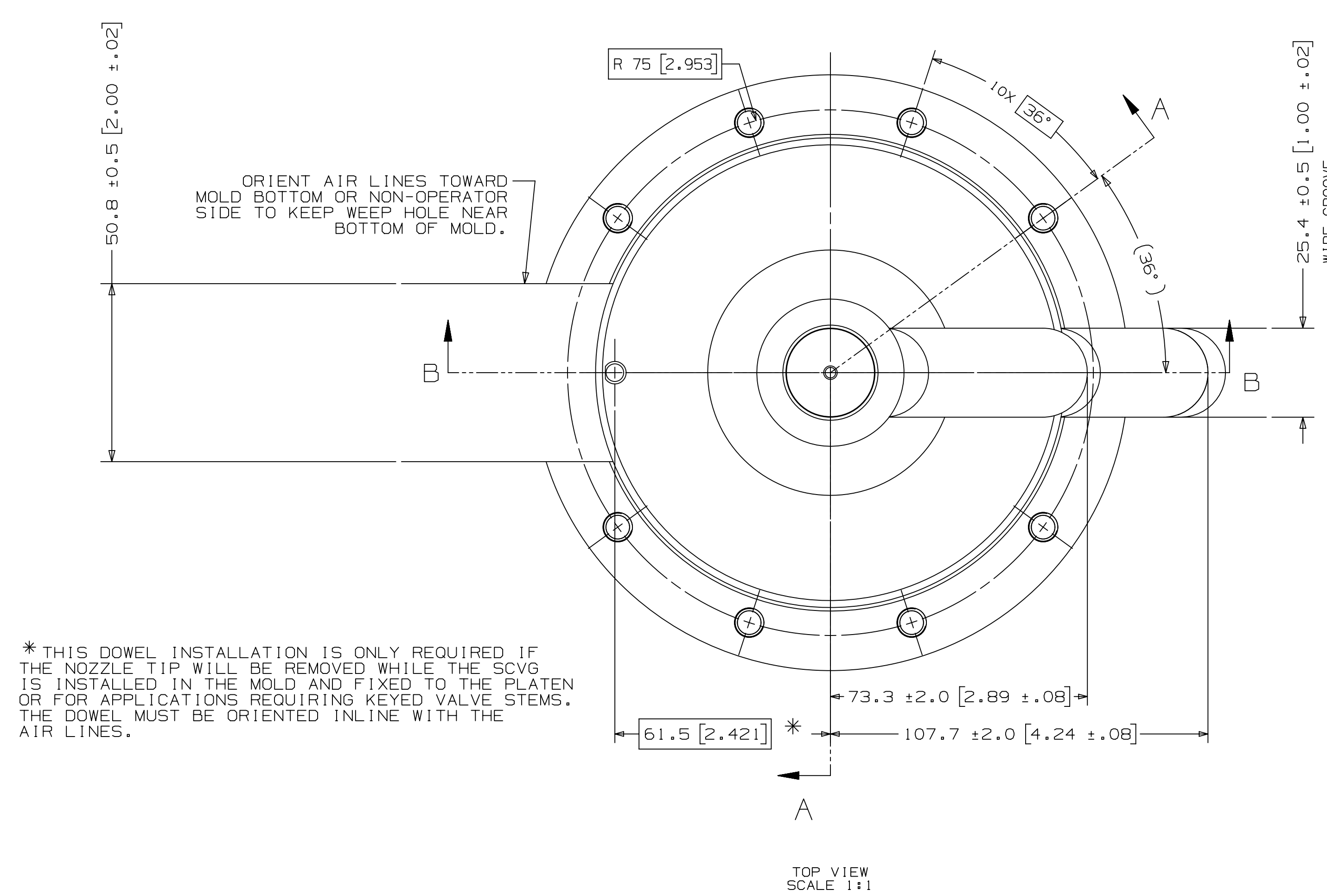


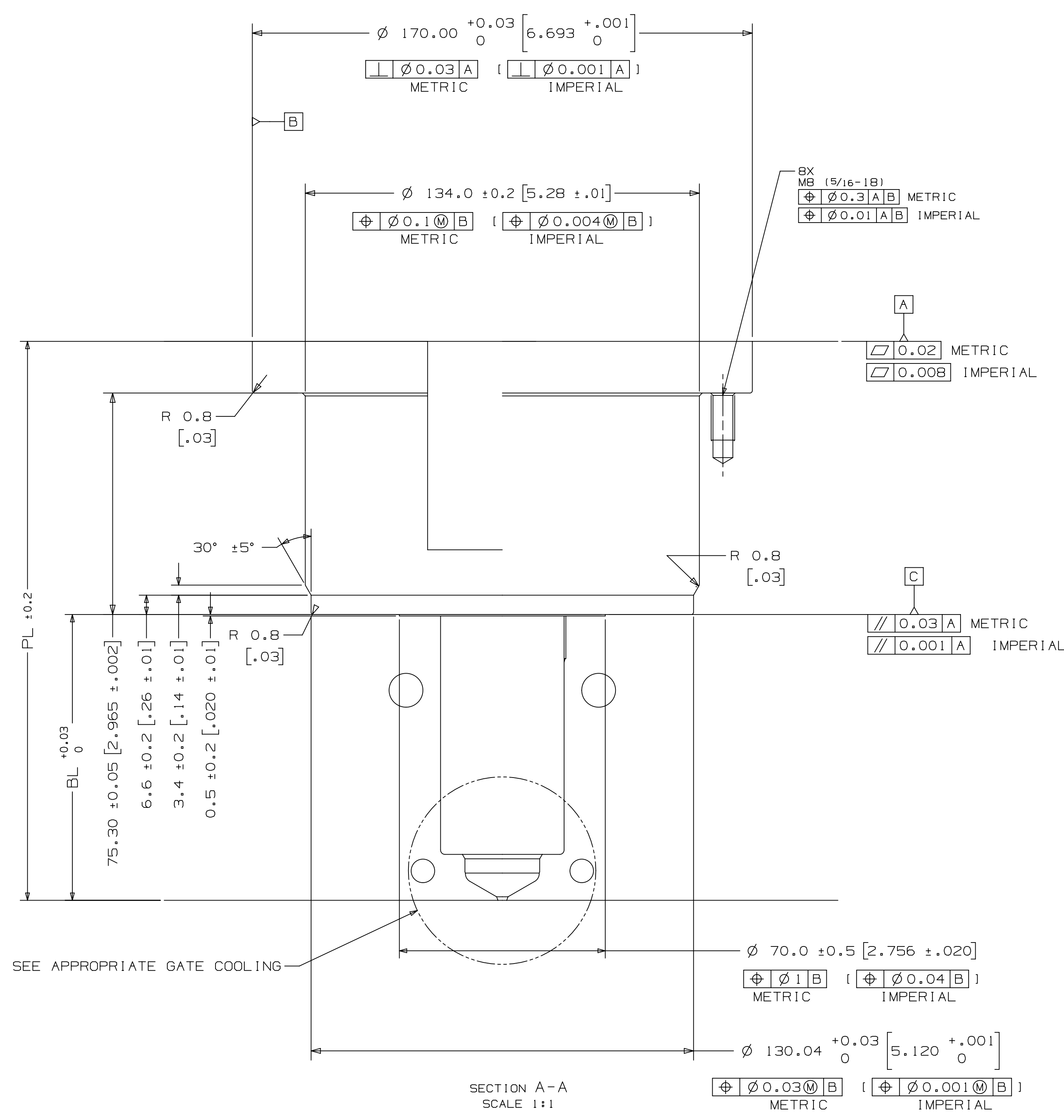
INSTALLATION DRAWING

DRAWING NO. 8151647

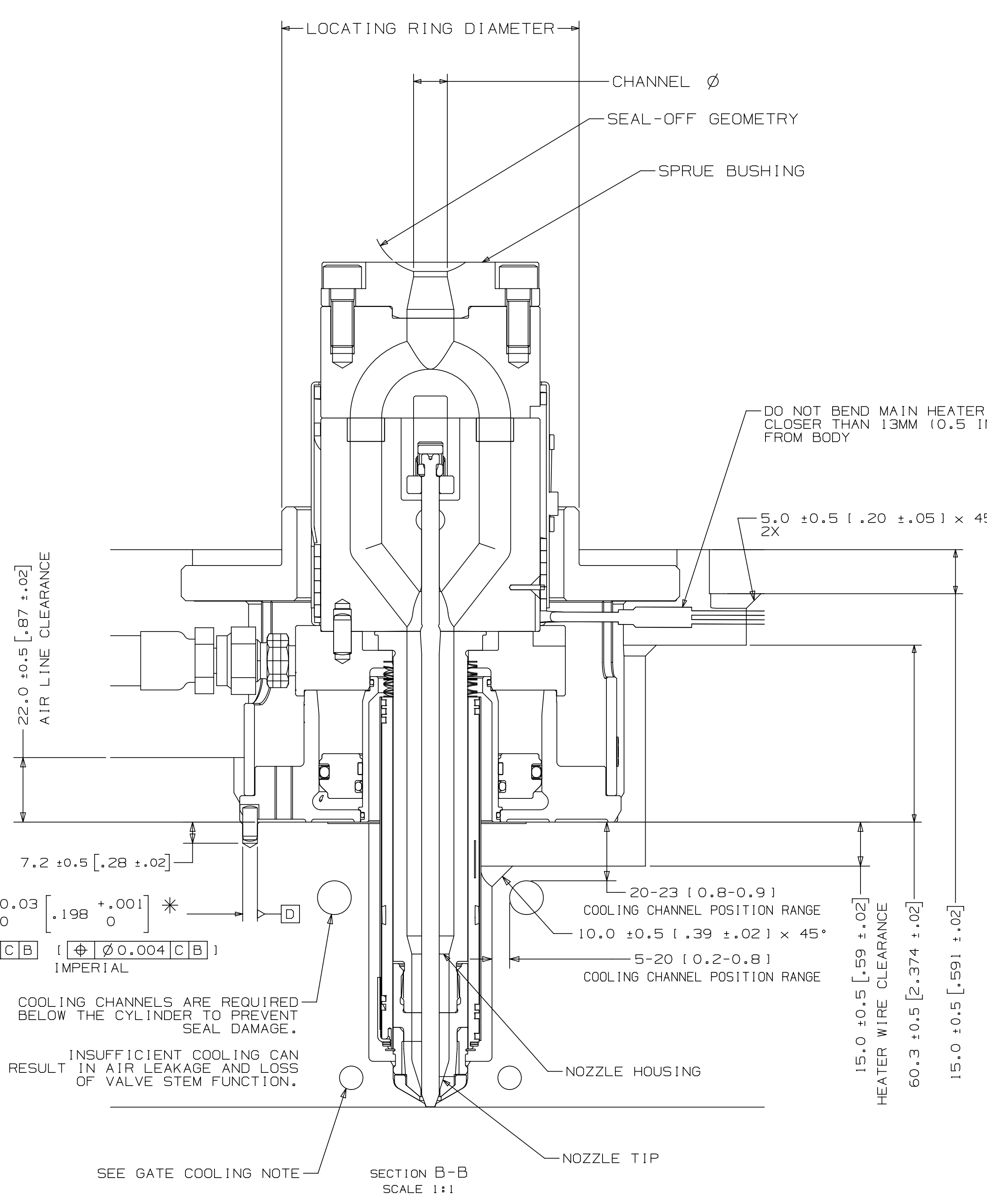


* THIS DOWEL INSTALLATION IS ONLY REQUIRED IF THE NOZZLE TIP WILL BE REMOVED WHILE THE SCVG IS INSTALLED IN THE MOLD AND FIXED TO THE PLATEN OR FOR APPLICATIONS REQUIRING KEYS VALVE STEMS. THE DOWEL MUST BE ORIENTED IN LINE WITH THE AIR LINES.

TOP VIEW SCALE 1:1



SECTION A-A SCALE 1:1



SECTION B-B SCALE 1:1

