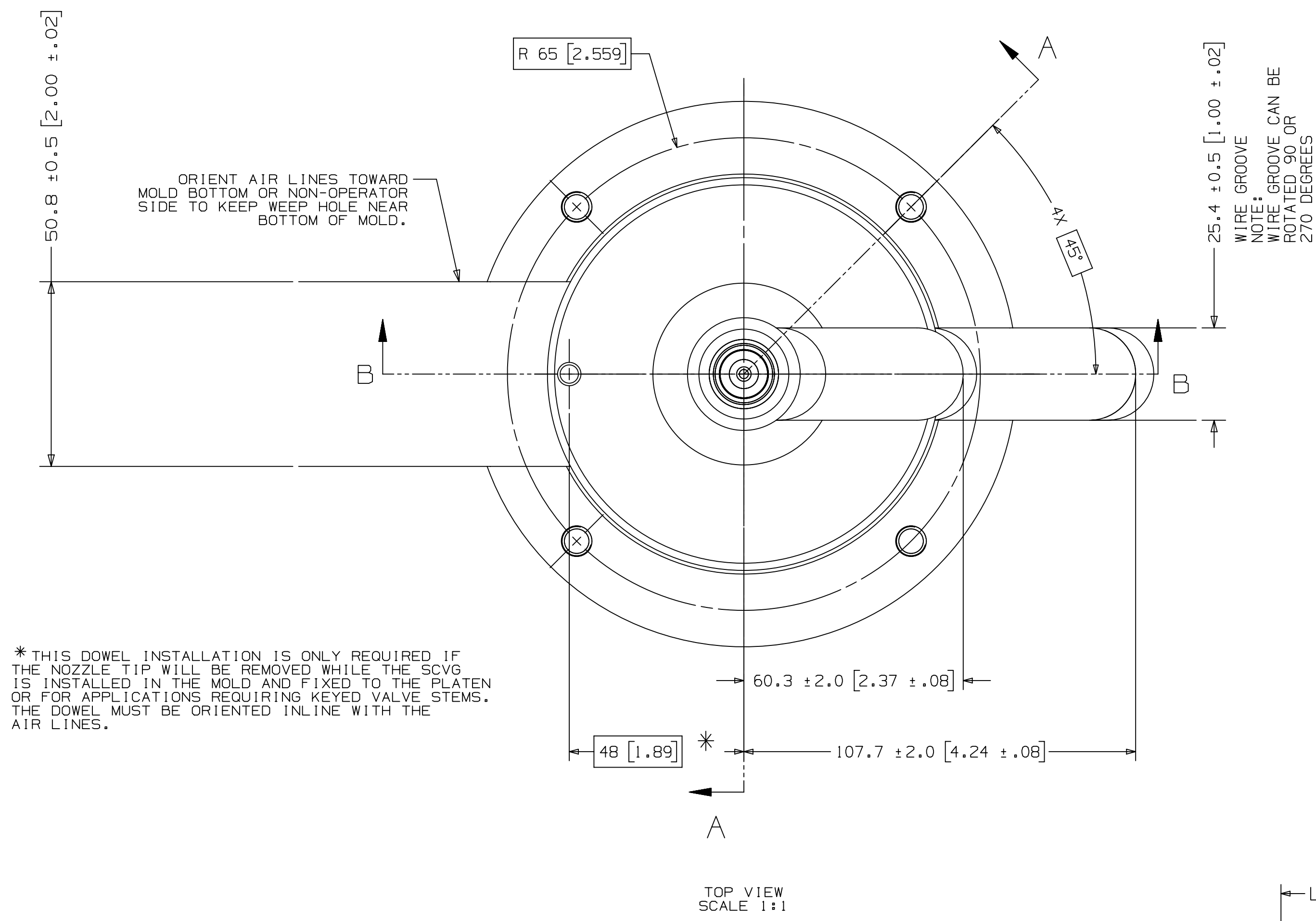
