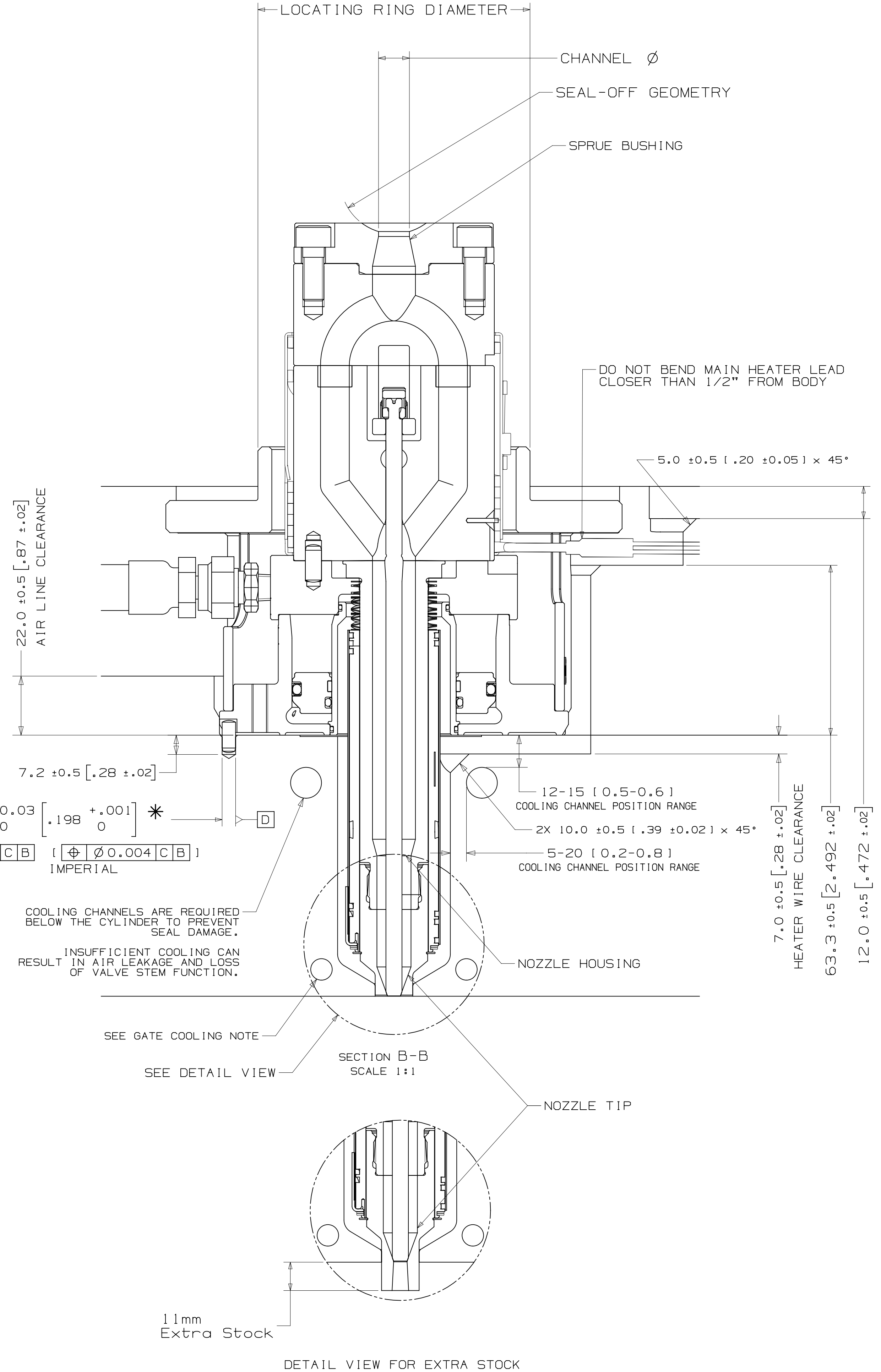
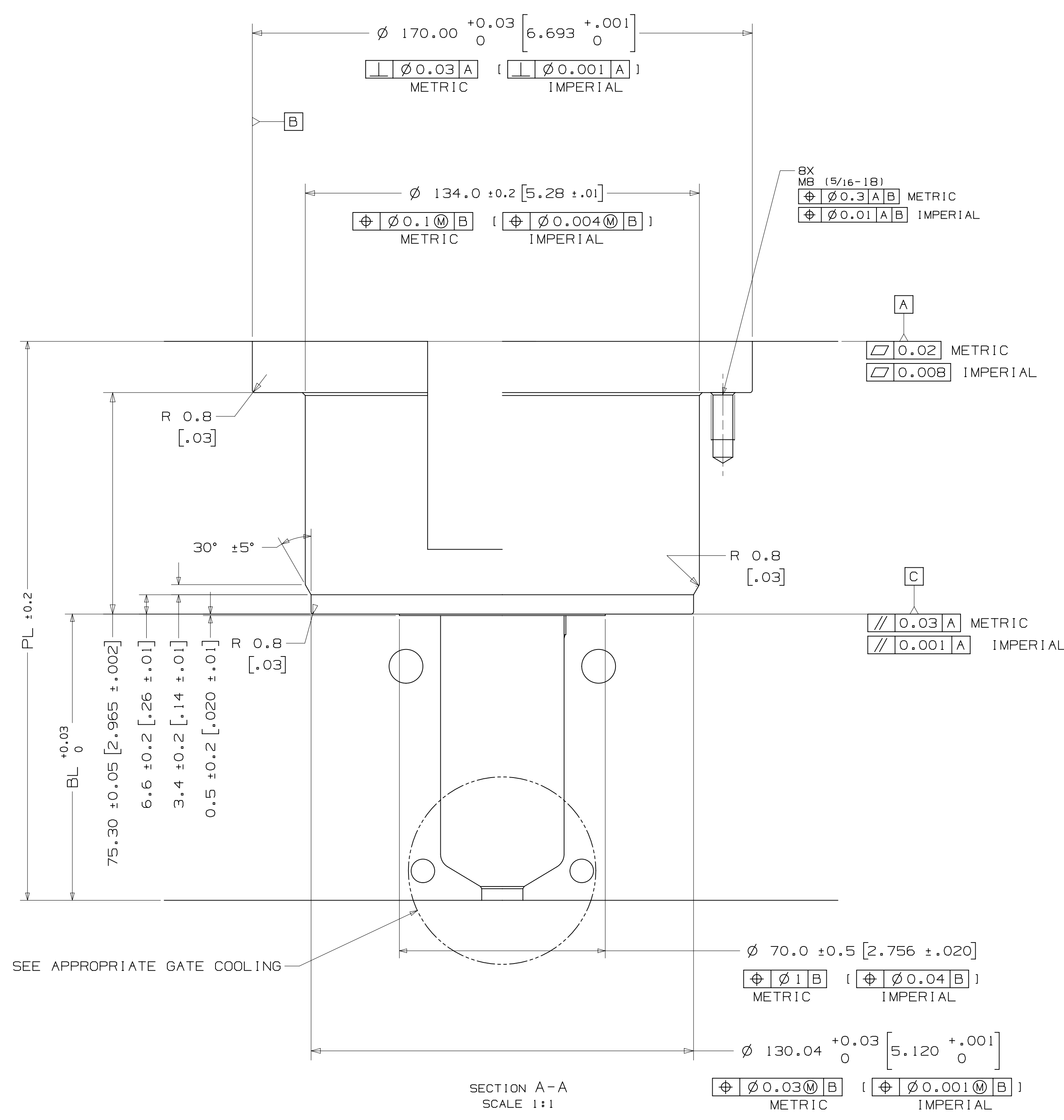
