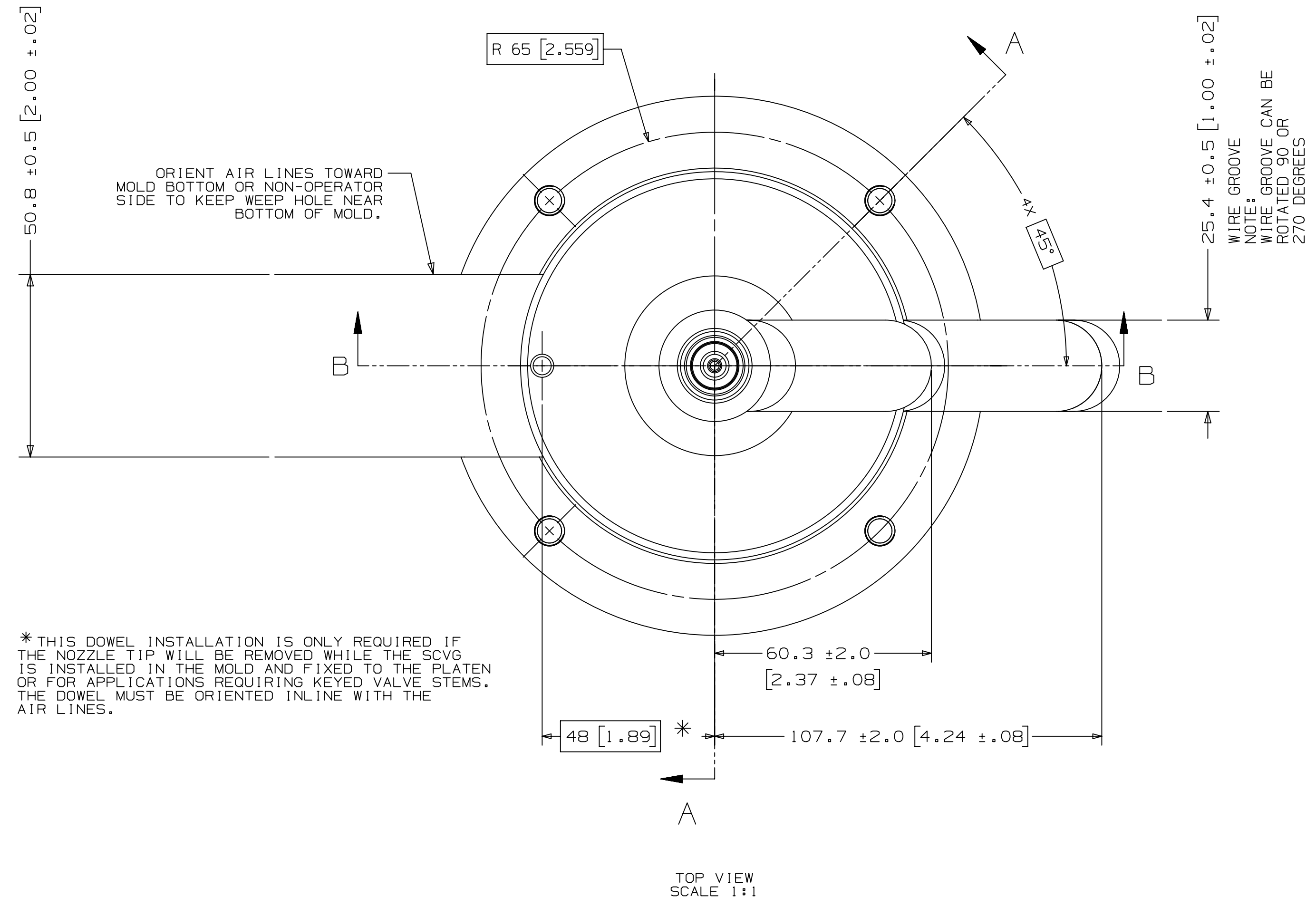
