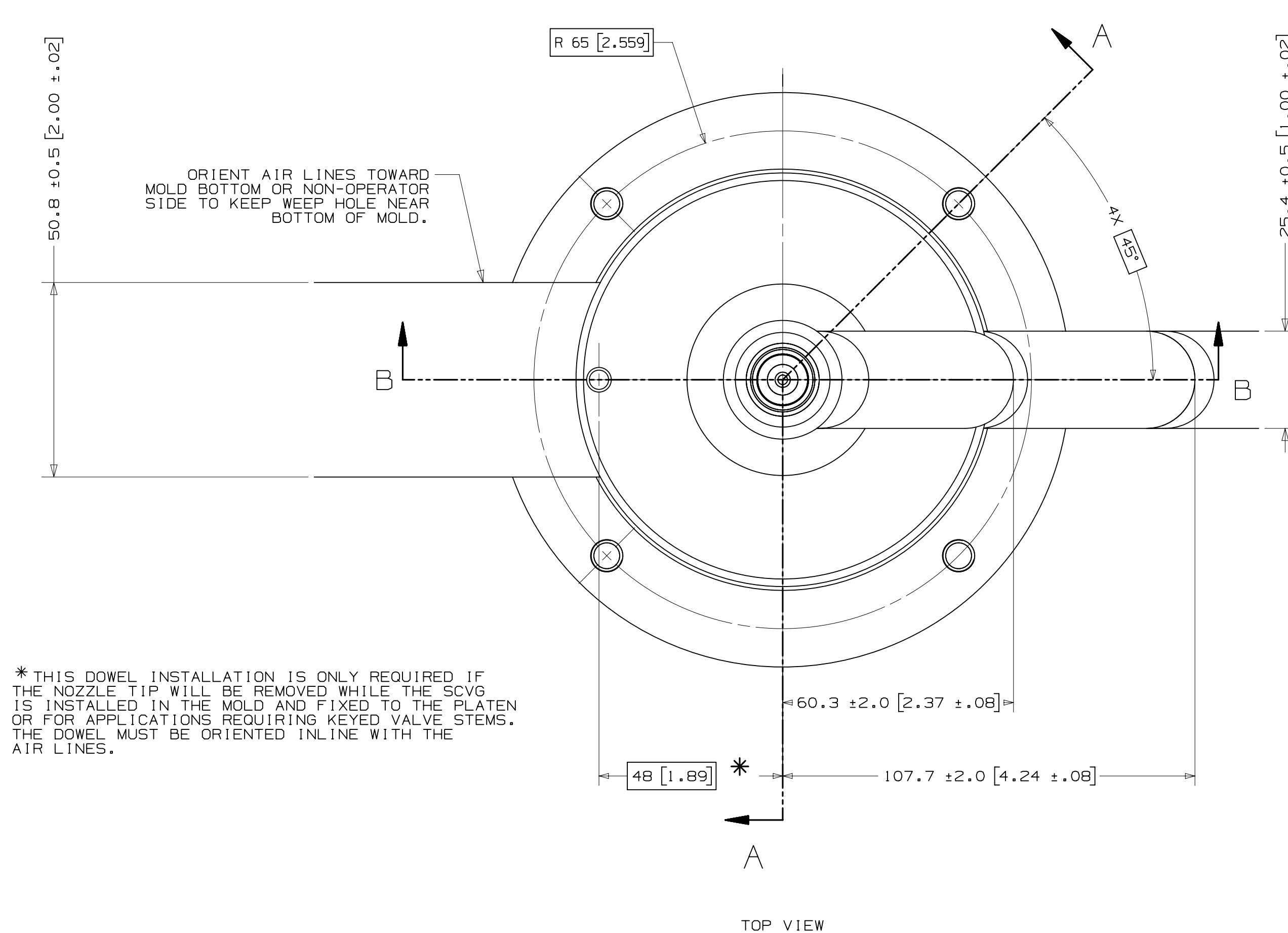
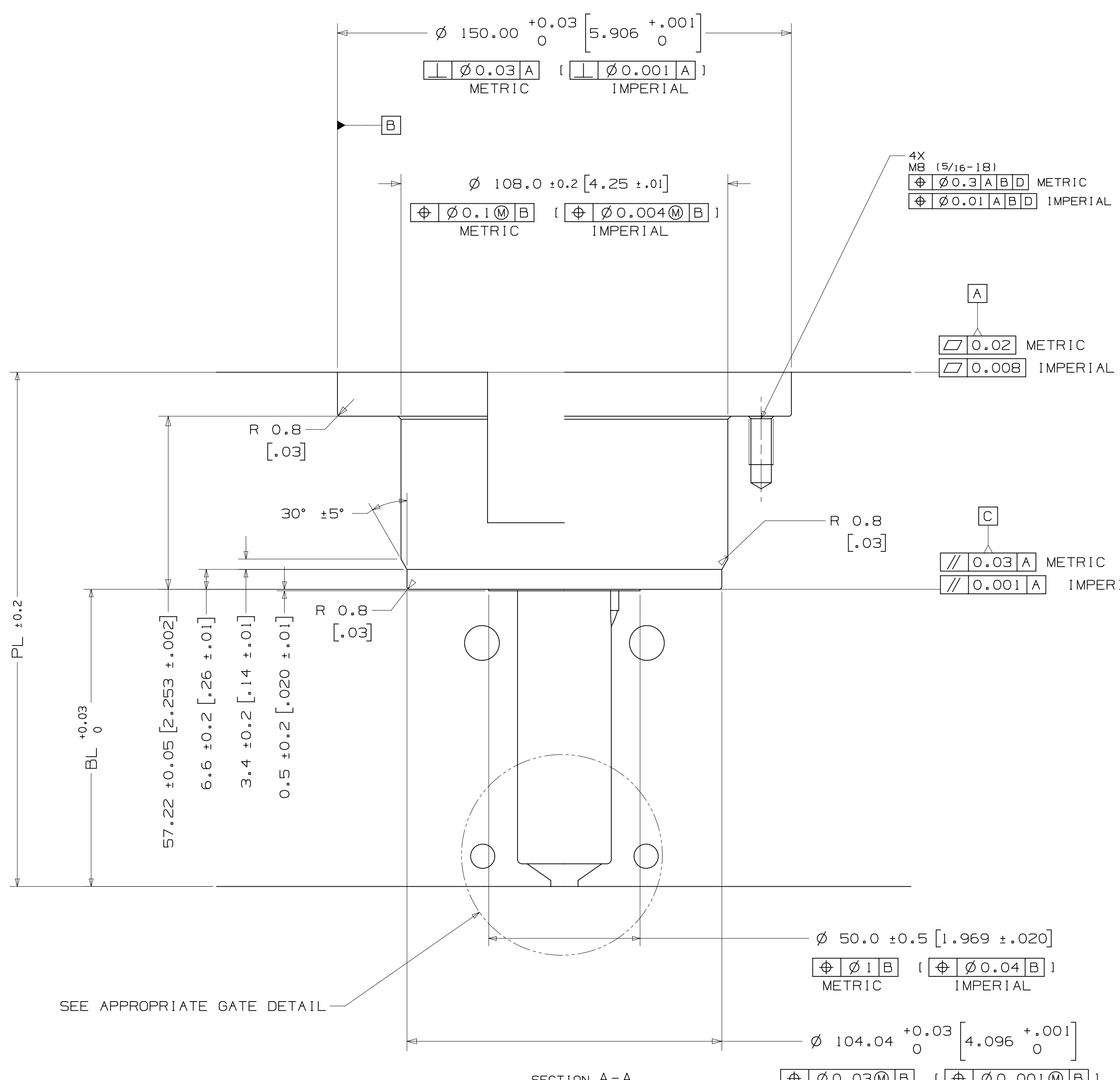


# INSTALLATION DRAWING

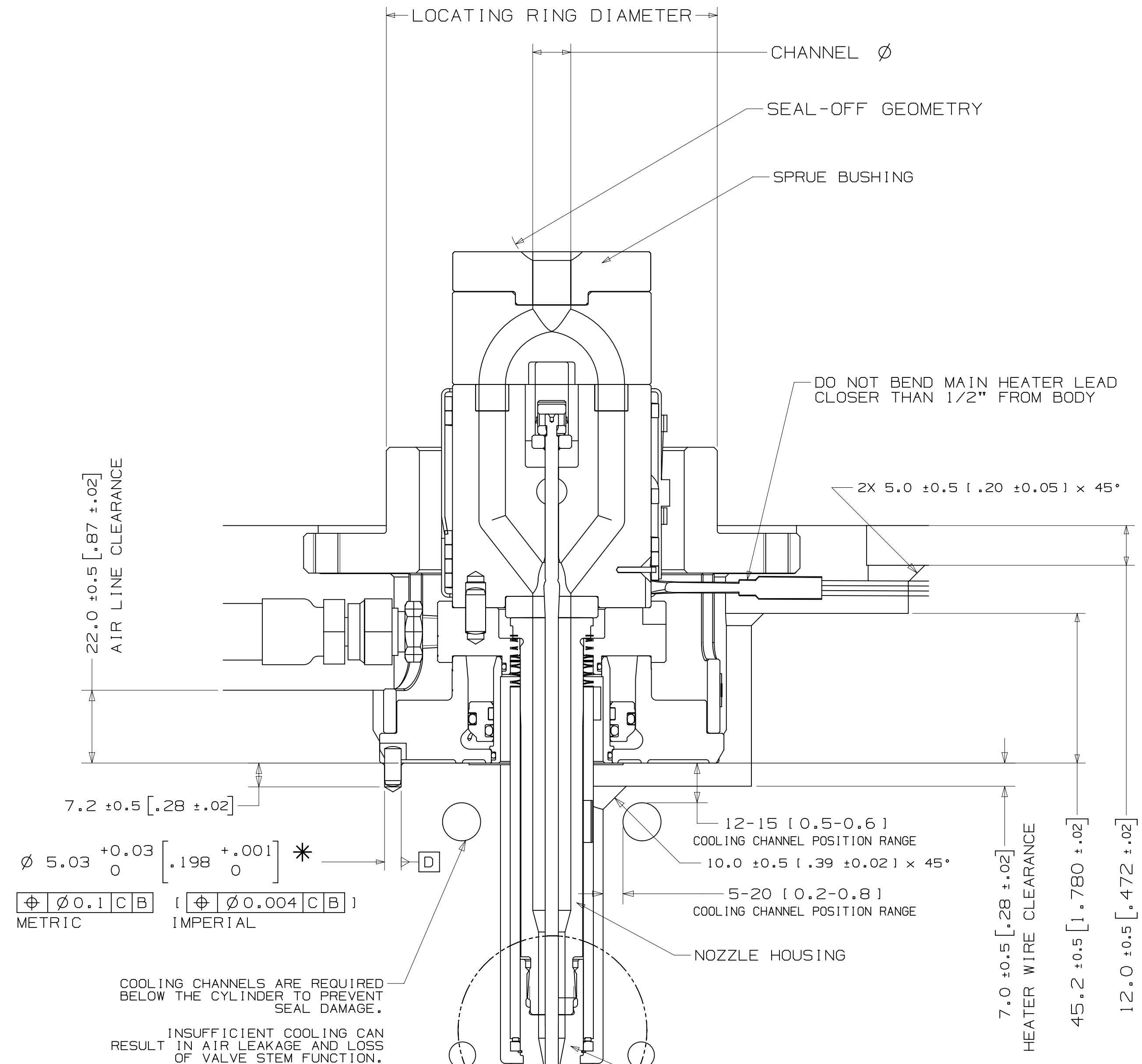


\* THIS DOWEL INSTALLATION IS ONLY REQUIRED IF THE NOZZLE TIP WILL BE REMOVED WHILE THE SCVGS IS INSTALLED IN THE MOLD AND FIXED TO THE PLATEN OR FOR APPLICATIONS REQUIRING KEVED VALVE STEMS. THE DOWEL MUST BE ORIENTED IN-LINE WITH THE AIR LINES.