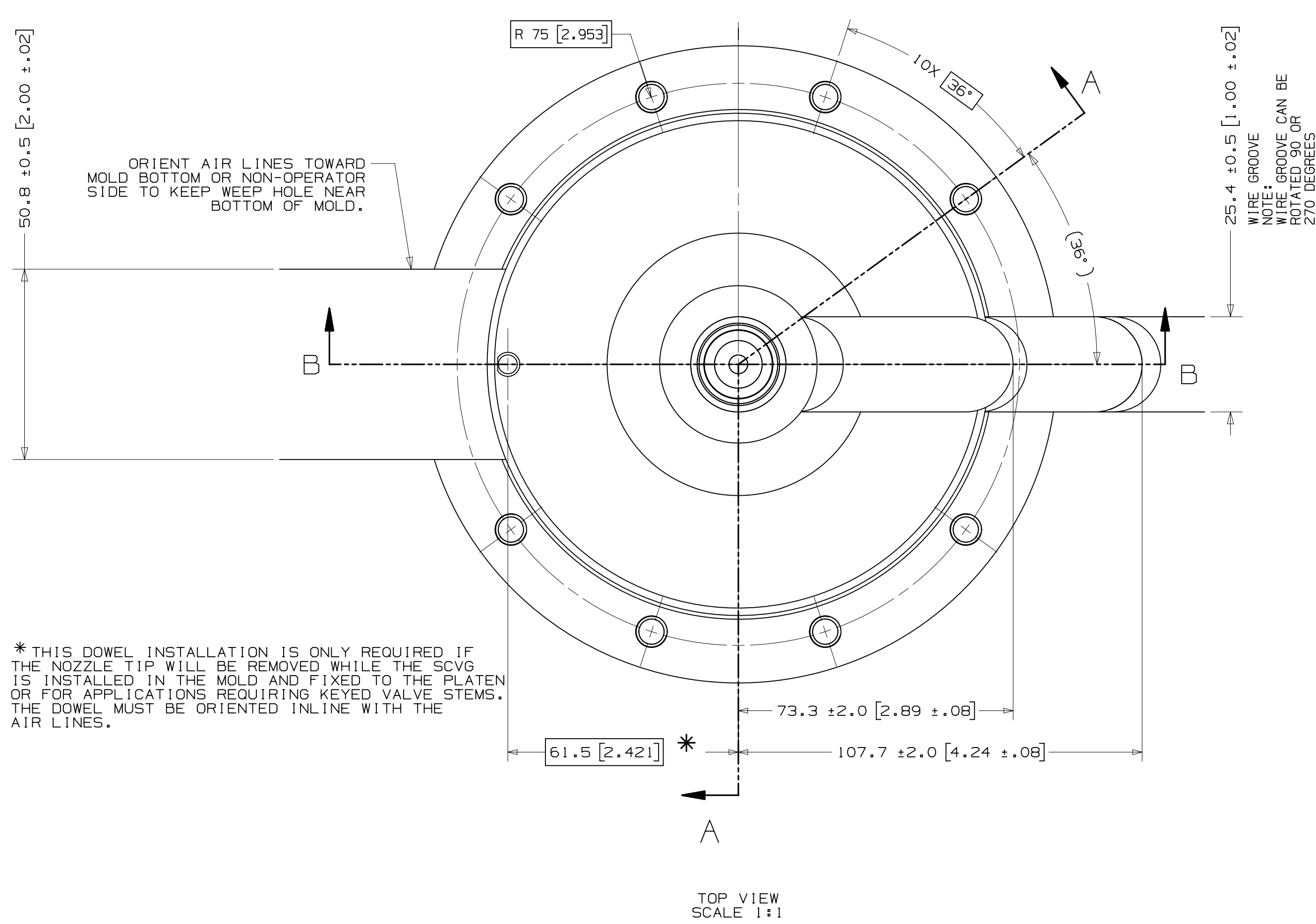