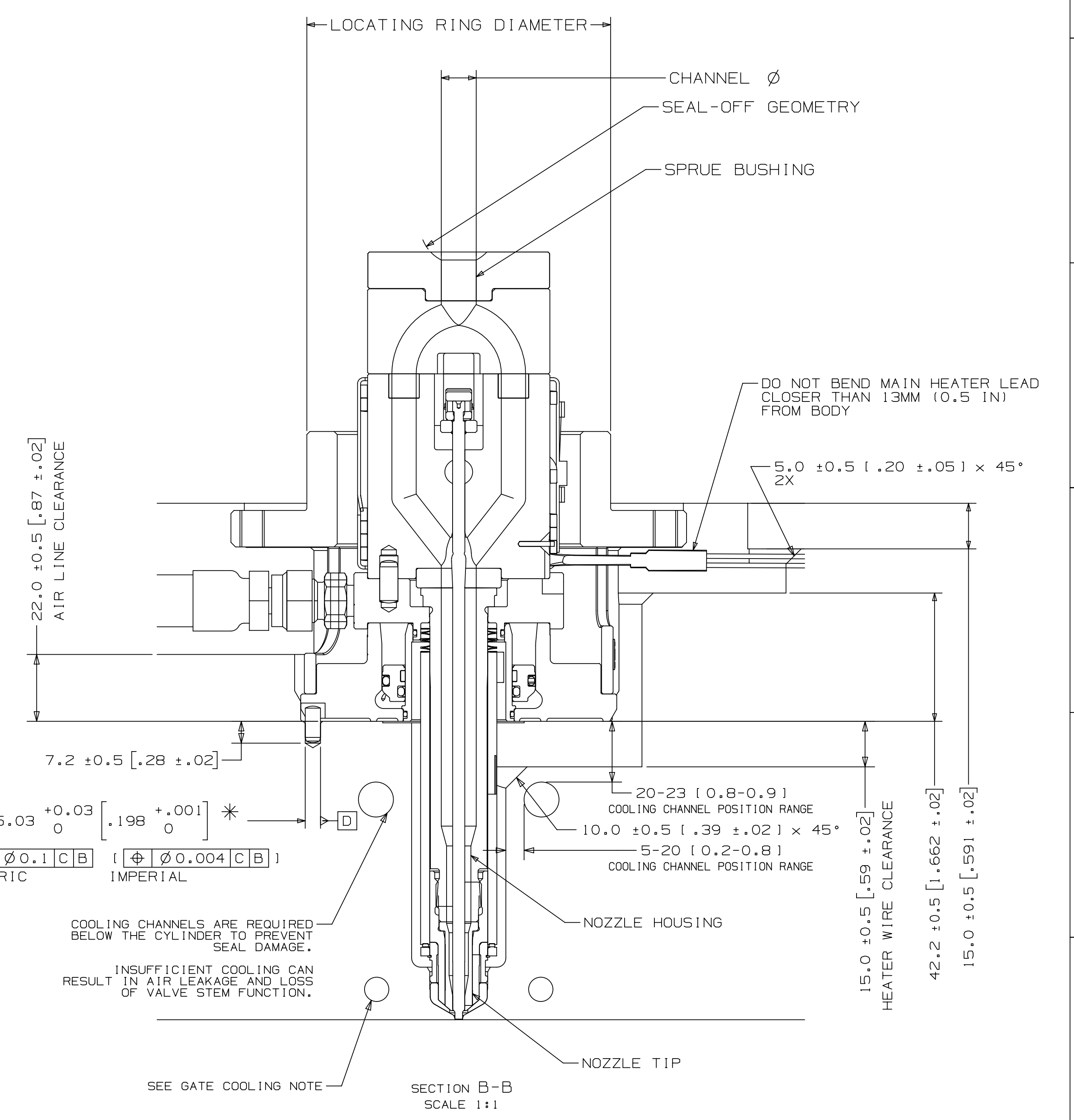
