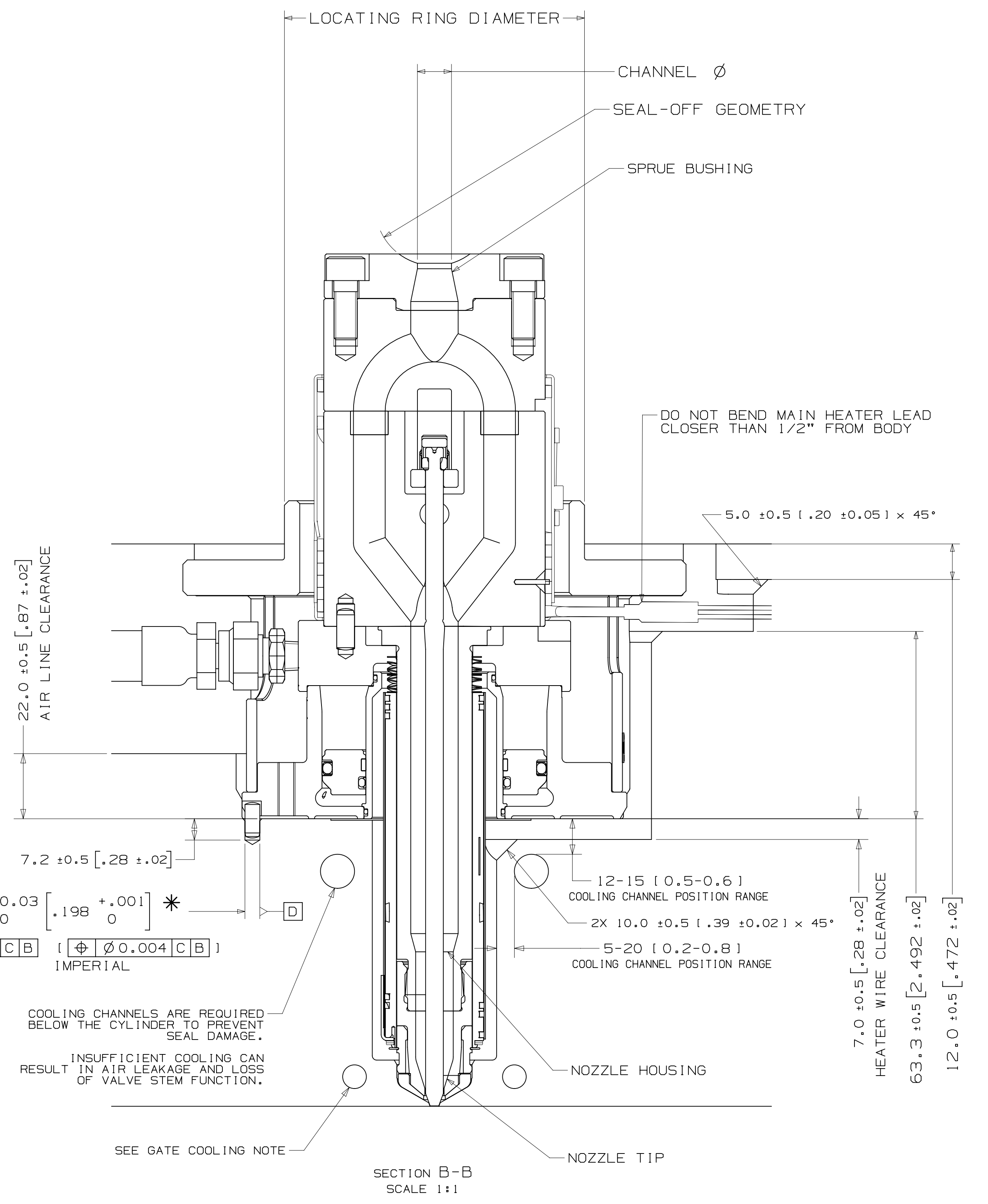
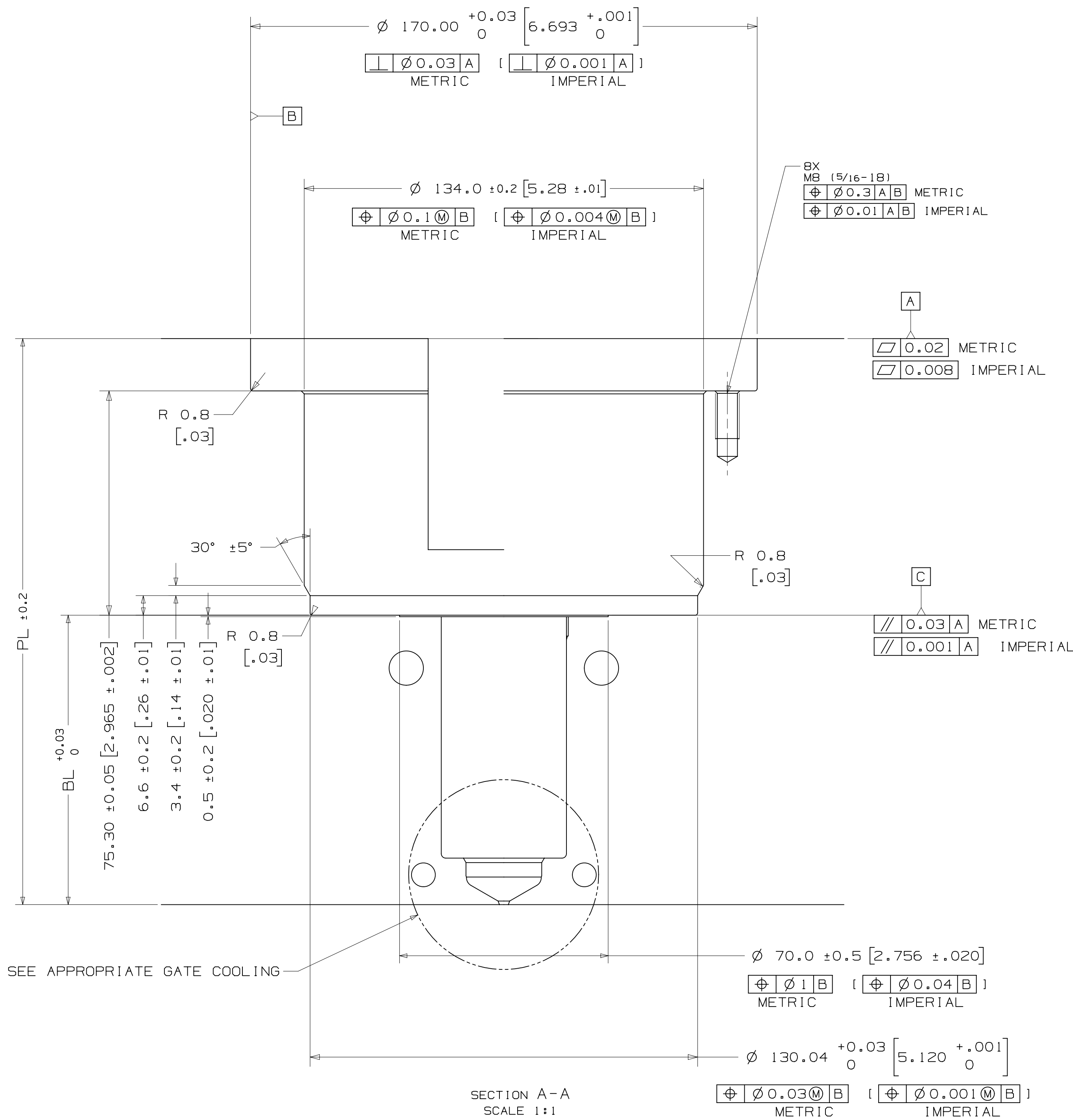