NOZZLE SERIES	NOZZLE TIP	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
	100
	101.3 [3.99]
	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 FOR CERTAIN APPLICATIONS. CONTACT YOUR HUSKY REPRESENTATIVE WITH QUESTIONS.
 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.
 A1S1 H13 [48-51 Rc]
 A1S1 420 [48-51 Rc]

RECOMMENDED GATE MANUFACTURING GUIDELINES
 - HARDENED GATE INSERTS (48-51) 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.

DAT PER ASME Y14.1M-1994 AND HUSKY ADDENDUM - HUSKA UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS DIMENSIONS IN PARENTHESES ARE IN INCHES DIMENSIONS IN SQUARE BRACKETS ARE IN METRIC DIMENSIONS IN BRACKETS ARE IN IMPERIAL GENERAL TOLERANCES ARE BASIC BROKEN EDGES/CHAMFER: 1 ± 0.2 X 45° FILLET/RADIUS: R0.8 ± 0.2 SURFACE FINISH: 6.3	UNFINISHED DRAWING FEATURES UNLESS OTHERWISE SPECIFIED MATERIAL: N/A FINISH/TREATMENT:	HUSKY TITLE: SCVG Single Cavity Valve Gate U1000-SCVG-VG SCALE: 1:1 SIZE: AOR SHEET: 1 OF 2 DRAWING NO.: 8151647 REV: 1
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