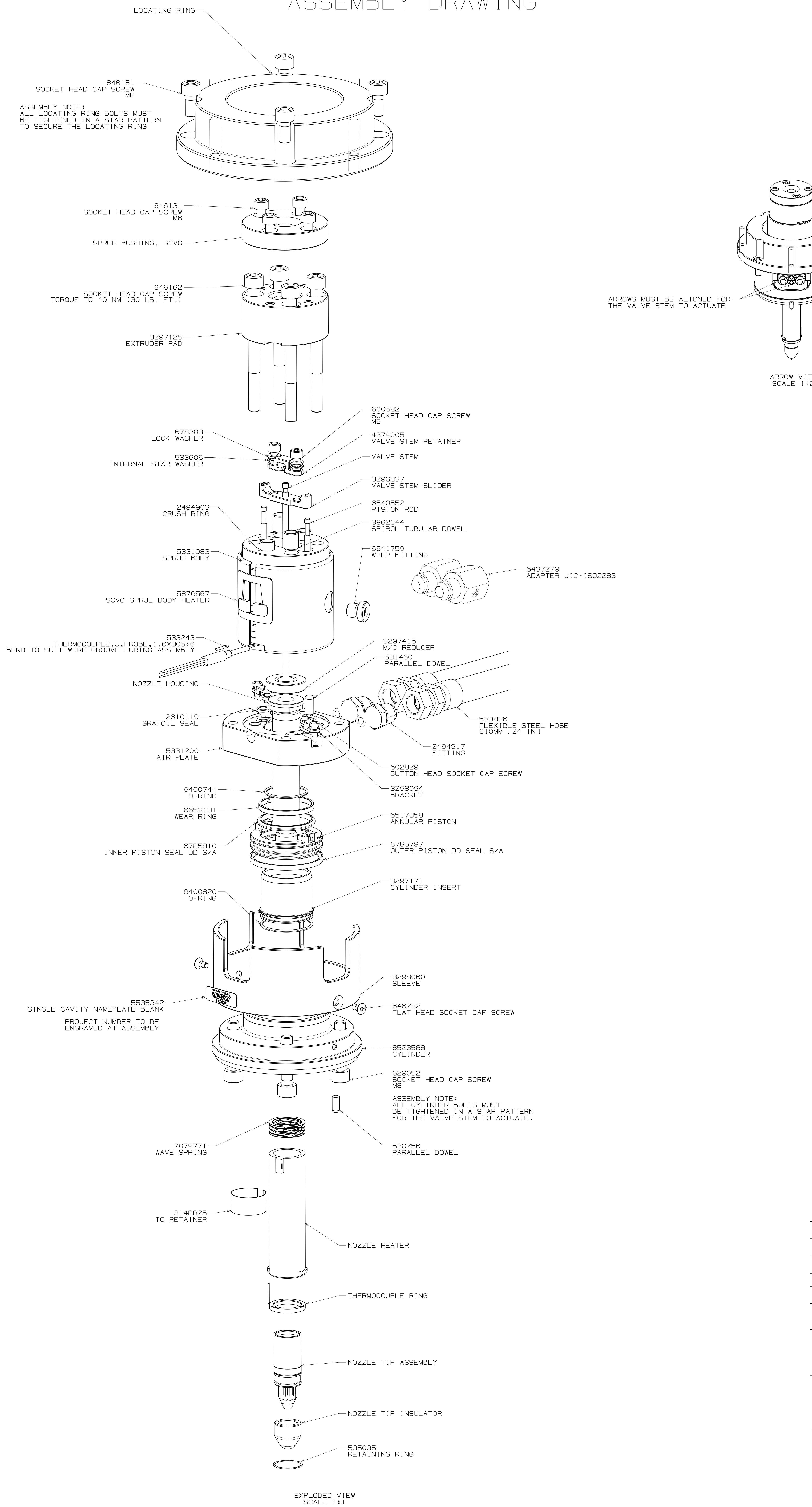
REV	DATE	DESCRIPTION
0	2017-12-19	ORIGINAL ISSUE - DESIGNED BY: DHANANLEYAN

DRWN	CHKD	APPV
DHANANLEYAN	PICHLER KLAUS	

UNFINISHED DRAWING FEATURES	FINISH/TREATMENT	WEIGHT	SCALE	DATE	REV
NO FINISH/TREATMENT	NO FINISH/TREATMENT	0.04 ± 0.01 X 45°	1:1	2017-12-19	0

TITLE	SCALE	DATE	REV
Single Cavity Valve Gate U750_SCVG_VG-R-PKG	1:1	2017-12-19	0

ASSEMBLY DRAWING



ASSEMBLY NOTE:
ALL LOCATING RING BOLTS MUST BE TIGHTENED IN A STAR PATTERN TO SECURE THE LOCATING RING

ARROWS MUST BE ALIGNED FOR THE VALVE STEM TO ACTUATE

ARROW VIEW
SCALE 1:2

ASSEMBLY NOTE:
ALL CYLINDER BOLTS MUST BE TIGHTENED IN A STAR PATTERN FOR THE VALVE STEM TO ACTUATE.

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
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
1 1/8	280	207
1 1/4	350	258
1 1/2	450	332
M4	4.6	3.4
M5	6.8	5.0
M6	9.8	7.2
M8	16.7	12.3
M10	23.5	17.4
M12	31.4	23.1
M14	41.3	30.4
M16	55.2	40.5
M20	89.1	65.4
M24	138.0	100.8

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	DRWN	CHKD
0	2017-12-19	ORIGINAL ISSUE - DESIGNED BY DHANALEKIAN	DRWN1	CHKD1
			DRWN1	CHKD1
			DRWN1	CHKD1
			DRWN1	CHKD1
			DRWN1	CHKD1
			DRWN1	CHKD1
			DRWN1	CHKD1
			DRWN1	CHKD1
			DRWN1	CHKD1
			DRWN1	CHKD1

DEFINING DRAWING FEATURES		METRIC	HUSKY
MATERIAL	N/A	SCALE 1:1	TITLE
FINISH/TREATMENT		SCALE 1:2	Single Cavity Valve Gate
WEIGHT	- kg	SCALE 1:1	U750_SCVG_VG-R_PKG
		SCALE 1:2	8333407
		SCALE 1:1	REV
		SCALE 1:2	0