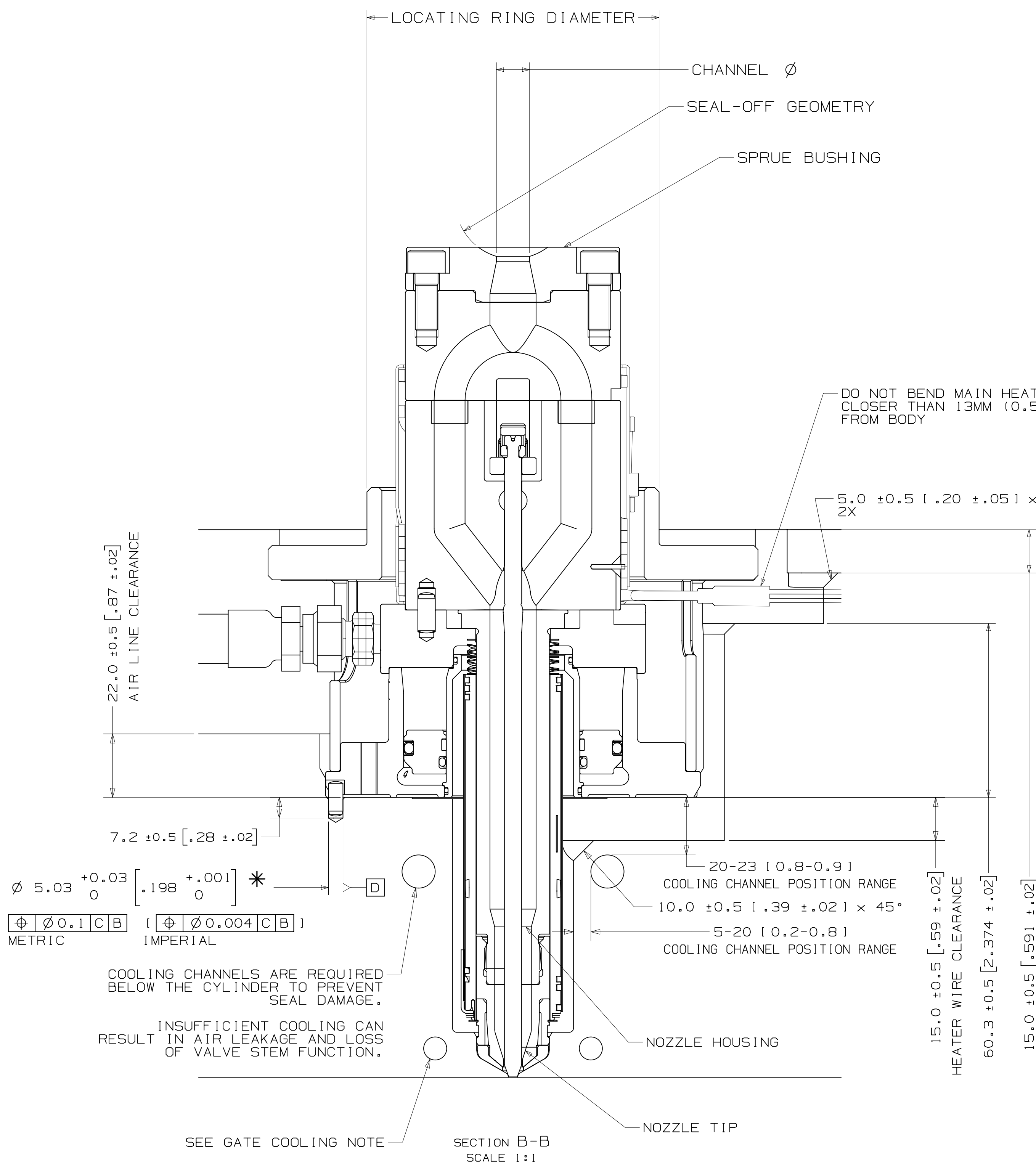
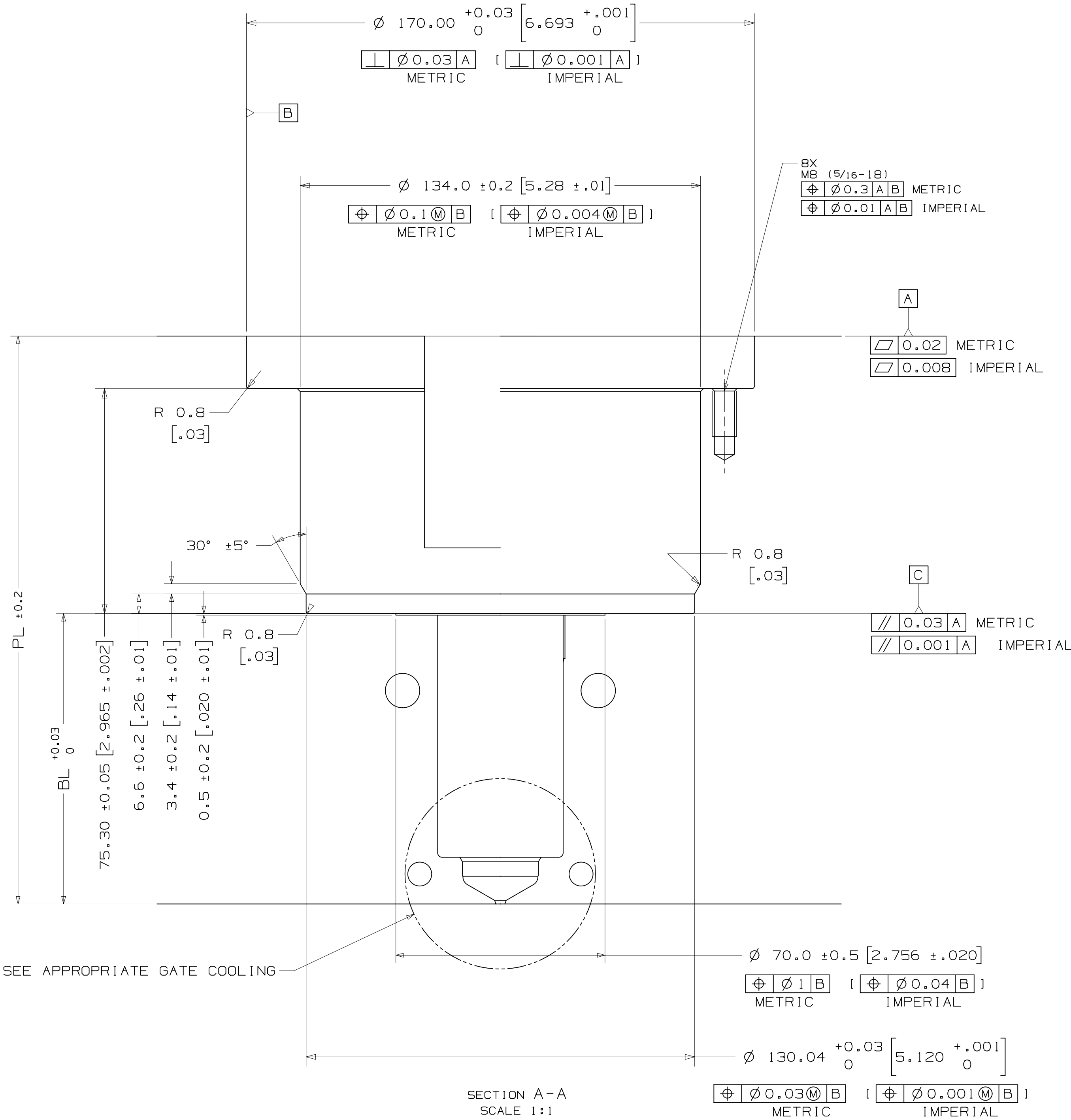