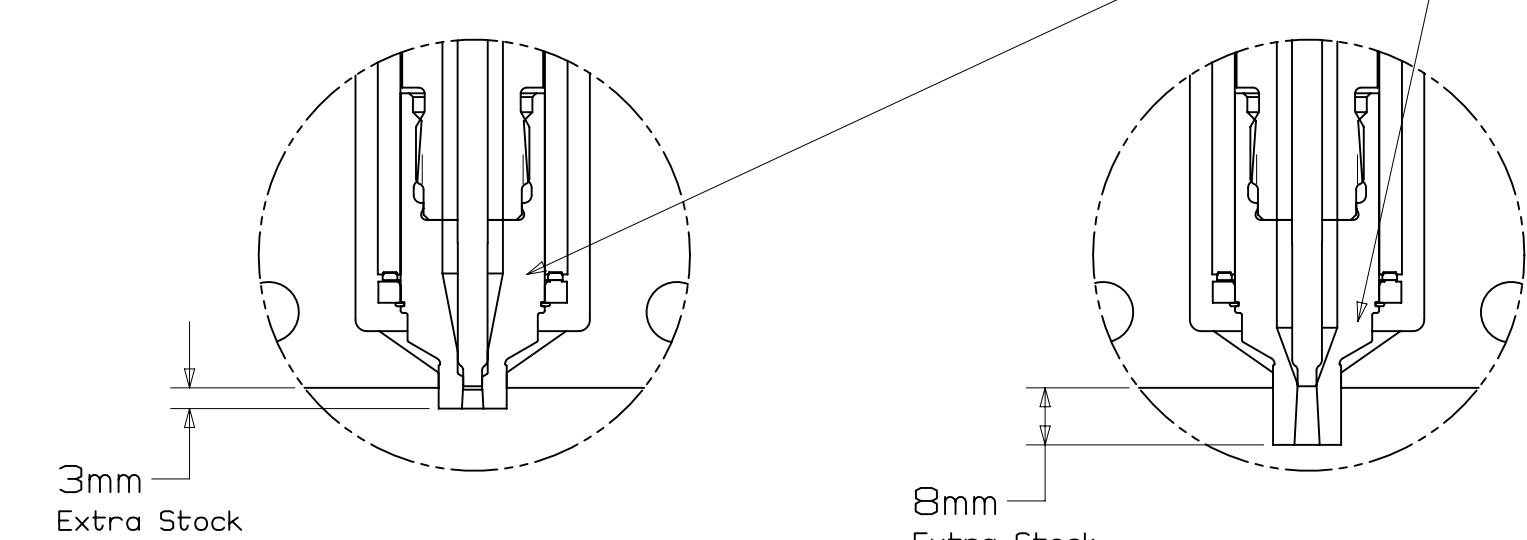
TOP VIEW SCALE 1:1



SECTION A-A SCALE 1:1



SECTION B-B SCALE 1:1



DETAIL VIEWS FOR EXTRA STOCK

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° F 140° F-174° F	80° C-99° F 176° F-210° F	100° C-119° C 122° F-246° F	120° C-139° C 124° F-282° F	140° C-159° C 128° F-318° F	160° C-179° C 132° F-354° F	180° C-199° C 136° F-390° F	200° C-219° C 140° F-426° F	220° C-239° C 144° F-462° F	240° C-259° C 148° F-498° F	260° C-279° C 152° F-534° F	280° C-300° C 156° F-570° F					
U750	VX / VX with 3mm Extra Stock / VX with 8mm Extra Stock	50	98 (3.858)	107 (4.213)	27.96 (1.101)	27.97 (1.101)	27.98 (1.102)	28.00 (1.102)	28.01 (1.103)	28.02 (1.103)	28.04 (1.104)	28.05 (1.104)	28.06 (1.105)	28.08 (1.106)	28.09 (1.106)	28.11 (1.107)	28.12 (1.107)				
		60	108 (4.252)	117 (4.606)	37.97 (1.495)	37.98 (1.495)	38.00 (1.496)	38.01 (1.496)	38.03 (1.497)	38.04 (1.498)	38.06 (1.498)	38.07 (1.499)	38.09 (1.500)	38.11 (1.501)	38.12 (1.501)	38.14 (1.502)	38.15 (1.502)	38.17 (1.503)			
		70	118 (4.646)	127 (5.000)	47.98 (1.889)	47.99 (1.889)	48.01 (1.890)	48.03 (1.891)	48.04 (1.891)	48.06 (1.892)	48.08 (1.893)	48.10 (1.894)	48.12 (1.894)	48.14 (1.895)	48.16 (1.896)	48.18 (1.897)	48.19 (1.897)	48.21 (1.898)	48.23 (1.899)		