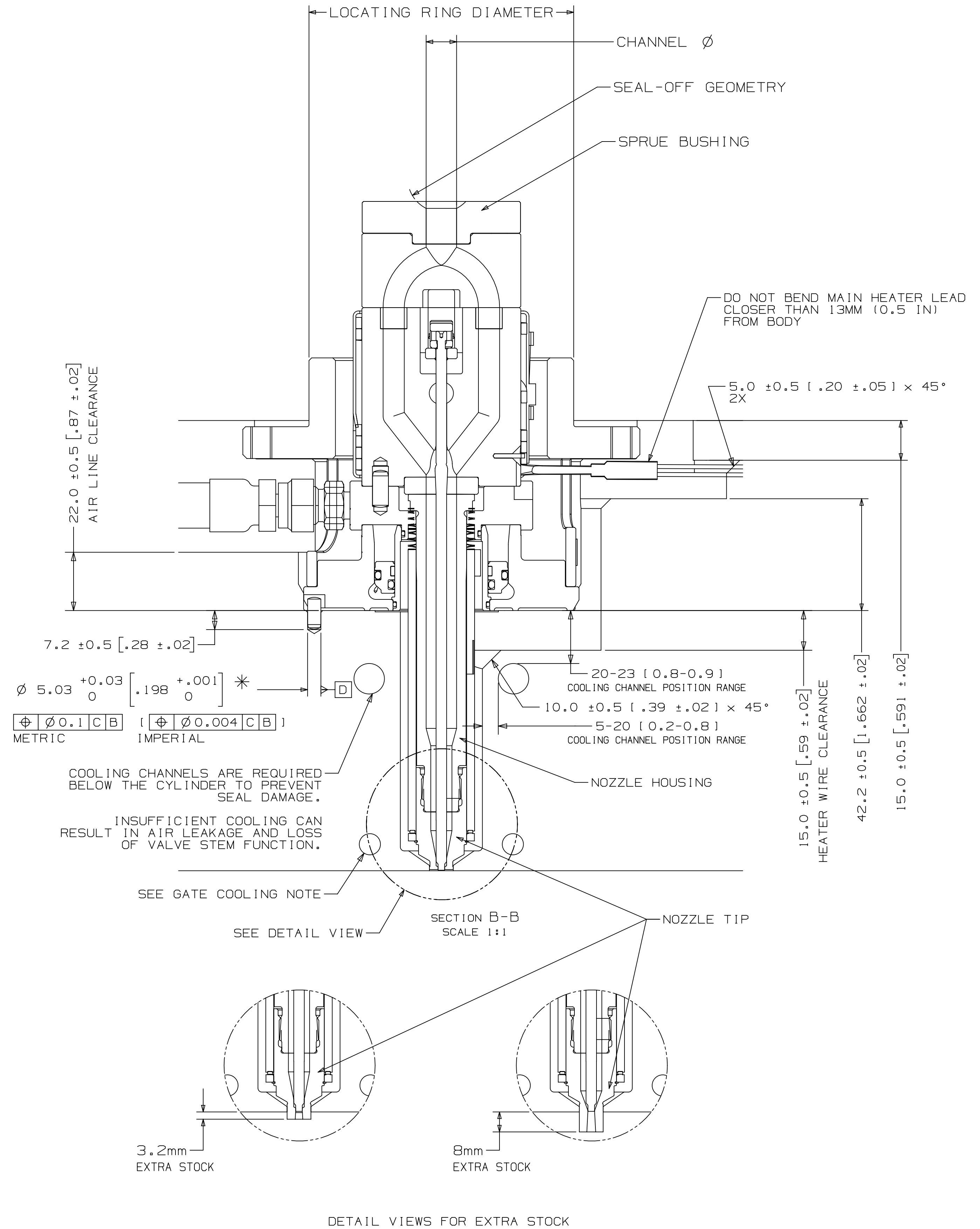
