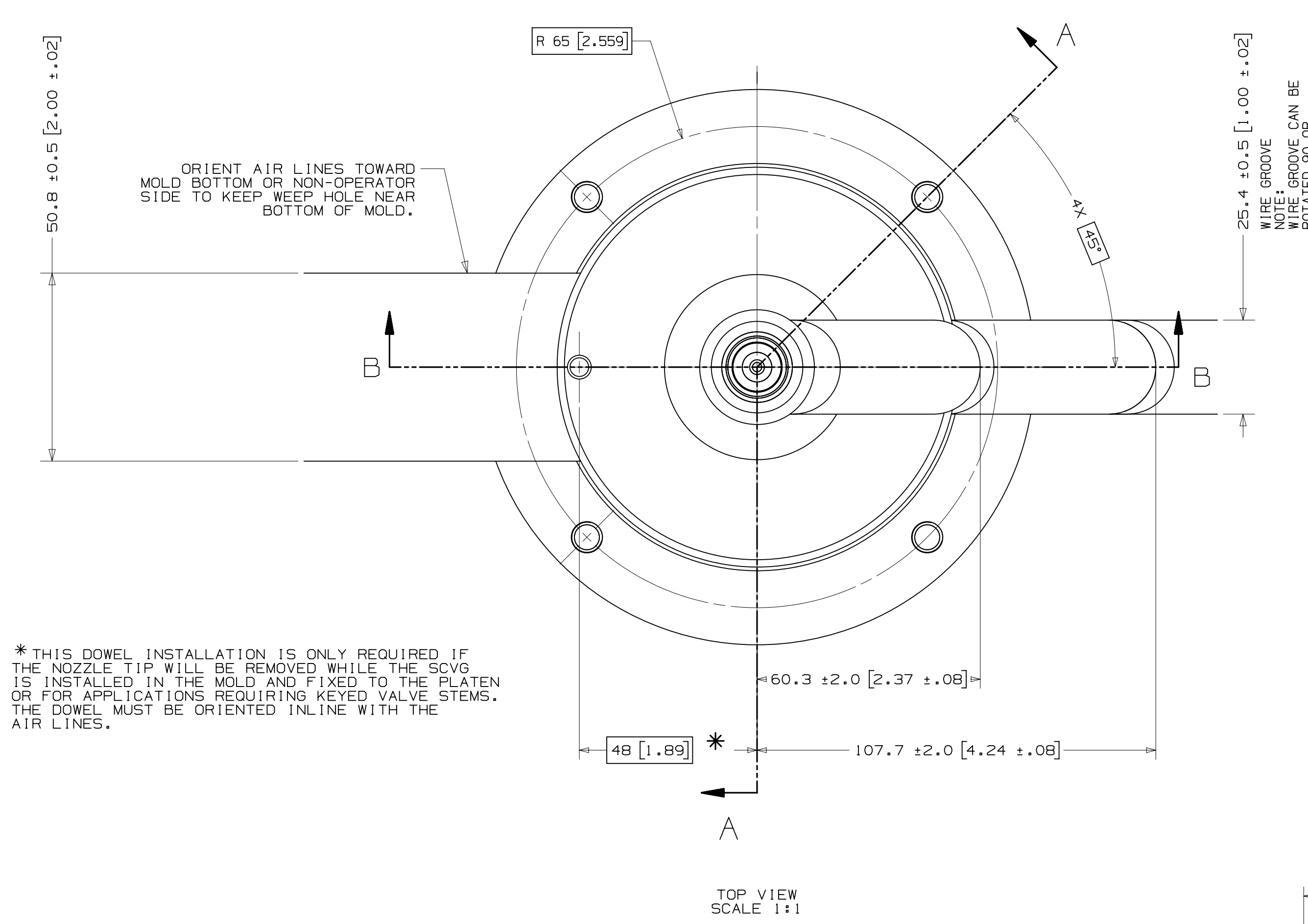