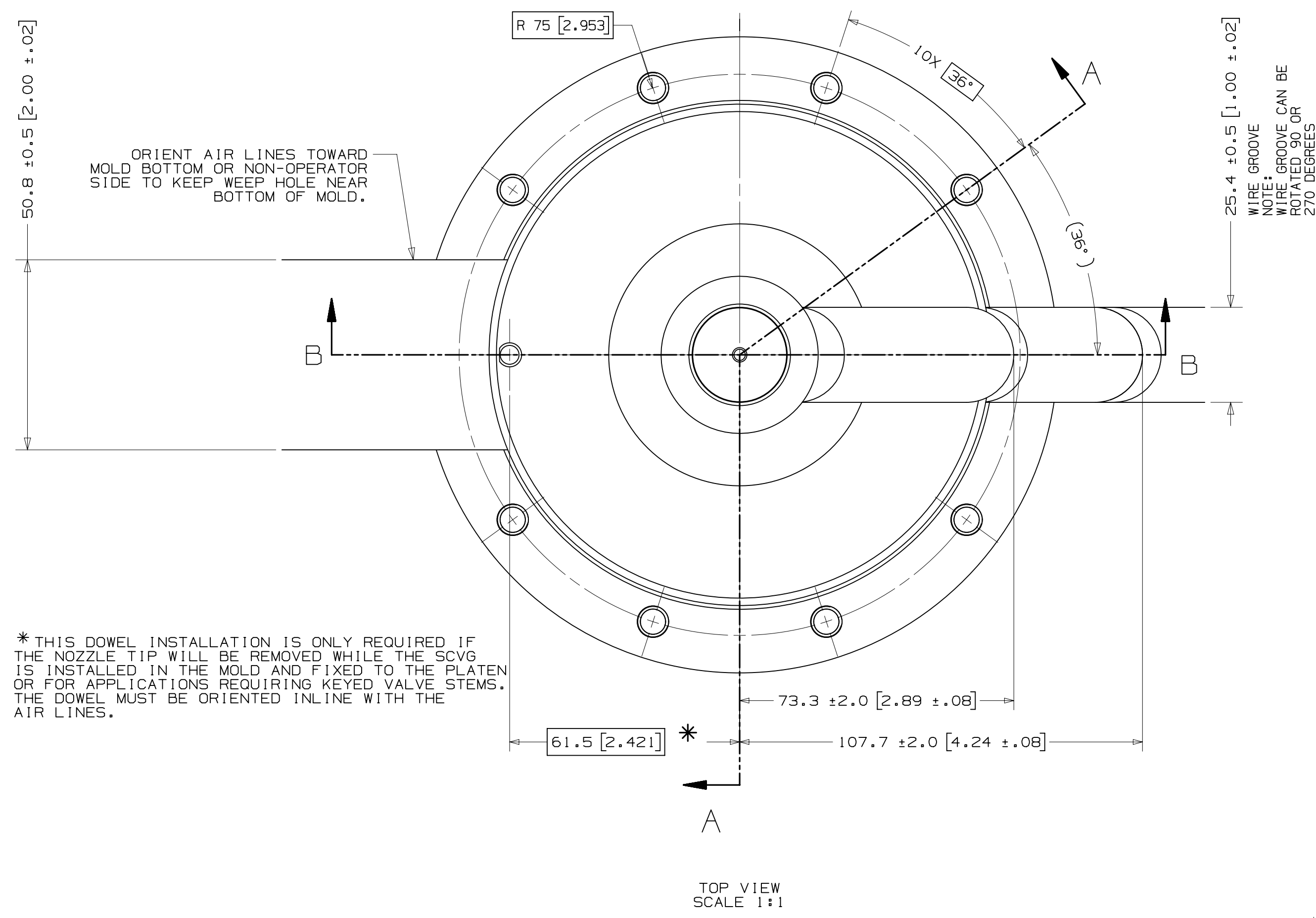


