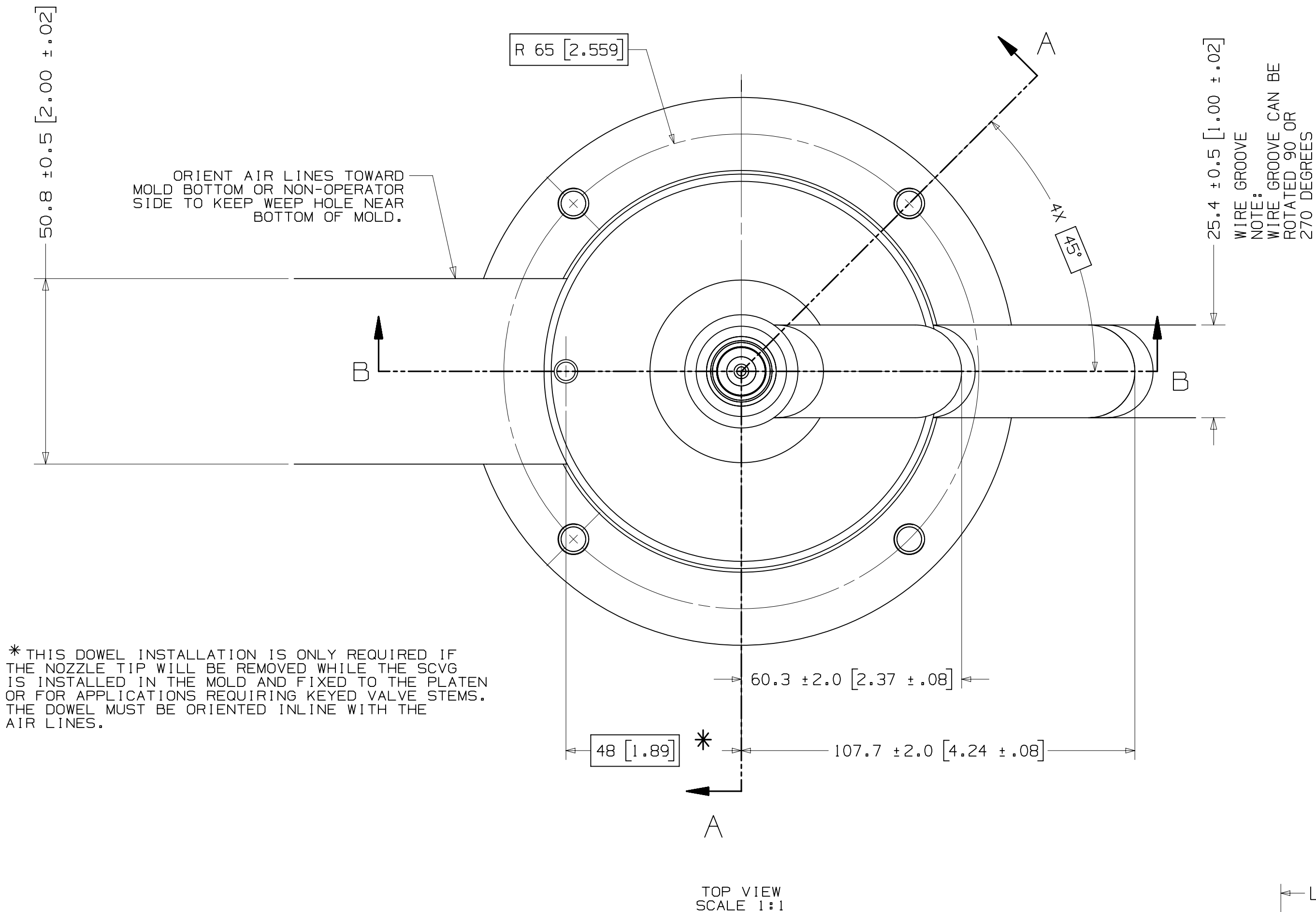