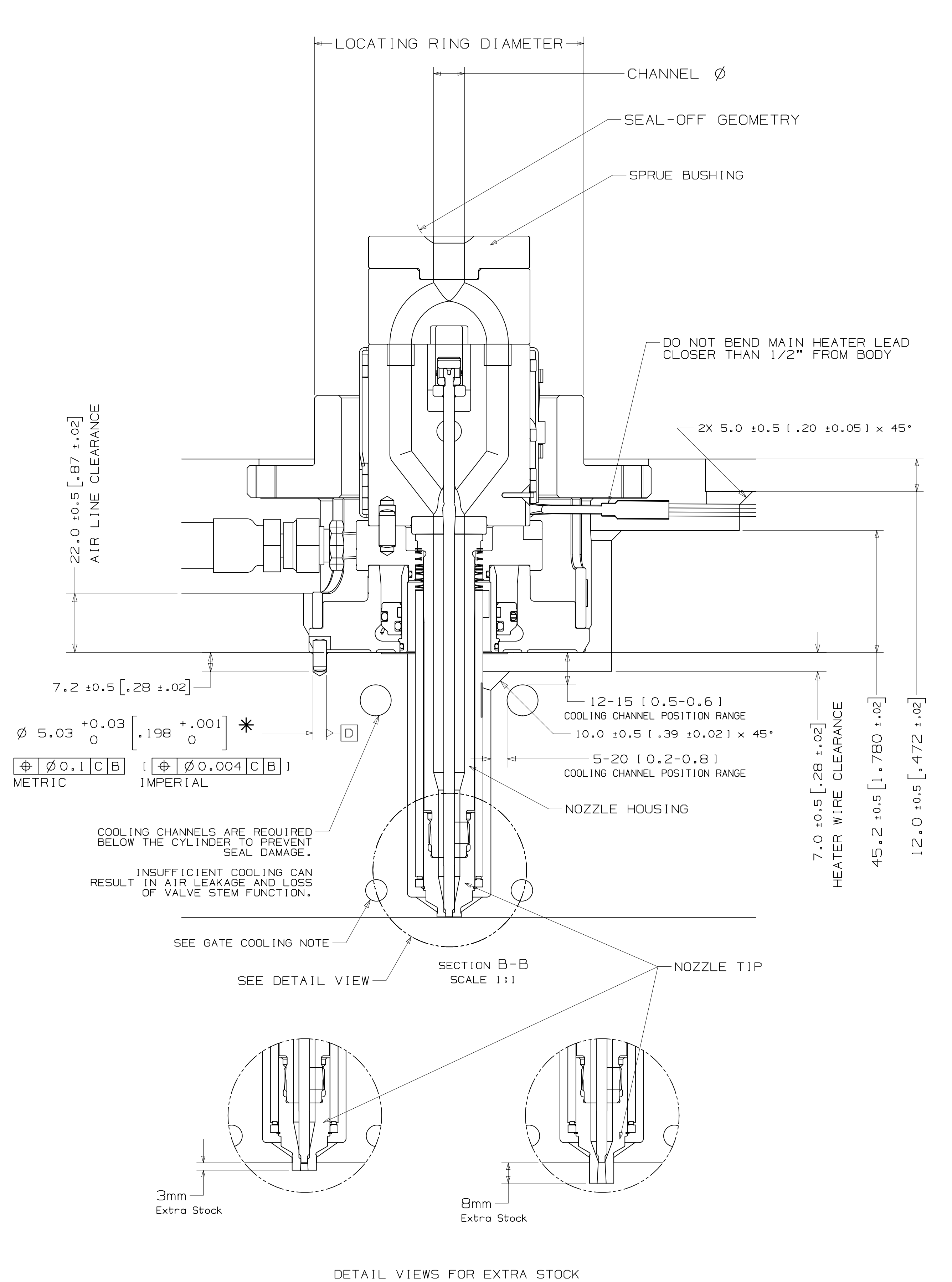