# INSTALLATION DRAWING

REV: 0  
8151647



NOZZLE SERIES	NOZZLE TIP	PL RANGE	Approx. BL
U1000	VG	124,52 (4,902) - 254,81 (10,032)	37 (1,46) - 157 (6,18)

\*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.

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

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

**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](http://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.

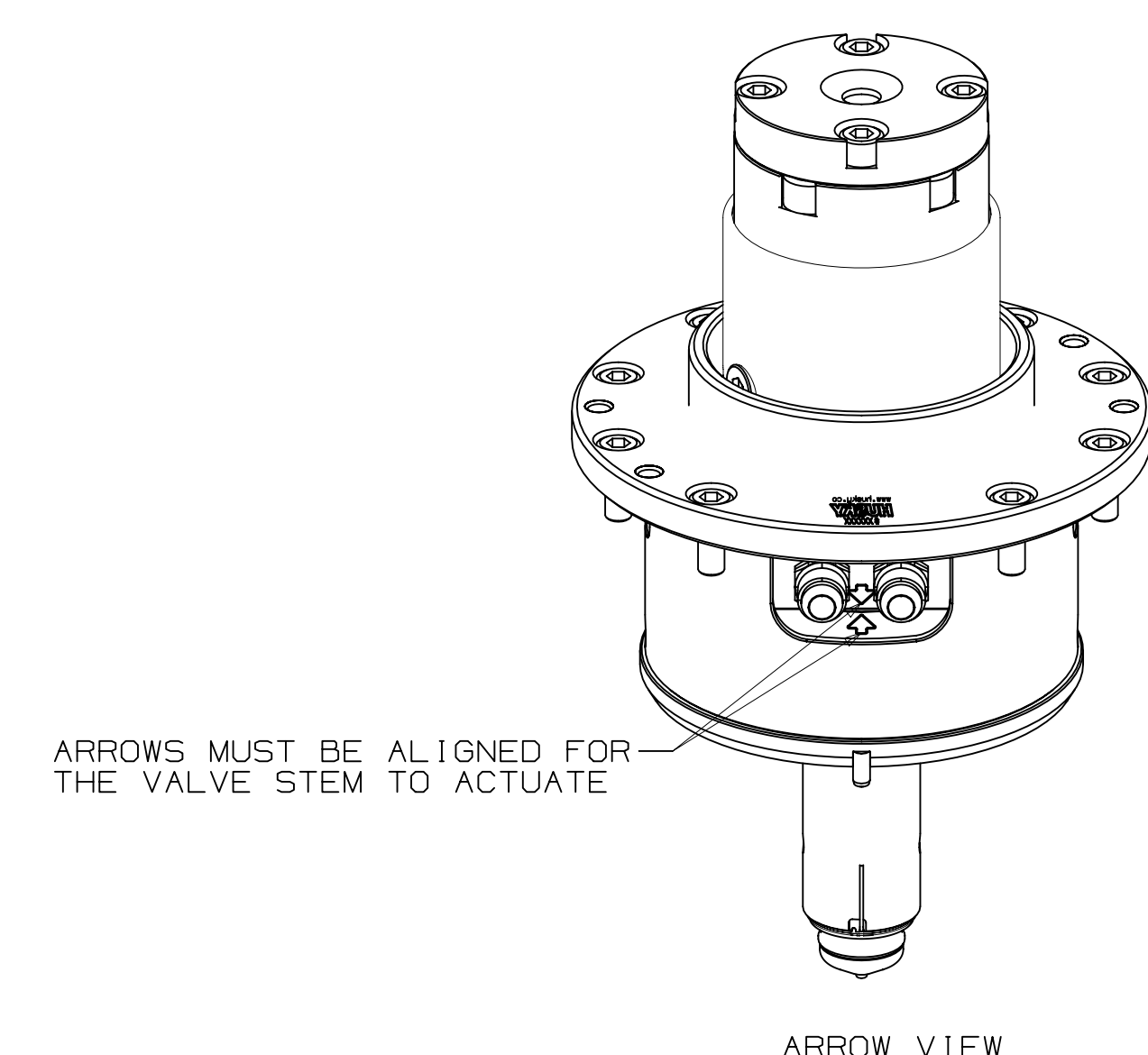
