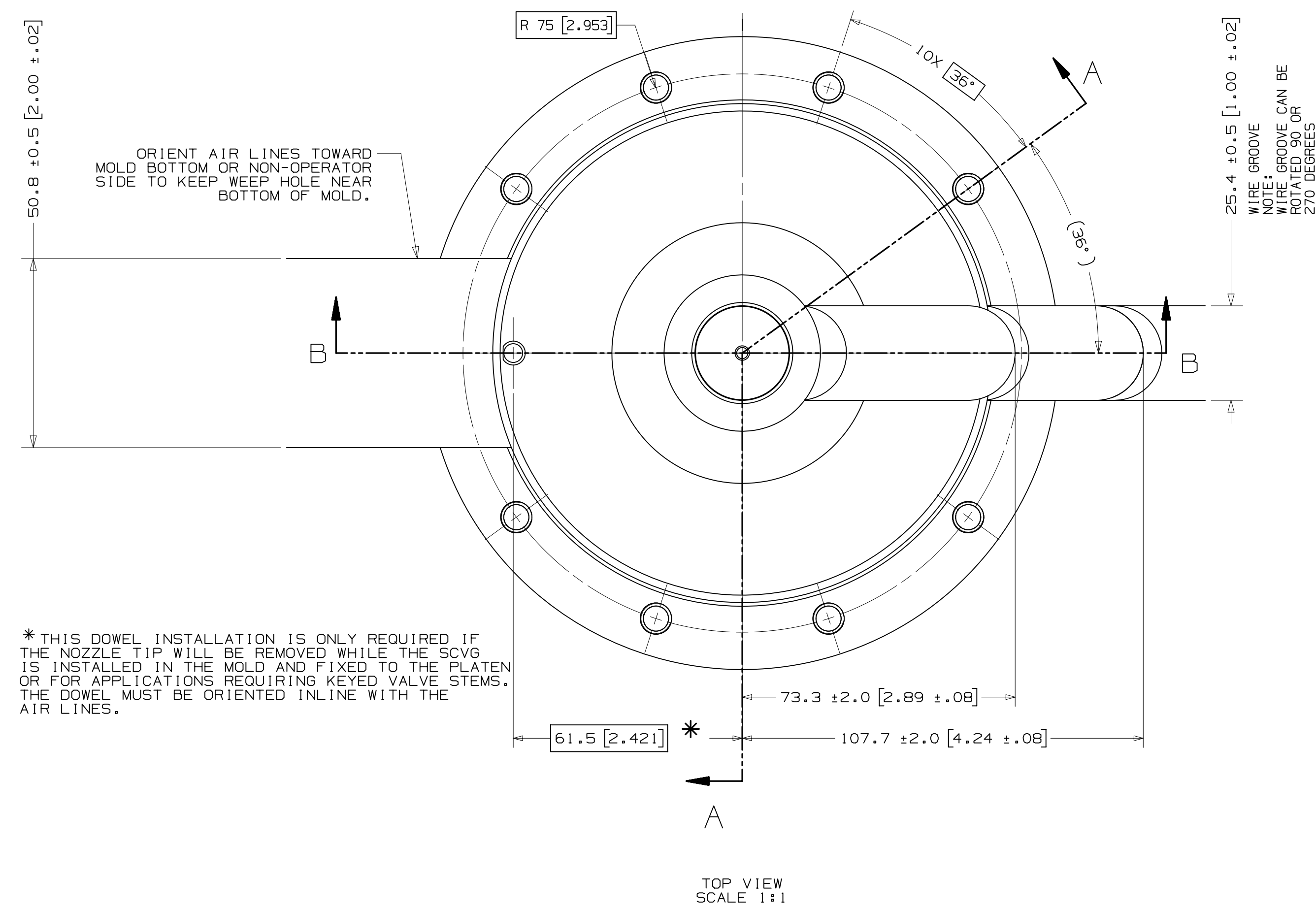


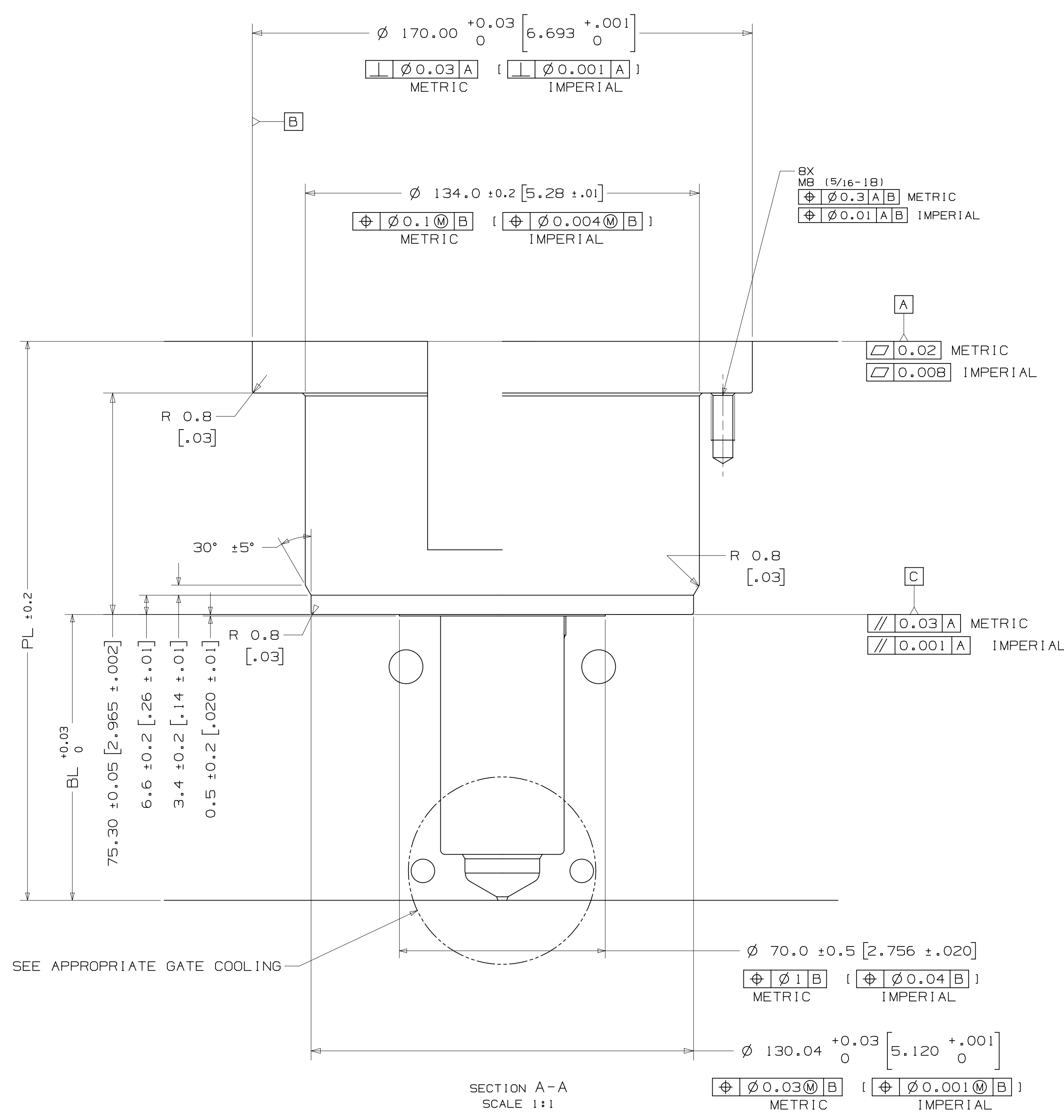
INSTALLATION DRAWING

STATUS: 8151647 0

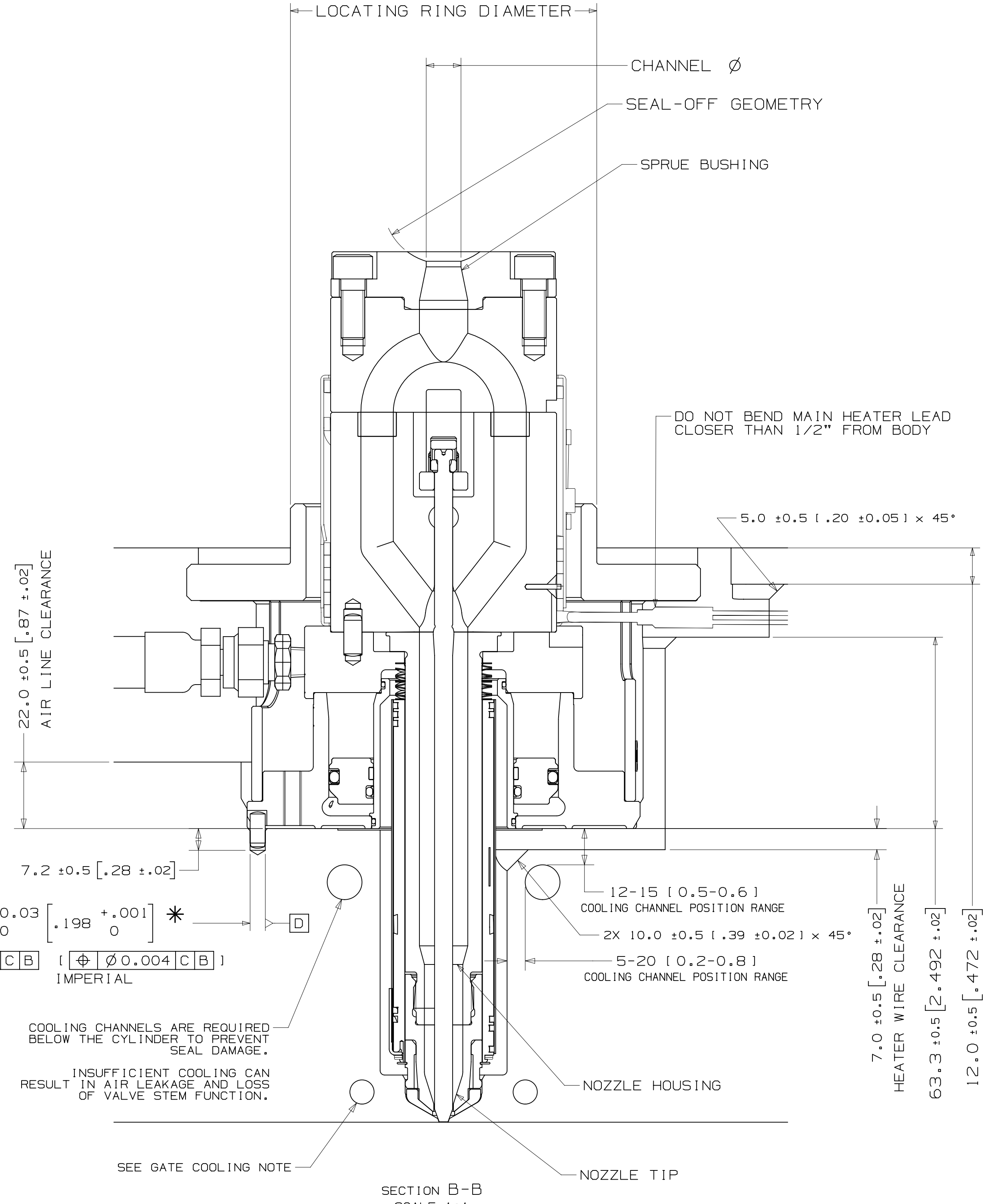


* THIS DOWEL INSTALLATION IS ONLY REQUIRED IF THE NOZZLE TIP WILL BE REMOVED WHILE THE SCVG IS INSTALLED IN THE MOLD AND FIXED TO THE PLATEN OR FOR APPLICATIONS REQUIRING KEVED VALVE STEMS. THE DOWEL MUST BE ORIENTED IN LINE WITH THE AIR LINES.