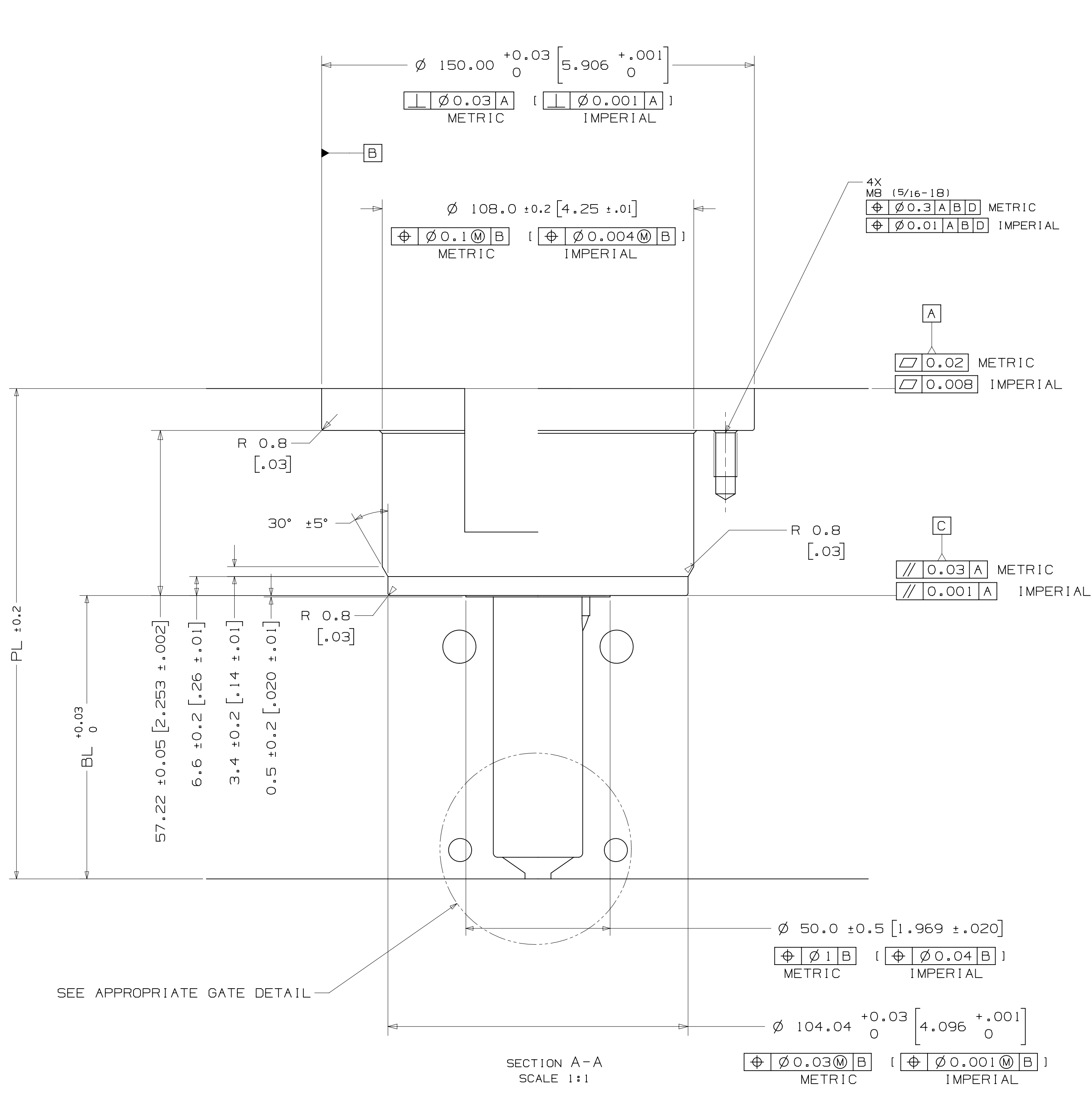


