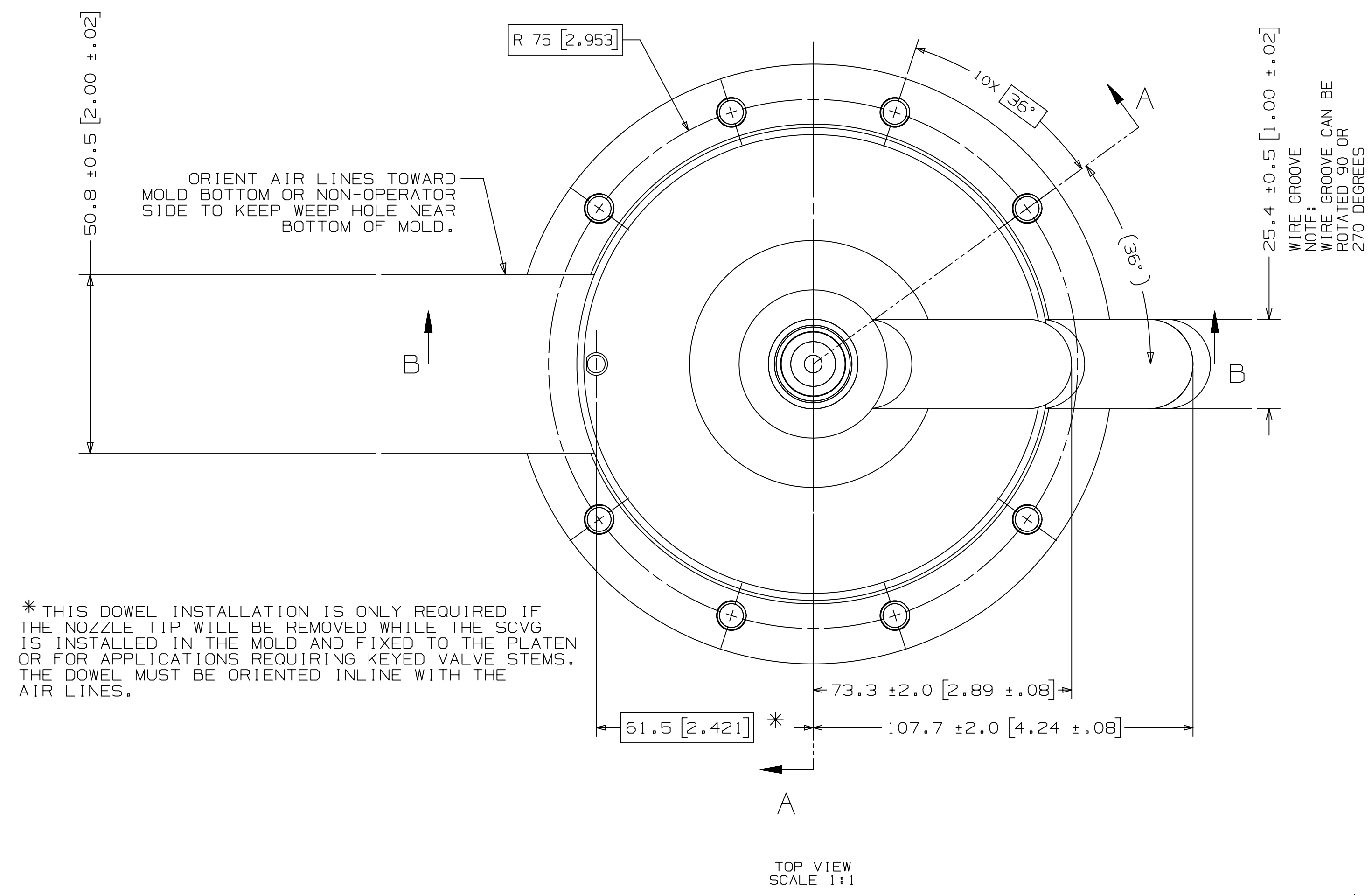
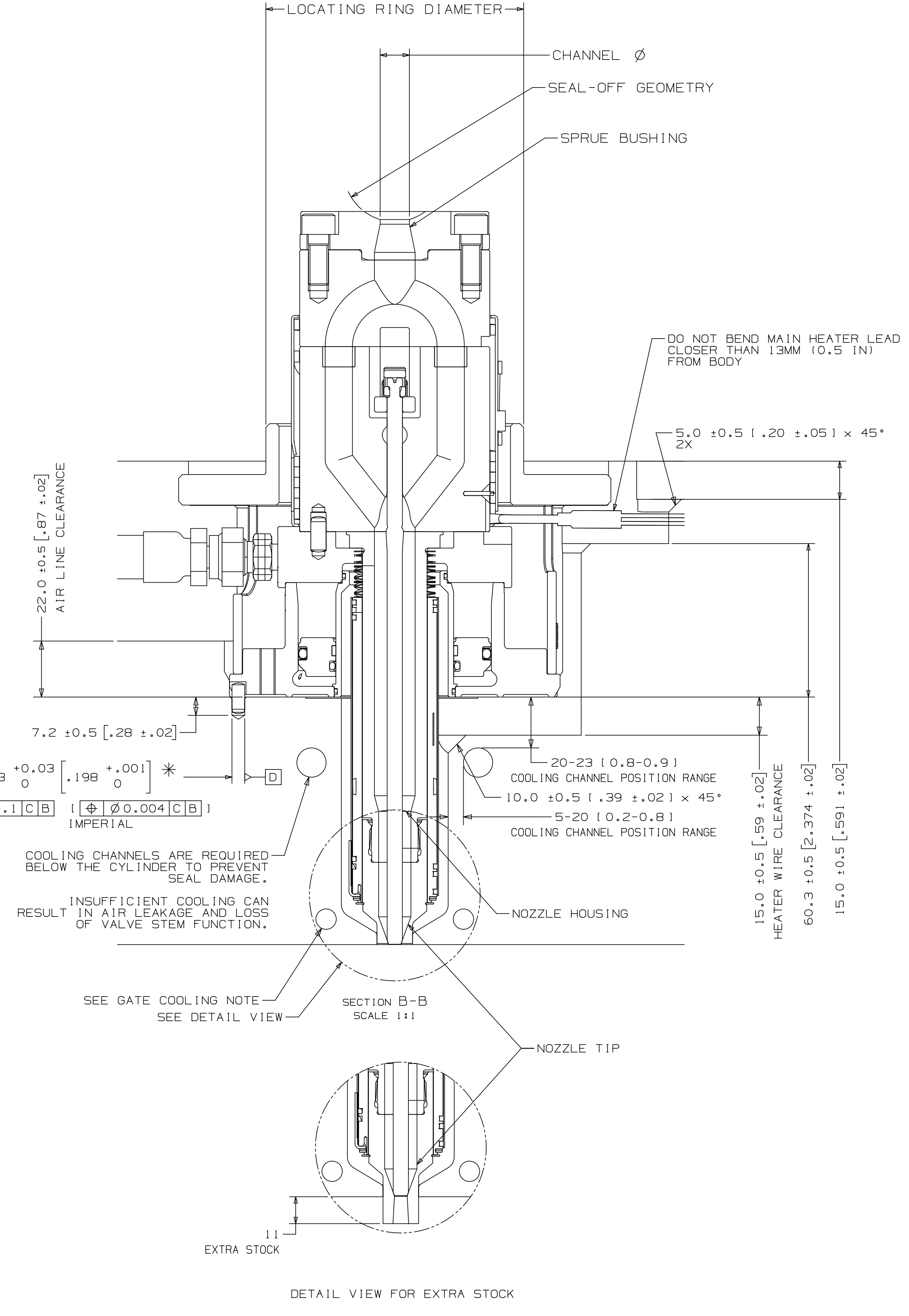
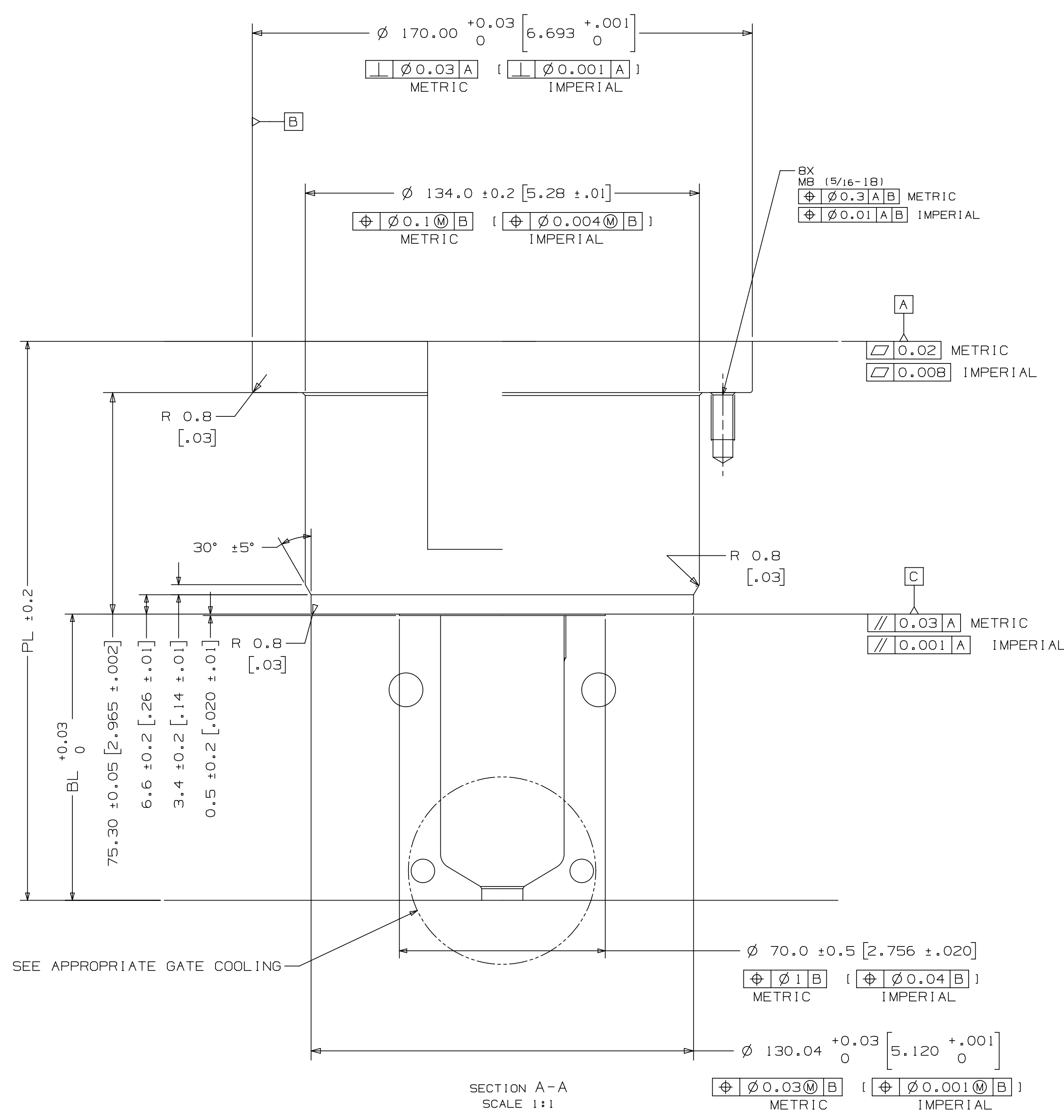


# INSTALLATION DRAWING

REV 1  
8153509



\* 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 KEYED VALVE STEMS. THE DOWEL MUST BE ORIENTED INLINE WITH THE AIR LINES.



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	
	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 MORE DETAILED GUIDELINES.  