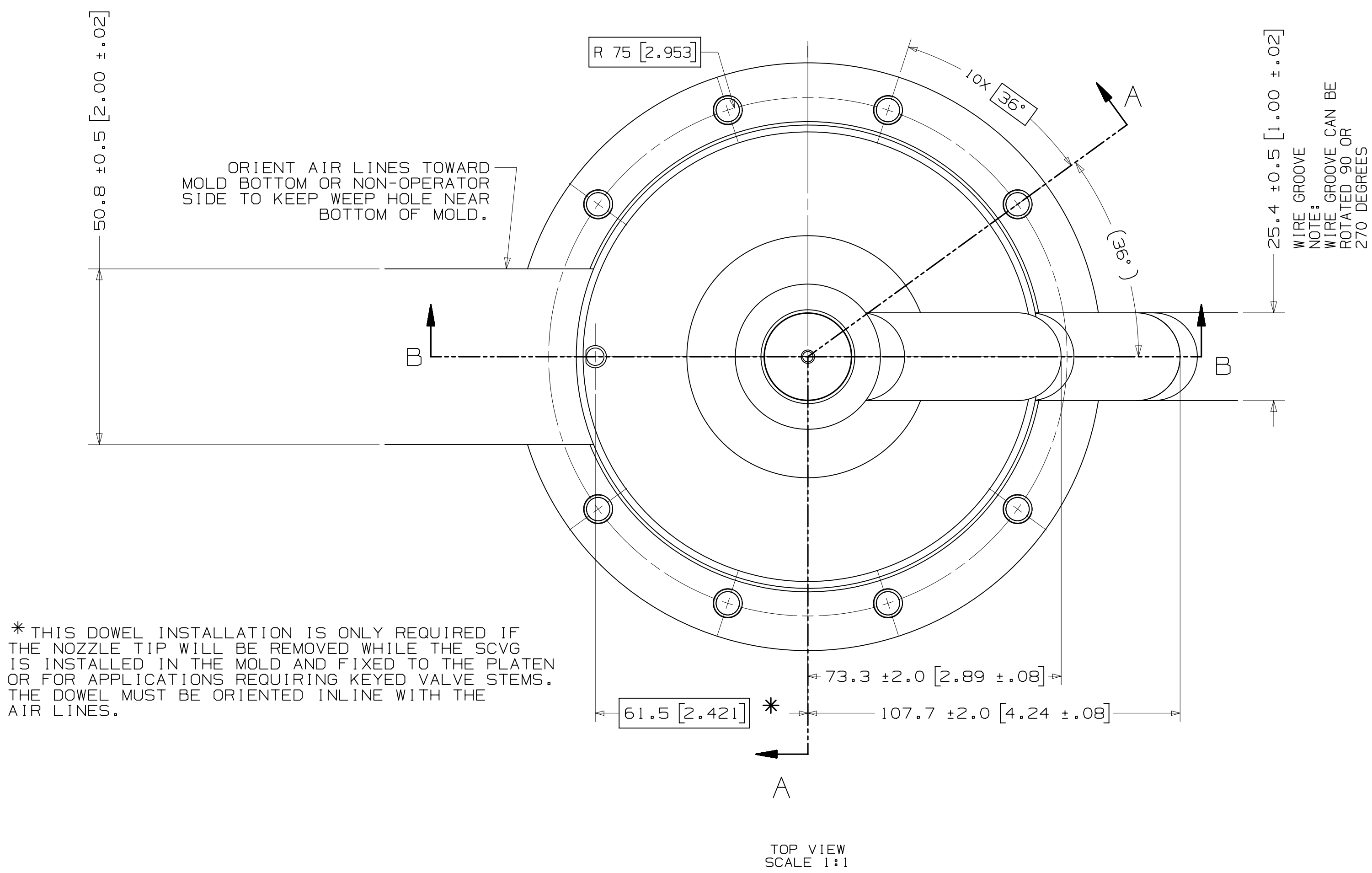


