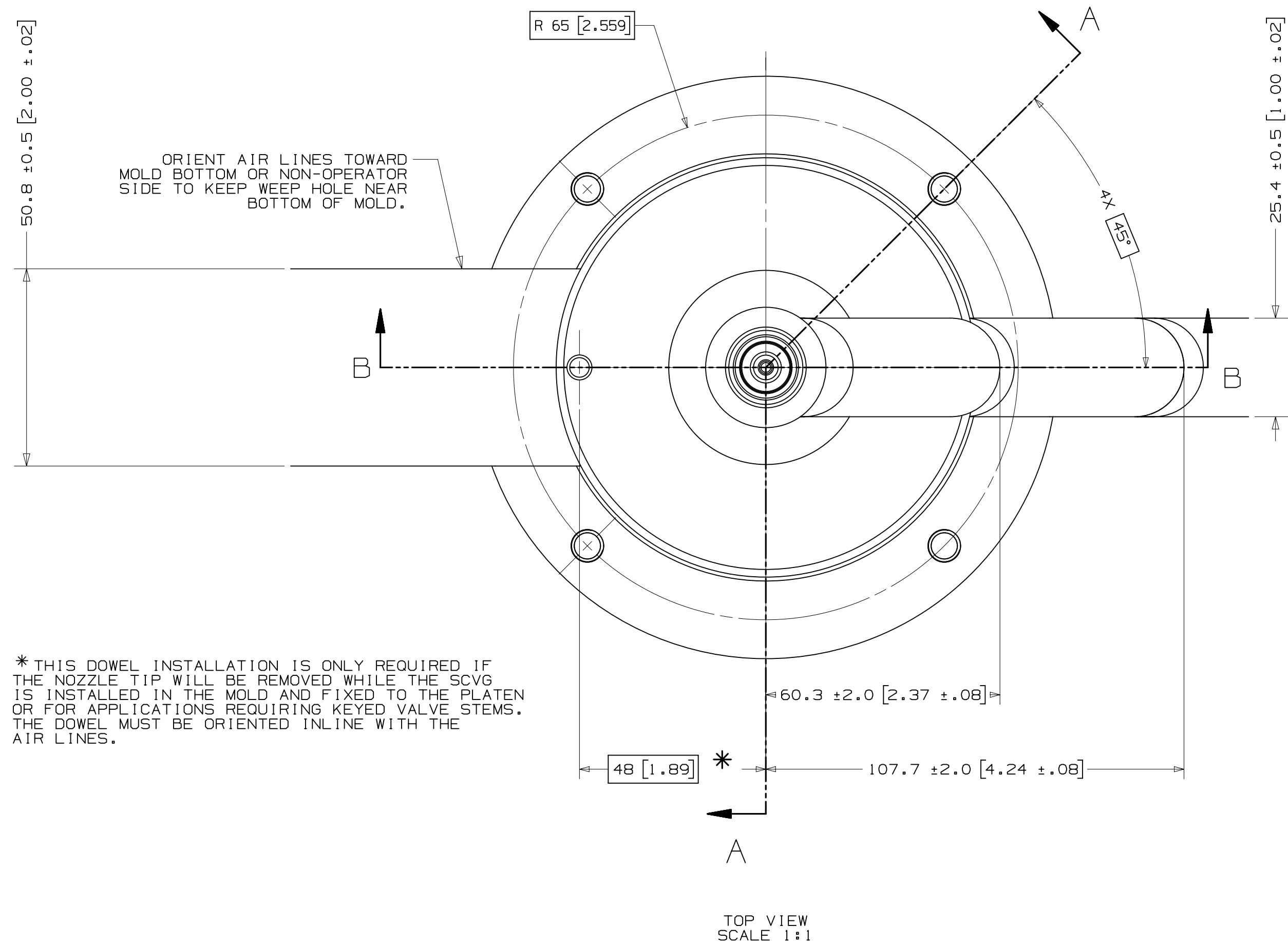


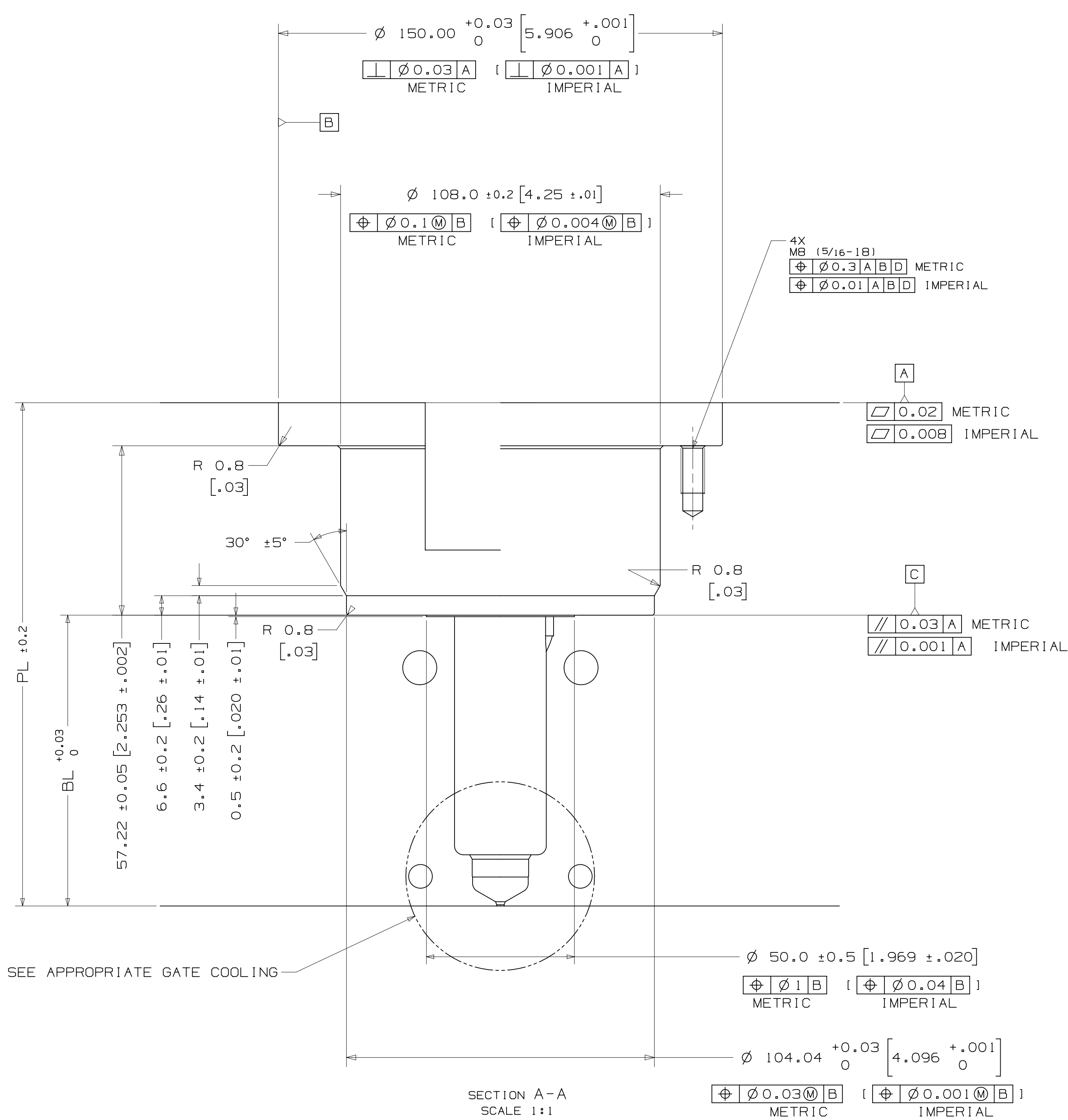
# INSTALLATION DRAWING

DRAWING NO. 7972286

