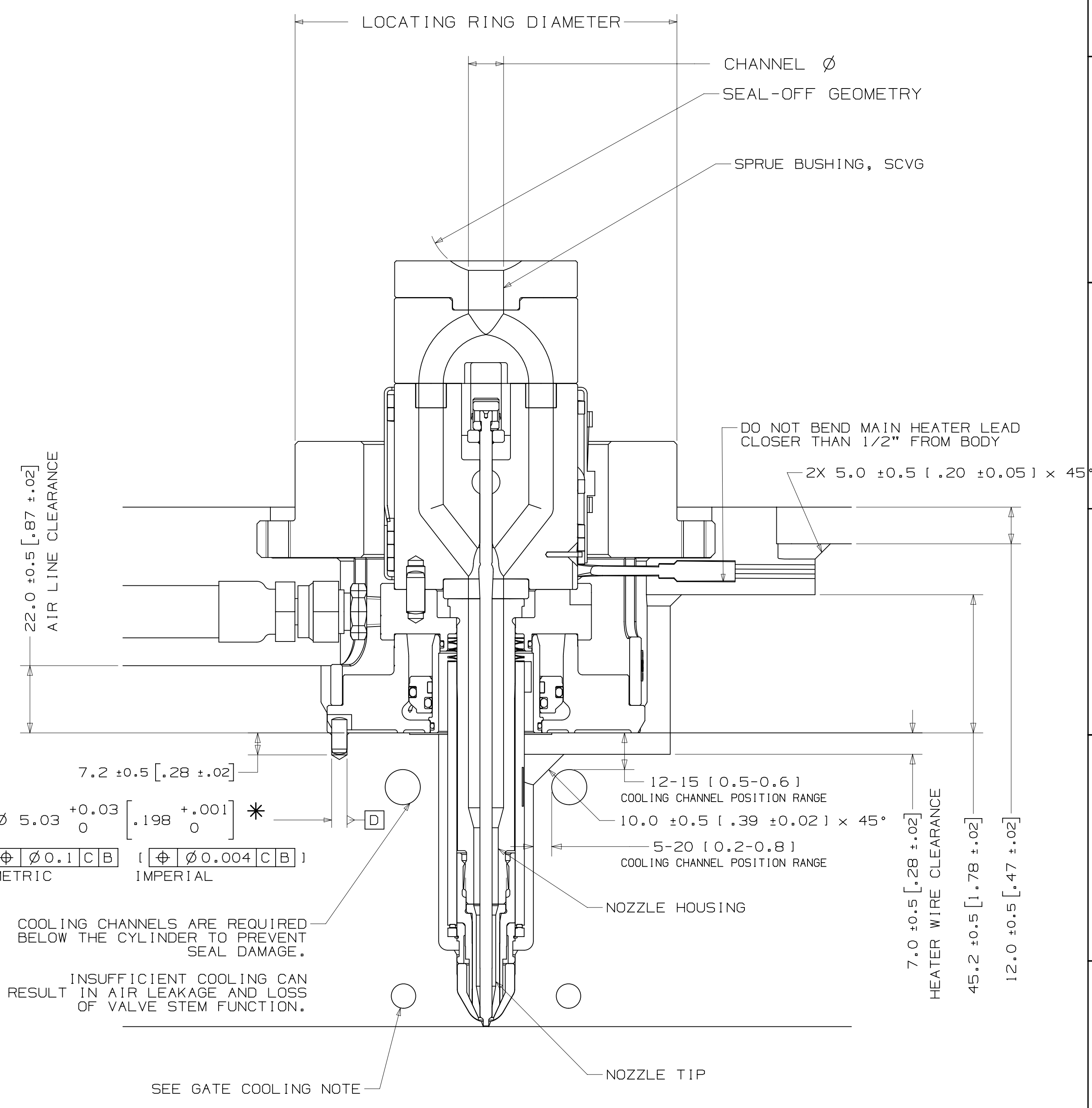