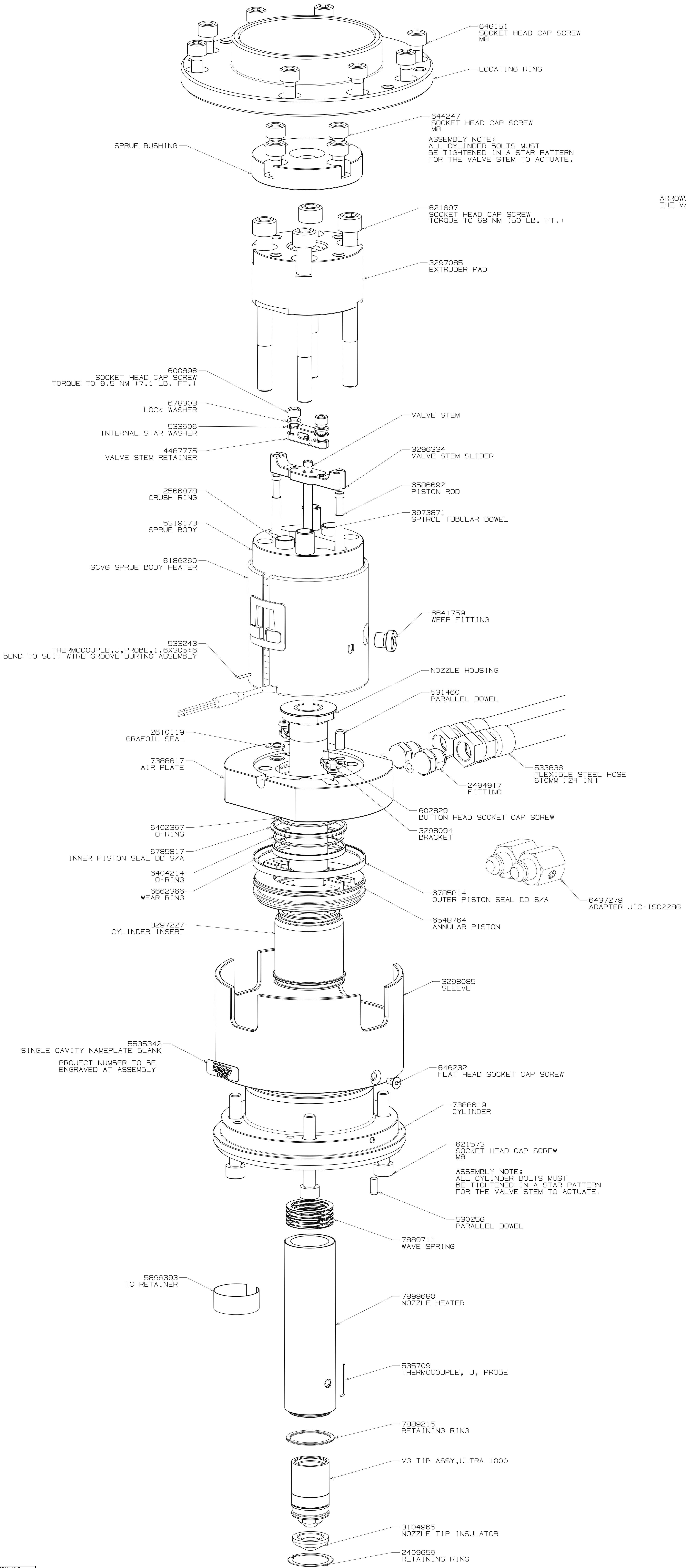
REV	DATE	DESCRIPTION	DESIGNED BY	CHECKED BY
4	2020-05-29	TABLE UPDATED PER LATEST CALCULATION	DRWINI DEEBAN N T	CHKD1
3	2019-07-09	TEMPLATE VALUES UPDATED AS PER SOL. 2.0	DRWINI MURALIDHARAN	CHKD1
2	2018-04-06	DRAWING NAME CHANGED	DRWINI ANUSHAL	CHKD1
1	2018-01-12	BL NOTE UPDATED	DRWINI DHANANLEYAN	CHKD1
0	2017-09-15	ORIGINAL ISSUE - DESIGNED BY: DHANANLEYAN	DRWINI DHANANLEYAN	CHKD1
			DRWINI PICHLER KLAUS	CHKD1

