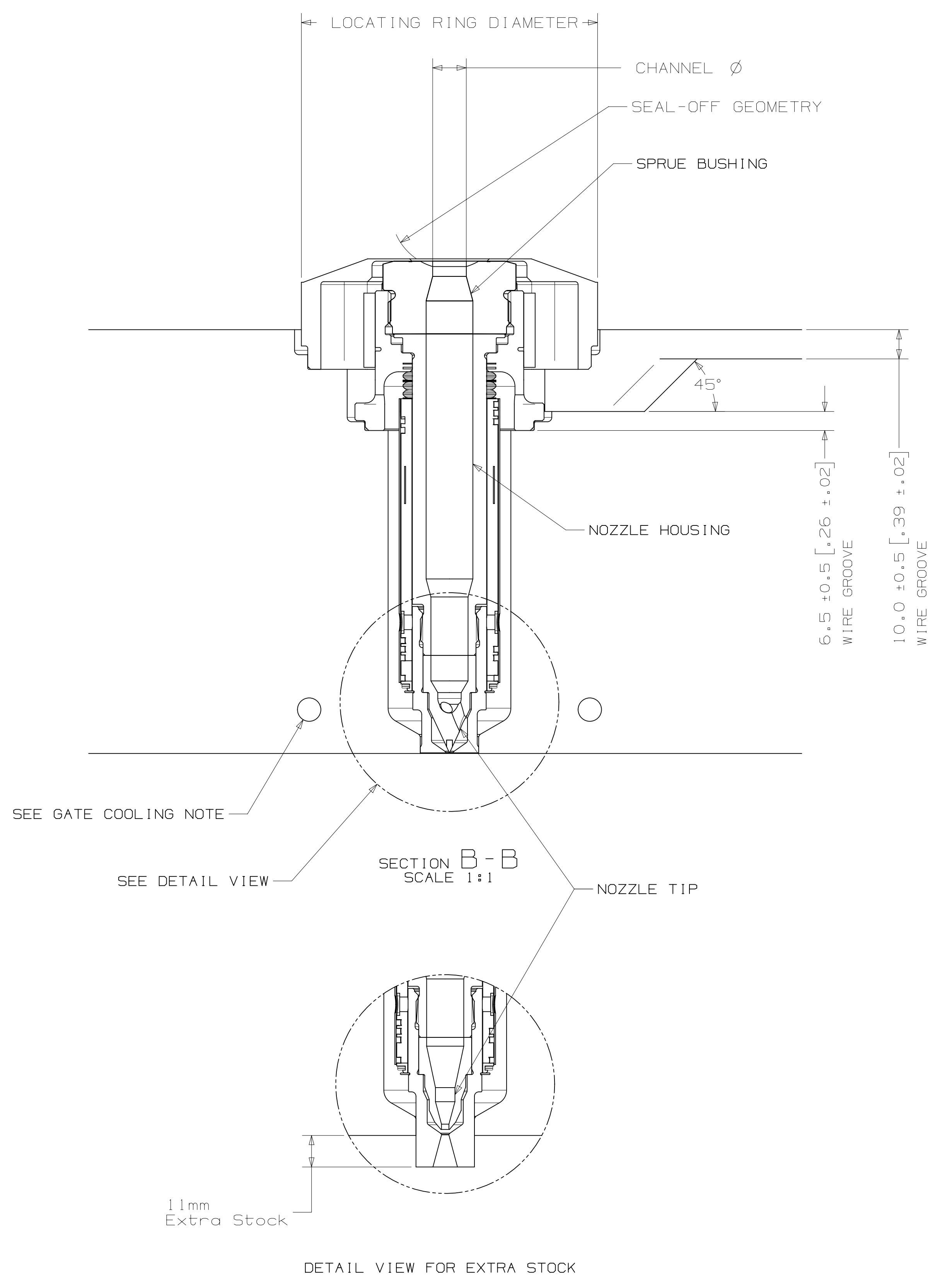