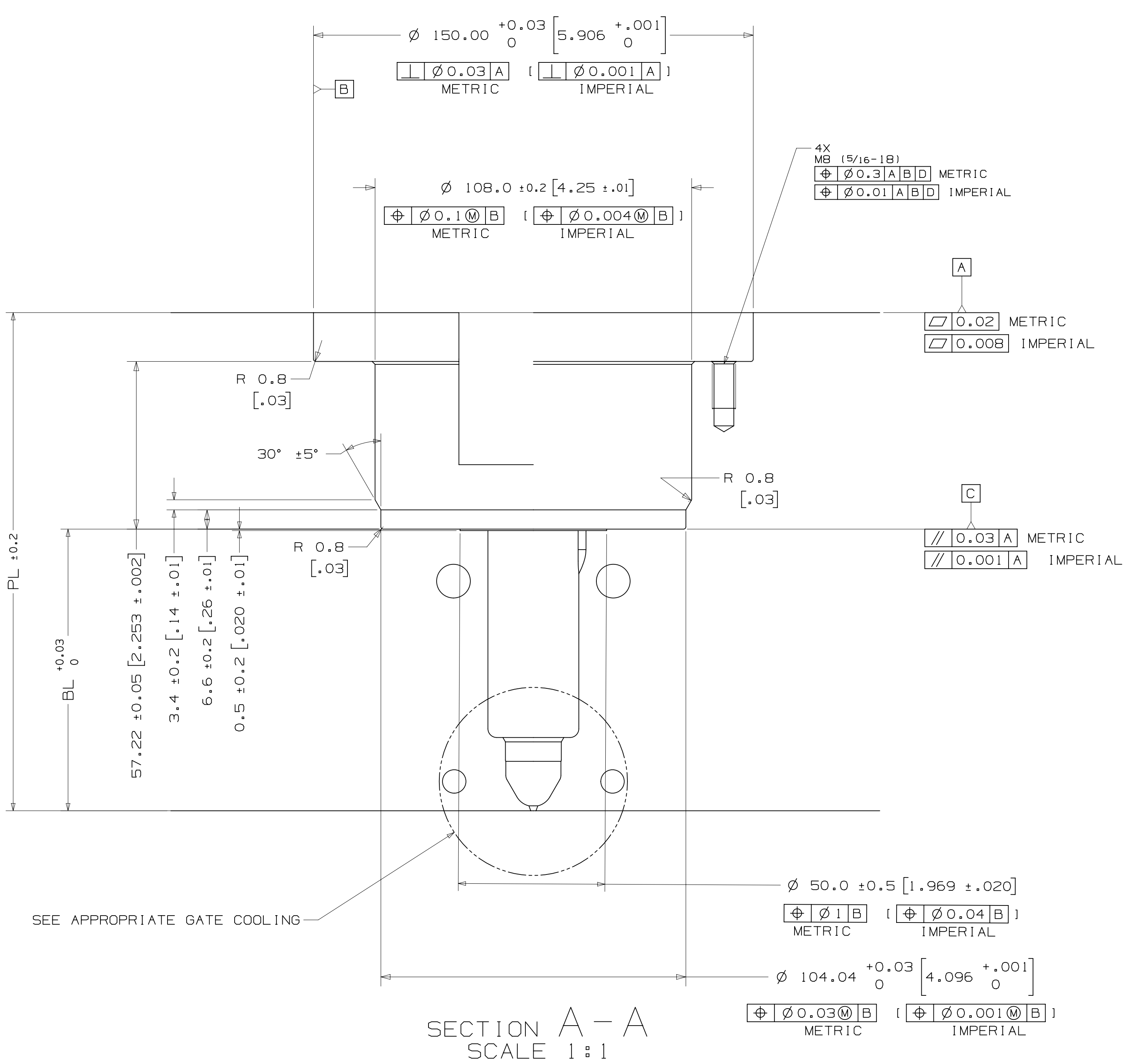