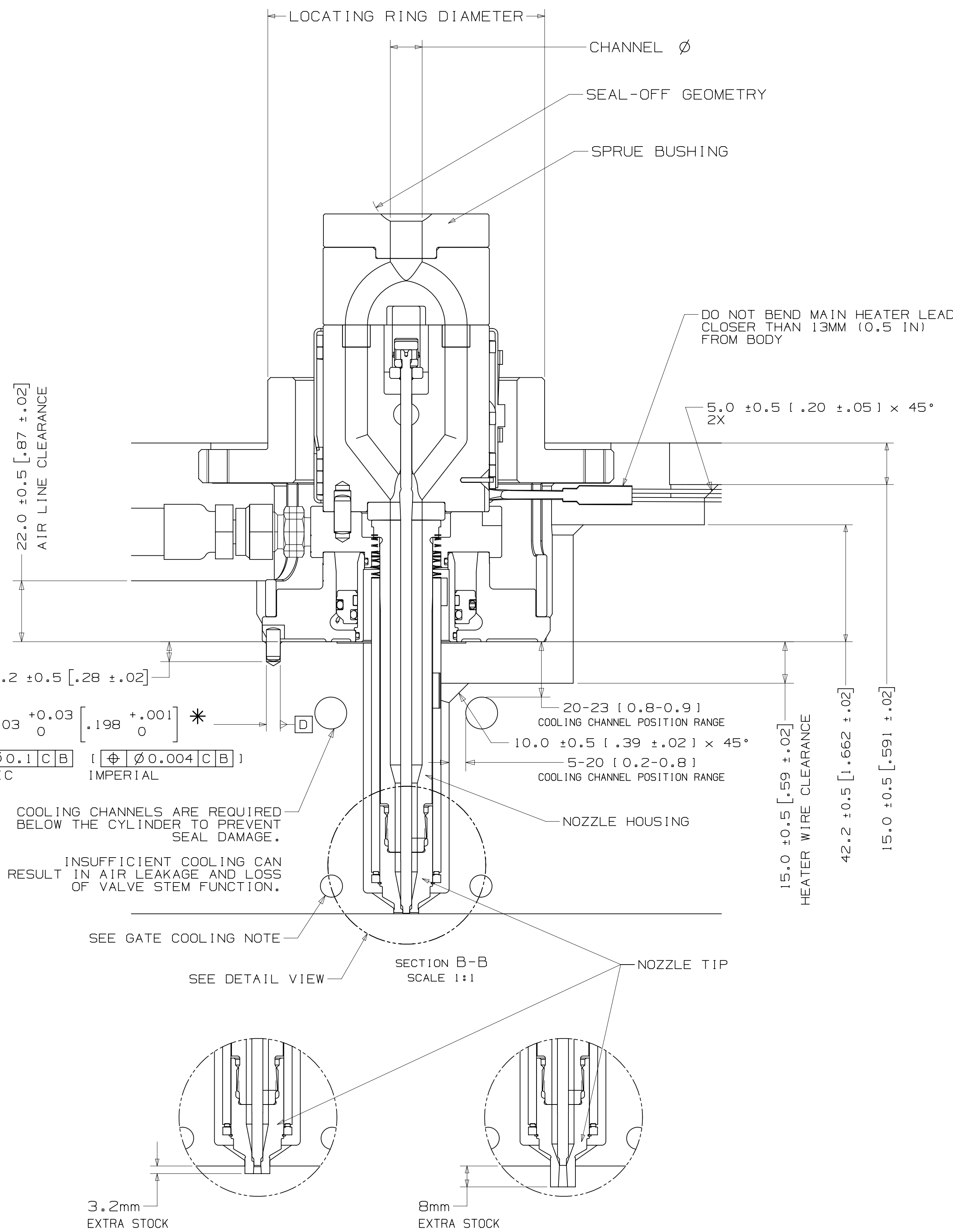