INSTALLATION DRAWING

REV 0
8153509



NOZZLE SERIES	NOZZLE TIP	PL RANGE	Approx. BL*
U1000	VX	124.67(4.908) - 254.96(10.038)	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		LOCATING RING DIAMETER
	SEAL-OFF GEOMETRY	CHANNEL Ø IN - OUT	
	FLAT	11.5 - 16.00	100mm
	SEAL-OFF 12.7 [1/2"]		101.3mm [3.99"]
	SEAL-OFF 15.5		
	SEAL-OFF 19.05 [3/4"]		
	SEAL-OFF 20		
	SEAL-OFF 40	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

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)

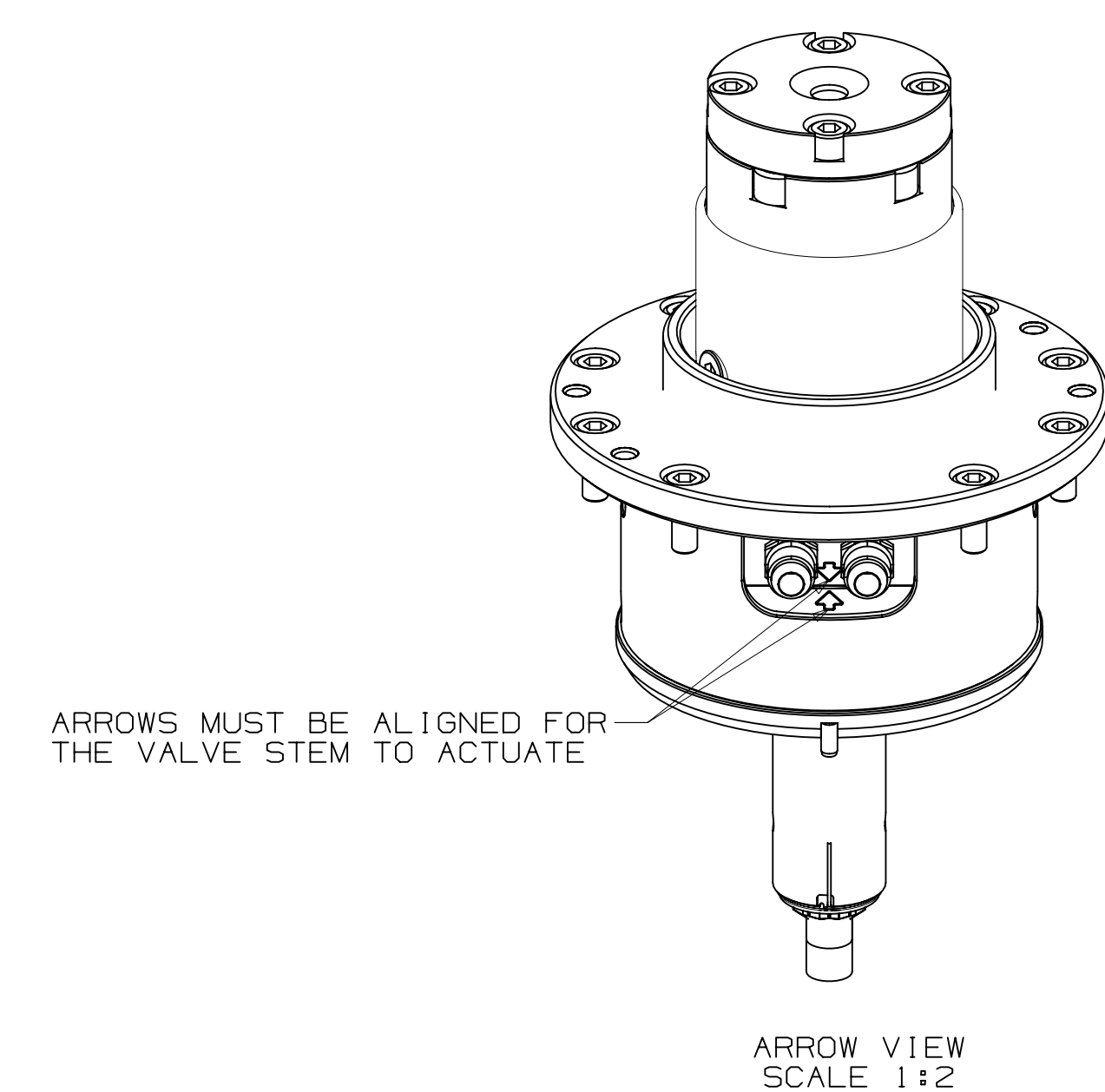
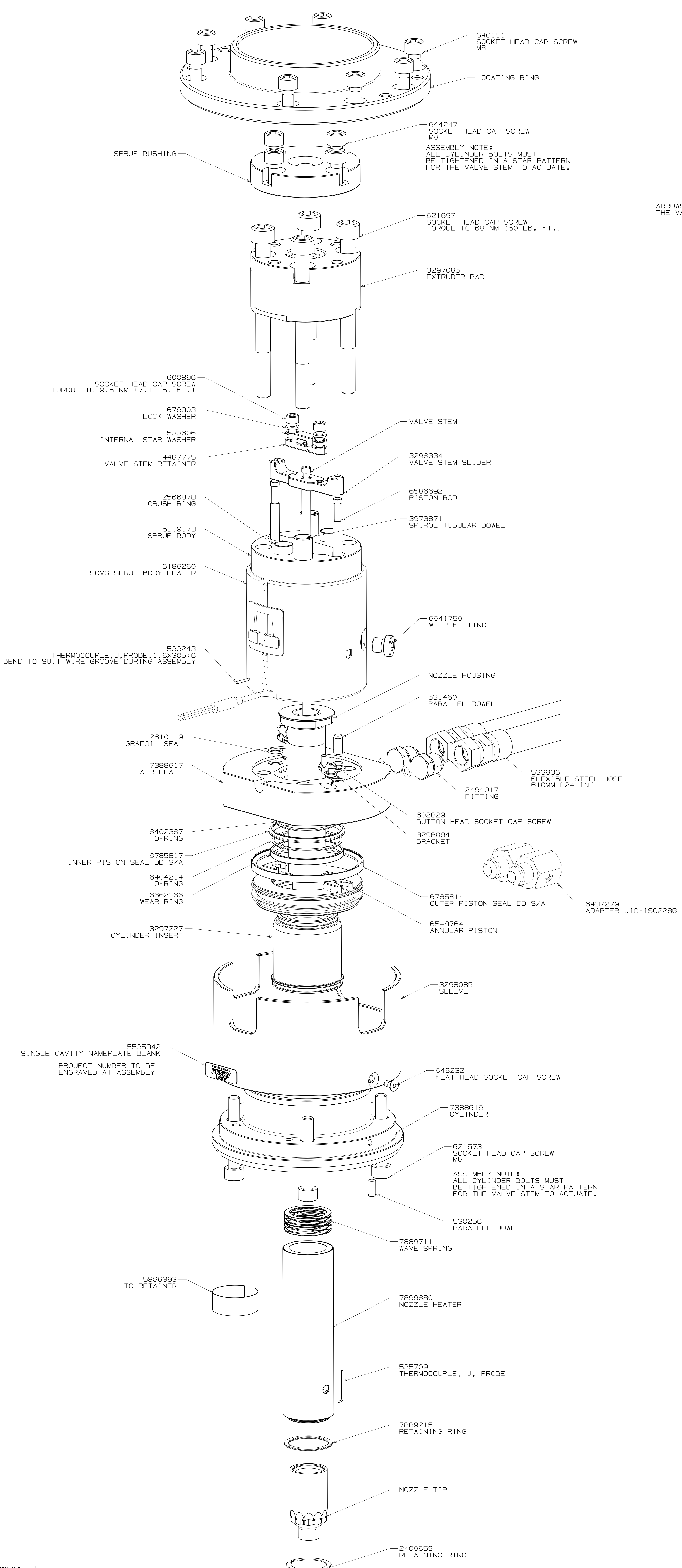
RECOMMENDED GATE MANUFACTURING GUIDELINES
- HARDENED GATE INSERTS (49-51) ARE RECOMMENDED WHEN USING SOFTER CAVITY STEELS. SOFTER CAVITIES MAY BE ACCEPTABLE FOR CERTAIN APPLICATIONS. CONTACT YOUR HUSKY REPRESENTATIVE WITH QUESTIONS.
- EDM'ING THE GATE AREA CAUSES MICRO CRACKS WHICH LEAD TO BRITTLE GATE 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	NAME
4	2020-05-29	TABLE UPDATED PER LATEST CALCULATION	DRWNI DEEBAN N T	
3	2019-07-09	TEMPLATE VALUES UPDATED AS PER SOL 2.0	DRWNI MURALIDHARAN	
2	2018-04-06	DRAWING NAME CHANGED	DRWNI ANUSHAL	
1	2018-01-12	BL NOTE UPDATED	DRWNI DHANANLEYAN	
0	2017-09-15	ORIGINAL ISSUE - DESIGNED BY: DHANANLEYAN	DRWNI DHANANLEYAN	

