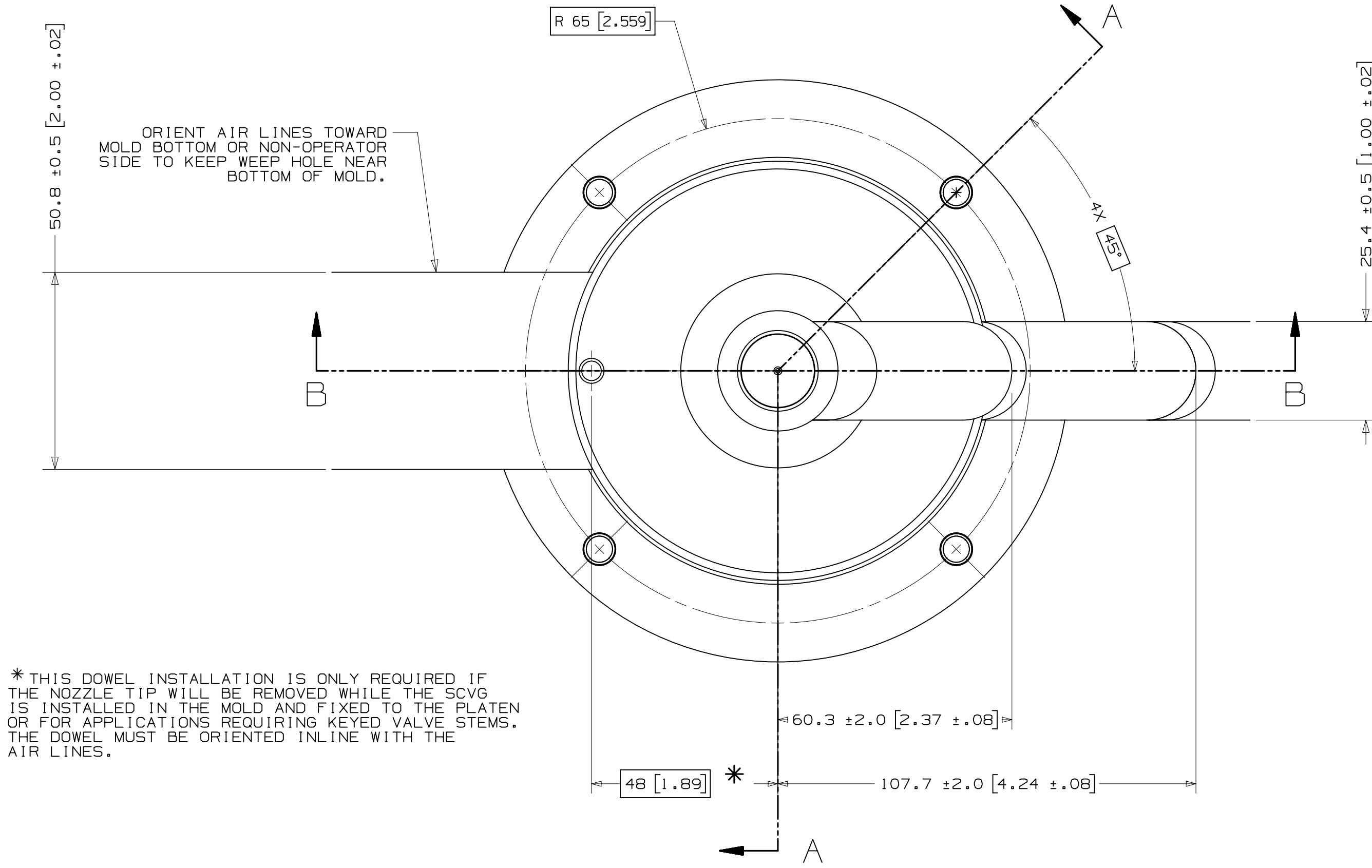
