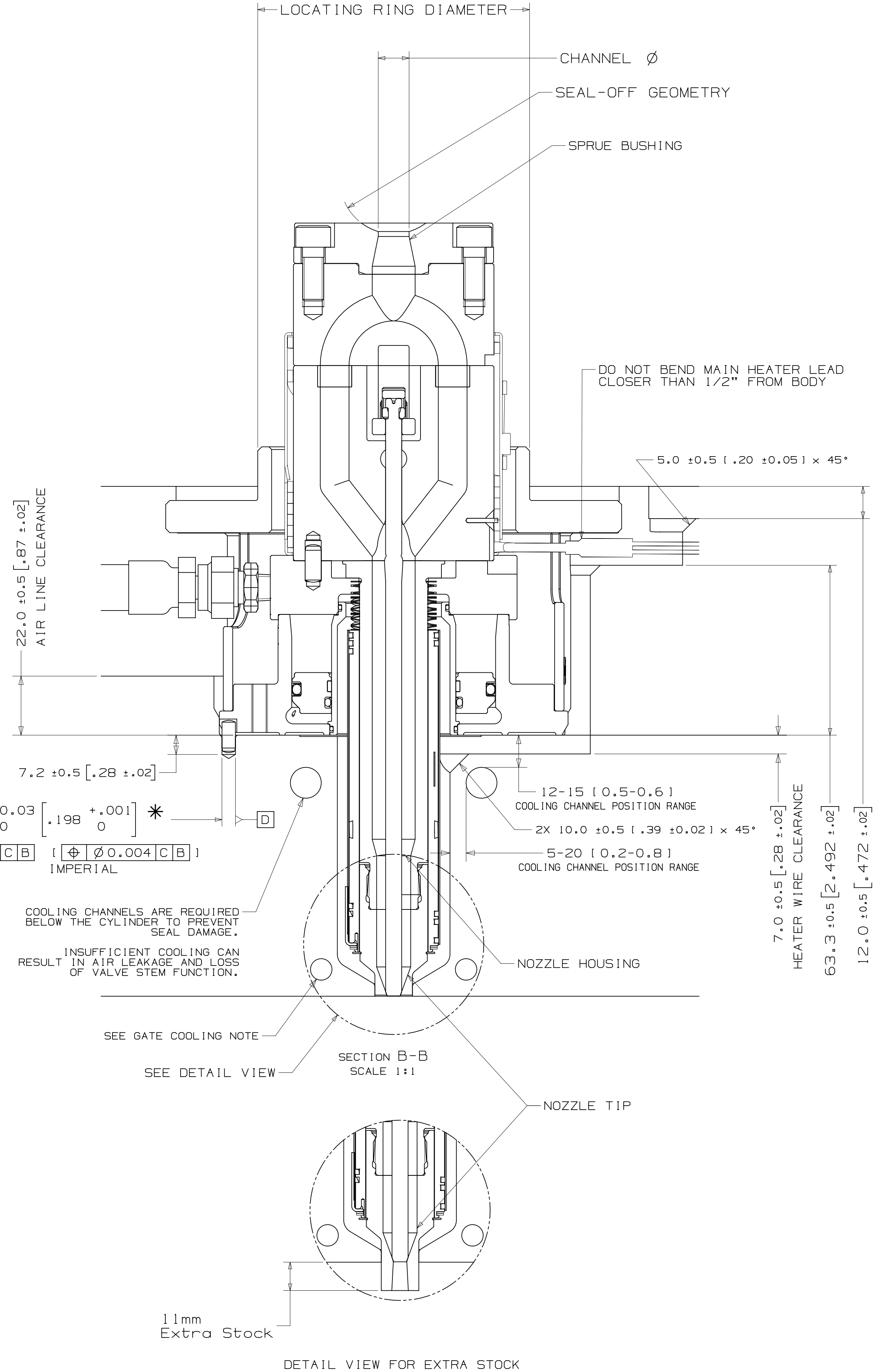
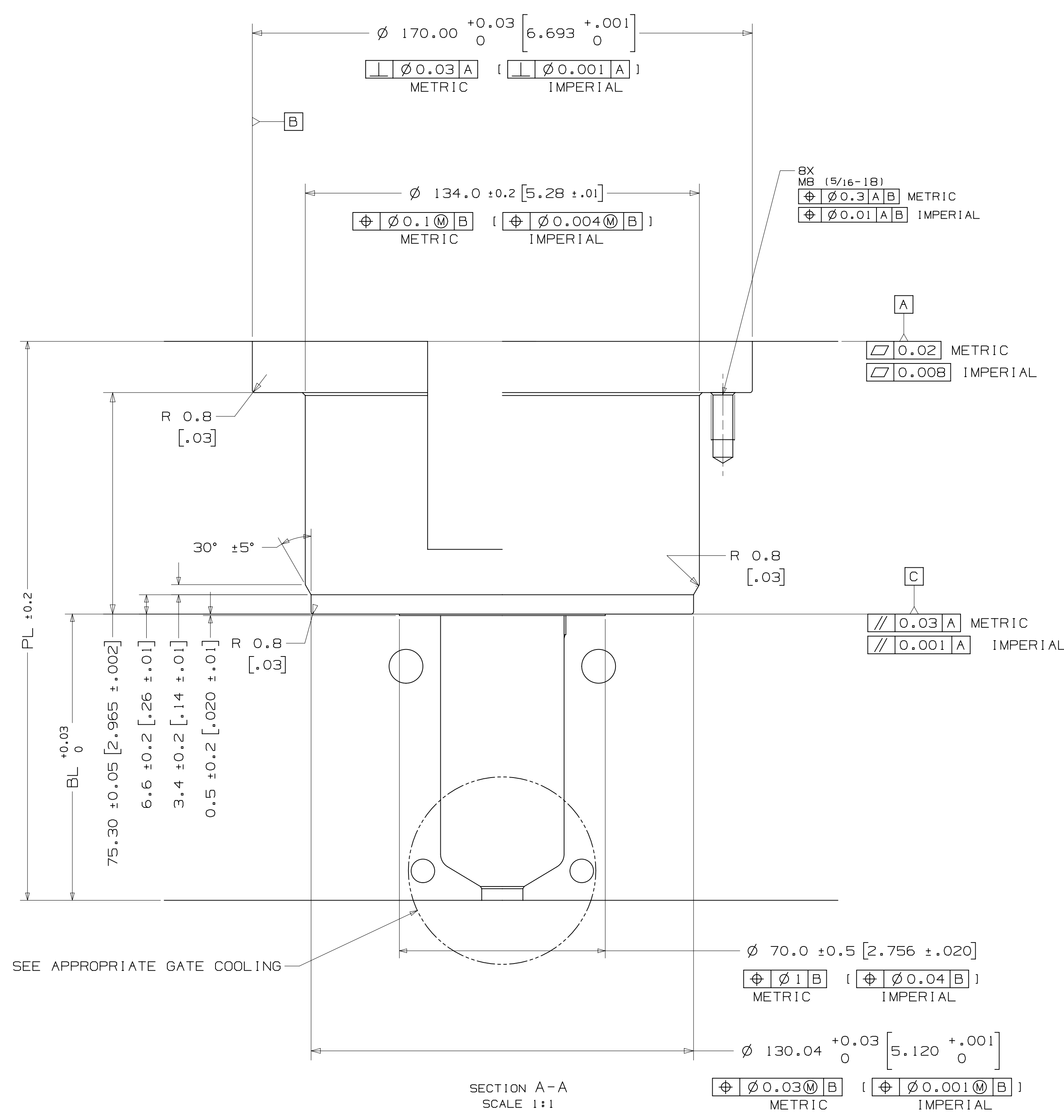
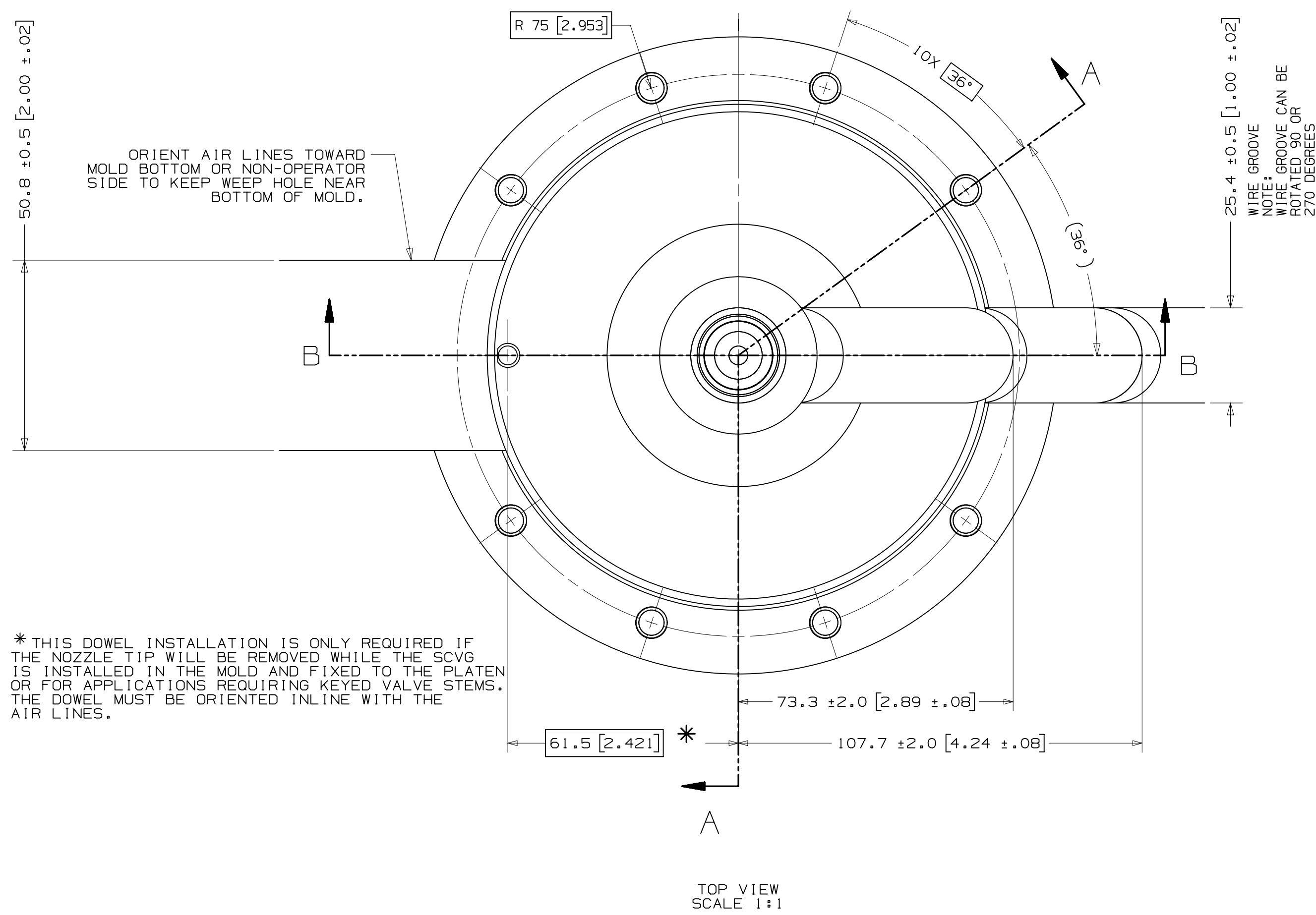


INSTALLATION DRAWING

DRAWING NO. 8153509 0



NOZZLE SERIES	NOZZLE TIP	NOZZLE HOUSING		PL		"BL" AT DELTA TEMP (DELTA TEMP = TEMP OF MELT - TEMP OF MOLD) *															
		LENGTH	MIN [INCH]	MAX [INCH]	60° C-79° C [140° F-174° F]	80° C-99° C [176° F-210° F]	100° C-119° C [212° F-246° F]	120° C-139° C [248° F-282° F]	140° C-159° C [284° F-318° F]	160° C-179° C [320° F-354° F]	180° C-199° C [356° F-388° F]	200° C-219° C [392° F-428° F]	220° C-239° C [428° F-462° F]	240° C-259° C [464° F-498° F]	260° C-279° C [500° F-534° F]	280° C-300° C [538° F-572° F]					
