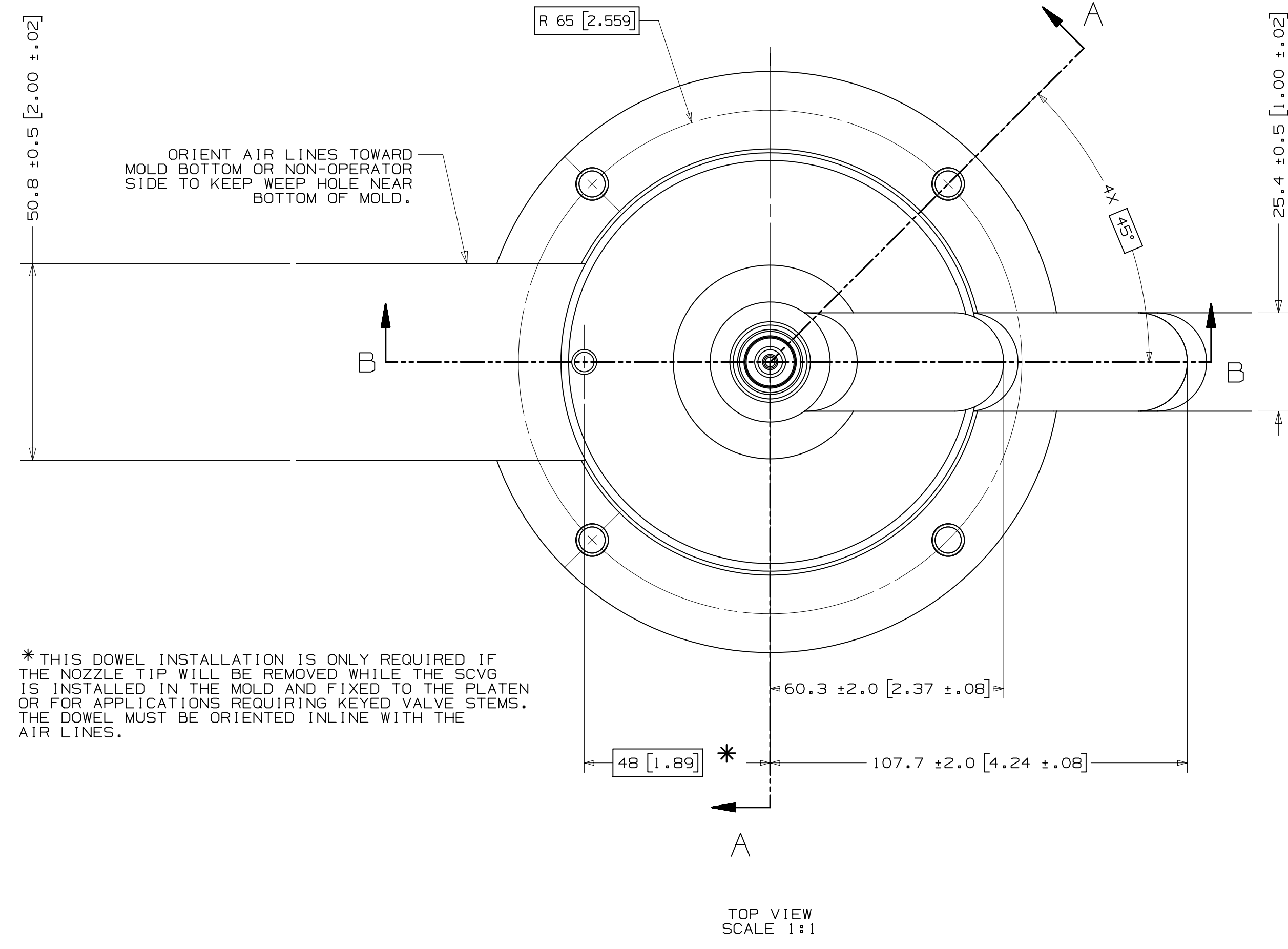