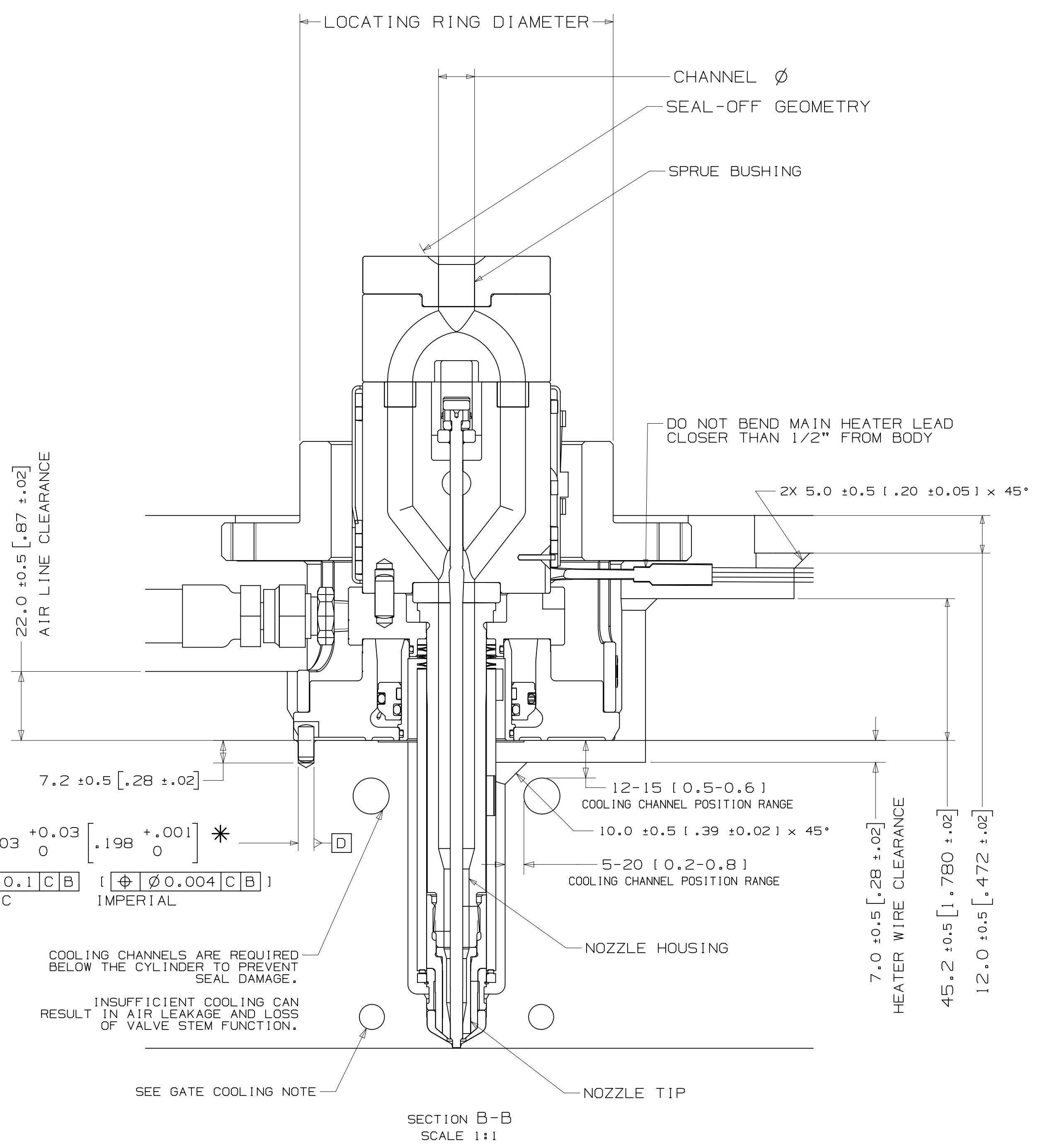


\* THIS DOWEL INSTALLATION IS ONLY REQUIRED IF THE NOZZLE TIP WILL BE REMOVED WHILE THE SCVG IS INSTALLED IN THE MOLD AND FIXED TO THE PLATEN OR FOR APPLICATIONS REQUIRING KEYS VALVE STEMS. THE DOWEL MUST BE ORIENTED IN LINE WITH THE AIR LINES.