U1000	VX	70	125 [4.921]	135 [5.315]	36.99 [1.456]	37.01 [1.457]	37.02 [1.457]	37.04 [1.458]	37.06 [1.459]	37.08 [1.460]	37.10 [1.461]	37.12 [1.461]	37.14 [1.462]	37.16 [1.463]	37.19 [1.464]	37.21 [1.465]					
		90	145 [5.709]	155 [6.102]	57.00 [2.244]	57.03 [2.245]	57.05 [2.246]	57.07 [2.247]	57.10 [2.248]	57.12 [2.249]	57.15 [2.250]	57.17 [2.251]	57.20 [2.252]	57.22 [2.253]	57.25 [2.254]	57.28 [2.255]					
		110	165 [6.496]	175 [6.890]	77.02 [3.032]	77.05 [3.033]	77.07 [3.034]	77.10 [3.035]	77.13 [3.037]	77.16 [3.038]	77.19 [3.039]	77.22 [3.040]	77.25 [3.041]	77.28 [3.043]	77.32 [3.044]	77.35 [3.045]					
		130	185 [7.283]	195 [7.677]	97.03 [3.820]	97.07 [3.822]	97.10 [3.823]	97.13 [3.824]	97.17 [3.826]	97.20 [3.827]	97.23 [3.828]	97.27 [3.830]	97.30 [3.831]	97.34 [3.832]	97.38 [3.834]	97.42 [3.835]					
		150	205 [8.071]	215 [8.465]	117.05 [4.608]	117.09 [4.610]	117.12 [4.611]	117.16 [4.613]	117.20 [4.614]	117.24 [4.616]	117.28 [4.617]	117.32 [4.619]	117.36 [4.620]	117.40 [4.622]	117.44 [4.624]	117.49 [4.626]					
		170	225 [8.858]	235 [9.252]	137.07 [5.396]	137.11 [5.398]	137.15 [5.400]	137.19 [5.401]	137.23 [5.403]	137.28 [5.405]	137.32 [5.406]	137.37 [5.408]	137.41 [5.410]	137.46 [5.412]	137.51 [5.414]	137.56 [5.416]					