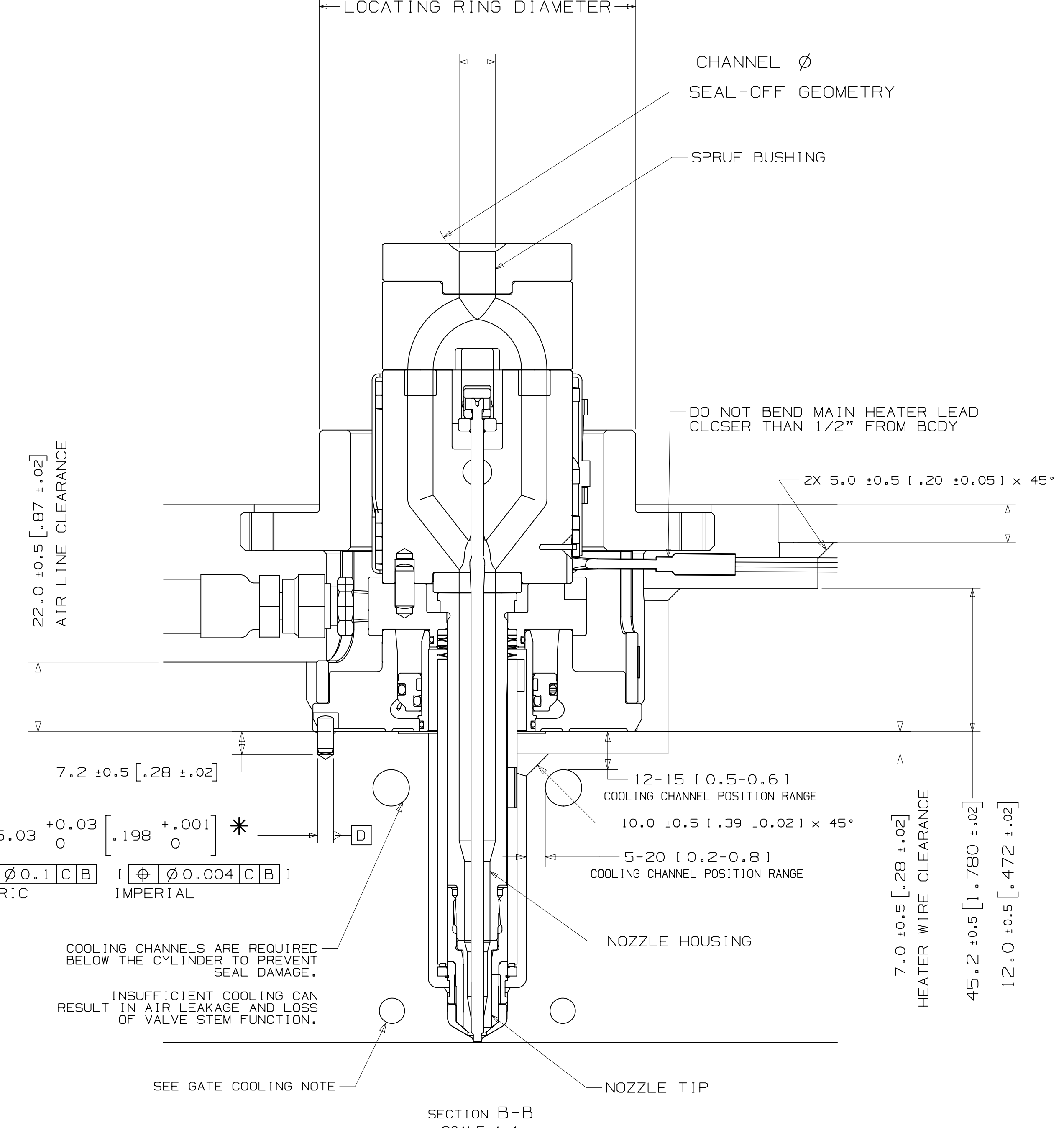
