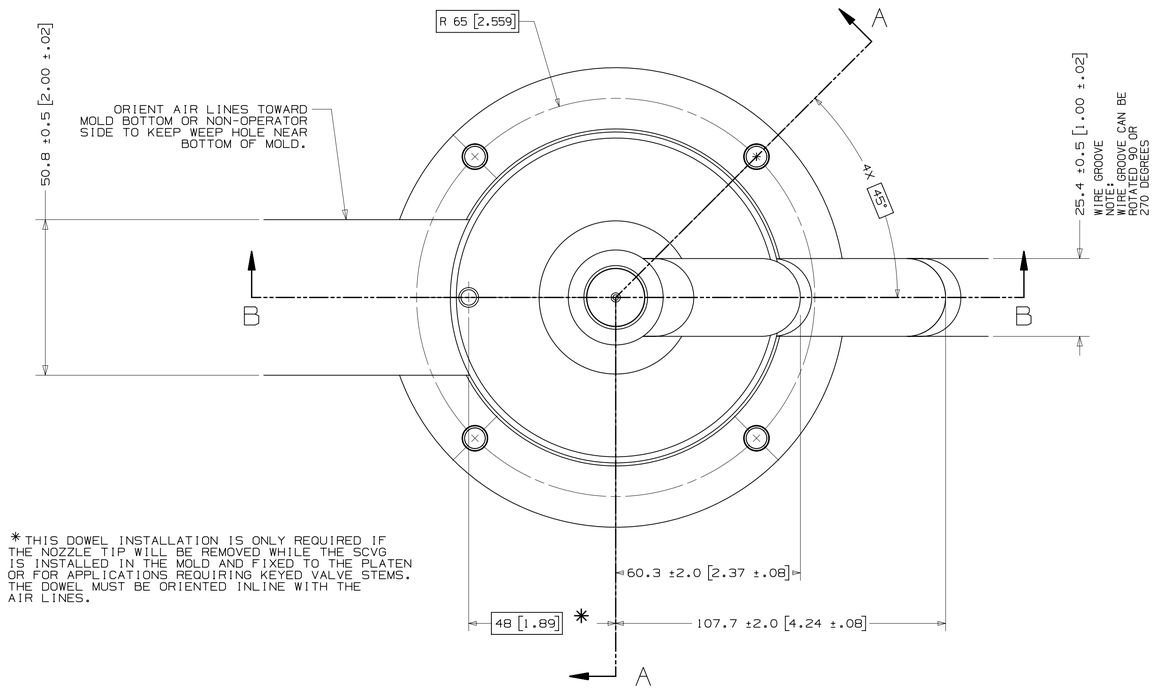