		190	245 [9.646]	255 [10.039]	157.08 [6.184]	157.13 [6.186]	157.17 [6.188]	157.22 [6.190]	157.27 [6.192]	157.32 [6.194]	157.37 [6.196]	157.42 [6.198]	157.47 [6.200]	157.52 [6.202]	157.57 [6.204]	157.63 [6.206]					

* BL VALUES IN THE TABLE ARE REFERENCES WHICH CAN DEVIATE BY +/- 0.03mm. FINAL BL VALUE CAN BE FOUND 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	
	SEAL-OFF GEOMETRY	CHANNEL Ø IN - OUT
U1000	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	

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 [49-51 Rc]
AISI 420 [49-51 Rc]

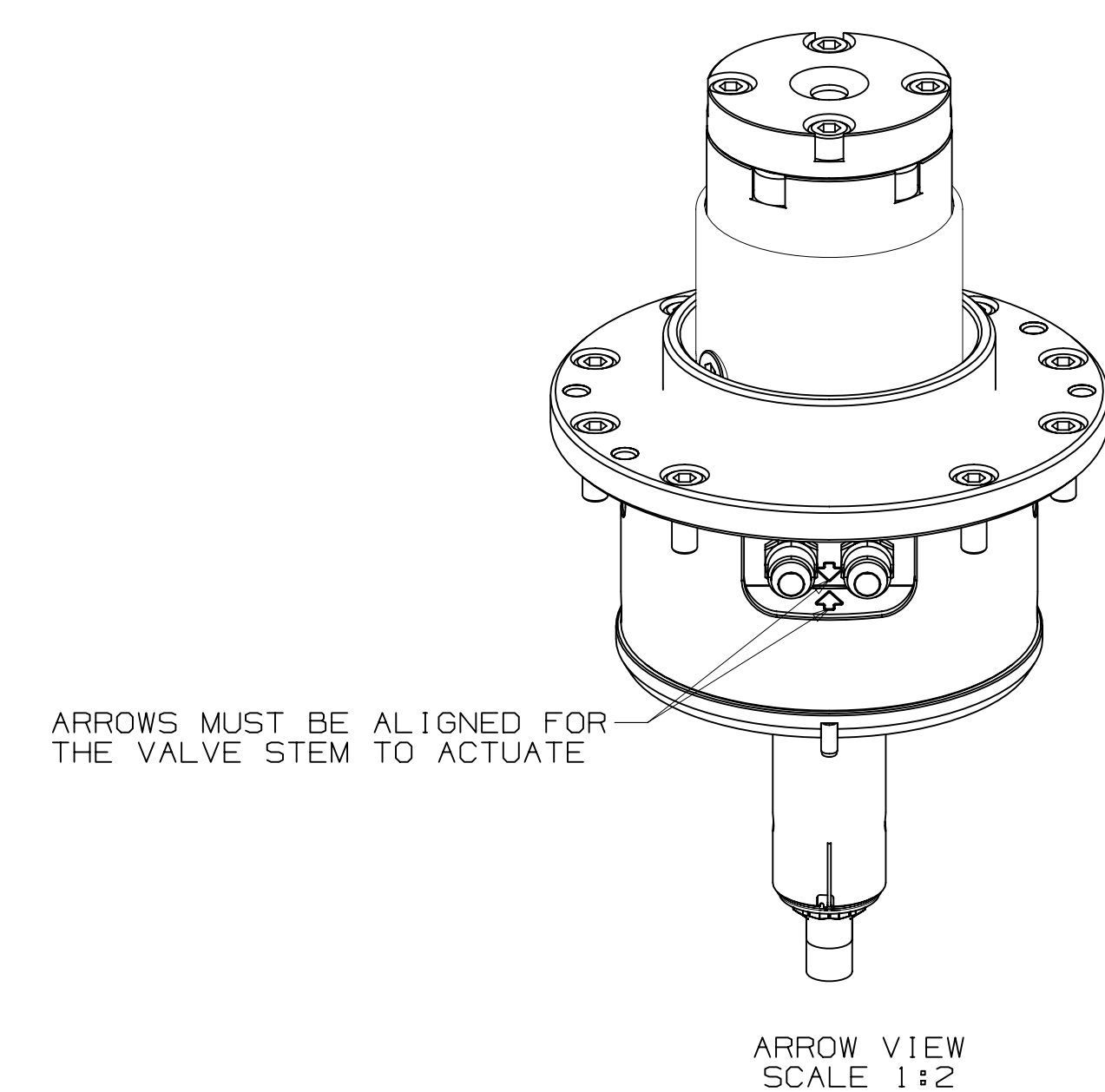
