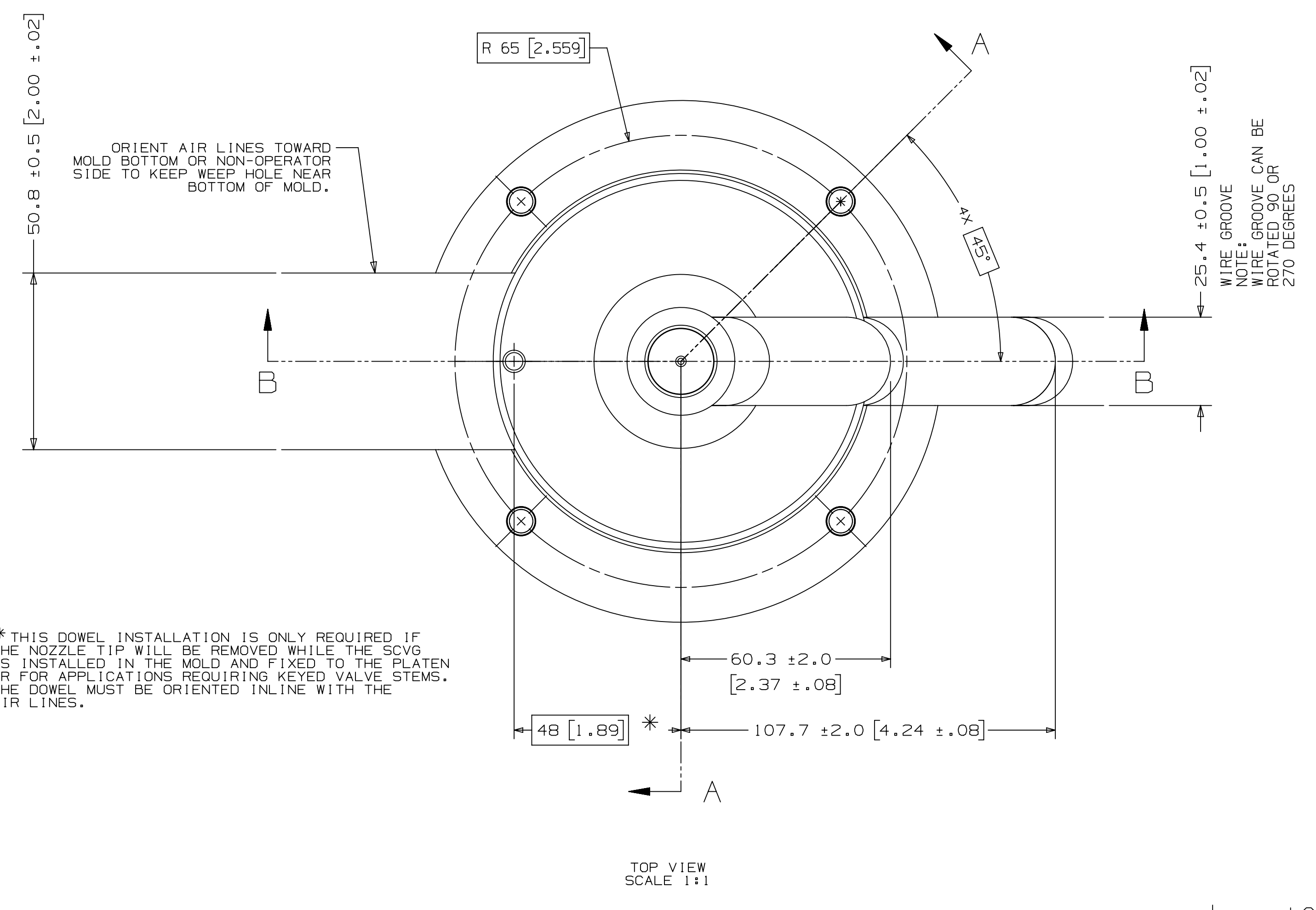
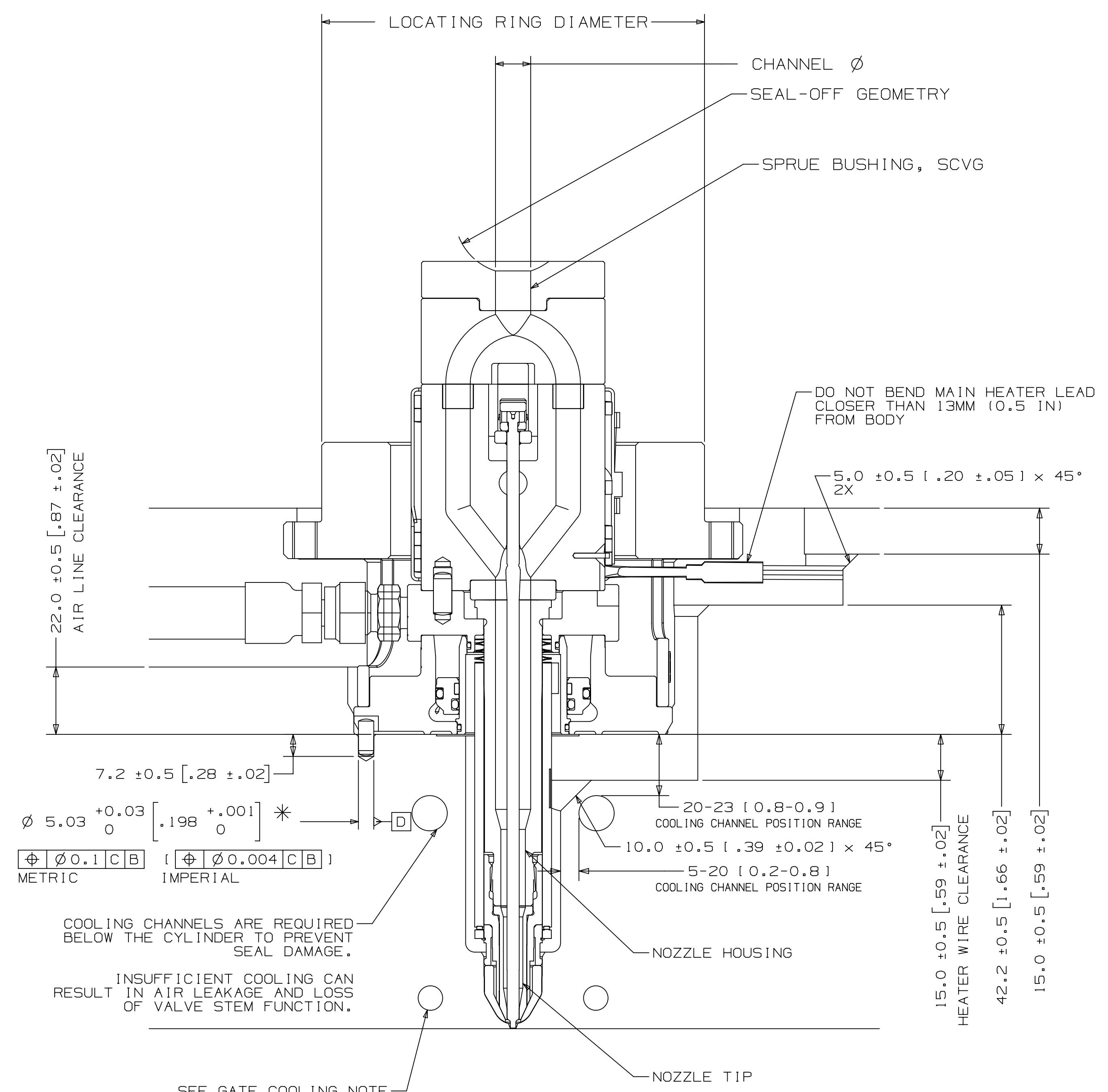