		80	128 (5.039)	137 (5.394)	57.98 (2.283)	58.00 (2.283)	58.02 (2.284)	58.04 (2.285)	58.06 (2.286)	58.08 (2.287)	58.10 (2.287)	58.12 (2.288)	58.14 (2.289)	58.16 (2.290)	58.19 (2.291)	58.21 (2.292)	58.22 (2.292)	58.24 (2.293)	58.26 (2.294)		
		90	138 (5.433)	147 (5.787)	67.99 (2.677)	68.01 (2.678)	68.03 (2.678)	68.06 (2.680)	68.08 (2.680)	68.10 (2.681)	68.12 (2.682)	68.15 (2.683)	68.17 (2.684)	68.19 (2.685)	68.22 (2.686)	68.25 (2.687)	68.26 (2.687)	68.28 (2.688)	68.30 (2.689)		
		100	148 (5.827)	157 (6.181)	78.00 (3.071)	78.02 (3.072)	78.05 (3.073)	78.07 (3.074)	78.10 (3.075)	78.12 (3.076)	78.15 (3.077)	78.17 (3.078)	78.20 (3.079)	78.22 (3.080)	78.25 (3.081)	78.28 (3.082)	78.29 (3.082)	78.31 (3.083)	78.33 (3.084)		
		110	158 (6.220)	167 (6.575)	88.01 (3.465)	88.03 (3.466)	88.06 (3.467)	88.09 (3.468)	88.11 (3.469)	88.14 (3.470)	88.17 (3.471)	88.20 (3.472)	88.22 (3.473)	88.25 (3.474)	88.29 (3.475)	88.32 (3.476)	88.33 (3.476)	88.35 (3.477)	88.37 (3.478)	88.39 (3.479)	
		120	168 (6.614)	177 (6.969)	98.01 (3.859)	98.04 (3.860)	98.07 (3.861)	98.10 (3.862)	98.13 (3.863)	98.16 (3.865)	98.19 (3.866)	98.22 (3.867)	98.25 (3.868)	98.28 (3.869)	98.32 (3.871)	98.35 (3.872)	98.36 (3.872)	98.38 (3.873)	98.40 (3.874)	98.42 (3.875)	
		130	178 (7.009)	187 (7.362)	108.02 (4.253)	108.05 (4.254)	108.08 (4.255)	108.11 (4.256)	108.15 (4.258)	108.18 (4.259)	108.21 (4.260)	108.25 (4.262)	108.28 (4.263)	108.31 (4.264)	108.35 (4.266)	108.39 (4.267)	108.40 (4.267)	108.42 (4.268)	108.44 (4.269)	108.46 (4.270)	