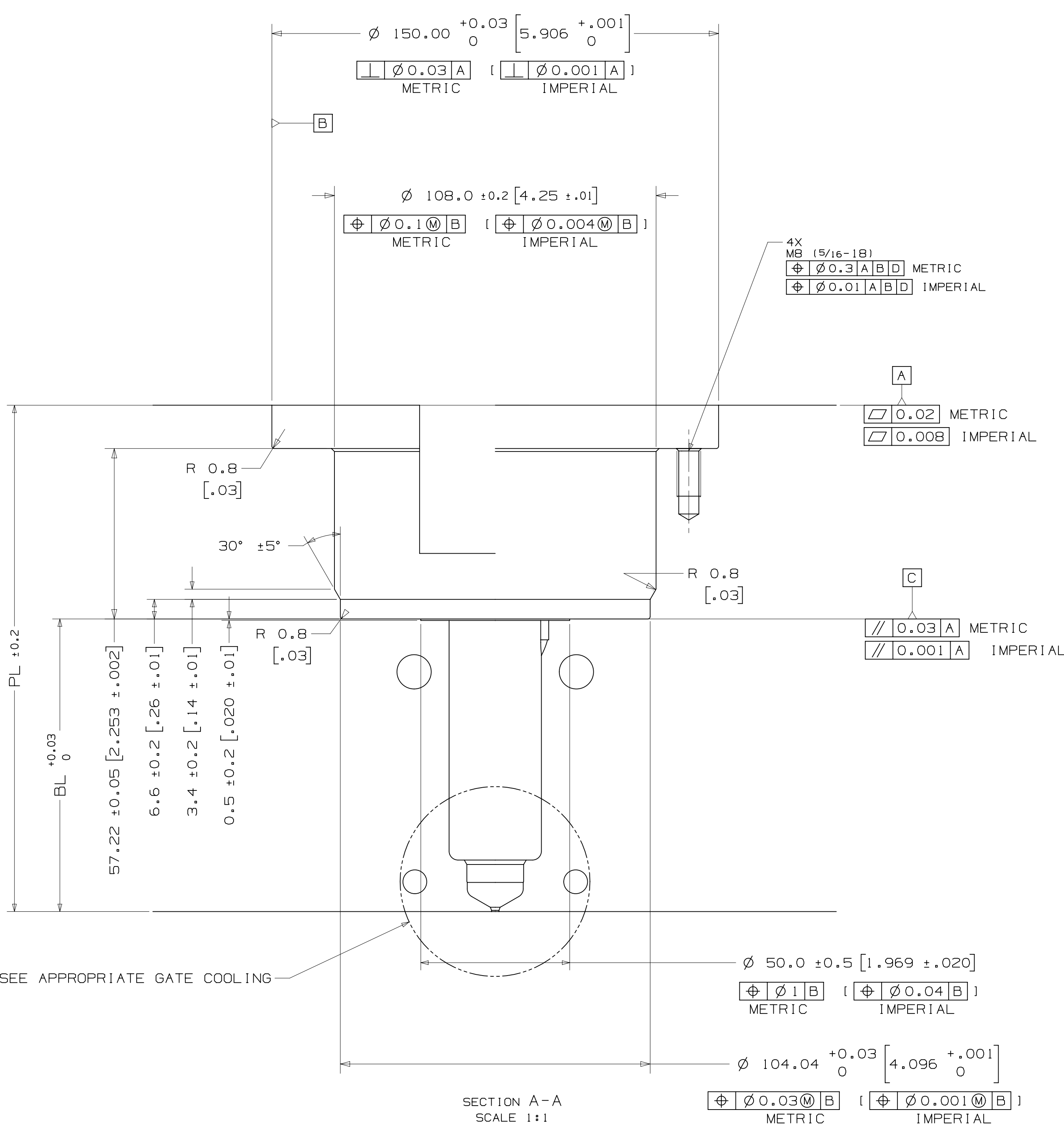
INSTALLATION DRAWING