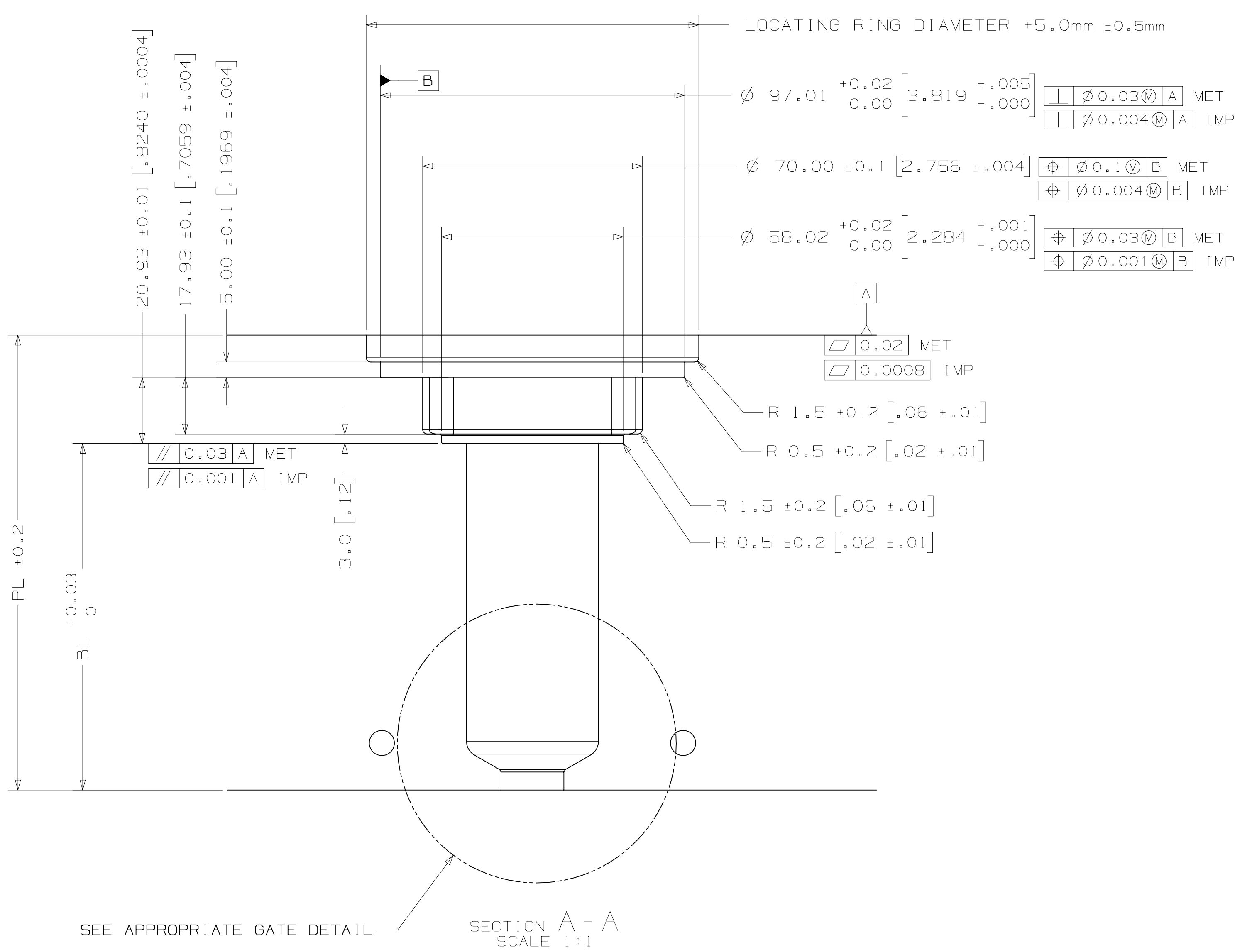