TOP VIEW SCALE 1:1



SECTION A-A SCALE 1:1



SECTION B-B SCALE 1:1

NOZZLE SERIES	NOZZLE TIP	NOZZLE HOUSING LENGTH	PL		"BL" AT DELTA TEMP (DELTA TEMP = TEMP OF MELT - TEMP OF MOLD) *															
			MIN [INCH]	MAX [INCH]	60° C-79° F [149° F-174° F]	80° C-99° F [176° F-210° F]	100° C-119° F [212° F-246° F]	120° C-139° F [248° F-282° F]	140° C-159° F [284° F-318° F]	160° C-179° F [320° F-354° F]	180° C-199° F [358° F-390° F]	200° C-219° F [392° F-426° F]	220° C-239° F [428° F-462° F]	240° C-259° F [464° F-498° F]	260° C-279° F [500° F-534° F]	280° C-300° F [536° F-572° F]				
U1000	VG	70	124 [4.882]	134 [5.276]	36.84 [1.450]	36.86 [1.451]	36.87 [1.452]	36.89 [1.452]	36.91 [1.453]	36.93 [1.454]	36.95 [1.455]	36.97 [1.456]	36.99 [1.456]	37.01 [1.457]	37.04 [1.458]	37.06 [1.459]				
		90	145 [5.709]	154 [6.063]	56.85 [2.238]	56.88 [2.239]	56.90 [2.240]	56.92 [2.241]	56.95 [2.242]	56.97 [2.243]	57.00 [2.244]	57.02 [2.245]	57.05 [2.246]	57.07 [2.247]	57.10 [2.248]	57.13 [2.249]				
		110	165 [6.496]	174 [6.850]	76.87 [3.026]	76.90 [3.028]	76.92 [3.028]	76.95 [3.030]	76.98 [3.031]	77.01 [3.032]	77.04 [3.033]	77.07 [3.034]	77.10 [3.035]	77.13 [3.037]	77.17 [3.038]	77.20 [3.039]				
		130	185 [7.283]	194 [7.638]	96.88 [3.814]	96.92 [3.816]	96.95 [3.817]	96.98 [3.818]	97.02 [3.820]	97.05 [3.821]	97.08 [3.822]	97.12 [3.824]	97.16 [3.825]	97.19 [3.826]	97.23 [3.828]	97.27 [3.830]				
		150	205 [8.071]	214 [8.425]	116.90 [4.602]	116.94 [4.604]	116.97 [4.605]	117.01 [4.607]	117.05 [4.608]	117.09 [4.610]	117.13 [4.611]	117.17 [4.613]	117.21 [4.615]	117.25 [4.616]	117.30 [4.618]	117.34 [4.620]				
		170	225 [8.858]	235 [9.252]	136.92 [5.391]	136.96 [5.392]	137.00 [5.394]	137.04 [5.395]	137.08 [5.397]	137.13 [5.399]	137.17 [5.400]	137.22 [5.402]	137.26 [5.404]	137.31 [5.406]	137.36 [5.408]	137.41 [5.410]				
		190	245 [9.646]	255 [10.039]	156.93 [6.178]	156.98 [6.180]	157.02 [6.182]	157.07 [6.184]	157.12 [6.186]	157.17 [6.188]	157.22 [6.190]	157.27 [6.192]	157.32 [6.194]	157.37 [6.196]	157.43 [6.198]	157.48 [6.200]				

* BL VALUES IN THE TABLE ARE REFERENCES WHICH CAN DEVIATE BY +/-0.03mm FINAL BL VALUE CAN BE FIND ON GATE DETAIL DRAWING AND 3D AFTER FINISHED DESIGN.

NOZZLE SERIES	LOCATING RING DIAMETER
U1000	100mm
	101.3mm [3.99"]
	125mm

NOZZLE SERIES	SPRUE BUSHING		CHANNEL Ø IN - OUT
	SEAL-OFF GEOMETRY SPHERICAL RADIUS	FLAT	
U1000	SEAL-OFF 12.7 [1/2"]		11.5-16.00
	SEAL-OFF 15.5		
	SEAL-OFF 19.05 [3/4"]		
	SEAL-OFF 20		
	SEAL-OFF 40		

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.co

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]