		140	188 (7.402)	197 (7.756)	118.03 (4.647)	118.06 (4.648)	118.10 (4.650)	118.13 (4.651)	118.16 (4.652)	118.20 (4.654)	118.23 (4.655)	118.27 (4.656)	118.31 (4.658)	118.34 (4.659)	118.38 (4.661)	118.42 (4.662)	118.43 (4.662)	118.45 (4.663)	118.47 (4.664)	118.49 (4.665)	
		150	198 (7.795)	207 (8.150)	128.04 (5.041)	128.07 (5.042)	128.11 (5.044)	128.14 (5.045)	128.18 (5.046)	128.22 (5.048)	128.26 (5.050)	128.29 (5.051)	128.33 (5.052)	128.37 (5.054)	128.41 (5.056)	128.45 (5.057)	128.46 (5.057)	128.48 (5.058)	128.50 (5.059)	128.52 (5.060)	
		160	208 (8.189)	217 (8.543)	138.05 (5.435)	138.08 (5.436)	138.12 (5.438)	138.16 (5.439)	138.20 (5.441)	138.24 (5.443)	138.28 (5.444)	138.32 (5.446)	138.36 (5.447)	138.40 (5.449)	138.45 (5.451)	138.49 (5.452)	138.50 (5.452)	138.52 (5.453)	138.54 (5.454)	138.56 (5.455)	
		170	218 (8.583)	227 (8.937)	148.05 (5.829)	148.09 (5.830)	148.13 (5.832)	148.17 (5.833)	148.22 (5.835)	148.26 (5.837)	148.30 (5.839)	148.34 (5.840)	148.39 (5.842)	148.43 (5.844)	148.48 (5.846)	148.53 (5.848)	148.54 (5.848)	148.56 (5.849)	148.58 (5.850)	148.60 (5.851)	