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	107.57(4,235) - 267.93(10,548)	38(1,50) - 188(7,40)

\*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
	SPHERICAL RADIUS	6.35 - 11.5
	FLAT	
	SEAL-OFF 12.7 (1/2")	11.5-THRU
	SEAL-OFF 15.5	
	SEAL-OFF 19.05 (3/4")	
	SEAL-OFF 20	
	SEAL-OFF 40	

U750	LOCATING RING DIAMETER
	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](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)

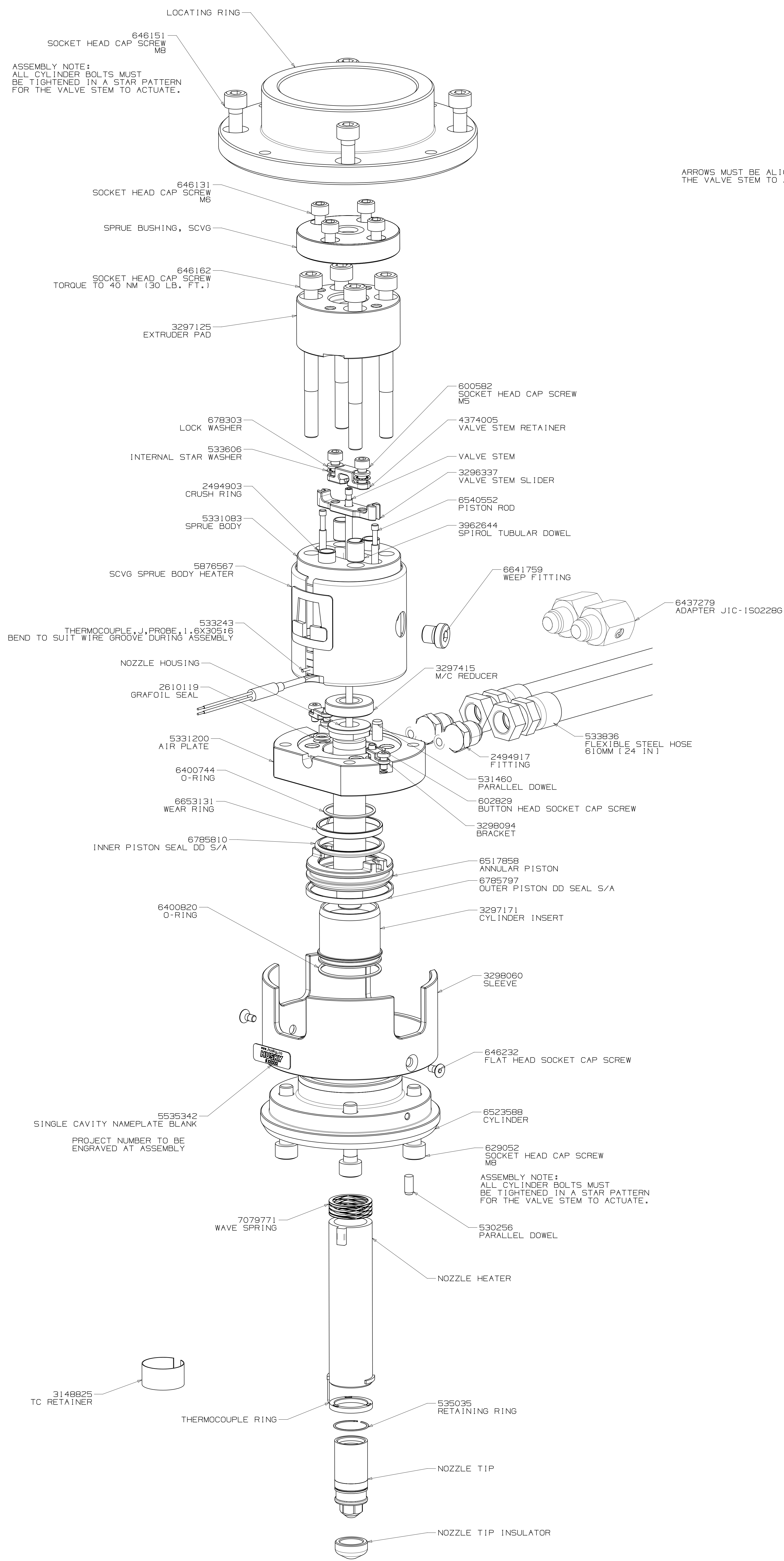
**RECOMMENDED GATE MANUFACTURING GUIDELINES**  
- HARDENED GATE INSERTS (49-51) ARE RECOMMENDED WHEN USING SOFTER CAVITY STEELS. SOFTER CAVITIES MAY BE ACCEPTABLE FOR CERTAIN APPLICATIONS. CONTACT YOUR HUSKY REPRESENTATIVE WITH QUESTIONS.  
- EDM'ING THE GATE AREA CAUSES MICRO CRACKS WHICH LEAD TO BRITTLE 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	DRAWN BY
4	2020-05-29	TABLE UPDATED PER LATEST CALCULATION	DRWINI DEEBAN N T	CHKD: DRWINI DEEBAN N T
3	2019-07-09	TEMPLATE VALUES UPDATED AS PER SOL. 2.0	DRWINI MURALIDHARAN	CHKD: DRWINI MURALIDHARAN
2	2018-04-06	DRAWING NAME CHANGED	DRWINI ANUSHAL	CHKD: DRWINI ANUSHAL
1	2018-01-12	BL NOTE UPDATED	DRWINI DHANANLEYAN	CHKD: DRWINI DHANANLEYAN
0	2017-09-08	ORIGINAL ISSUE - DESIGNED BY: DHANANLEYAN	DRWINI DHANANLEYAN	CHKD: DRWINI DHANANLEYAN