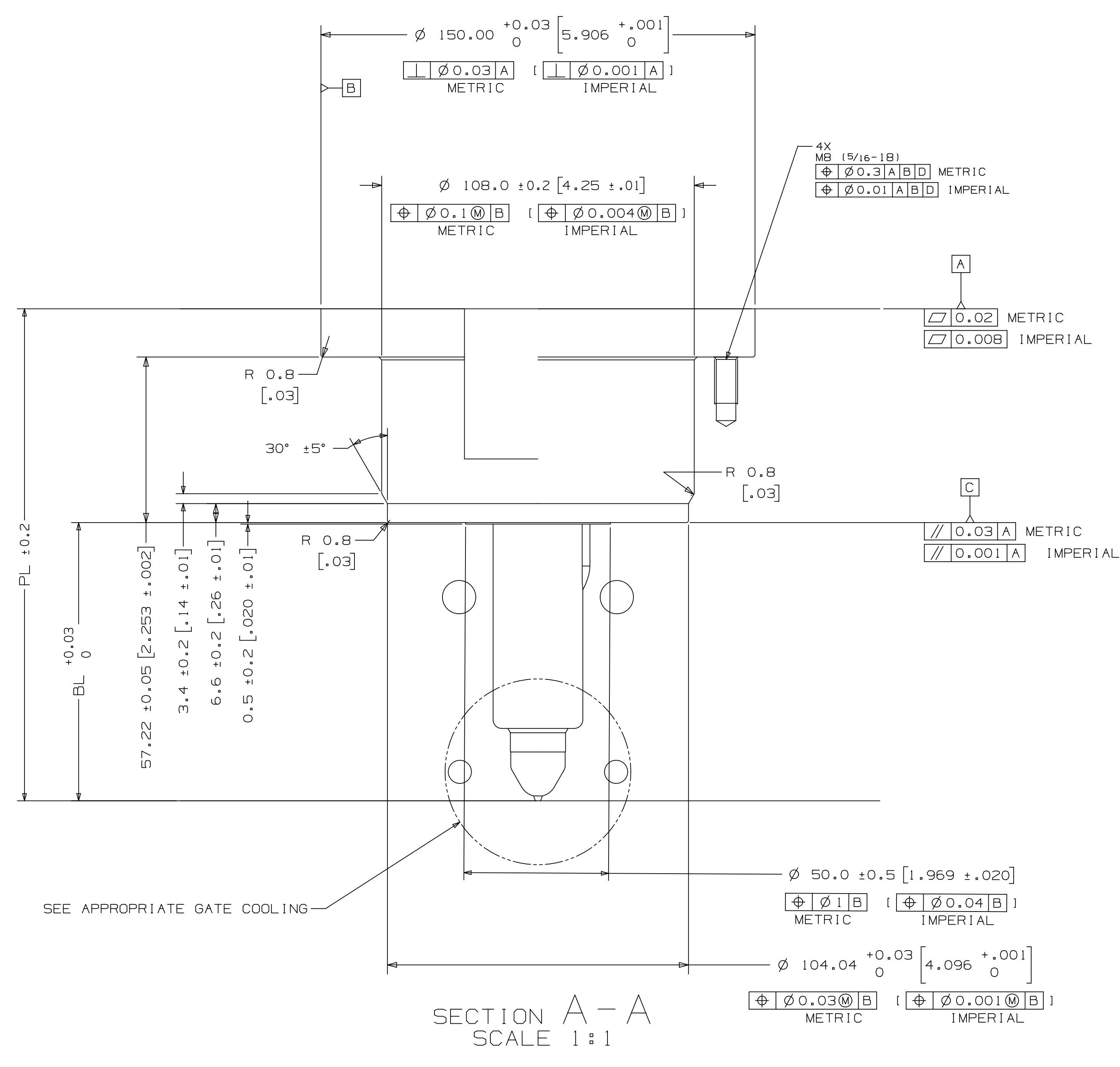


