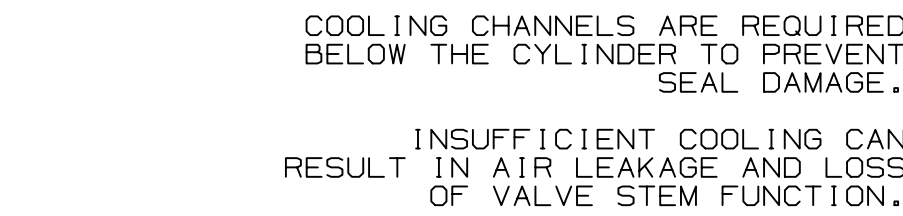
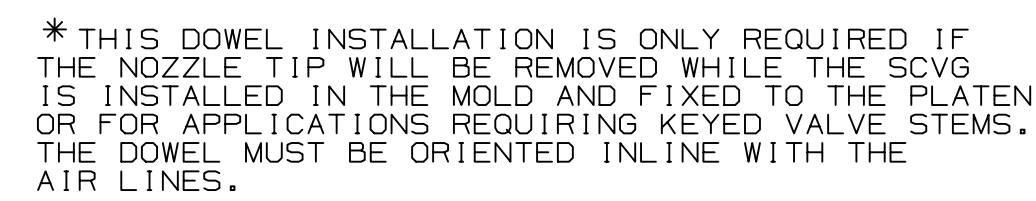


DRAWING	REV
7072286	3





*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	LOCATING RING DIAMETER
	100
	101.3 (3.99)
	125

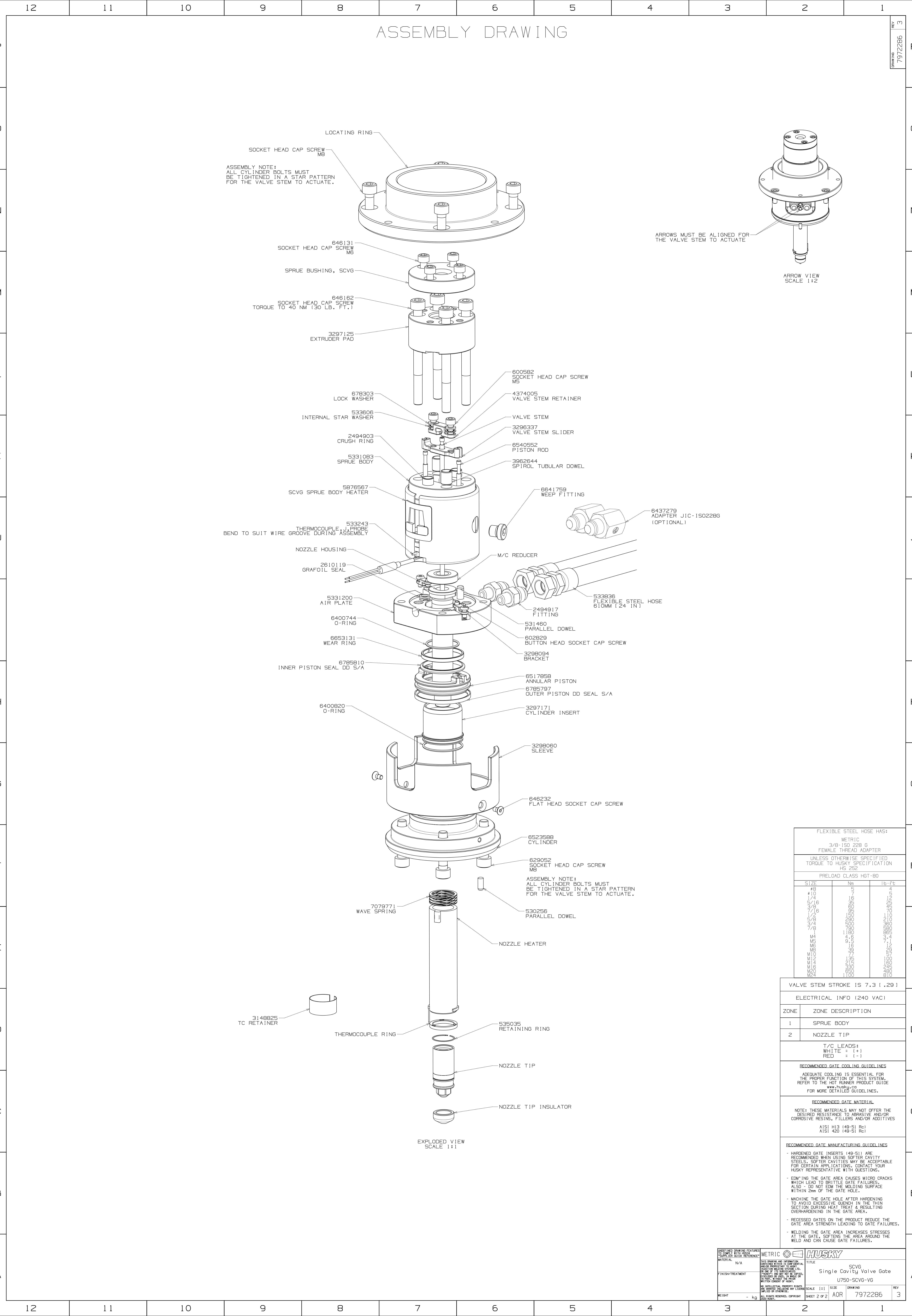
AISI H13 (49-5) Rc)
AISI 420 (49-5) Rc)

GO&T PER ASME Y14.5M-1994
AND HUSKY ADDENDUM - HS254
UNLESS OTHERWISE SPECIFIED:
CAD MODEL IS BASIC.
NON-TOLERANCED DIMENSIONS
ARE BASIC.

	METRIC	IMPERIAL
GENERAL TOLERANCE:	 0.4 ?	 0.02
BROKEN EDGE/CHAMFER:	$1 \pm 0.2 \times 45^\circ$	$0.04 \pm 0.01 \times$
FILLET/ROUND:	$R0.8 \pm 0.2$	$R0.03 \pm 0.01$
SURFACE FINISH:	$6.3 \sqrt{\text{in}}$	

HUSKY

SCALE 1:1	SIZE
SHEET 1 OF 2	A0



FLEXIBLE STEEL HOSE HAS:		
METRIC		
3/8-150 228 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	19	14
5/16	25	18
3/8	35	26
1/2	60	44
5/8	90	66
3/4	150	110
7/8	230	170
M4	500	360
M5	700	510
M6	1180	860
M8	1600	1180
M10	2300	1700
M12	2900	2100
M14	3300	2400
M16	3500	2500
M20	6500	4800
M24	11000	8100

VALVE STEM STROKE IS 7.3 (.29)

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 (48-51 Rc)
AISI 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. SOFTENS THE AREA AROUND THE
WELD AND CAN CAUSE GATE FAILURES.

DEFINED DRAWING FEATURES (TO COMPLY WITH ISO 15780) SUPPLIER QUICK REFERENCE		MATERIAL		FINISH/TREATMENT		WEIGHT		HUSKY		TITLE		SCALE		SIZE		DRAWING		REV	
N/A		N/A		N/A		N/A		HUSKY		Single Cavity Valve Gate U750-SCVG-VG		1:1		AOR		7972286		3	