REV 0
7972286



* 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



NOZZLE SERIES	NOZZLE TIP	NOZZLE HOUSING		PL		*BL* AT DELTA TEMP (DELTA TEMP = TEMP OF MELT - TEMP OF MOLD) *																
		LENGTH	MIN (INCH)	MAX (INCH)	60° C-79° C (140° F-174° F)	80° C-99° C (116° 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 (484° F-498° F)	260° C-279° C (500° F-534° F)	280° C-300° C (538° F-572° F)						
U750	VG	50	108 [4.252]	117 [4.606]	37.96 [1.494]	37.98 [1.495]	38.00 [1.496]	38.02 [1.497]	38.03 [1.497]	38.05 [1.498]	38.06 [1.498]	38.08 [1.499]	38.09 [1.500]	38.11 [1.500]	38.13 [1.501]	38.13 [1.501]						
		60	118 [4.646]	127 [5.000]	47.97 [1.889]	47.99 [1.889]	48.00 [1.890]	48.02 [1.891]	48.04 [1.891]	48.05 [1.892]	48.07 [1.893]	48.09 [1.893]	48.10 [1.894]	48.12 [1.894]	48.14 [1.895]	48.16 [1.896]						
		70	128 [5.039]	137 [5.394]	57.98 [2.283]	58.00 [2.283]	58.02 [2.284]	58.03 [2.285]	58.05 [2.285]	58.07 [2.286]	58.09 [2.287]	58.11 [2.288]	58.13 [2.289]	58.15 [2.289]	58.18 [2.291]	58.20 [2.291]						
		80	138 [5.433]	147 [5.787]	67.99 [2.677]	68.01 [2.678]	68.03 [2.678]	68.05 [2.679]	68.07 [2.680]	68.09 [2.681]	68.11 [2.681]	68.14 [2.683]	68.16 [2.683]	68.18 [2.684]	68.21 [2.685]	68.23 [2.686]						
		90	148 [5.827]	157 [6.181]	77.99 [3.070]	78.02 [3.072]	78.04 [3.072]	78.06 [3.073]	78.09 [3.074]	78.11 [3.075]	78.14 [3.076]	78.16 [3.077]	78.19 [3.078]	78.21 [3.079]	78.24 [3.080]	78.27 [3.081]						
		100	158 [6.220]	167 [6.575]	88.00 [3.465]	88.03 [3.466]	88.05 [3.467]	88.08 [3.468]	88.10 [3.469]	88.13 [3.470]	88.15 [3.471]	88.19 [3.472]	88.21 [3.473]	88.24 [3.474]	88.27 [3.475]	88.30 [3.476]						
		110	168 [6.614]	177 [6.969]	98.01 [3.859]	98.04 [3.860]	98.06 [3.861]	98.09 [3.862]	98.12 [3.863]	98.15 [3.864]	98.18 [3.865]	98.21 [3.867]	98.24 [3.868]	98.27 [3.869]	98.31 [3.870]	98.34 [3.872]						
		120	178 [7.008]	187 [7.362]	108.02 [4.253]	108.05 [4.254]	108.08 [4.255]	108.11 [4.256]	108.14 [4.257]	108.17 [4.259]	108.20 [4.260]	108.23 [4.261]	108.27 [4.263]	108.30 [4.264]	108.34 [4.265]	108.37 [4.267]						
		130	188 [7.402]	197 [7.756]	118.03 [4.647]	118.06 [4.648]	118.09 [4.649]	118.12 [4.650]	118.16 [4.652]	118.19 [4.653]	118.22 [4.654]	118.26 [4.656]	118.29 [4.657]	118.33 [4.659]	118.37 [4.660]	118.41 [4.662]						
		140	198 [7.795]	207 [8.150]	128.03 [5.041]	128.07 [5.042]	128.10 [5.043]	128.14 [5.045]	128.17 [5.046]	128.21 [5.048]	128.25 [5.049]	128.28 [5.050]	128.32 [5.052]	128.36 [5.054]	128.40 [5.055]	128.44 [5.057]						
		150	208 [8.189]	217 [8.543]	138.04 [5.435]	138.08 [5.436]	138.11 [5.437]	138.15 [5.439]	138.19 [5.441]	138.23 [5.442]	138.27 [5.444]	138.31 [5.445]	138.35 [5.447]	138.39 [5.448]	138.44 [5.450]	138.48 [5.452]						
160	218 [8.583]	227 [8.937]	148.05 [5.829]	148.09 [5.830]	148.13 [5.832]	148.17 [5.833]	148.21 [5.835]	148.25 [5.837]	148.29 [5.838]	148.33 [5.840]	148.37 [5.841]	148.42 [5.843]	148.47 [5.845]	148.51 [5.847]								
170	228 [8.976]	237 [9.331]	158.06 [6.223]	158.10 [6.224]	158.14 [6.226]	158.18 [6.228]	158.22 [6.229]	158.27 [6.231]	158.31 [6.233]	158.36 [6.235]	158.40 [6.236]	158.45 [6.238]	158.50 [6.240]	158.55 [6.242]								
180	238 [9.370]	247 [9.724]	168.06 [6.617]	168.11 [6.619]	168.15 [6.620]	168.20 [6.622]	168.24 [6.624]	168.29 [6.626]	168.33 [6.627]	168.38 [6.629]	168.43 [6.631]	168.48 [6.633]	168.53 [6.635]	168.58 [6.637]								
190	248 [9.764]	257 [10.118]	178.07 [7.011]	178.12 [7.013]	178.16 [7.014]	178.21 [7.016]	178.26 [7.018]	178.31 [7.020]	178.36 [7.022]	178.41 [7.024]	178.46 [7.026]	178.51 [7.028]	178.57 [7.030]	178.62 [7.032]								
200	258 [10.157]	268 [10.551]	188.08 [7.405]	188.13 [7.407]	188.18 [7.409]	188.23 [7.411]	188.28 [7.413]	188.33 [7.415]	188.38 [7.417]	188.43 [7.419]	188.48 [7.420]	188.54 [7.423]	188.60 [7.425]	188.65 [7.427]								