PART PER ASM: 114-50-1994 AND HEAVY ASSEMBLY - H2524 BASIS: CUSTOMER SPECIFIED CAD MODEL IS DATE: NEW TOLERANCES DIMENSIONS: ARE BASIC	METRIC GENERAL TOLERANCES: (S-4) (S-17) (S-17)	IMPERIAL (S-17) (S-17)	FINISH/TREATMENT R0.8 ± 0.2 R0.03 ± 0.01 R0.03 ± 0.01 SURFACE FINISH: 6.3	HUSKY TITLE Single Cavity Valve Gate U1000-SCVG-VX SCALE: 1:1 SHEET 1 OF 2 DATE: 8/15/2019 REV: 0
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ASSEMBLY DRAWING

REV 0
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	6.1	4.5
M6	8.0	5.9
M8	13.0	9.5
M10	19.0	14.0
M12	27.0	20.0
M14	37.0	27.0
M16	50.0	36.0
M20	85.0	62.0
M25	130.0	95.0

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

DEFINING DRAWING FEATURES		MATERIAL		FINISH/TREATMENT		WEIGHT	
N/A		N/A		N/A		-	
HUSKY		TITLE		SCALE		REV	
Single Cavity Valve Gate		1:1		AOR		8153509	
SCVG		UJ000-SCVG-VX		SHEET 2 OF 2		0	