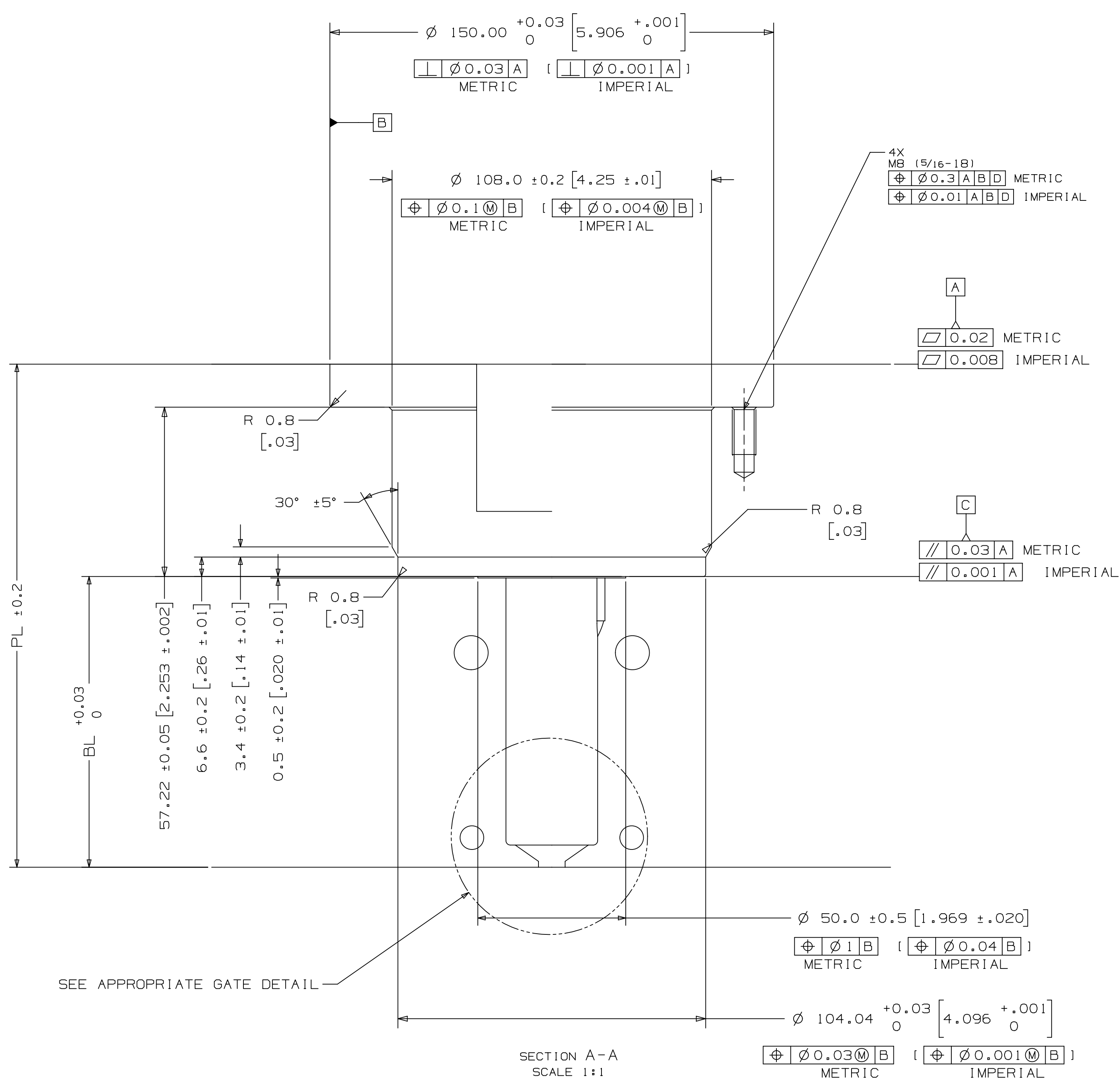