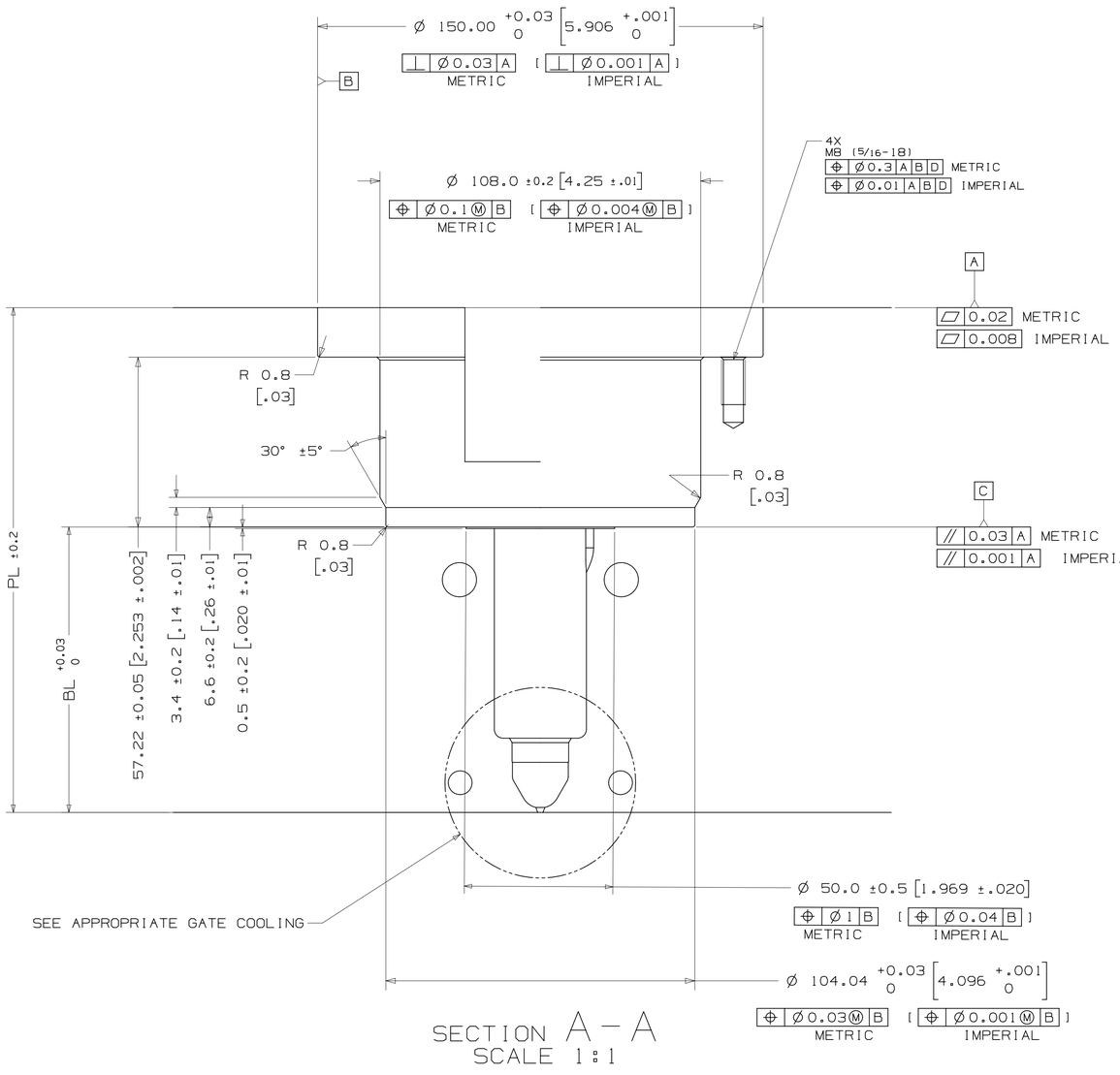
INSTALLATION DRAWING