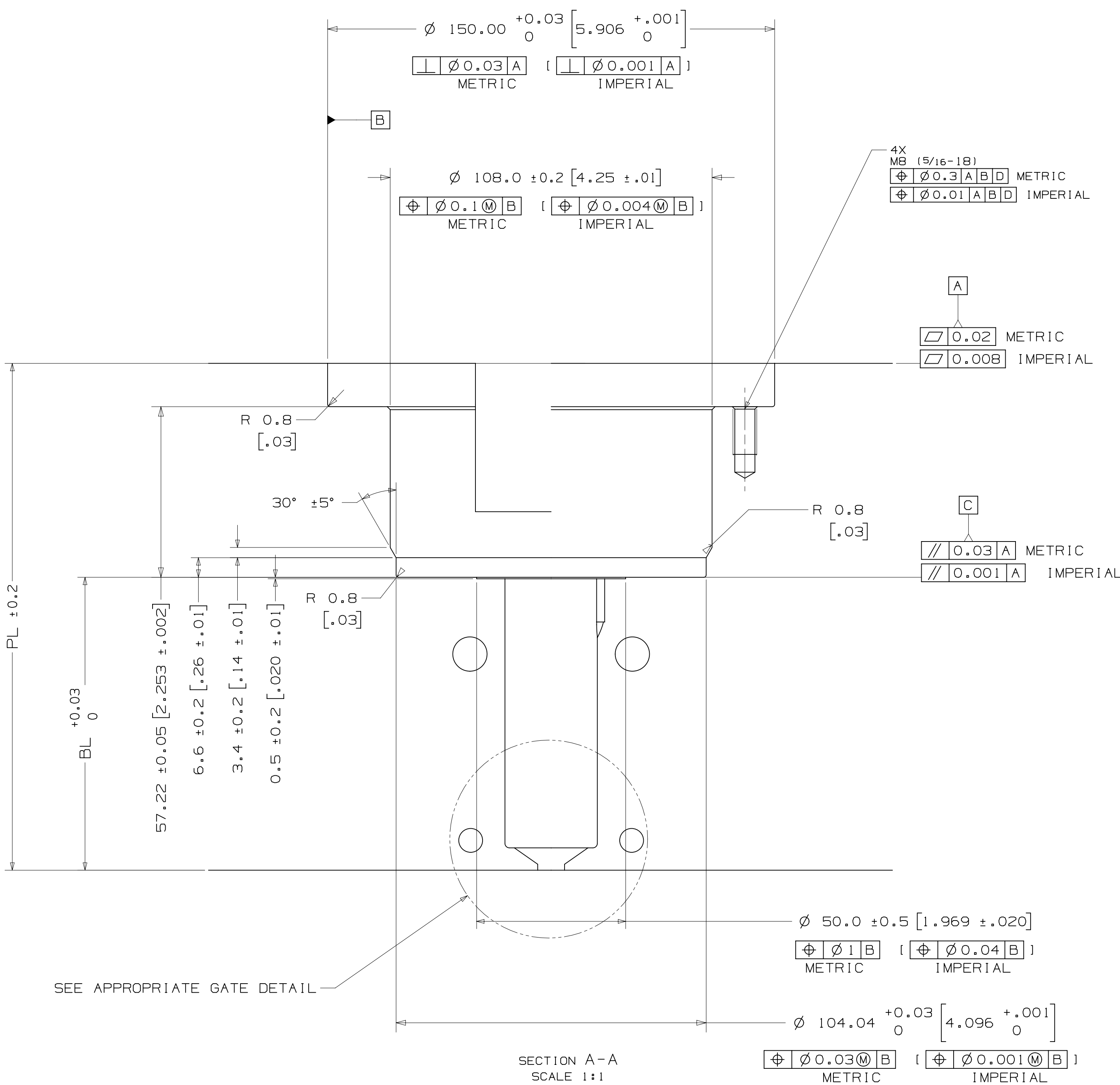