INSTALLATION DRAWING

REV: 2
8142261



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



NOZZLE SERIES	NOZZLE TIP	PL RANGE	Approx. BL*
U750	VG-R	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 SPHERICAL RADIUS	CHANNEL Ø IN - OUT
	FLAT	6.35 - 11.5
	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	

U750	LOCATING RING DIAMETER	
	DIAMETER	
	100	
	101.3 [3.991]	
	125	

DIMENSIONS SHOWN AS: millimeters [inches]

RECOMMENDED GATE COOLING GUIDELINES
ADEQUATE COOLING IS ESSENTIAL FOR THE PROPER FUNCTION OF THIS SYSTEM. REFER TO THE HOT RUNNER PRODUCT GUIDE FOR CERTAIN APPLICATIONS. CONTACT YOUR HUSKY REPRESENTATIVE WITH QUESTIONS.
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 148-51 Rc1
AISI 420 148-51 Rc1

RECOMMENDED GATE MANUFACTURING GUIDELINES

- HARDENED GATE INSERTS (49-511) 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.

<p>Q&T PER ASME Y14.2M-1994 AND HDXV ADDENDUM - HIGH PRESSURE COINTEGRATED SPECIFICATIONS ARE BASIC.</p> <p>GENERAL TOLERANCES: METRIC: (M) (S) (H) IMPERIAL: (S) (H) (M)</p> <p>BROKEN EDGE/CHAMFER: 1: ± 0.2 X 45° 0.04 ± 0.01 X 45°</p> <p>FILLET/RADIUS: R0.8 ± 0.2 R0.03 ± 0.01</p> <p>SURFACE FINISH: 6.3</p>	<p>UNFINISHED DRAWING FEATURES TO SHOW BY THE MODEL (EXCEPT AS OTHERWISE SPECIFIED):</p> <p>MATERIAL: N/A</p> <p>FINISH/TREATMENT: (S) (H) (M)</p> <p>NO INTELLECTUAL PROPERTY RIGHTS ARE CLAIMED FOR ANY LOGOS, MARKINGS OR IDENTIFIERS APPLIED OR OTHERWISE APPLIED TO THIS DRAWING.</p> <p>ALL RIGHTS RESERVED. COPYRIGHT © 2010 HUSKY</p>	<p>TITLE: Single Cavity Valve Gate U750_VG-R</p> <p>SCALE: 1:1</p> <p>SHEET: 2 OF 2</p> <p>AOR: 8142261</p> <p>REV: 2</p>
---	---	---