INSTALLATION DRAWING



* 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 3.2mm / VX with extra stock 8mm	97.55 [3.84] - 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	
	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

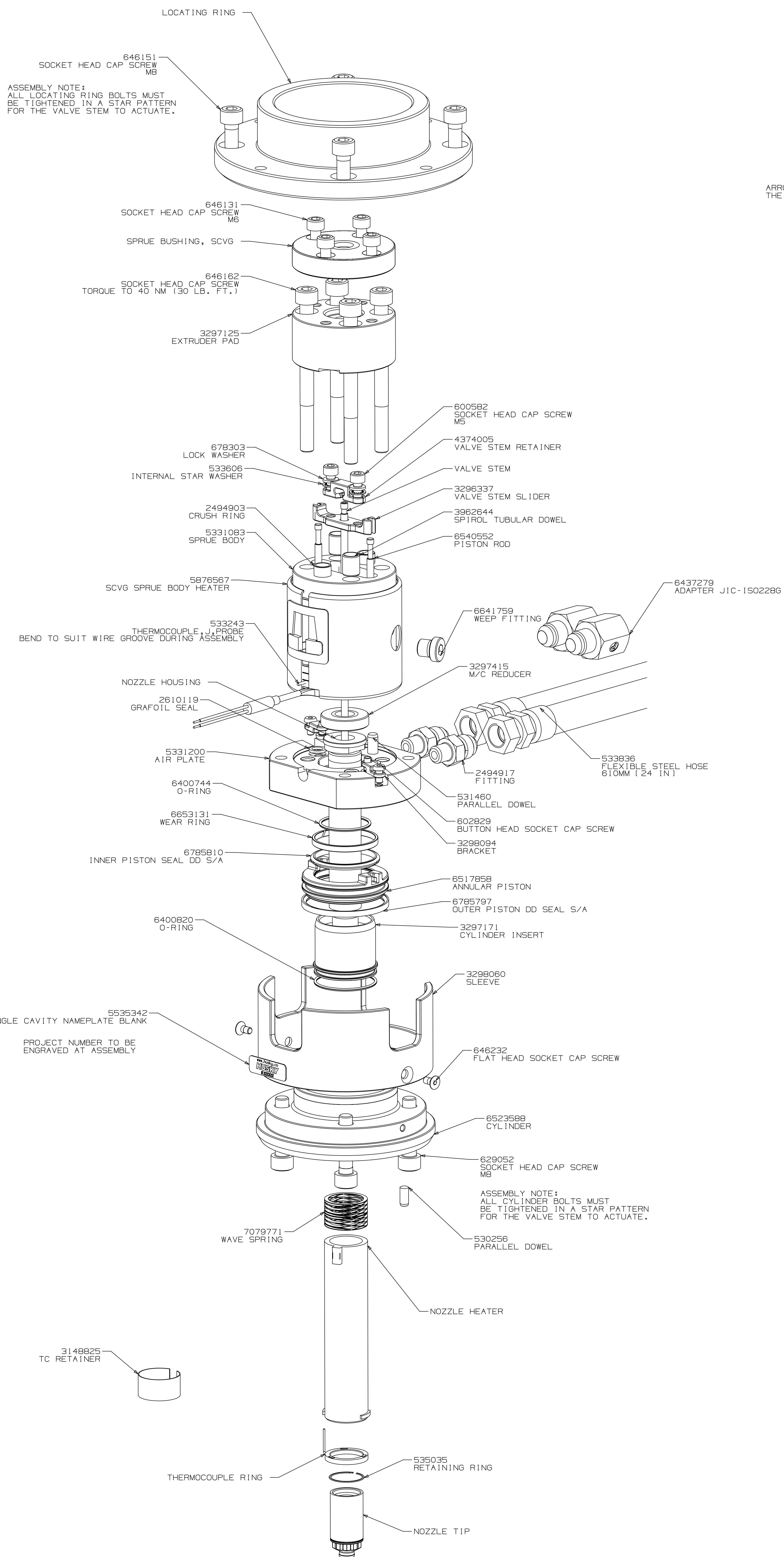
RECOMMENDED GATE MATERIAL
NOTE: THESE MATERIALS MAY NOT OFFER THE DESIRED RESISTANCE TO ABRASIVE AND/OR CORROSIVE RESINS, FILLERS AND/OR ADDITIVES.
AISI H13 148-51 Rc1
AISI 420 148-51 Rc1

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.

DAT PER ASME Y14.1M-1994 AND HUSKY ADDENDUM - H2004 UNLESS OTHERWISE SPECIFIED DIM MODEL IS BASIC GENERAL TOLERANCES ARE BASIC BROKEN EDGES/CHAMFER: 1 ± 0.2 X 45° FILLET/RADIUS: R0.8 ± 0.2 SURFACE FINISH: 6.3	UNFINISHED DRAWING FEATURES MATERIAL: N/A FINISH/TREATMENT:	HUSKY TITLE: SCVG Single Cavity Valve Gate U750-SCVG-VX SCALE: 1:1 SHEET: 1 OF 2 AOR: 8028646 REV: 2
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ASSEMBLY DRAWING

REV 2
8028646



ARROWS MUST BE ALIGNED FOR THE VALVE STEM TO ACTUATE
ARROW VIEW SCALE 1:2

5535342
SINGLE CAVITY NAMEPLATE BLANK
PROJECT NUMBER TO BE ENGRAVED AT ASSEMBLY

ASSEMBLY NOTE:
ALL CYLINDER BOLTS MUST BE TIGHTENED IN A STAR PATTERN FOR THE VALVE STEM TO ACTUATE.

EXPLODED VIEW
SCALE 1:1

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	19	12
5/16	25	18
3/8	35	25
1/2	50	35
5/8	65	45
3/4	85	60
7/8	110	80
1	150	110
M4	7	5
M5	9	7
M6	11	8
M8	16	12
M10	22	16
M12	29	21
M14	39	29
M16	50	37
M20	75	55
M24	110	80

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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DEFINED DRAWING FEATURES		MATERIAL		FINISH/TREATMENT		WEIGHT	
100% DIMENSIONAL ACCURACY	100% DIMENSIONAL ACCURACY	N/A	N/A	N/A	N/A	-	-
HUSKY		TITLE		SCALE		REV	
Single Cavity Valve Gate		U750-SCVG-VX		1:1		2	
SHEET 2 OF 2		DRAWING		8028646		2	