GENERAL TOLERANCES	FINISH/TREATMENT	WEIGHT	SCALE	SHEET	REV
GENERAL TOLERANCES: METRIC: [0.17] IMPERIAL: [0.017]	FINISH/TREATMENT: [0.017]	WEIGHT: - kg	SCALE: 1:1	SHEET: 1 OF 2	REV: 0

**HUSKY**  
TITLE: Single Cavity Valve Gate  
U1000-SCVG-VG  
SCALE: 1:1  
SHEET: 1 OF 2  
REV: 0

# 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
7/16	35	26
1/2	50	37
5/8	70	52
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	20	15
M10	30	22
M12	45	33
M14	70	52
M16	100	74
M20	180	133
M25	300	221
M30	450	331
M36	700	515
M42	1100	810

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 = (-)

**RECOMMENDED GATE COOLING GUIDELINES**  
ADEQUATE COOLING IS ESSENTIAL FOR THE PROPER FUNCTION OF THIS SYSTEM. REFER TO THE HOT RUNNER PRODUCT GUIDE FOR CERTAIN APPLICATIONS. CONTACT YOUR HUSKY REPRESENTATIVE WITH QUESTIONS.  
[www.husky.co](http://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	DRWNG	CHKD
4	2020-05-29	TABLE UPDATED PER LATEST CALCULATION	DRWNG DEEBAN N T	CHKD
3	2019-07-09	TEMPLATE VALUES UPDATED AS PER SOL 2.0	DRWNG MURALIDHARAN	CHKD
2	2018-04-06	DRAWING NAME CHANGED	DRWNG ANUSHAL	CHKD
1	2018-01-12	BL NOTE UPDATED	DRWNG DHANALEYAN	CHKD
0	2017-09-15	ORIGINAL ISSUE - DESIGNED BY: DHANALEYAN	DRWNG DHANALEYAN	CHKD
			DRWNG PICHLER KLAUS	CHKD

MATERIAL	FINISH/TREATMENT	WEIGHT	SCALE	SIZE	DRAWING	REV
N/A		- kg	1:1	AOR	8151647	0