* 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	SPRUE BUSHING		
U750	SEAL-OFF GEOMETRY	11.5-THRU	
	100mm		SEAL-OFF 12.7 (1/2")
	101.3mm (3.99")		SEAL-OFF 15.5
	125mm		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)

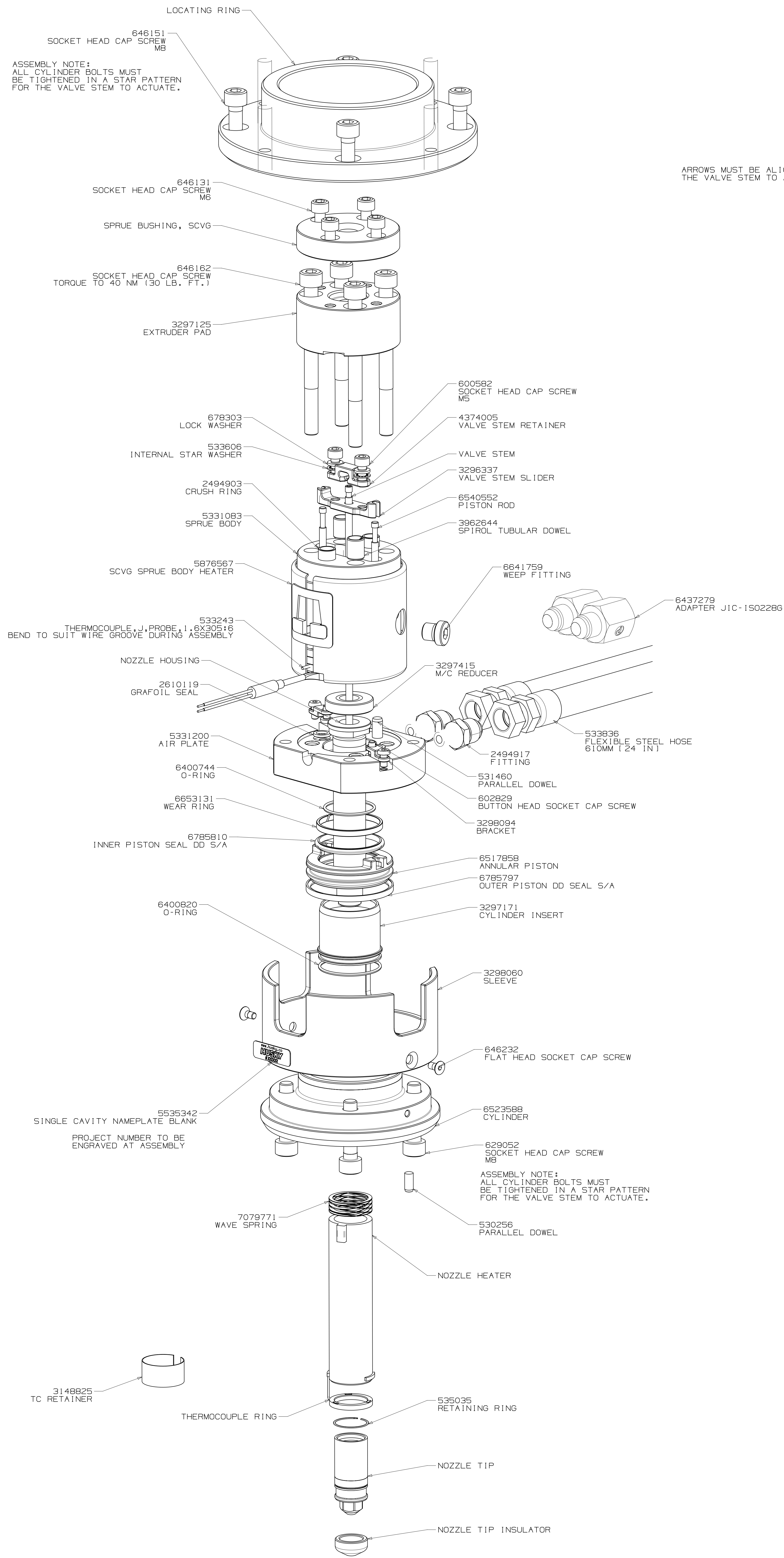
RECOMMENDED GATE MANUFACTURING GUIDELINES
- HARDENED GATE INSERTS (49-51) ARE RECOMMENDED WHEN USING SOFTER CAVITY STEELS. SOFTER CAVITIES MAY BE ACCEPTABLE FOR CERTAIN APPLICATIONS. CONTACT YOUR HUSKY REPRESENTATIVE WITH QUESTIONS.
- EDM'ING THE GATE AREA CAUSES MICRO CRACKS WHICH LEAD TO BRITTLE GATE 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. SOFTENS THE AREA AROUND THE WELD AND CAN CAUSE GATE FAILURES.