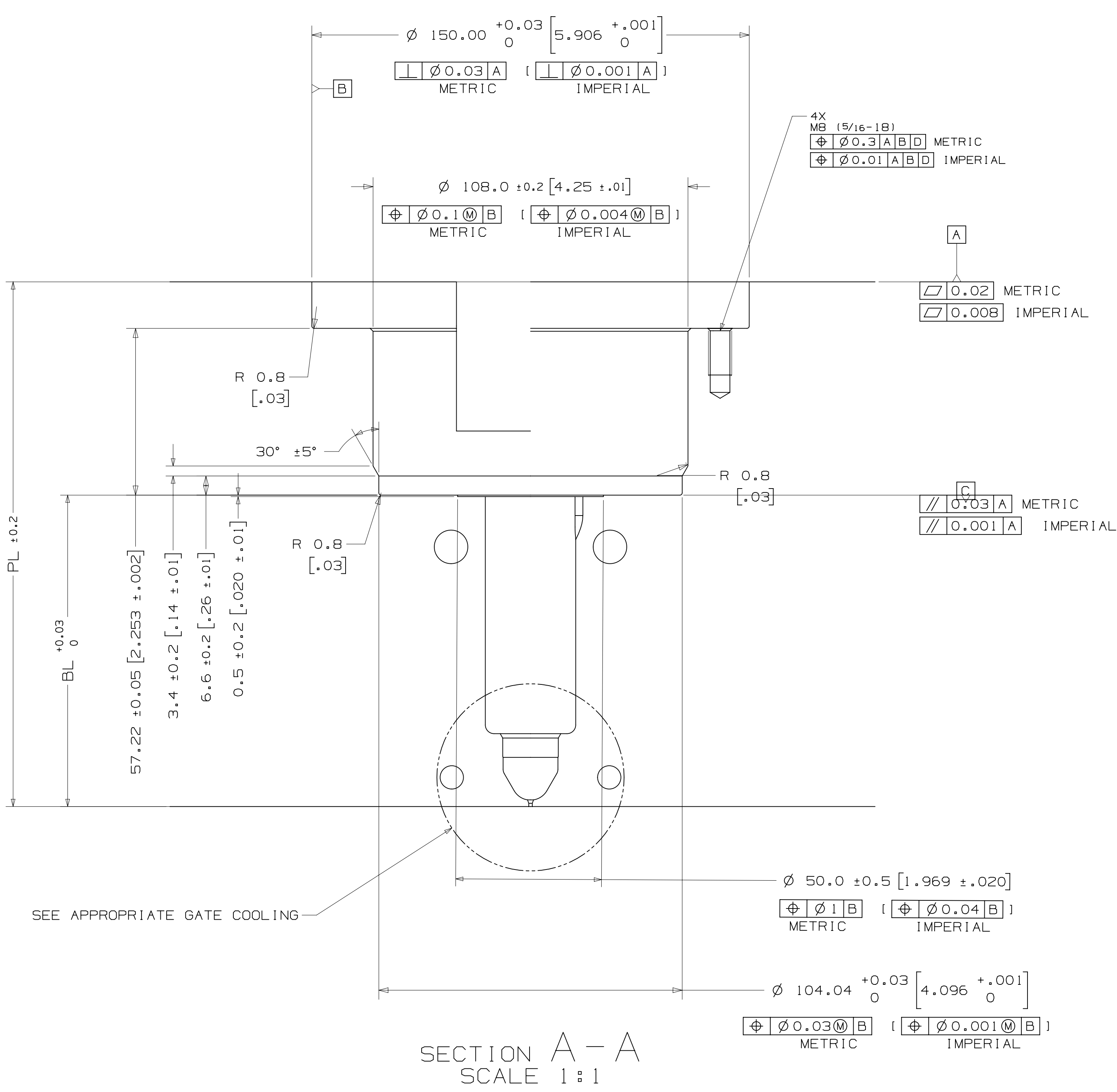