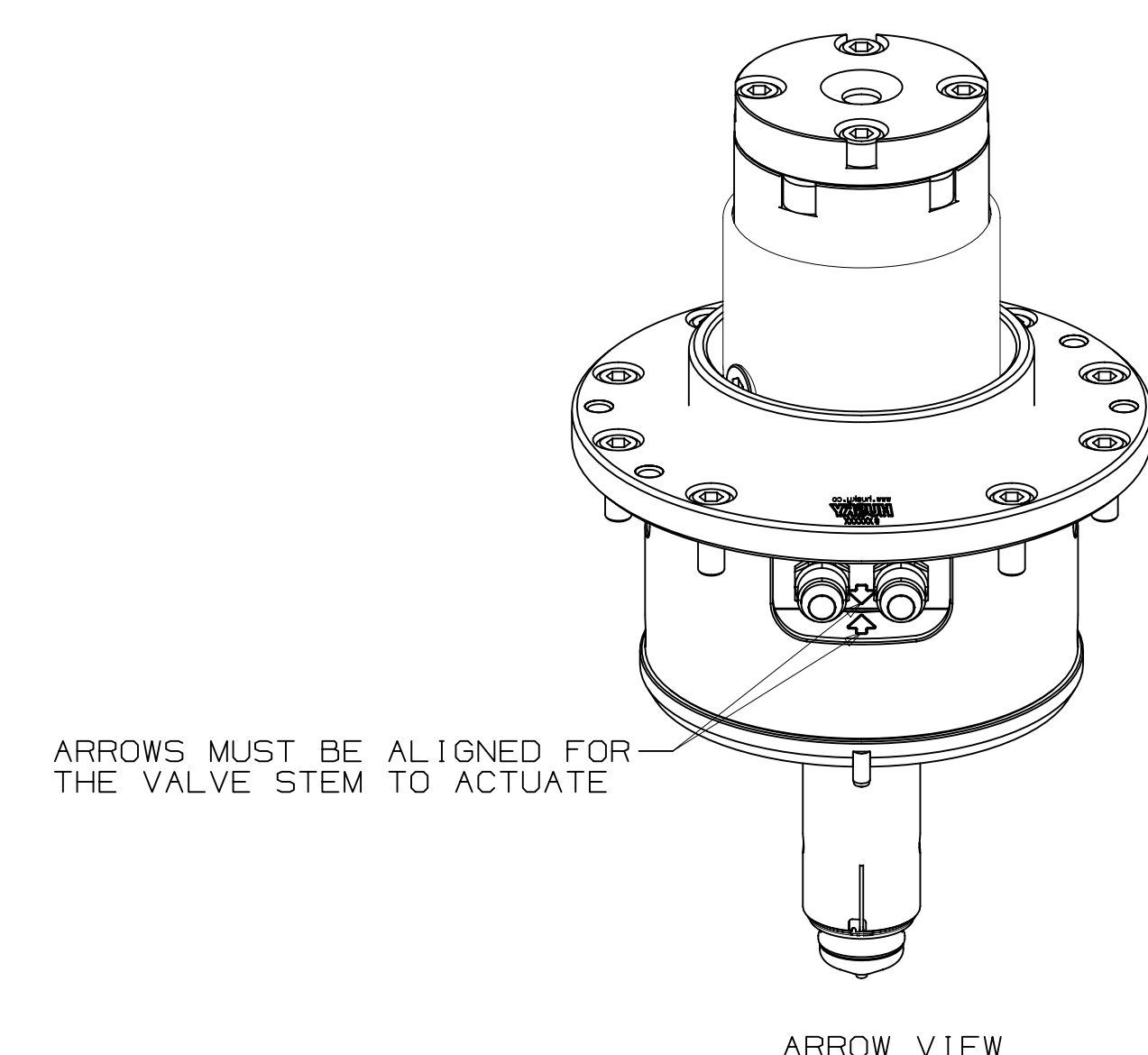
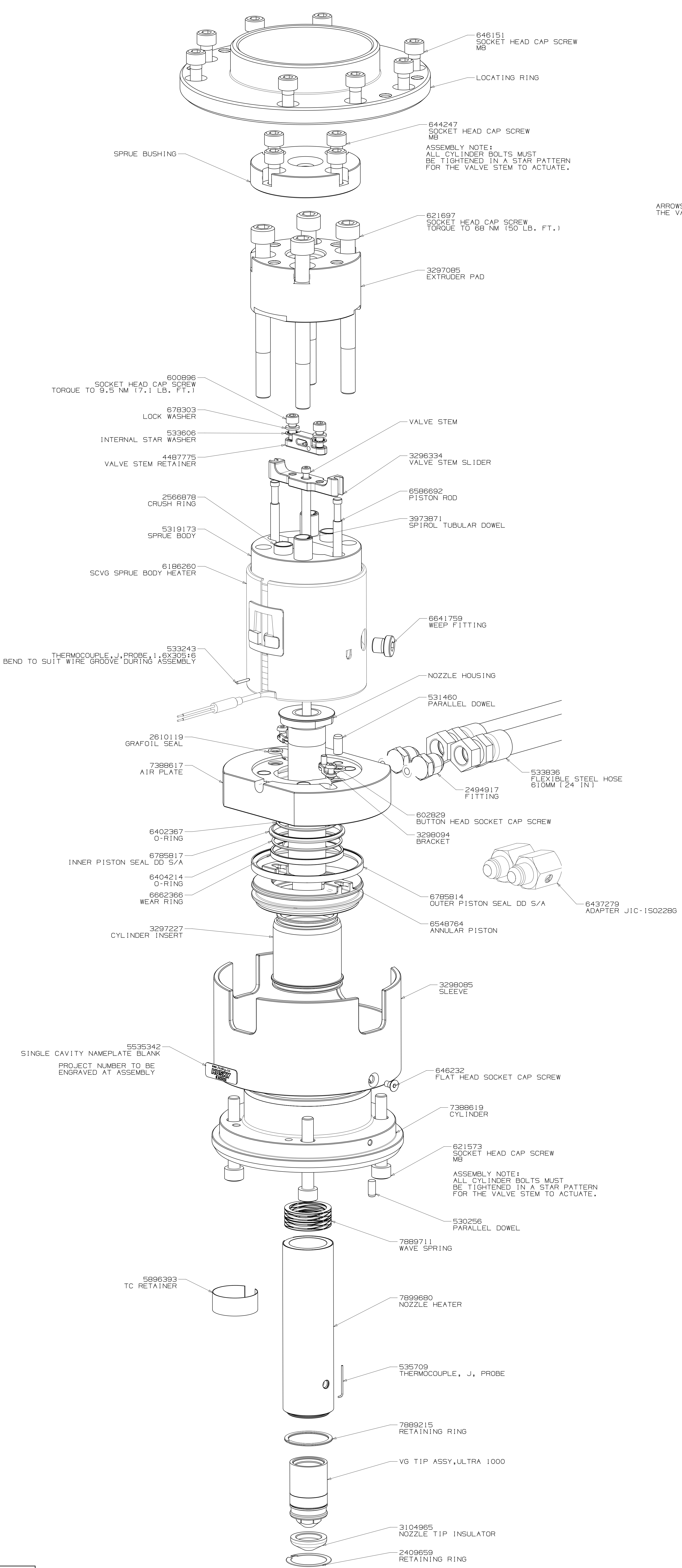
RECOMMENDED GATE MANUFACTURING GUIDELINES
- HARDENED GATE INSERTS (49-51) ARE RECOMMENDED WHEN USING SOFTER CAVITY STEELS. SOFTER CAVITIES MAY BE ACCEPTABLE FOR CERTAIN APPLICATIONS. CONTACT YOUR HUSKY REPRESENTATIVE WITH QUESTIONS.
- EDM'ING THE GATE AREA CAUSES MICRO CRACKS WHICH LEAD TO BRITTLE GATE 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.