		180	228 (8.976)	237 (9.331)	158.06 (6.223)	158.10 (6.224)	158.15 (6.226)	158.19 (6.228)	158.23 (6.230)	158.28 (6.231)	158.32 (6.233)	158.37 (6.235)	158.41 (6.237)	158.46 (6.239)	158.51 (6.241)	158.56 (6.243)	158.57 (6.243)	158.59 (6.244)	158.61 (6.245)	158.63 (6.246)	
		190	238 (9.370)	247 (9.724)	168.07 (6.617)	168.11 (6.619)	168.16 (6.620)	168.20 (6.622)	168.25 (6.624)	168.30 (6.626)	168.34 (6.628)	168.39 (6.630)	168.44 (6.631)	168.49 (6.633)	168.54 (6.635)	168.59 (6.637)	168.60 (6.637)	168.62 (6.638)	168.64 (6.639)	168.66 (6.640)	
		200	248 (9.764)	258 (10.157)	178.08 (7.011)	178.12 (7.013)	178.17 (7.015)	178.22 (7.017)	178.27 (7.019)	178.32 (7.020)	178.37 (7.022)	178.42 (7.024)	178.47 (7.026)	178.52 (7.028)	178.58 (7.031)	178.63 (7.033)	178.64 (7.033)	178.66 (7.034)	178.68 (7.035)	178.70 (7.036)	

\* 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		SPRUE BUSHING	
		SEAL-OFF GEOMETRY	CHANNEL Ø
		SPHERICAL RADIUS	IN - OUT
U750	100mm	FLAT	6.35 - 11.5
	101.3mm (3.99")	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 FOR MORE DETAILED GUIDELINES.  
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)

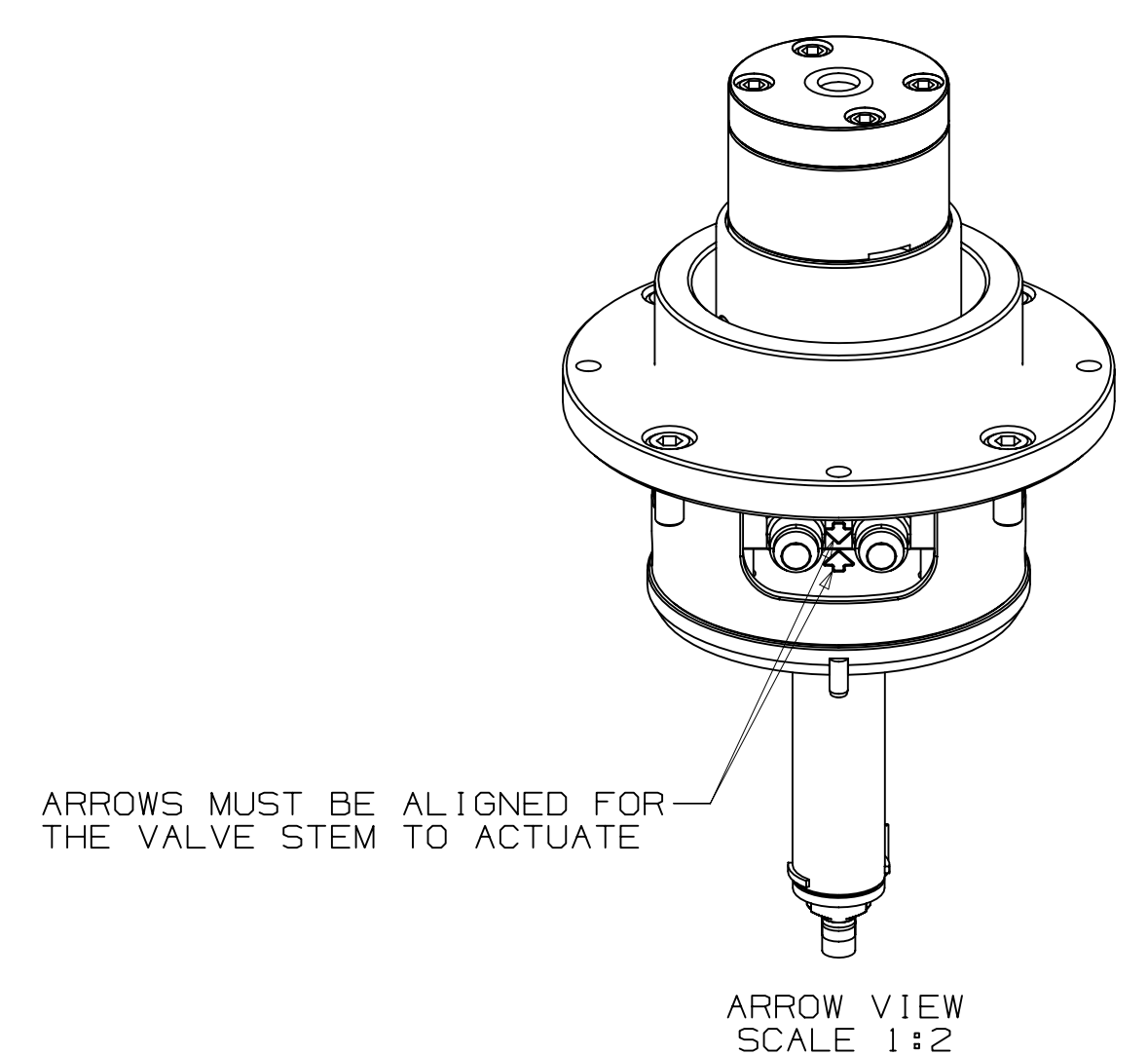
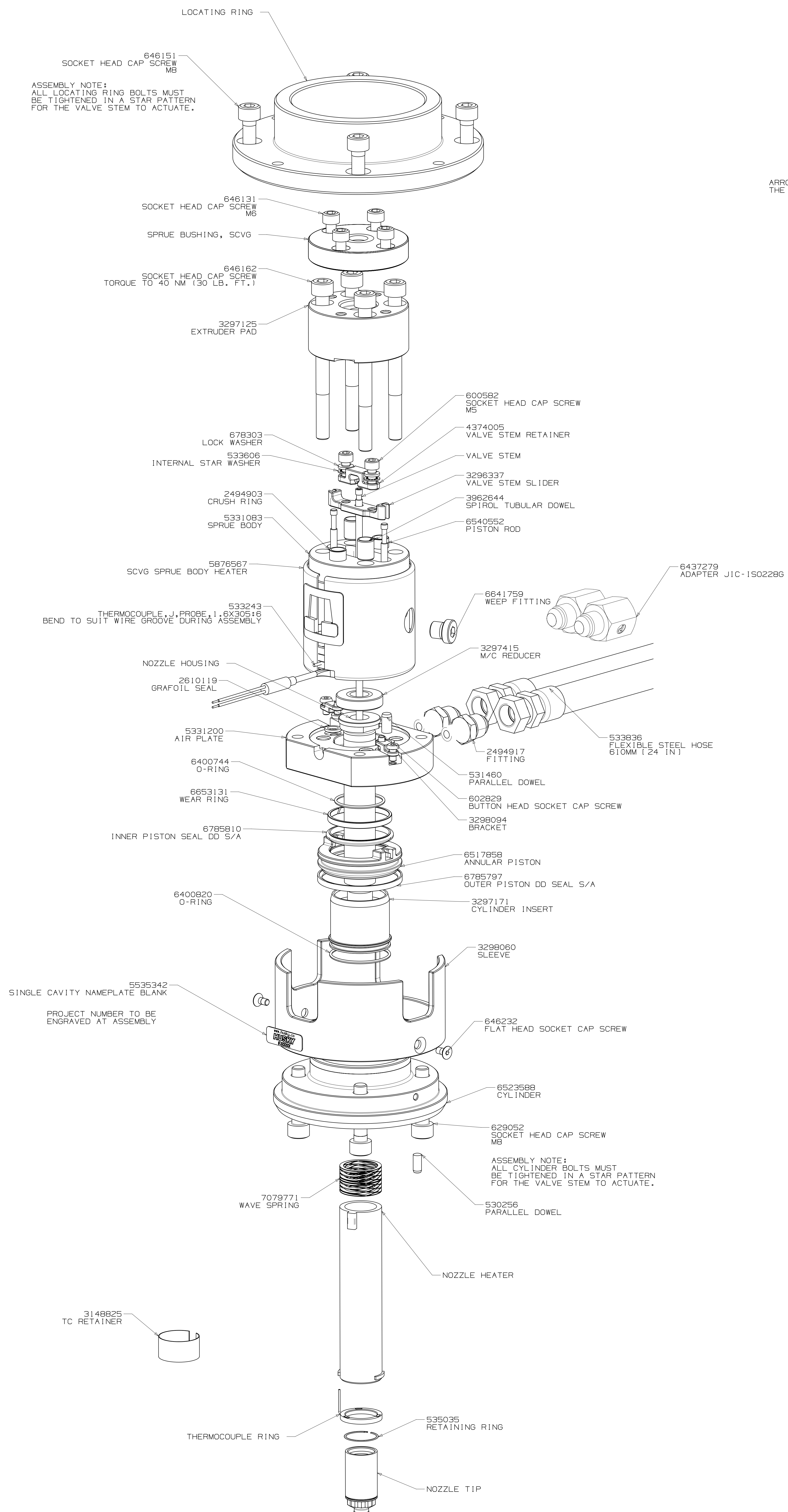
**RECOMMENDED GATE MANUFACTURING GUIDELINES**  
- HARDENED GATE INSERTS (49-51) ARE RECOMMENDED WHEN USING SOFTER STEELS. SOFTER CAVITIES MAY BE ACCEPTABLE FOR CERTAIN APPLICATIONS. CONTACT YOUR HUSKY REPRESENTATIVE WITH QUESTIONS.  