DATE PER ASME Y14.5M-1994 AND HEAVY ADDENDUM - H2014	UNFINISHED DRAWING FEATURES	METRIC	INCH	TITLE
BASED ON THE SPECIFIED BUSINESS OPERATING SPECIFICATIONS ARE BASIC.	N/A	mm	in	Single Cavity Valve Gate
GENERAL TOLERANCES: METRIC: ±0.17 IMPERIAL: ±0.017	FINISH/TREATMENT			U750-SCVG-VG
BROKEN EDGE/CHAMFER: 1: ±0.2 X 45° 0.04 ±0.01 X 45°				SCALE: 1:1
FILLET/RADIUS: R0.8 ±0.2 R0.03 ±0.01				SIZE: AOR
SURFACE FINISH: Ra 3.2				DRAWING NO. 7972286
				SHEET 1 OF 2
				REV 0

# ASSEMBLY DRAWING

REV 0  
7972286



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
5/16	16	12
3/8	25	18
1/2	50	37
5/8	85	62
3/4	150	110
7/8	250	183
1	350	258
1 1/8	500	368
1 1/4	700	515
M4	4.6	3.4
M5	6.8	5.0
M6	9.8	7.2
M8	19	14
M10	29	21
M12	39	29
M14	59	43
M16	78	58
M20	135	100
M25	215	159
M30	350	258
M36	500	368
M42	700	515

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 FOR MORE DETAILED GUIDELINES.  
[www.husky.ca](http://www.husky.ca)

**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	DRWNG	CHKD
4	2020-05-29	TABLE UPDATED PER LATEST CALCULATION	DRWNG DEEBAN N T	CHKD
3	2019-07-09	TEMPLATE VALUES UPDATED AS PER SOL 2.0	DRWNG MURALIDHARAN	CHKD
2	2018-04-06	DRAWING NAME CHANGED	DRWNG ANUSHAL	CHKD
1	2018-01-12	BL NOTE UPDATED	DRWNG DHANALEYAN	CHKD
0	2017-09-08	ORIGINAL ISSUE - DESIGNED BY: DHANALEYAN	DRWNG DHANALEYAN	CHKD
			DRWNG PICHLER KLAUS	CHKD

MATERIAL	FINISH/TREATMENT	WEIGHT	SCALE	DRWNG	REV
N/A		- kg	1:1	7972286	0