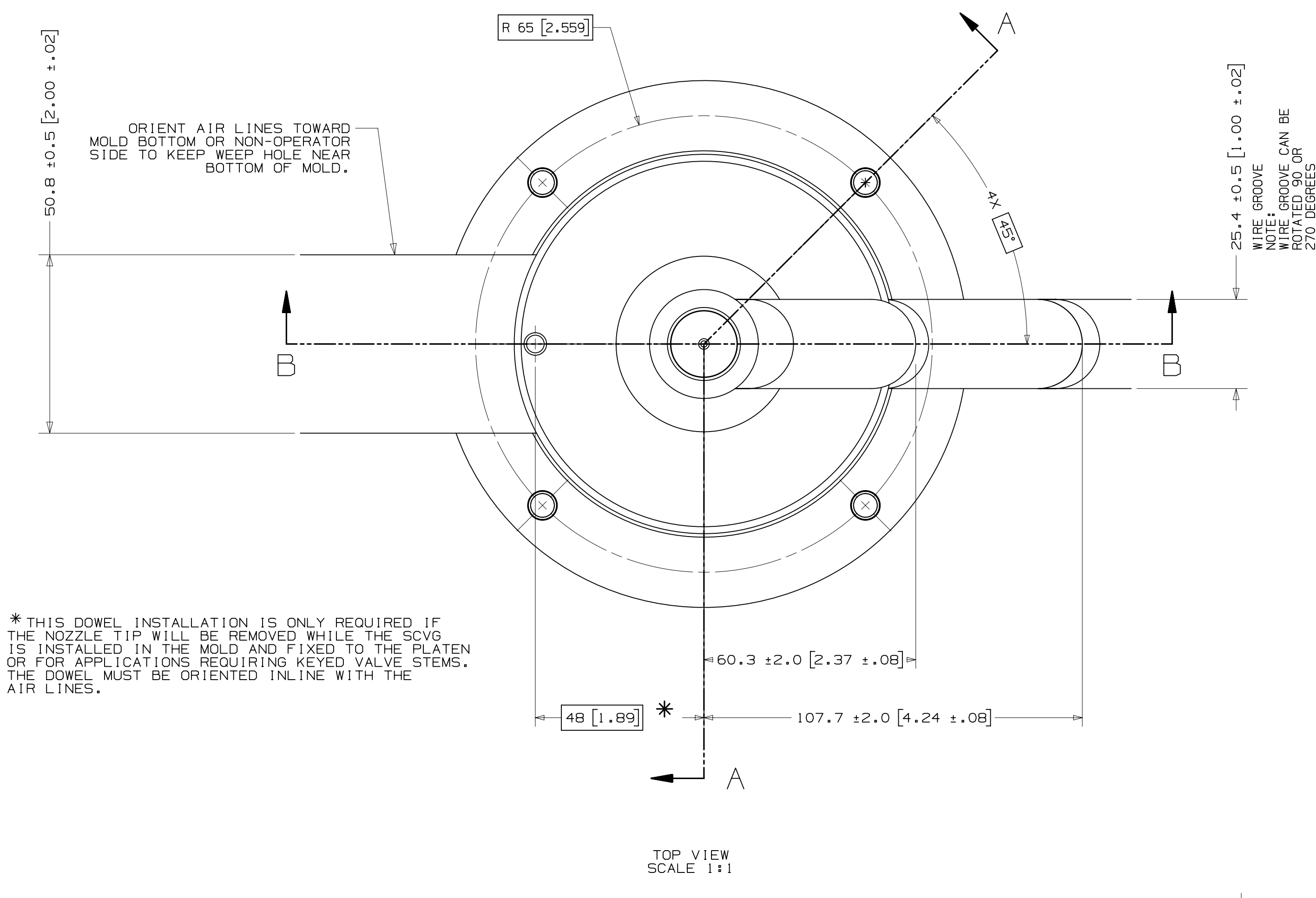