- EDM'ING THE GATE AREA CAUSES MICRO CRACKS WHICH LEAD TO BRITTLE GATE 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	BY	CHKD
0	2017-09-04	ORIGINAL ISSUE - DESIGNED BY DHANALEKIAN		

DATE PER ASME Y14.5M-1994 AND HEAVY ADDENDUM - H2004	UNFINISHED DRAWING FEATURES (BY DATE) (BY DATE) (BY DATE) (BY DATE)	METRIC	INCH	FINISH/TREATMENT	WEIGHT	SCALE	SHEET	OF	TOTAL	REV
NO TOLERANCES SPECIFIED ARE BASIC	NO UNFINISHED DIMENSIONS ARE BASIC	mm	in		- kg	1:1	2	2	2	0
BROKEN EDGE/CHAMFER: F 1.5 ± 0.2 X 45°	FILLET ROUNDS: R0.8 ± 0.2									
<p><b>HUSKY</b></p> <p>NO INTELLECTUAL PROPERTY RIGHTS ARE CLAIMED FOR ANY LOGO, TRADE NAME OR DESIGN.</p> <p>NO RIGHTS RESERVED. COPYRIGHT © 2017 HUSKY CORPORATION.</p>		<p>SCVGS Single Cavity Valve Gate U750-SCVG-VX</p>								

# 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	300	221
1 1/4	400	294
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	18.5
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 = (-)

**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](http://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)  
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REV	DATE	DESCRIPTION	NAME
0	2017-09-04	ORIGINAL ISSUE - DESIGNED BY: DHANALEKIAN	DHANI DHANALEKIAN
			DRING DHANALEKIAN
			CHKD: PICHLER KLAUS

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