REV 0
DRAWING 8142261

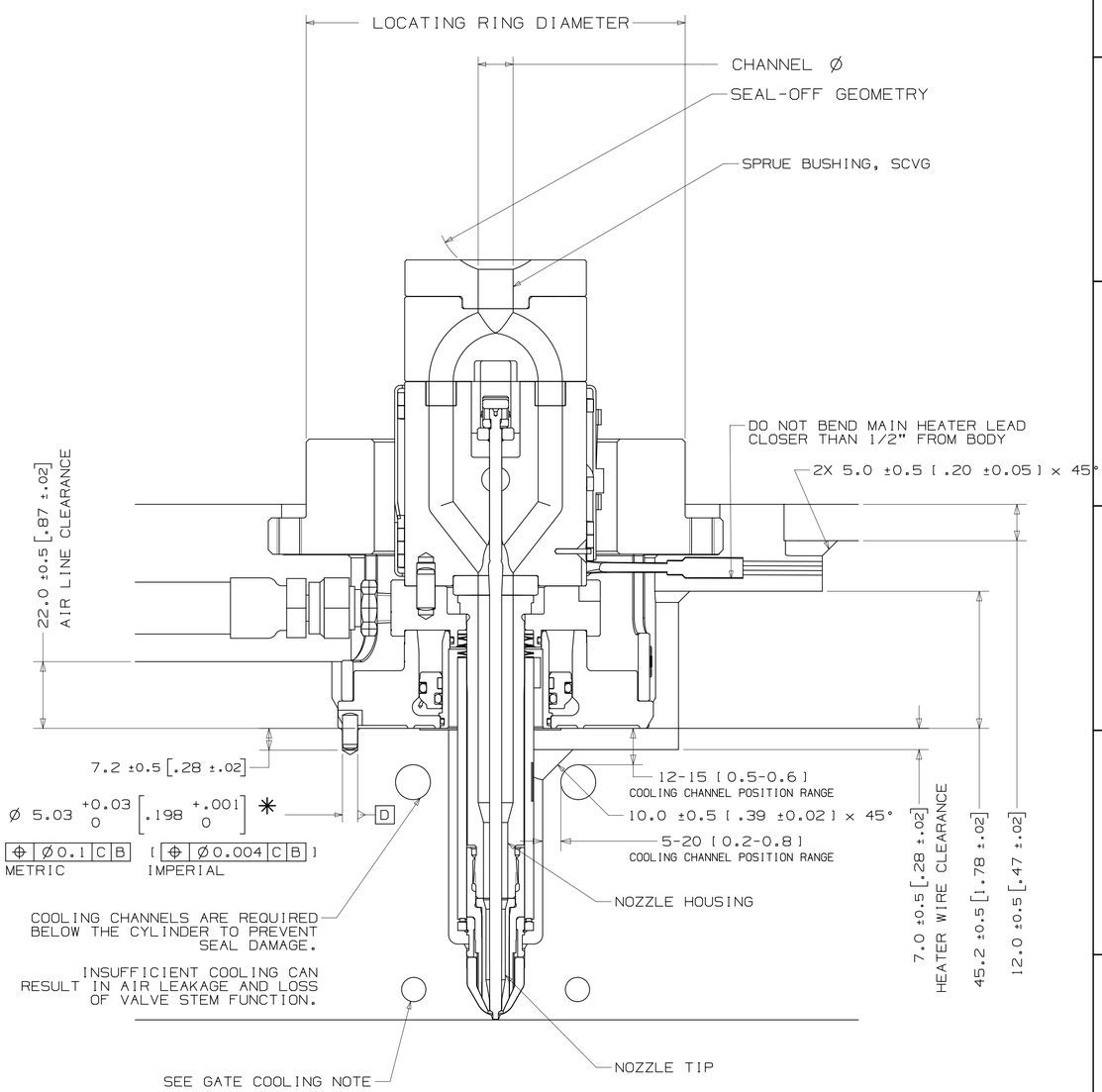


* THIS DOWEL INSTALLATION IS ONLY REQUIRED IF THE NOZZLE TIP WILL BE REMOVED WHILE THE SCVG IS INSTALLED IN THE MOLD AND FIXED TO THE PLATEN OR FOR APPLICATIONS REQUIRING KEYED VALVE STEMS. THE DOWEL MUST BE ORIENTED INLINE WITH THE AIR LINES.