INSTALLATION DRAWING



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

TOP VIEW
SCALE 1:1



DETAIL VIEWS FOR EXTRA STOCK

NOZZLE SERIES	NOZZLE TIP	PL RANGE	Approx. BL *
U750	VX / VX with extra stock 3.2mm / VX with extra stock 8mm	97.55 [3.841] - 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 [3.991]
	125

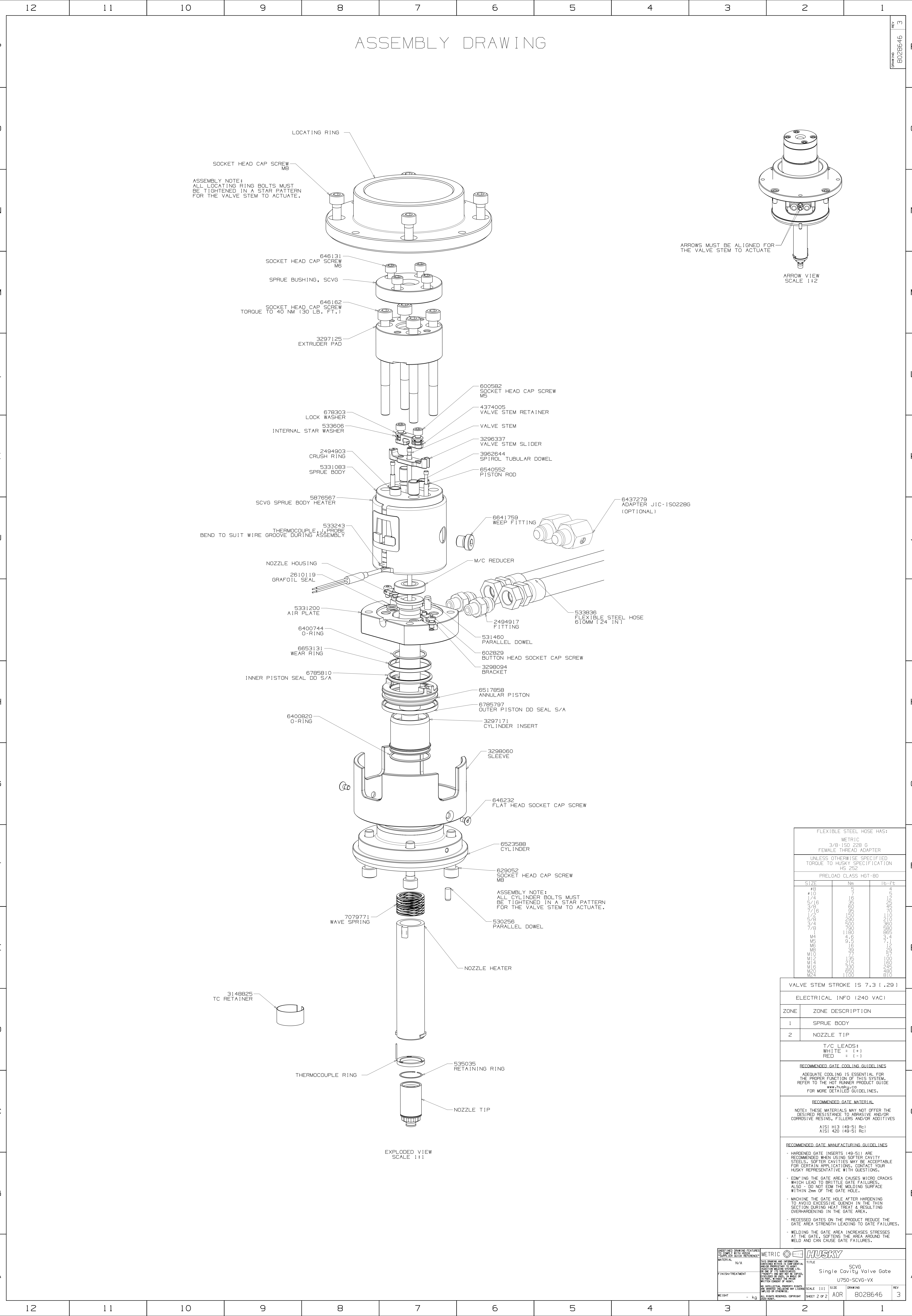
DIMENSIONS SHOWN AS: millimeters [inches]

RECOMMENDED GATE COOLING GUIDELINES
ADEQUATE COOLING IS ESSENTIAL FOR THE PROPER FUNCTION OF THIS SYSTEM. REFER TO THE HOT RUNNER PRODUCT GUIDE 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]
AISI 420 [49-51 Rc]

RECOMMENDED GATE MANUFACTURING GUIDELINES
• HARDENED GATE INSERTS (49-51) 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.

QUAL PER ASME Y14.5M-1994 AND HEAVY ADDENDUM - HUSKY		DEFINED DRAWING FEATURES		MATERIAL		FINISH/TREATMENT		TOLERANCES		BROKEN EDGE/CHAMFER		FILLET/ROUND		SURFACE FINISH		WEIGHT		HUSKY		TITLE		SCALE		SIZE		DRAWING		REV	
UNLESS OTHERWISE SPECIFIED		N/A		N/A		N/A		N/A		N/A		N/A		N/A		N/A		N/A		Single Cavity Valve Gate		1:1		A0R		8028646		3	



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

ARROWS MUST BE ALIGNED FOR
THE VALVE STEM TO ACTUATE

ARROW VIEW
SCALE 1:2

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	25
1/2	60	45
5/8	90	65
3/4	150	110
7/8	230	170
1	350	250
M4	4.6	3.4
M5	6.6	4.9
M6	9.6	7.1
M8	16	12
M10	29	21
M12	47	35
M14	75	55
M16	135	100
M18	215	160
M20	330	245
M22	500	360
M24	650	480
M26	1100	810

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 = (-)

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AT THE GATE. SOFTENS THE AREA AROUND THE
WELD AND CAN CAUSE GATE FAILURES.

DEFINED DRAWING FEATURES TO DIMS 8170-0000 SUPPLIER QUICK REFERENCE	METRIC		TITLE	SCVG
MATERIAL	N/A		Single Cavity Valve Gate	
FINISH/TREATMENT			U750-SCVG-VX	
WEIGHT	- kg		SCALE 1:1	SIZE
			AOR	8028646
			SHEET 2 OF 2	REV
				3