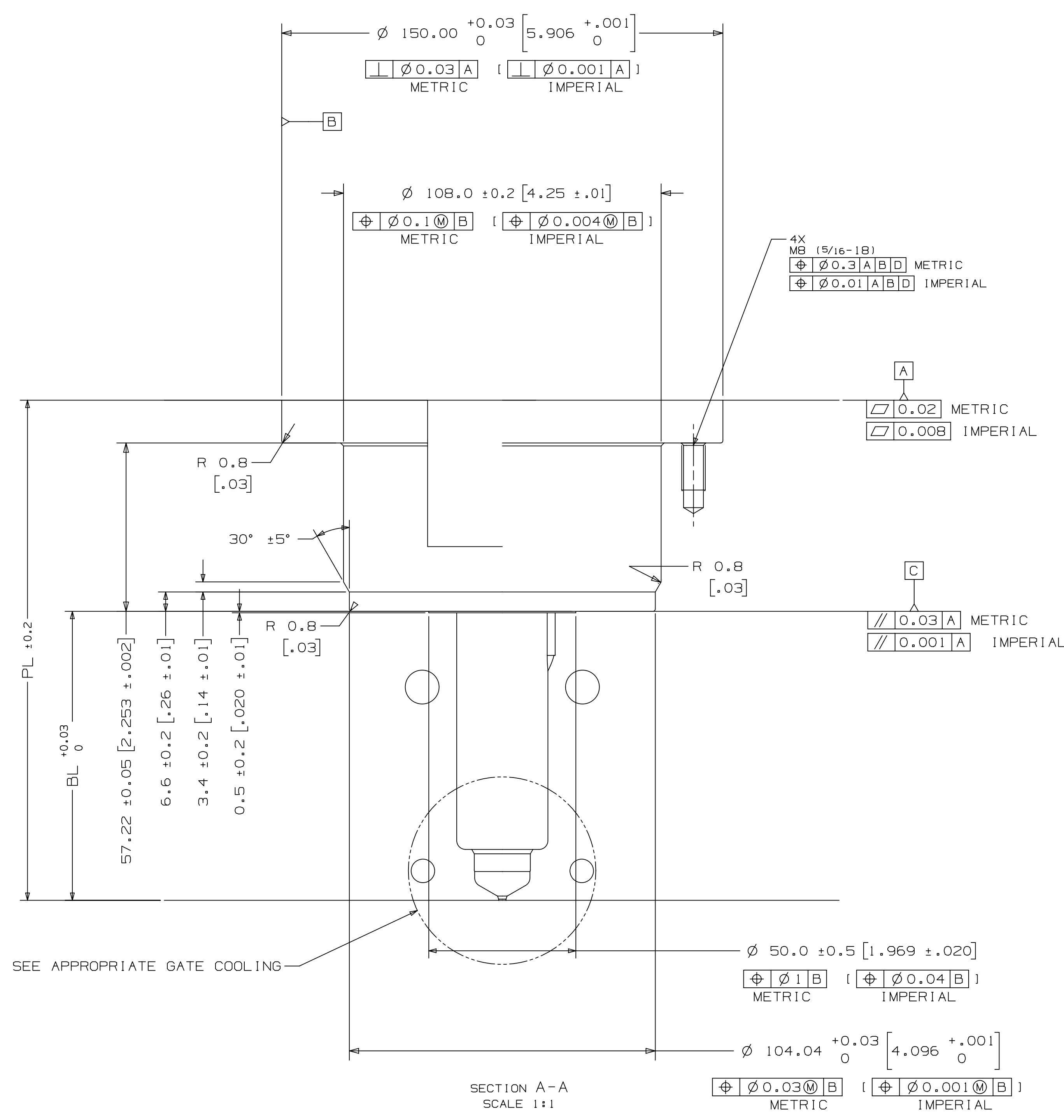