INSTALLATION DRAWING

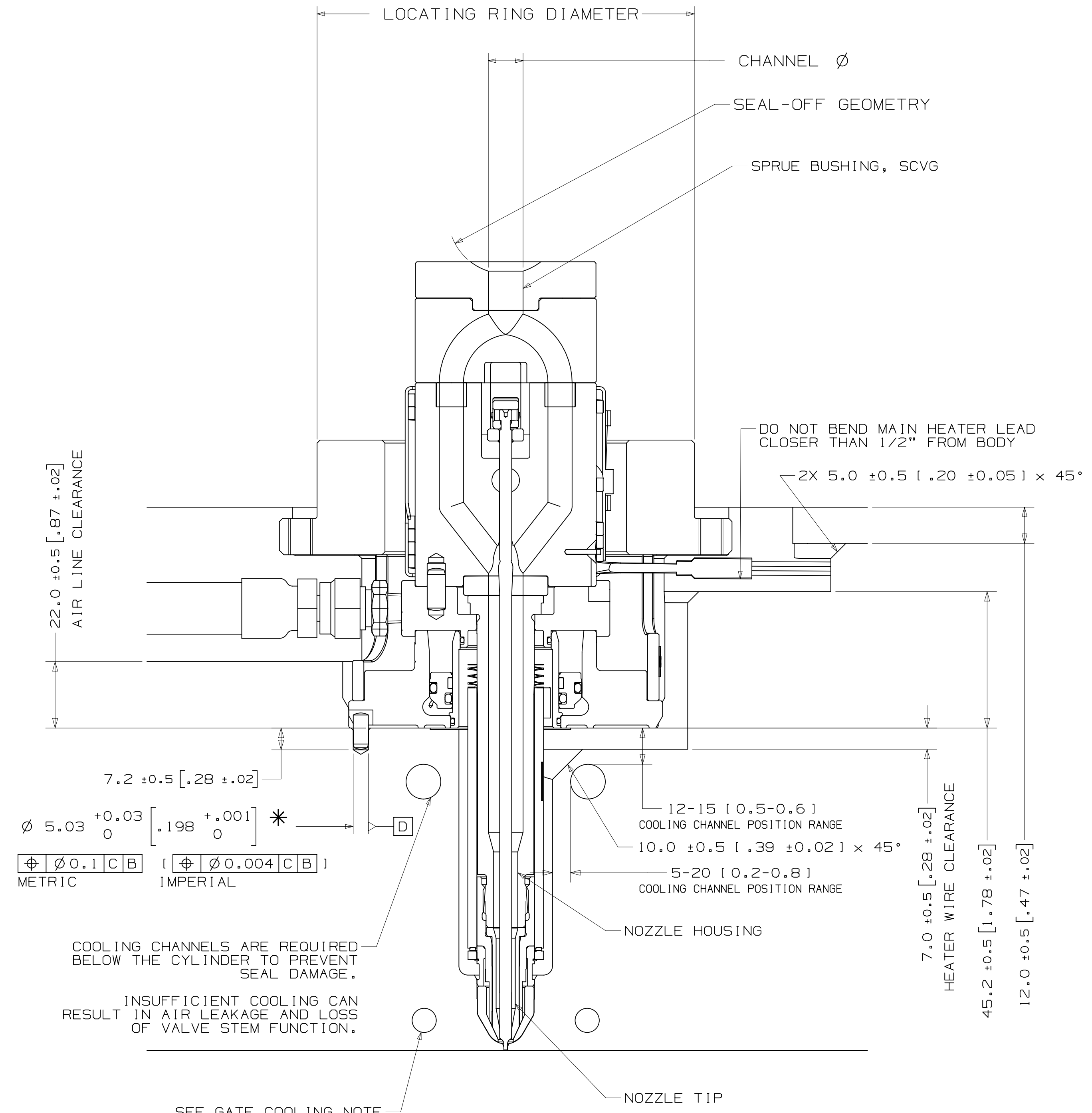


* THIS DOWEL INSTALLATION IS ONLY REQUIRED IF THE NOZZLE TIP WILL BE REMOVED WHILE THE SCVG IS INSTALLED IN THE MOLD AND FIXED TO THE PLATEN OR FOR APPLICATIONS REQUIRING KEYS VALVE STEMS. THE DOWEL MUST BE ORIENTED IN LINE WITH THE AIR LINES.

TOP VIEW
SCALE 1:1



SECTION A-A
SCALE 1:1



SECTION B-B
SCALE 1:1

NOZZLE SERIES	NOZZLE TIP	PL RANGE	Approx. BL
U750	VG-R-PKG	115.46(4.546) - 275.83(10.859)	46(1.81) - 196(7.72)

*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.

SPRUE BUSHING	
U750	SEAL-OFF GEOMETRY SPHERICAL RADIUS
	FLAT
	FLAT
	SEAL-OFF 12.7 [1/2"]
	SEAL-OFF 15.5
	SEAL-OFF 19.05 [3/4"]
	SEAL-OFF 20
	SEAL-OFF 40

LOCATING RING DIAMETER	
U750	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