INSTALLATION DRAWING



* 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 KEVED VALVE STEMS. THE DOWEL MUST BE ORIENTED IN LINE WITH THE AIR LINES.



NOZZLE SERIES	NOZZLE TIP	PL RANGE	Approx. BL*
U750	VX / VX with extra stock 5mm / VX with extra stock 8mm	97.55(3.841) - 257.9(10.154)	28(1.10) - 178(7.01)

*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 SPHERICAL RADIUS	CHANNEL Ø IN - OUT
	FLAT	6.35 - 11.5
	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")	

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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)

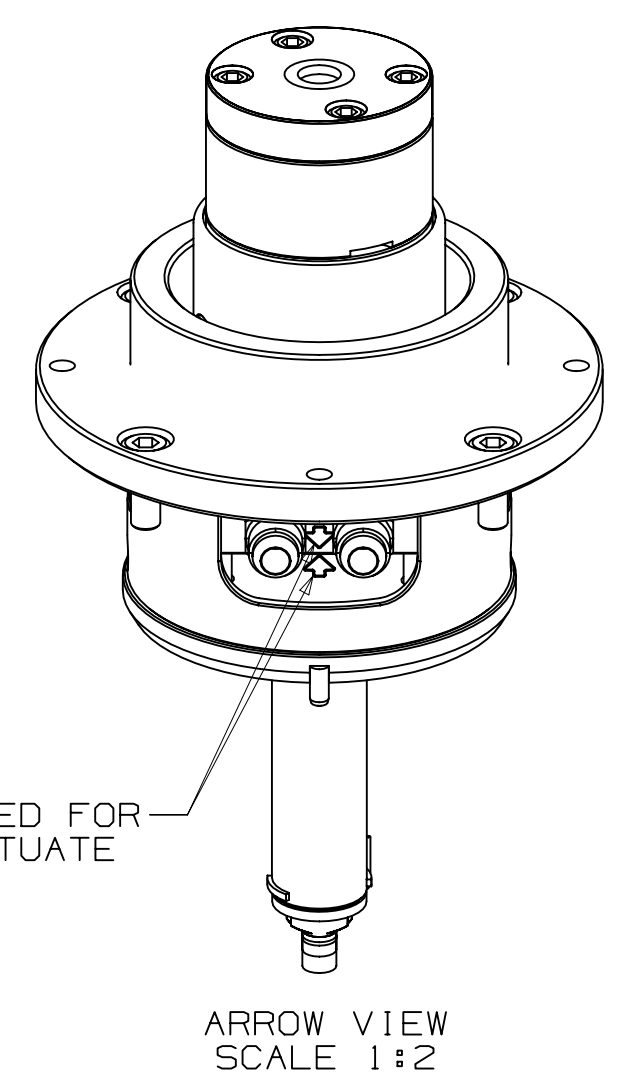
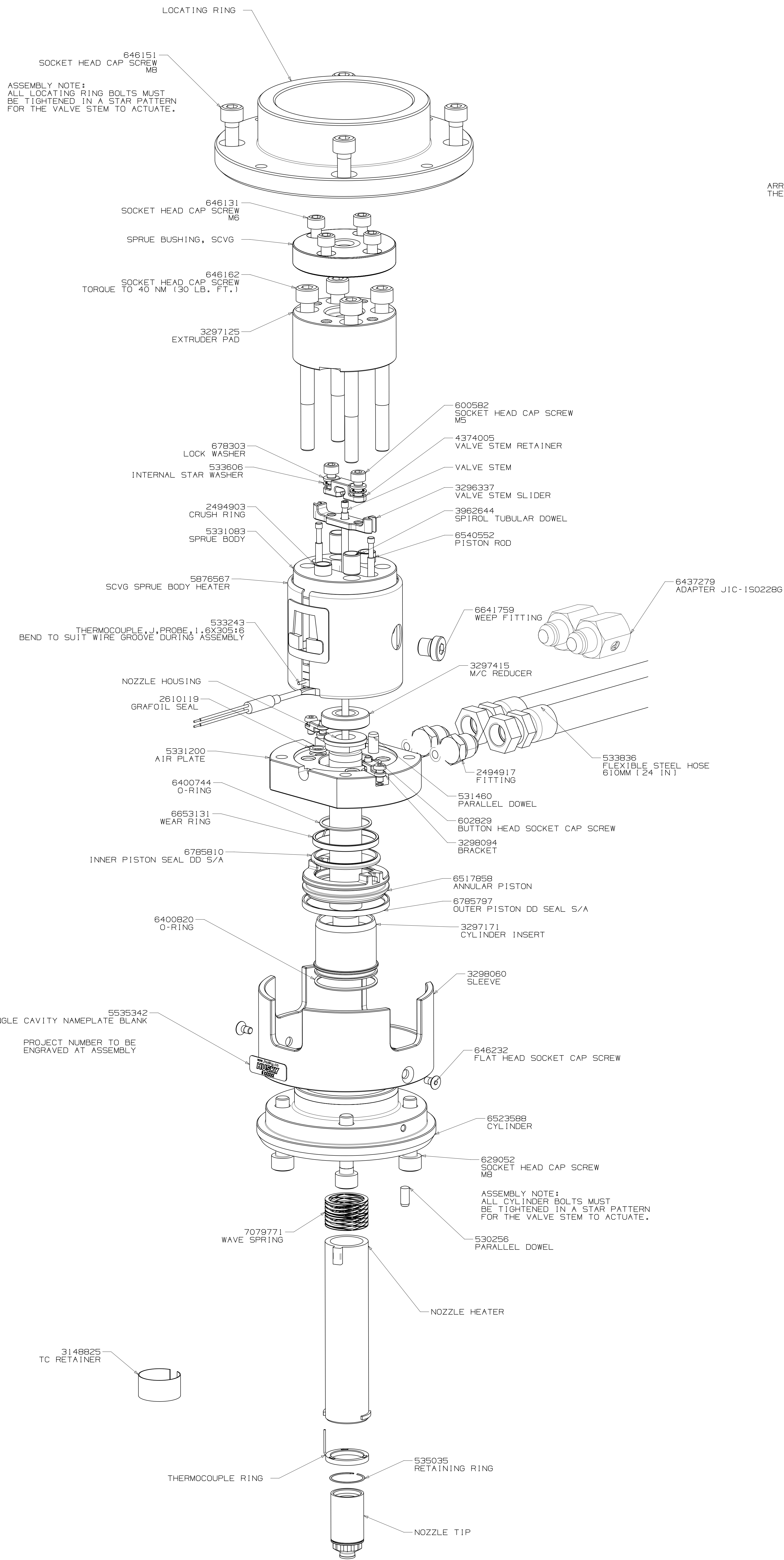
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- WELDING THE GATE AREA INCREASES STRESSES AT THE GATE, SOFTENS THE AREA AROUND THE WELD AND CAN CAUSE GATE FAILURES.