# INSTALLATION DRAWING

REV: 0  
8142261



| NOZZLE SERIES | NOZZLE TIP | PL RANGE                       | Approx. BL*          |
|---------------|------------|--------------------------------|----------------------|
| U750          | VG-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.

| U750        | SPRUE BUSHING         |                    |
|-------------|-----------------------|--------------------|
|             | SEAL-OFF GEOMETRY     | CHANNEL Ø IN - OUT |
|             | FLAT                  | 6.35 - 11.5        |
|             | FLAT                  | 6.35 - 11.5        |
|             | SEAL-OFF 12.7 (1/2")  | 11.5 - THRU        |
|             | SEAL-OFF 15.5         | 11.5 - THRU        |
|             | SEAL-OFF 19.05 (3/4") | 11.5 - THRU        |
| SEAL-OFF 20 | 11.5 - THRU           |                    |
| SEAL-OFF 40 | 11.5 - THRU           |                    |

| U750 | LOCATING RING DIAMETER |
|------|------------------------|
| U750 | 100mm                  |
| U750 | 101.3mm [3.99"]        |
| U750 | 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](http://www.husky.co)

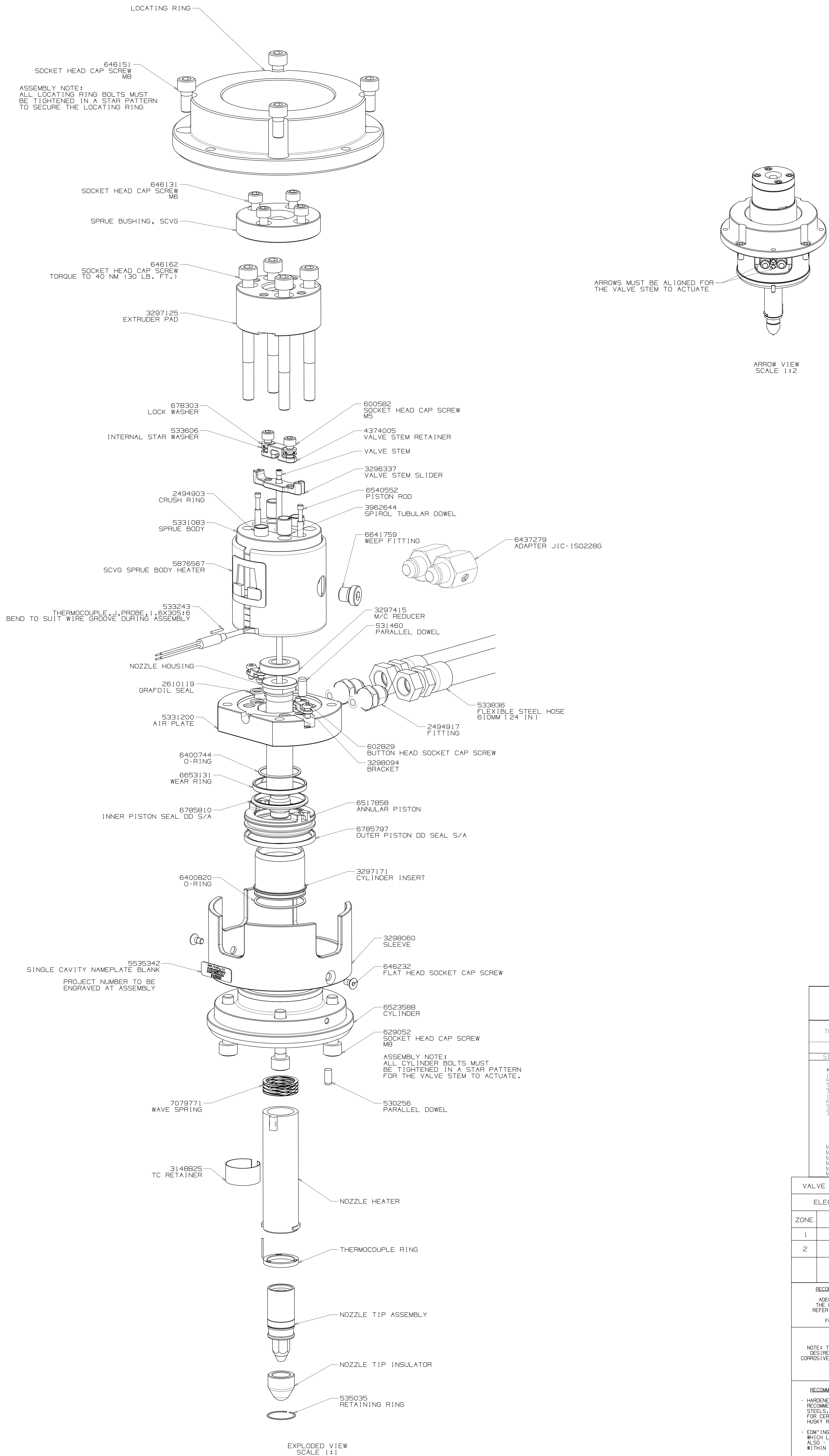
**RECOMMENDED GATE MATERIAL**  
NOTE: THESE MATERIALS MAY NOT OFFER THE DESIRED RESISTANCE TO ABRASIVE AND/OR CORROSIVE RESINS, FILLERS AND/OR ADDITIVES.  
AISI H13 (49-51 Rc)  
AISI 420 (49-51 Rc)