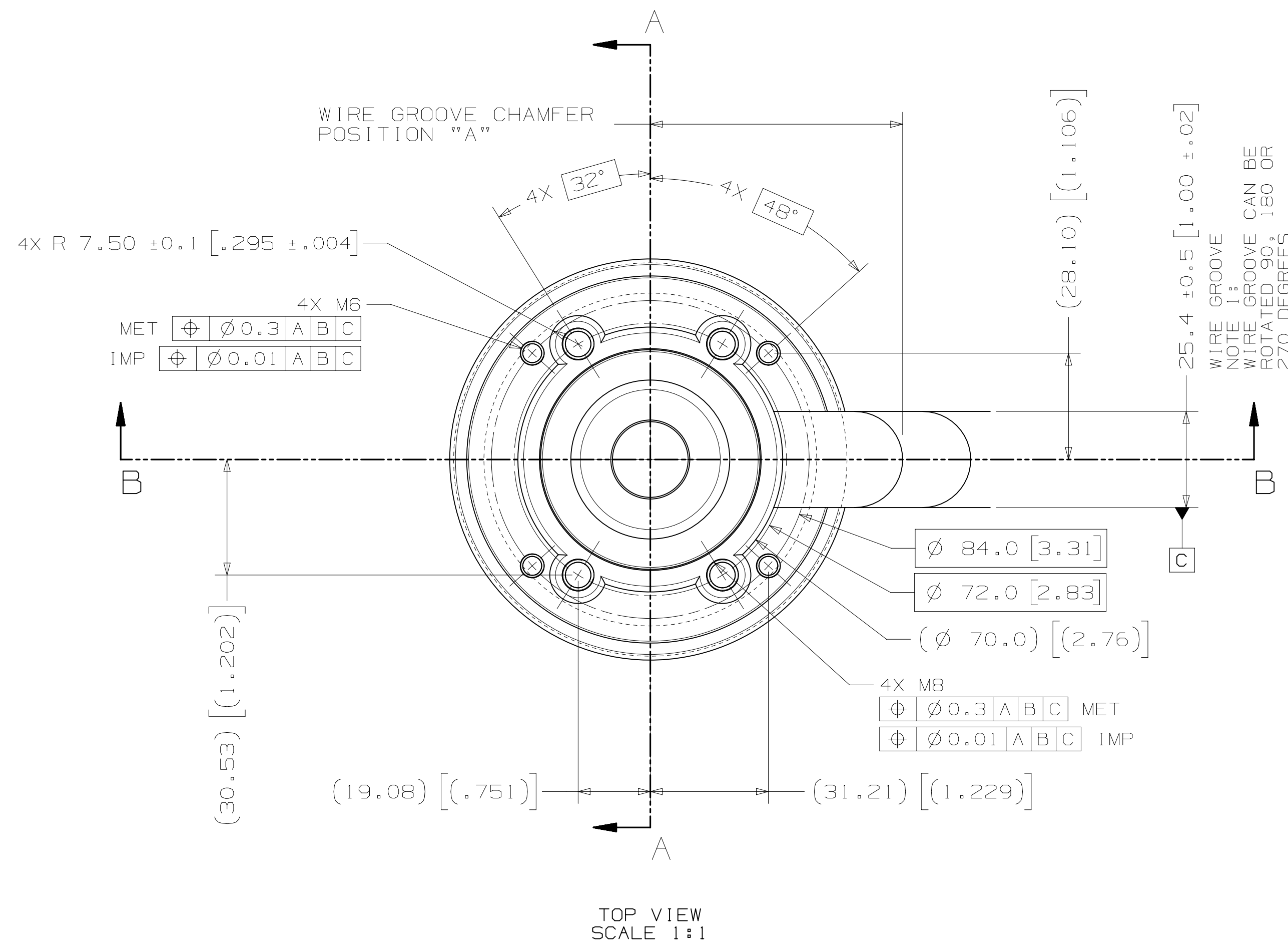