TOP VIEW
SCALE 1:1



SECTION A-A
SCALE 1:1



SECTION B-B
SCALE 1:1

NOZZLE SERIES	NOZZLE TIP	NOZZLE HOUSING LENGTH	PL MIN [INCH]	PL MAX [INCH]	"BL" AT DELTA TEMP (DELTA TEMP = TEMP OF MELT - TEMP OF MOLD)* 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	VG-R	50	115 [4.528]	124 [4.882]	45.86 [1.806]	45.87 [1.806]	45.89 [1.807]	45.91 [1.807]	45.92 [1.808]	45.94 [1.809]	45.96 [1.809]	45.97 [1.810]	45.99 [1.811]	46.01 [1.811]	46.03 [1.812]	46.05 [1.813]
		60	125 [4.921]	134 [5.276]	55.87 [2.200]	55.88 [2.200]	55.90 [2.201]	55.92 [2.202]	55.94 [2.202]	55.96 [2.203]	55.98 [2.204]	56.00 [2.205]	56.02 [2.206]	56.04 [2.206]	56.06 [2.207]	56.08 [2.208]
		70	135 [5.315]	145 [5.709]	65.87 [2.593]	65.89 [2.594]	65.92 [2.595]	65.94 [2.596]	65.96 [2.597]	65.98 [2.598]	66.00 [2.598]	66.02 [2.599]	66.04 [2.600]	66.07 [2.601]	66.09 [2.602]	66.12 [2.603]
		80	146 [5.748]	155 [6.102]	75.88 [2.987]	75.90 [2.988]	75.93 [2.989]	75.95 [2.990]	75.97 [2.991]	76.00 [2.992]	76.02 [2.993]	76.05 [2.994]	76.07 [2.995]	76.10 [2.996]	76.12 [2.997]	76.15 [2.998]
		90	156 [6.142]	165 [6.496]	85.89 [3.381]	85.91 [3.382]	85.94 [3.383]	85.97 [3.385]	85.99 [3.385]	86.02 [3.387]	86.04 [3.387]	86.07 [3.389]	86.10 [3.390]	86.13 [3.391]	86.16 [3.392]	86.19 [3.393]
		100	166 [6.535]	175 [6.890]	95.90 [3.776]	95.92 [3.776]	95.95 [3.778]	95.98 [3.779]	96.01 [3.780]	96.04 [3.781]	96.07 [3.782]	96.10 [3.783]	96.13 [3.785]	96.16 [3.786]	96.19 [3.787]	96.22 [3.788]
		110	176 [6.929]	185 [7.283]	105.91 [4.170]	105.94 [4.171]	105.96 [4.172]	105.99 [4.173]	106.03 [4.174]	106.06 [4.176]	106.09 [4.177]	106.12 [4.178]	106.15 [4.179]	106.18 [4.180]	106.22 [4.182]	106.26 [4.183]
		120	186 [7.323]	195 [7.677]	115.91 [4.563]	115.95 [4.565]	115.98 [4.566]	116.01 [4.567]	116.04 [4.569]	116.08 [4.570]	116.11 [4.571]	116.15 [4.573]	116.18 [4.574]	116.21 [4.575]	116.25 [4.577]	116.29 [4.578]
		130	196 [7.717]	205 [8.071]	125.92 [4.957]	125.96 [4.959]	125.99 [4.960]	126.02 [4.961]	126.06 [4.963]	126.10 [4.965]	126.13 [4.966]	126.17 [4.967]	126.21 [4.969]	126.24 [4.970]	126.29 [4.972]	126.33 [4.974]
		140	206 [8.110]	215 [8.465]	135.93 [5.352]	135.97 [5.353]	136.00 [5.354]	136.04 [5.356]	136.08 [5.357]	136.12 [5.359]	136.15 [5.360]	136.19 [5.362]	136.23 [5.363]	136.27 [5.365]	136.32 [5.367]	136.36 [5.369]
		150	216 [8.504]	225 [8.858]	145.94 [5.746]	145.98 [5.747]	146.01 [5.748]	146.05 [5.750]	146.09 [5.752]	146.14 [5.754]	146.18 [5.755]	146.22 [5.757]	146.26 [5.758]	146.30 [5.760]	146.35 [5.762]	146.40 [5.764]
		160	226 [8.898]	235 [9.252]	155.94 [6.139]	155.99 [6.141]	156.03 [6.143]	156.07 [6.144]	156.11 [6.146]	156.15 [6.148]	156.20 [6.150]	156.24 [6.151]	156.29 [6.153]	156.33 [6.155]	156.38 [6.157]	156.43 [6.159]
		170	236 [9.291]	245 [9.646]	165.95 [6.533]	166.00 [6.535]	166.04 [6.537]	166.08 [6.539]	166.13 [6.541]	166.17 [6.542]	166.22 [6.544]	166.27 [6.546]	166.31 [6.548]	166.36 [6.550]	166.42 [6.552]	166.47 [6.554]
		180	246 [9.685]	255 [10.039]	175.96 [6.928]	176.01 [6.930]	176.05 [6.931]	176.10 [6.933]	176.15 [6.935]	176.19 [6.937]	176.24 [6.939]	176.29 [6.941]	176.34 [6.943]	176.39 [6.944]	176.45 [6.947]	176.50 [6.949]
		190	256 [10.079]	265 [10.433]	185.97 [7.322]	186.02 [7.324]	186.06 [7.325]	186.11 [7.327]	186.16 [7.329]	186.21 [7.331]	186.26 [7.333]	186.32 [7.335]	186.37 [7.337]	186.42 [7.339]	186.48 [7.342]	186.54 [7.344]
		200	266 [10.472]	276 [10.866]	195.98 [7.716]	196.03 [7.718]	196.08 [7.720]	196.13 [7.722]	196.18 [7.724]	196.23 [7.726]	196.29 [7.728]	196.34 [7.730]	196.40 [7.732]	196.45 [7.734]	196.51 [7.737]	196.57 [7.739]