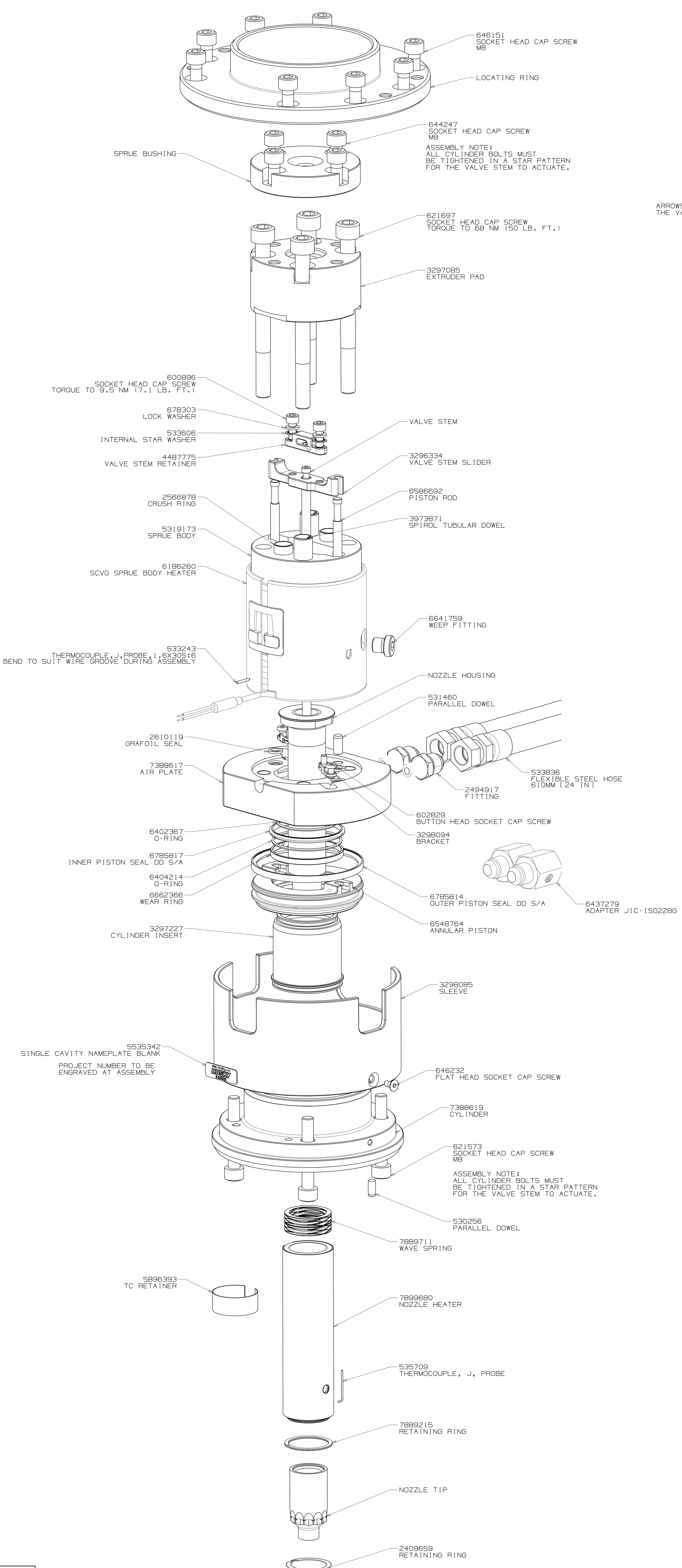
RECOMMENDED GATE MANUFACTURING GUIDELINES
- HARDENED GATE INSERTS (49-51) ARE RECOMMENDED WHEN USING SOFTER CAVITY STEELS. SOFTER CAVITIES MAY BE ACCEPTABLE FOR CERTAIN APPLICATIONS. CONTACT YOUR HUSKY REPRESENTATIVE WITH QUESTIONS.
- EDM'ING THE GATE AREA CAUSES MICRO CRACKS WHICH LEAD TO BRITTLE GATE 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: METRIC IMPERIAL BROKEN EDGE/CHAMFER: 1 ± 0.2 X 45° 0.04 ± 0.01 X 45° FILLET/RADIUS: R0.8 ± 0.2 R0.03 ± 0.01 SURFACE FINISH: Ra 3.2	UNFINISHED DRAWING FEATURES DIM MODEL IS BASIC UNLESS OTHERWISE SPECIFIED: ARE BASIC FINISH/TREATMENT: N/A NO INTELLECTUAL PROPERTY RIGHTS ARE CLAIMED FOR THIS DRAWING. ALL RIGHTS RESERVED. COPYRIGHT © 2017 HUSKY.	HUSKY TITLE: SCVG Single Cavity Valve Gate U1000-SCVG-VX SCALE: 1:1 SIZE: AOR SHEET: 1 OF 2 DRAWING NO.: 8153509 REV: 0
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ASSEMBLY DRAWING

REV: 0
DRAWING: 8153509



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	75	55
3/4	100	74
7/8	150	110
1	200	148
M4	4.6	3.4
M5	6.8	5.0
M6	9.8	7.2
M8	16	12
M10	23	17
M12	35	26
M14	50	37
M16	75	55
M20	150	110
M25	250	184

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: U1000-SCVG-VX
	SHEET 2 OF 2	DRAWING: 8153509
		REV: 0