# INSTALLATION DRAWING

REV 0  
8151196



| NOZZLE SERIES | NOZZLE TIP | PL RANGE                       | Approx. BL*            |
|---------------|------------|--------------------------------|------------------------|
| U750          | HT-TS      | 96.44 (3.797) - 233.53 (9.194) | 71 (2.80) - 190 (7.48) |

\*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                 | 6.5 - 16           |
|                       | 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 | WIRE GROOVE CHAMFER POSITION "A" (±2.0) |
|-------|------------------------|---|
|       | 100mm                  | 66.7                                    |
|       | 101.3mm (3.99")        | 66.7                                    |
|       | 125mm                  | 78.7                                    |

**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.

**RECOMMENDED GATE MATERIAL**  
NOTE: THESE MATERIALS MAY NOT OFFER THE DESIRED RESISTANCE TO ABRASIVE AND/OR CORROSIVE RESINS, FILLERS AND/OR ADDITIVES  
A1S1 H13 (48-5) Rc1  
A1S1 420 (48-5) 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.

| REV | DATE       | DESCRIPTION                               | DRWNG              | CHKD                |
|-----|------------|---|--------------------|---------------------|
| 5   | 2020-05-29 | TABLE UPDATED PER LATEST CALCULATION      | DRWNG DEEBAN N T   | CHKD:               |
| 4   | 2019-07-09 | TEMPLATE VALUES UPDATED AS PER SOL 2.0    | DRWNG MURALIDHARAN | CHKD:               |
| 3   | 2019-02-05 | SINGLE CAVITY NAMEPLATE REMOVED           | DRWNG ARJUN        | CHKD:               |
| 2   | 2018-05-20 | DRAWING NAME CHANGED                      | DRWNG ANUSHAL      | CHKD:               |
| 0   | 2017-09-14 | ORIGINAL ISSUE - DESIGNED BY: DHANANLEYAN | DRWNG DHANANLEYAN  | CHKD: PICHLER KLAUS |

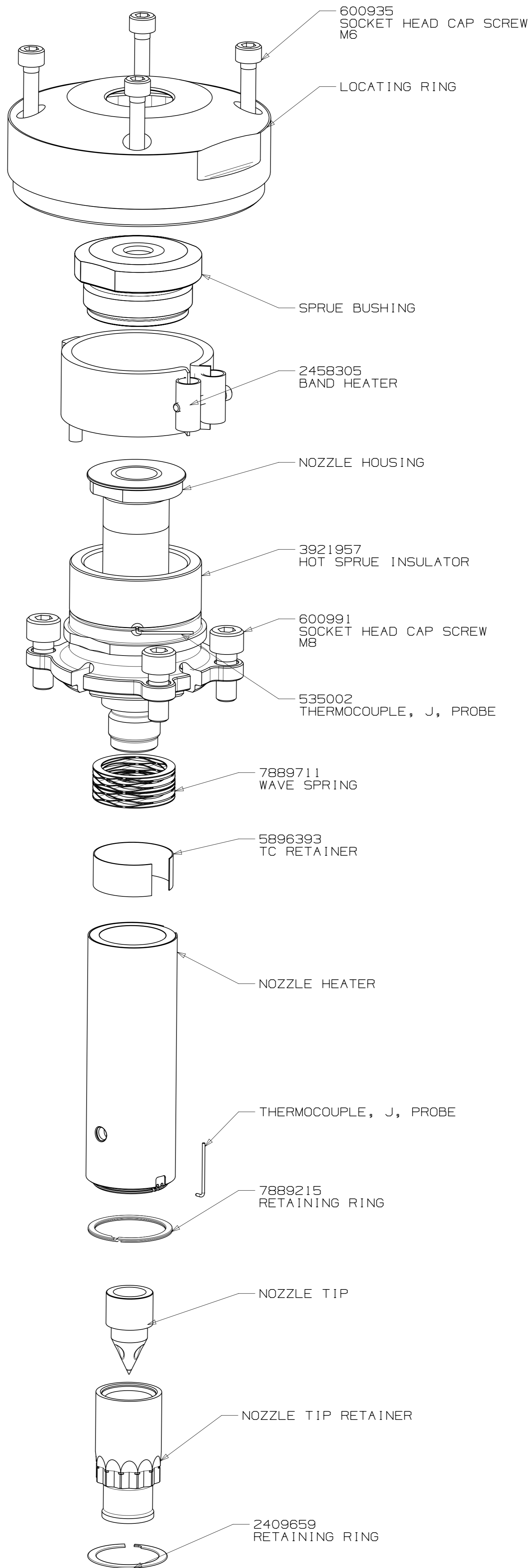
|                    |            |               |
|--------------------|------------|---------------|
| GENERAL TOLERANCES | METRIC     | IMPERIAL      |
| FILLET/RADIUS      | R0.8 ± 0.2 | R0.031 ± 0.01 |
| SURFACE FINISH     | 1.2        | 3.2           |