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

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

	SPRUE BUSHING	
	SEAL-OFF GEOMETRY SPHERICAL RADIUS	CHANNEL Ø IN - OUT
U750	FLAT	6.35 - 11.5
	FLAT	11.5 - THRU
	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 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
			DRWN:
			CHKD:
			DRWN:
			CHKD:
			DRWN:
			CHKD:
			DRWN:
			CHKD:
0	2017-09-09	ORIGINAL ISSUE - DESIGNED BY: DHANANJEYAN	DRWN: DHANANJEYAN
			CHKD: PICHLER KLAUS

GD&T PER ASME Y14.5M-1994 AND HUSKY ADDENDUM - HS254
UNLESS OTHERWISE SPECIFIED:
CAD MODEL IS BASIC. NON-TOLERANCED DIMENSIONS ARE BASIC.
GENERAL TOLERANCE: METRIC ▱ 0.4 [7] IMPERIAL ▱ 0.02 [7]
BROKEN EDGE/CHAMFER: METRIC 1 ±0.2 X 45° IMPERIAL 0.04 ±0.01 X 45°
FILLET/ROUND: METRIC R0.8 ±0.2 IMPERIAL R0.03 ±0.01
SURFACE FINISH: 6.3

UNDEFINED DRAWING FEATURES TO COMPLY WITH HS534 "SUPPLIER QUICK REFERENCE"
MATERIAL: N/A
FINISH/TREATMENT:
WEIGHT: - kg

METRIC

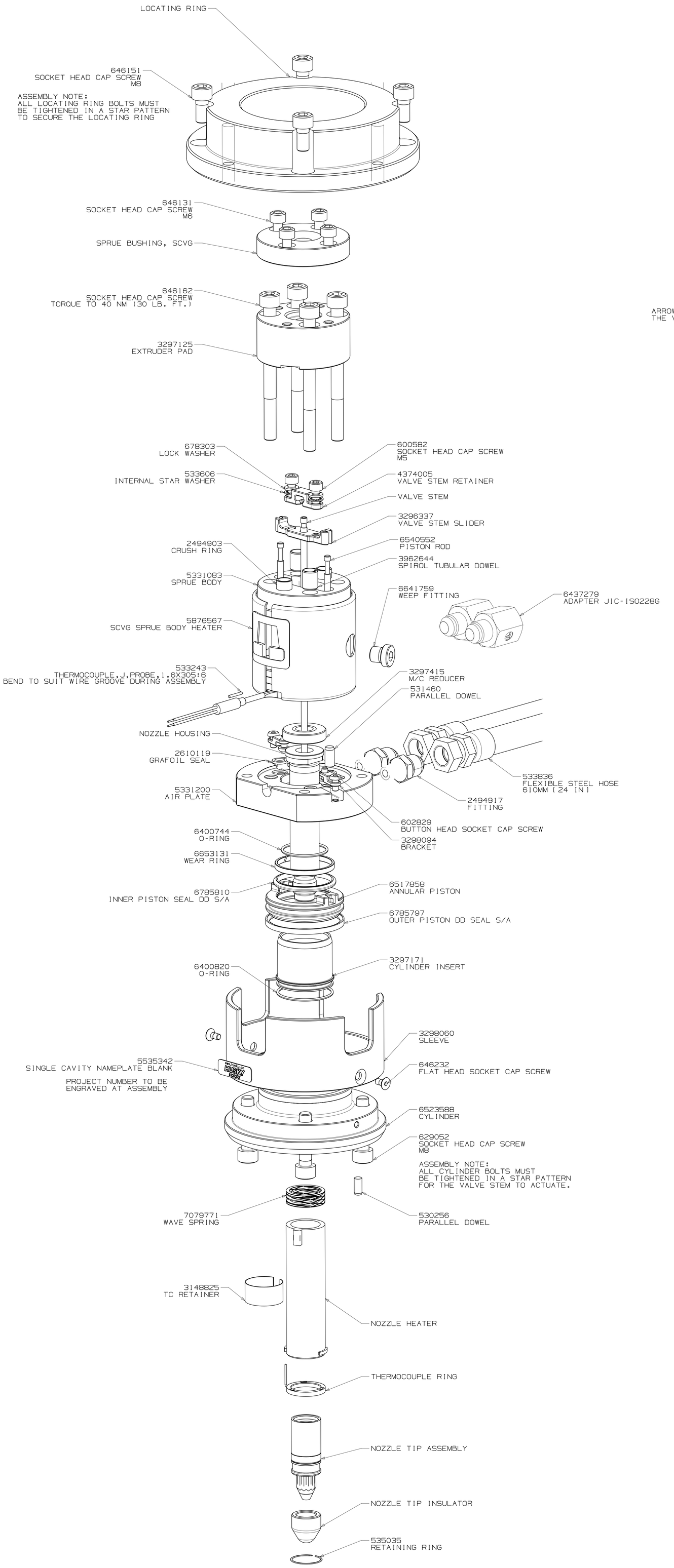
HUSKY

TITLE
SCVG
Single Cavity Valve Gate
U750-VG-R