INSTALLATION DRAWING



NOZZLE SERIES	NOZZLE TIP	PL RANGE	Approx. BL *
U1000	VG	124.52 [4.902] - 254.81 [10.032]	37 [1.46] - 157 [6.18]

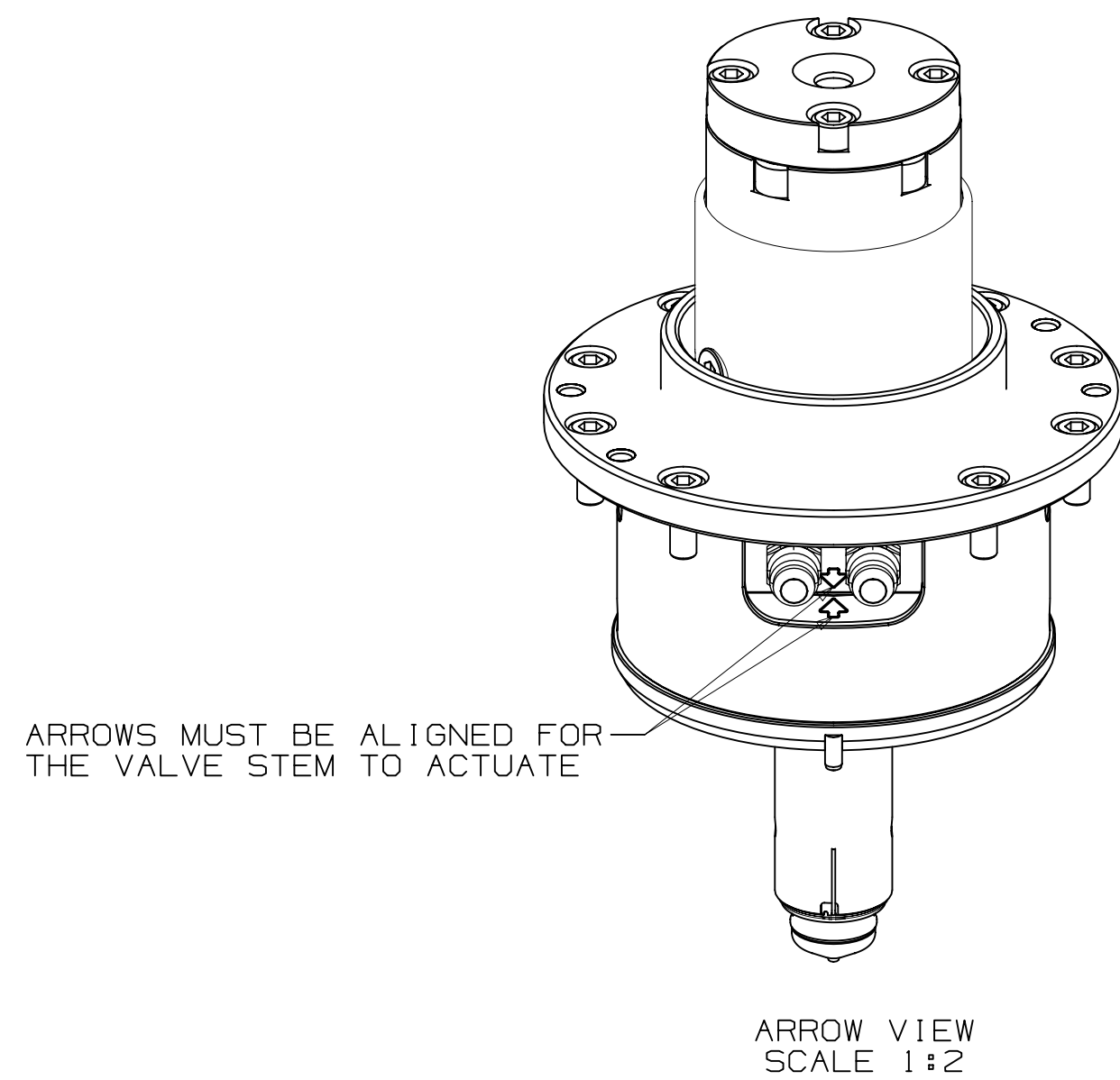
*Approx.BL VALUES IN THE TABLE ARE REFERENCES WHICH CAN DEVIATE BY +/-1mm. FINAL BL VALUE CAN BE FOUND ON GATE DETAIL DRAWING AND 3D AFTER FINISHED DESIGN. BL AVAILABLE IN THE INCREMENT OF 10mm WITHIN RANGE.