REV	DATE	DESCRIPTION	DRWN	CHKD
0	2017-09-15	ORIGINAL ISSUE - DESIGNED BY DHANALEKIAN	DRWN: DHANALEKIAN	CHKD: PICHLER KLAUS

DWT PER ASME Y14.5M-1994 AND HEAVY ADDENDUM - H254 UNLESS OTHERWISE SPECIFIED: DIM. MODEL IS BASIC. UNLESS OTHERWISE SPECIFIED: ARE BASIC. GENERAL TOLERANCES: FRACTIONS: ± 0.13 METRIC ± 0.005 IMPERIAL DECIMALS: ± 0.13 METRIC ± 0.005 IMPERIAL HOLE POSITION: ± 0.13 METRIC ± 0.005 IMPERIAL SURFACE FINISH: $R_{a} 0.8$ METRIC $R_{a} 0.032$ IMPERIAL	UNFINISHED DRAWING FEATURES: MATERIAL: N/A FINISH/TREATMENT:	HUSKY TITLE: SCVG Single Cavity Valve Gate U1000-SCVG-VG SCALE: 1:1 SHEET: 1 OF 2 AOR: 8151647 REV: 0
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ASSEMBLY DRAWING

REV: 0
8151647



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	5.2
5/16	16	12
3/8	25	18
1/2	50	37
5/8	75	55
3/4	100	74
7/8	150	110
1	200	148
M4	4.6	3.4
M5	7.7	5.7
M6	11.6	8.5
M8	23	17
M10	39	29
M12	58	43
M14	89	65
M16	135	100
M20	215	160
M25	350	258
M30	500	368
M36	810	600

VALVE STEM STROKE IS 13.7 (1.54)	
ELECTRICAL INFO (240 VAC)	
ZONE	ZONE DESCRIPTION
1	SPRUE BODY
2	NOZZLE TIP
T/C LEADS: WHITE = (+) RED = (-)	

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0	2017-09-15	ORIGINAL ISSUE - DESIGNED BY: DHANALEYAN	DRWN: DHANALEYAN	CHKD: PICHLER KLAUS

DEFINING DRAWING FEATURES	METRIC	HUSKY
MATERIAL: N/A	FINISH/TREATMENT	TITLE: SCVG Single Cavity Valve Gate
WEIGHT: - kg	SCALE: 1:1	SIZE: AOR
	SHEET 2 OF 2	REV: 0