**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                               | DESIGNED BY         | CHECKED BY |
|-----|------------|---|---------------------|------------|
| 5   | 2020-05-30 | TABLE UPDATED PER LATEST CALCULATION      | DRWIN DEEBAN N T    | CHKD1      |
| 3   | 2019-07-09 | TEMPLATE VALUES UPDATED AS PER SOL. 2.0   | DRWIN MURALIDHARAN  | CHKD1      |
| 2   | 2018-04-06 | DRAWING NAME CHANGED                      | DRWIN ANUSHAL       | CHKD1      |
| 1   | 2018-01-12 | BL NOTE UPDATED                           | DRWIN DHANANLEYAN   | CHKD1      |
| 0   | 2017-09-09 | ORIGINAL ISSUE - DESIGNED BY: DHANANLEYAN | DRWIN DHANANLEYAN   | CHKD1      |
|     |            |   | DRWIN PICHLER KLAUS | CHKD1      |

| LAST PER ASME Y14.5M-1994 AND HEAVY ADDENDUM - H2014 |              | UNFINISHED DRAWING FEATURES               |        | MATERIAL         |   | FINISH/TREATMENT |  | WEIGHT |  |
|--|--------------|---|--------|------------------|---|------------------|--|--------|--|
| GENERAL TOLERANCES:                                  | AS BASIC     | FINISH/TREATMENT:                         | N/A    | WEIGHT:          | - | kg               |  |        |  |
| BROKEN EDGE/CHAMFER:                                 | 1 ±0.2 X 45° | SCALE:                                    | 1:1    |                  |   |                  |  |        |  |
| FILLET/RADIUS:                                       | R0.8 ±0.2    | SIZE:                                     | AOR    |                  |   |                  |  |        |  |
| SURFACE FINISH:                                      | Ra 0.8 ±0.01 | SHEET:                                    | 1 OF 2 |                  |   |                  |  |        |  |
|  |              | TITLE: Single Cavity Valve Gate U750_VG-R |        | DRAWING: 8142261 |   | REV: 0           |  |        |  |

# 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    | 5.2     |
| 1/4   | 16   | 12      |
| 5/16  | 25   | 18      |
| 3/8   | 35   | 26      |
| 1/2   | 65   | 48      |
| 5/8   | 95   | 70      |
| 3/4   | 150  | 110     |
| 7/8   | 250  | 180     |
| 1   | 350  | 260     |
| M4  | 70   | 52      |
| M5  | 100  | 74      |
| M6  | 16   | 12      |
| M8  | 29   | 21      |
| M10   | 39   | 29      |
| M12   | 52   | 38      |
| M14   | 77   | 57      |
| M16   | 135  | 100     |
| M20   | 215  | 160     |
| M25   | 350  | 258     |
| M30   | 550  | 400     |
| M36   | 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:<br>WHITE = (+)<br>RED = (-) |                  |

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|-----|------------|--|-----------------------|
| 5   | 2020-05-30 | TABLE UPDATED PER LATEST CALCULATION     | DRWINI DEEBAN N T     |
| 3   | 2019-07-09 | TEMPLATE VALUES UPDATED AS PER SOL. 2.0  | DRWINI MURALIDHARAN   |
| 2   | 2018-04-06 | DRAWING NAME CHANGED                     | DRWINI ANUSHAL        |
| 1   | 2018-01-12 | DL NOTE UPDATED                          | DRWINI DHANALEYAN     |
| 0   | 2017-09-09 | ORIGINAL ISSUE - DESIGNED BY: DHANALEYAN | DRWINI DHANALEYAN     |
|     |            |  | DRWINI PITCHLER KLAUS |

|                            |   |                          |
|----------------------------|---|--------------------------|
| UNDEFINED DRAWING FEATURES | METRIC  | <b>HUSKY</b>             |
| MATERIAL: N/A              | DO NOT DRAW AND INFORMATION UNLESS SPECIFIED IN THE DRAWING     | TITLE: SCVG              |
| FINISH/TREATMENT           | NO DIMENSIONS UNLESS SPECIFIED IN THE DRAWING                   | Single Cavity Valve Gate |
| WEIGHT: - kg               | NO INTELLECTUAL PROPERTY RIGHTS ARE CLAIMED OR GRANTED BY HUSKY | U750_VG-R                |
|                            | ALL RIGHTS RESERVED. COPYRIGHT © 2020 HUSKY                     | SCALE: 1:1               |
|                            |   | SIZE: AOR                |
|                            |   | DRAWING NO: 8142261      |
|                            |   | REV: 0                   |