U1000	SPRUE BUSHING	
	SEAL-OFF GEOMETRY	CHANNEL Ø
	SPHERICAL RADIUS	IN - OUT
	FLAT	11.5-16.00
	SEAL-OFF 12.7 [1/2]	
	SEAL-OFF 19.5	
	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 www.husky.ca FOR MORE DETAILED GUIDELINES.	
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.	

GOAT PER ASME Y14.5M-1994 AND HUSKY ADDENDUM - HUSKY BUSINESS OPERATIONS SPECIFIED CAD MODEL TO BE USED: NON-TOLERANCED DIMENSIONS ARE BASIC. GENERAL TOLERANCES: METRIC: [0.4] IMPERIAL: [0.012] BROKEN EDGE/CHAMFER: 1 ±0.2 X 45° 0.04 ±0.01 X 45° FILLET/ROUND: R0.8 ±0.2 R0.03 ±0.01 SURFACE FINISH: Ra 3.2		DEFINED DRAWING FEATURES TO GOAT BY THIS DRAWING SUPPLIER QUICK REFERENCE: MATERIAL: N/A FINISH/TREATMENT: [0.0012] [0.0012] NO INTELLECTUAL PROPERTY RIGHTS CLAIMED OR INTENDED. ALL RIGHTS RESERVED. COPYRIGHT 2013 HUSKY		TITLE: Single Cavity Valve Gate U1000-SCVG-VG SCALE: 1:1 SIZE: DRAWING: 8151647 REV: 2	
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VALVE STEM STROKE IS 13.7 (.54)



ELECTRICAL INFO (240 VAC)	

T/C LEADS:
WHITE = (+)
RED = (-)

RECOMMENDED GATE MATERIAL

NOTE: THESE MATERIALS MAY NOT OFFER THE
DESIRED RESISTANCE TO ABRASIVE AND/OR
CORROSIVE RESINS, FILLERS AND/OR ADDITIVES

AISI H13 149-51 Rc1
AISI 420 149-51 Rc1

UNDESIGNED DRAWING FEATURES DO COMPLY WITH MOST "SUPPLIER QUALITY REFERENCE"		METRIC 					
N/A		THIS DRAWING AND INFORMATION CONTAINED HEREIN IS CONFIDENTIAL AND NOT BE LOANED, REPRODUCED, COPIED, REPRODUCED, OR DISCLOSED TO ANY OTHER PERSON WITHOUT THE WRITTEN CONSENT OF HUSKY.		TITLE		SCV6 Single Cavity Valve Gate	
FINISH/TREATMENT				U1000-SCV6-VG			
WEIGHT = kg		NO INTELLECTUAL PROPERTY RIGHTS ARE GRANTED INCLUDING ANY LICENSE UNLESS OTHERWISE ALL RIGHTS RESERVED. COPYRIGHT © 2000 HUSKY		SCALE 1:1 SHEET 2 OF 2		DRAWING 8151647	
				AOR		REV 2	