[www.husky.ca](http://www.husky.ca)

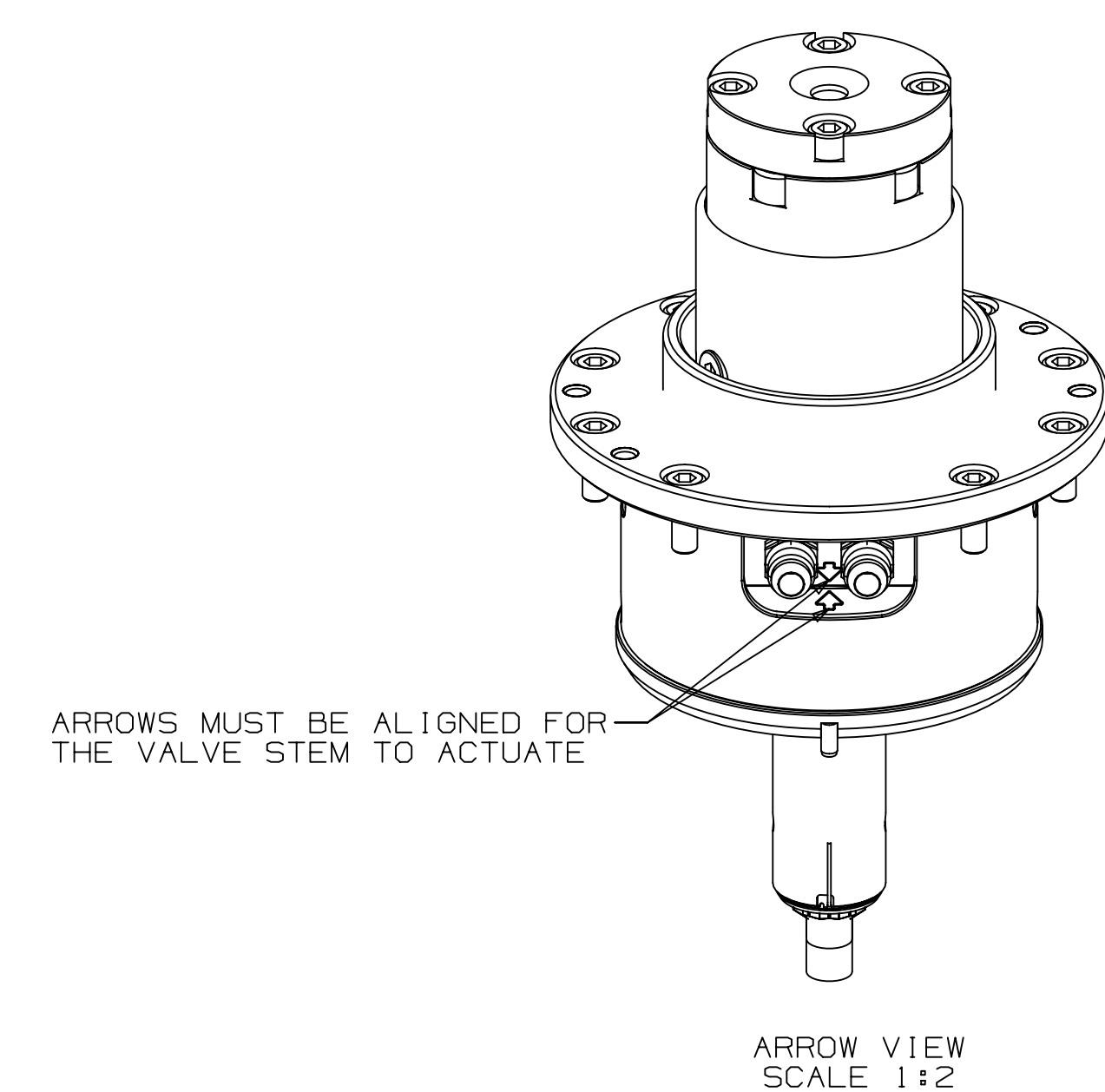
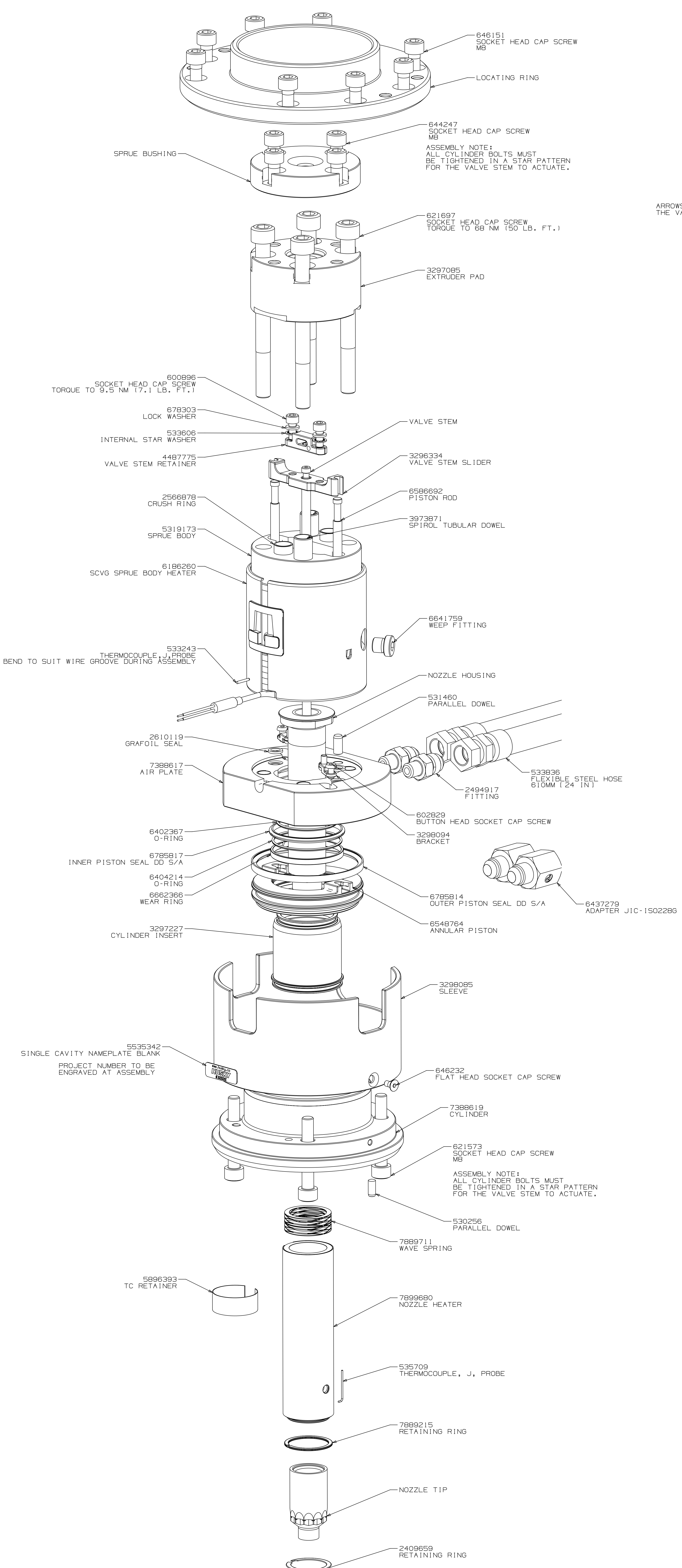
**RECOMMENDED GATE MATERIAL**  
NOTE: THESE MATERIALS MAY NOT OFFER THE DESIRED RESISTANCE TO ABRASIVE AND/OR CORROSIVE RESINS, FILLERS AND/OR ADDITIVES.  
AISI H13 148-51 Rc1  
AISI 420 148-51 Rc1

**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 Y14.2M-1994 AND HUSKY ADDENDUM - HUSKA UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE BASIC GENERAL TOLERANCES ARE BASIC BROKEN EDGE/CHAMFER: 1 ± 0.2 X 45° FILLET/RADIUS: R0.8 ± 0.2 SURFACE FINISH: 6.3	UNFINISHED DRAWING FEATURES MATERIAL: N/A FINISH/TREATMENT:	HUSKY TITLE: SCVG Single Cavity Valve Gate U1000-SCVG-VX SCALE: 1:1 SHEET: 1 OF 2 AOR: 8153509 REV: 1
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# ASSEMBLY DRAWING

REV 1  
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	16	12
5/16	25	18
3/8	35	25
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	7.8	5.7
M6	11.6	8.5
M8	23	17
M10	39	29
M12	58	43
M14	88	65
M16	135	100
M20	250	184
M24	400	295
M30	810	595

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  
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RECOMMENDED GATE MATERIAL  
NOTE: THESE MATERIALS MAY NOT OFFER THE DESIRED RESISTANCE TO ABRASIVE AND/OR CORROSIVE RESINS, FILLERS AND/OR ADDITIVES  
AISI H13 148-51 Rc1  
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DEFINED DRAWING FEATURES		MATERIAL		FINISH/TREATMENT		WEIGHT	
100% DIMENSIONAL ACCURACY	100% DIMENSIONAL ACCURACY	N/A	N/A	N/A	N/A	-	-
100% DIMENSIONAL ACCURACY	100% DIMENSIONAL ACCURACY	HUSKY		TITLE		SCALE 1:1	
HUSKY		Single Cavity Valve Gate		U1000-SCVG-VX		DRAWING	
HUSKY		8153509		REV 1		SHEET 2 OF 2	