INSTALLATION DRAWING



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



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 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
	100
	101.3 [3.99]
	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 MORE DETAILED GUIDELINES.
 www.husky.ca

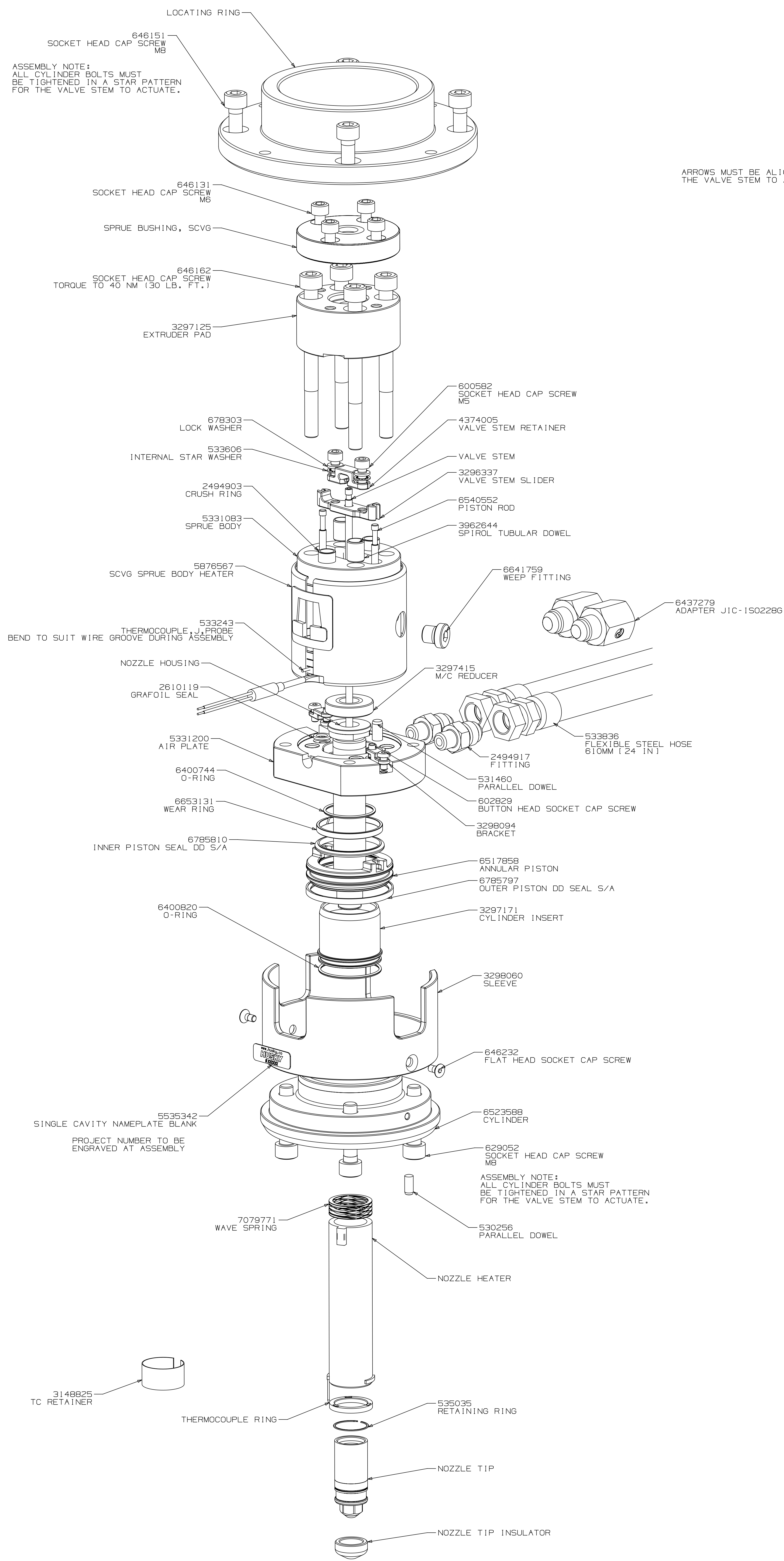
RECOMMENDED GATE MATERIAL
 NOTE: THESE MATERIALS MAY NOT OFFER THE DESIRED RESISTANCE TO ABRASIVE AND/OR CORROSIVE RESINS, FILLERS AND/OR ADDITIVES.
 A151 H13 (48-51 Rc)
 A151 420 (48-51 Rc)

RECOMMENDED GATE MANUFACTURING GUIDELINES
 - HARDENED GATE INSERTS (48-51) 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. SOFTEN THE AREA AROUND THE WELD AND CAN CAUSE GATE FAILURES.

<small> DAT PER ASME Y14.1M-1994 AND HSXZY ADDENDUM - HS204 UNLESS OTHERWISE SPECIFIED: DIM MODEL IS BASIC. DIMENSIONS UNLESS SPECIFIED ARE BASIC. GENERAL TOLERANCES: BROKEN EDGE/CHAMFER: 1 ± 0.2 X 45° 0.04 ± 0.01 X 45° FILLET/RADIUS: R0.8 ± 0.2 R0.03 ± 0.01 SURFACE FINISH: 6.3/ </small>	<small> UNFINISHED DRAWING FEATURES: TO DIMS #100 UNLESS OTHERWISE SPECIFIED MATERIAL: N/A FINISH/TREATMENT: </small>	HUSKY TITLE: Single Cavity Valve Gate U750-SCVG-VG SCALE: 1:1 SHEET: 1 OF 2 AOR: 7972286 REV: 2
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ASSEMBLY DRAWING

DRAWING NO. 7972286 REV. 2



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
1/2	65	48
5/8	95	70
3/4	150	110
7/8	250	180
1	350	250
M4	750	550
M5	1150	850
M6	1650	1200
M8	2900	2100
M10	4400	3200
M12	6300	4600
M14	8500	6200
M16	11000	8000
M20	17500	12800
M24	24000	17500

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 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 148-51 Rc1
AISI 420 148-51 Rc1

RECOMMENDED GATE MANUFACTURING GUIDELINES

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

DEFINED DRAWING FEATURES		UNLESS OTHERWISE SPECIFIED	
MATERIAL	N/A	TITLE	SCV G
FINISH/TREATMENT		DESCRIPTION	Single Cavity Valve Gate
WEIGHT	- kg	SCALE	1:1
		SIZE	AOR
		DRAWING NO.	7972286
		REV.	2
		SHEET	2 OF 2