REV	DATE	DESCRIPTION	DRWN	CHKD
0	2017-09-08	ORIGINAL ISSUE - DESIGNED BY: DHANANLEYAN	DRWN: DHANANLEYAN	CHKD: PICHLER KILIAS

QST PER ASME Y14.5M-1994 AND HEAVY ADDENDUM - H254 DIMENSIONS UNLESS OTHERWISE SPECIFIED ARE IN MILLIMETERS UNLESS OTHERWISE SPECIFIED ARE METRIC			UNFINISHED DRAWING FEATURES TO SHIP # THIS DRAWING SUPPLIER QUALITY REFERENCE			METRIC: 0.01, 0.03, 0.05, 0.1, 0.2, 0.3, 0.5, 1, 2, 3, 5, 10, 20, 30, 50, 100 IMPERIAL: 0.001, 0.003, 0.005, 0.01, 0.02, 0.03, 0.05, 0.1, 0.2, 0.3, 0.5, 1, 2, 3, 5, 10, 20, 30, 50, 100		
GENERAL TOLERANCES: ± 0.10 METRIC, ± 0.0075 IMPERIAL HOLE FINISH: $R_{a} 1.6$			HUSKY TITLE: SCVG Single Cavity Valve Gate U750-SCVG-VG			DRAWING NO.: 7972286 SHEET: 1 OF 2		

ASSEMBLY DRAWING

DRAWING NO. 7972286 REV. 0



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	200	150
1	250	180
1 1/8	350	250
1 1/4	450	330
M4	4.0	3.0
M5	5.0	3.7
M6	6.0	4.4
M8	10.0	7.4
M10	15.0	11.0
M12	20.0	14.7
M14	25.0	18.3
M16	35.0	25.7
M20	60.0	44.1
M25	110.0	80.7

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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REV	DATE	DESCRIPTION	DRWN	CHKD
0	2017-09-08	ORIGINAL ISSUE - DESIGNED BY: DHANALEYAN	DRWN1	CHKD1
			DRWN2	CHKD2
			DRWN3	CHKD3
			DRWN4	CHKD4
			DRWN5	CHKD5
			DRWN6	CHKD6
			DRWN7	CHKD7
			DRWN8	CHKD8
			DRWN9	CHKD9
			DRWN10	CHKD10

MATERIAL	FINISH/TREATMENT	WEIGHT	SCALE	SIZE	DRAWING	REV
N/A		- kg	1:1	AOR	7972286	0