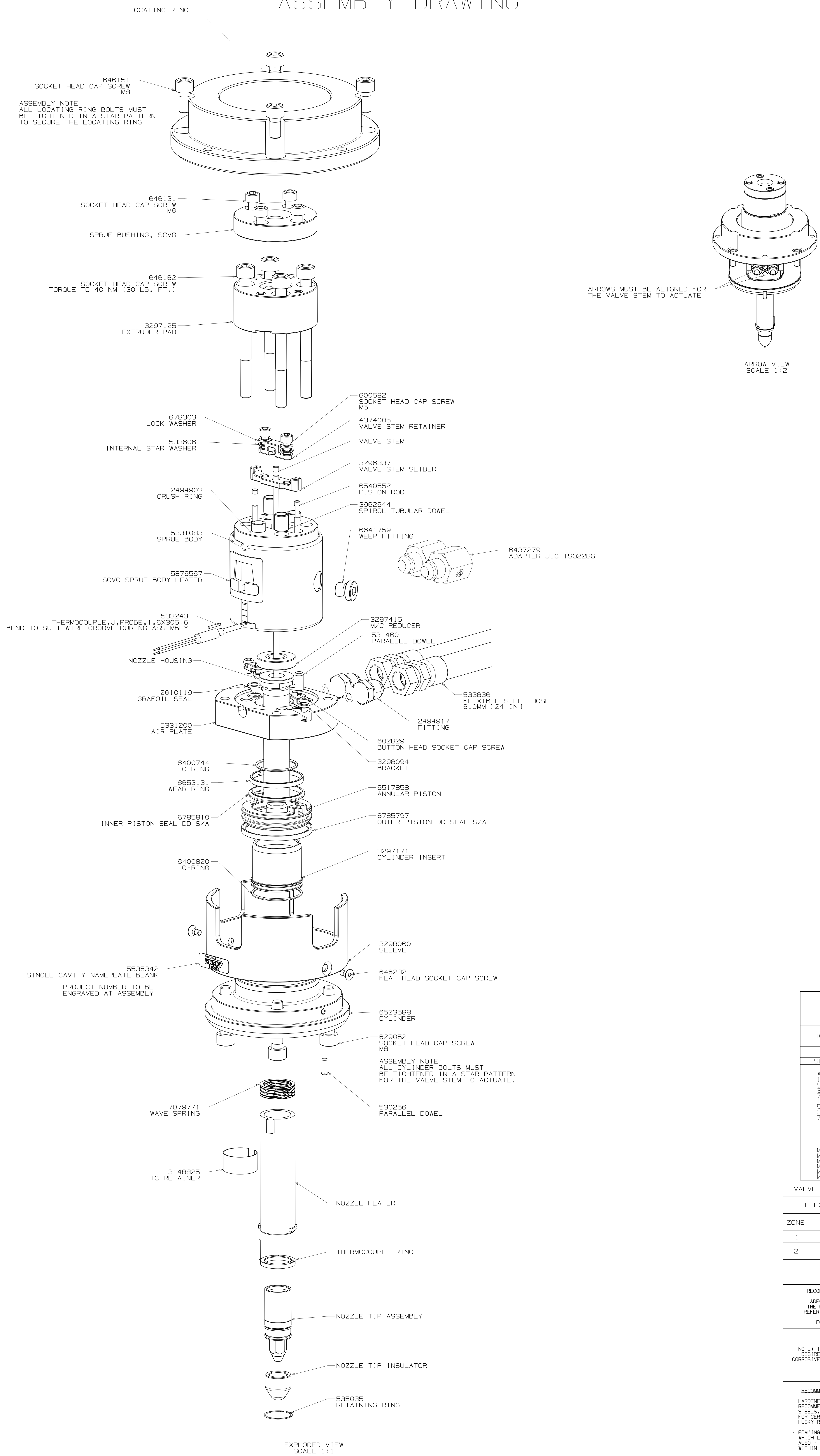
RECOMMENDED GATE MATERIAL
NOTE: THESE MATERIALS MAY NOT OFFER THE DESIRED RESISTANCE TO ABRASIVE AND/OR CORROSIVE RESINS, FILLERS AND/OR ADDITIVES.
AISI H13 (49-51 Rc)
AISI 420 (49-51 Rc)

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

REV	DATE	DESCRIPTION	DESIGNED BY	CHECKED BY
4	2020-05-29	TABLE UPDATED PER LATEST CALCULATION	DRWNI DEEBAN N T	CHKDI
3	2019-07-09	TEMPLATE VALUES UPDATED AS PER SOL. 2.0	DRWNI MURALIDHARAN	CHKDI
2	2018-04-06	DRAWING NAME CHANGED	DRWNI ANUSHAL	CHKDI
1	2018-01-12	BL NOTE UPDATED	DRWNI DHANANLEYAN	CHKDI
0	2017-12-19	ORIGINAL ISSUE - DESIGNED BY: DHANANLEYAN	DRWNI DHANANLEYAN	CHKDI
			DRWNI PICHLER KLAUS	CHKDI

UNFINISHED DRAWING FEATURES		FINISH/TREATMENT		MATERIAL		WEIGHT	
GENERAL TOLERANCES:	METRIC: [0.17] IMPERIAL: [0.007]						
BROKEN EDGES/CHAMFER:	1 ± 0.2 X 45° 0.04 ± 0.01 X 45°						
FILLET/RADIUS:	R0.8 ± 0.2 R0.03 ± 0.01						
SURFACE FINISH:	6.3						

ASSEMBLY DRAWING



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	25
7/16	50	35
1/2	70	50
5/8	100	70
3/4	150	110
7/8	250	180
1	350	250
1 1/8	500	350
1 1/4	700	500
1 1/2	1000	700
M4	4.6	3.4
M5	6.8	5.0
M6	9.8	7.2
M8	19.6	14.4
M10	29.4	21.6
M12	39.2	28.8
M14	49.0	36.0
M16	68.8	50.4
M20	137.6	100.8
M25	275.2	201.6

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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0	2017-12-19	ORIGINAL ISSUE - DESIGNED BY: DHANALEYAN	DRWINI DHANALEYAN
			DRWINI PITCHLER KLAUS

MATERIAL	FINISH/TREATMENT	WEIGHT	SCALE	SIZE	DRAWING	REV
N/A		- kg	1:1	AOR	8333407	0