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 DHANANLEYAN	CHKD
0	2017-09-04	ORIGINAL ISSUE - DESIGNED BY: DHANANLEYAN	DRWNG DHANANLEYAN	CHKD: PICHLER KLAUS

DWT PER ASME Y14.5M-1994 AND HEAVY ADDENDUM - H254 UNLESS OTHERWISE SPECIFIED: DIM MODEL IS BASIC UNF TOLERANCES UNLESS OTHERWISE SPECIFIED: ARE BASIC GENERAL TOLERANCES: METRIC: ± 0.17 IMPERIAL: ± 0.017 BROKEN EDGE/CHAMFER: $1 \pm 0.2 \times 45^\circ$ $0.04 \pm 0.01 \times 45^\circ$ FILLET/RADIUS: $R0.8 \pm 0.2$ $R0.03 \pm 0.01$ SURFACE FINISH: 6.3	UNFINISHED DRAWING FEATURES: MATERIAL: N/A FINISH/TREATMENT: NO. OF COATINGS: 1 NO. OF COATINGS PER PART: 1 NO. OF COATINGS PER SURFACE: 1 NO. OF COATINGS PER HOLE: 1 NO. OF COATINGS PER EDGE: 1 NO. OF COATINGS PER CORNER: 1 NO. OF COATINGS PER CHAMFER: 1 NO. OF COATINGS PER RADIUS: 1 NO. OF COATINGS PER TAP: 1 NO. OF COATINGS PER THREAD: 1 NO. OF COATINGS PER GROOVE: 1 NO. OF COATINGS PER SLOT: 1 NO. OF COATINGS PER KEYWAY: 1 NO. OF COATINGS PER HOLE: 1 NO. OF COATINGS PER EDGE: 1 NO. OF COATINGS PER CORNER: 1 NO. OF COATINGS PER CHAMFER: 1 NO. OF COATINGS PER RADIUS: 1 NO. OF COATINGS PER TAP: 1 NO. OF COATINGS PER THREAD: 1 NO. OF COATINGS PER GROOVE: 1 NO. OF COATINGS PER SLOT: 1 NO. OF COATINGS PER KEYWAY: 1	HUSKY TITLE: SCVG Single Cavity Valve Gate U750-SCVG-VX SCALE: 1:1 SIZE: AOR SHEET: 1 OF 2 DRAWING NO: 8028646 REV: 0
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ASSEMBLY DRAWING

REV 0
8028646



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
7/16	35	26
1/2	50	37
5/8	75	55
3/4	100	74
7/8	150	110
1	200	148
1 1/8	250	183
1 1/2	300	221
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	14.8
M14	25.0	18.3
M16	35.0	25.8
M20	60.0	44.1
M25	110.0	81.0

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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			DRWINI PICHLER KLAUS

DEFINING DRAWING FEATURES	METRIC	HUSKY
MATERIAL	N/A	TITLE
FINISH/TREATMENT		Single Cavity SCVG
WEIGHT	- kg	U750-SCVG-VX
		SCALE 1:1
		SIZE AOR
		DRAWING
		REV
		8028646
		0