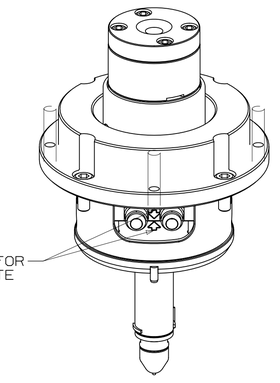
SCALE	SIZE	DRAWING	REV
1:1	A0R	8142261	0
SHEET 1 OF 2			

ASSEMBLY DRAWING

DRAWING 8142261 REV 0



EXPLODED VIEW
SCALE 1:1



ARROW VIEW
SCALE 1:2

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	35	25
3/8	60	45
7/16	95	70
1/2	150	110
5/8	290	210
3/4	500	360
7/8	790	580
1	1180	865
M4	4.6	3.4
M5	9.5	7.1
M6	16	12
M8	39	29
M10	77	57
M12	135	100
M14	215	160
M16	330	245
M20	650	480
M24	1100	810

VALVE STEM STROKE IS 7.3 [.29]	
ELECTRICAL INFO (240 VAC)	
ZONE	ZONE DESCRIPTION
1	SPRUE BODY
2	NOZZLE TIP
	T/C LEADS: WHITE = (+) RED = (-)

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REV	DATE	DESCRIPTION	NAME
			DRWN:
			CHKD:
			DRWN:
			CHKD:
			DRWN:
			CHKD:
			DRWN:
			CHKD:
0	2017-09-09	ORIGINAL ISSUE - DESIGNED BY: DHANANJEYAN	DRWN: DHANANJEYAN
			CHKD: PICHLER KLAUS

UNDEFINED DRAWING FEATURES TO COMPLY WITH HS534 "SUPPLIER QUICK REFERENCE"

METRIC

MATERIAL N/A

FINISH/TREATMENT

WEIGHT - kg

HUSKY

TITLE
SCVG
Single Cavity Valve Gate
U750-VG-R

SCALE 1:1	SIZE	DRAWING	REV
SHEET 2 OF 2	A0R	8142261	0