FOR TORQUE SPECIFICATIONS, REFER TO HS 252

|        |              |           |       |     |      |         |     |
|--------|--------------|-----------|-------|-----|------|---------|-----|
| METRIC | <b>HUSKY</b> | TITLE     | SCALE | NO  | SIZE | DRWNG   | REV |
|        |              | HOT SPRUE | 1:1   | AOR | A4   | 8151196 | 0   |

# ASSEMBLY DRAWING

REV 0  
DRAWING 8151196



EXPLODED VIEW  
SCALE 1:1

UNLESS OTHERWISE SPECIFIED  
TORQUE TO HUSKY SPECIFICATION  
HS 252

PRELOAD CLASS HGT-80

| SIZE | Nm   | lb-ft |
|------|------|-------|
| #8   | 5    | 4     |
| #10  | 7    | 5     |
| 1/4  | 16   | 12    |
| 5/16 | 35   | 25    |
| 3/8  | 60   | 45    |
| 7/16 | 95   | 70    |
| 1/2  | 150  | 110   |
| 5/8  | 290  | 210   |
| 3/4  | 500  | 360   |
| 7/8  | 790  | 580   |
| 1    | 1180 | 865   |
| M4   | 4.6  | 3.4   |
| M5   | 9.5  | 7.1   |
| M6   | 16   | 12    |
| M8   | 39   | 29    |
| M10  | 77   | 57    |
| M12  | 135  | 100   |
| M14  | 215  | 160   |
| M16  | 330  | 245   |
| M20  | 650  | 480   |
| M24  | 1100 | 810   |

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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[www.husky.cc](http://www.husky.cc)

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AISI H13 (49-51 Rc)  
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| REV | DATE       | DESCRIPTION                               | NAME                                     |
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| 4   | 2019-07-09 | TEMPLATE VALUES UPDATED AS PER SCL 2.0    | DRWN: MURALIDHARAN<br>CHKD:              |
| 3   | 2019-02-05 | SINGLE CAVITY NAMEPLATE REMOVED           | DRWN: ARUN<br>CHKD:                      |
| 2   | 2018-06-20 | DRAWING NAME CHANGED                      | DRWN: ANUSHLAL<br>CHKD:                  |
| 0   | 2017-09-14 | ORIGINAL ISSUE - DESIGNED BY: DHANANJEYAN | DRWN: DHANANJEYAN<br>CHKD: PICHLER KLAUS |

|  |  |                                    |  |                                   |  |
|--|--|------------------------------------|--|-----------------------------------|--|
| FOR TORQUE SPECIFICATIONS, REFER TO HS 252 |  | METRIC                             |  | HUSKY                             |  |
| WEIGHT - kg                                |  | TITLE<br>HOT SPRUE<br>U1000-HT-CAP |  | SCALE NONE SIZE AIR DRAWING REV 0 |  |
| SHEET 2 OF 2                               |  | 8151196                            |  | 0                                 |  |

8

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