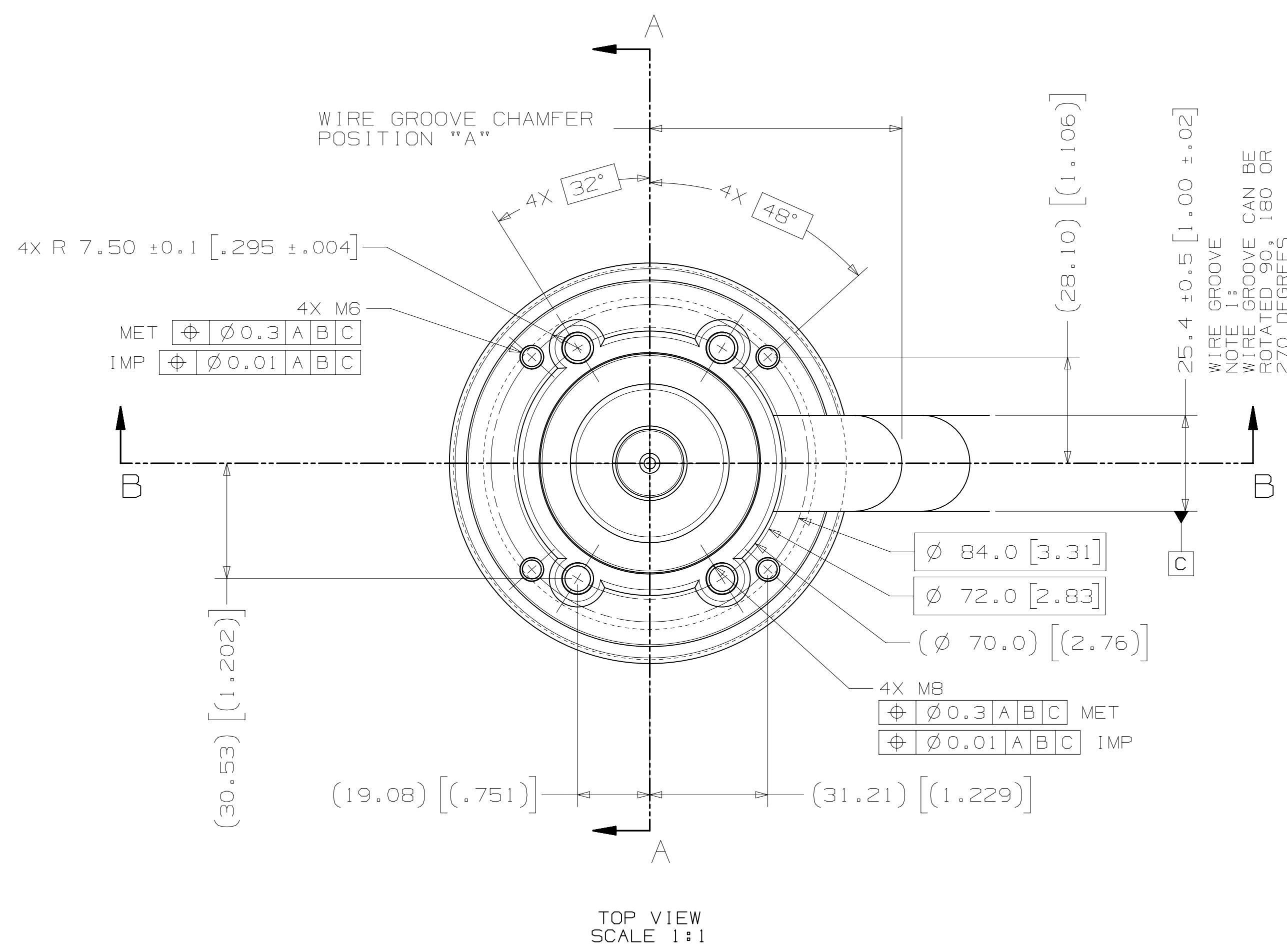
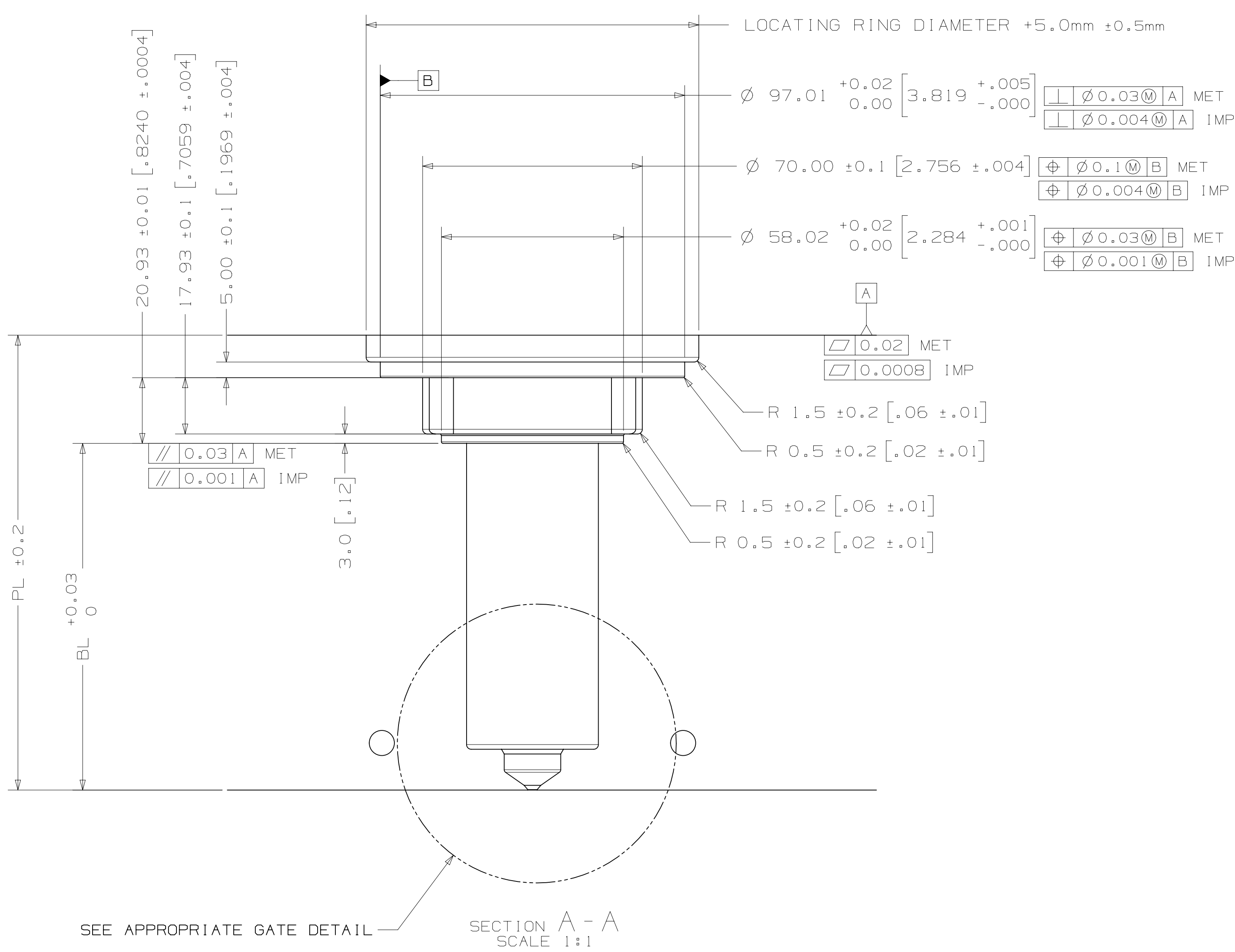


INSTALLATION DRAWING

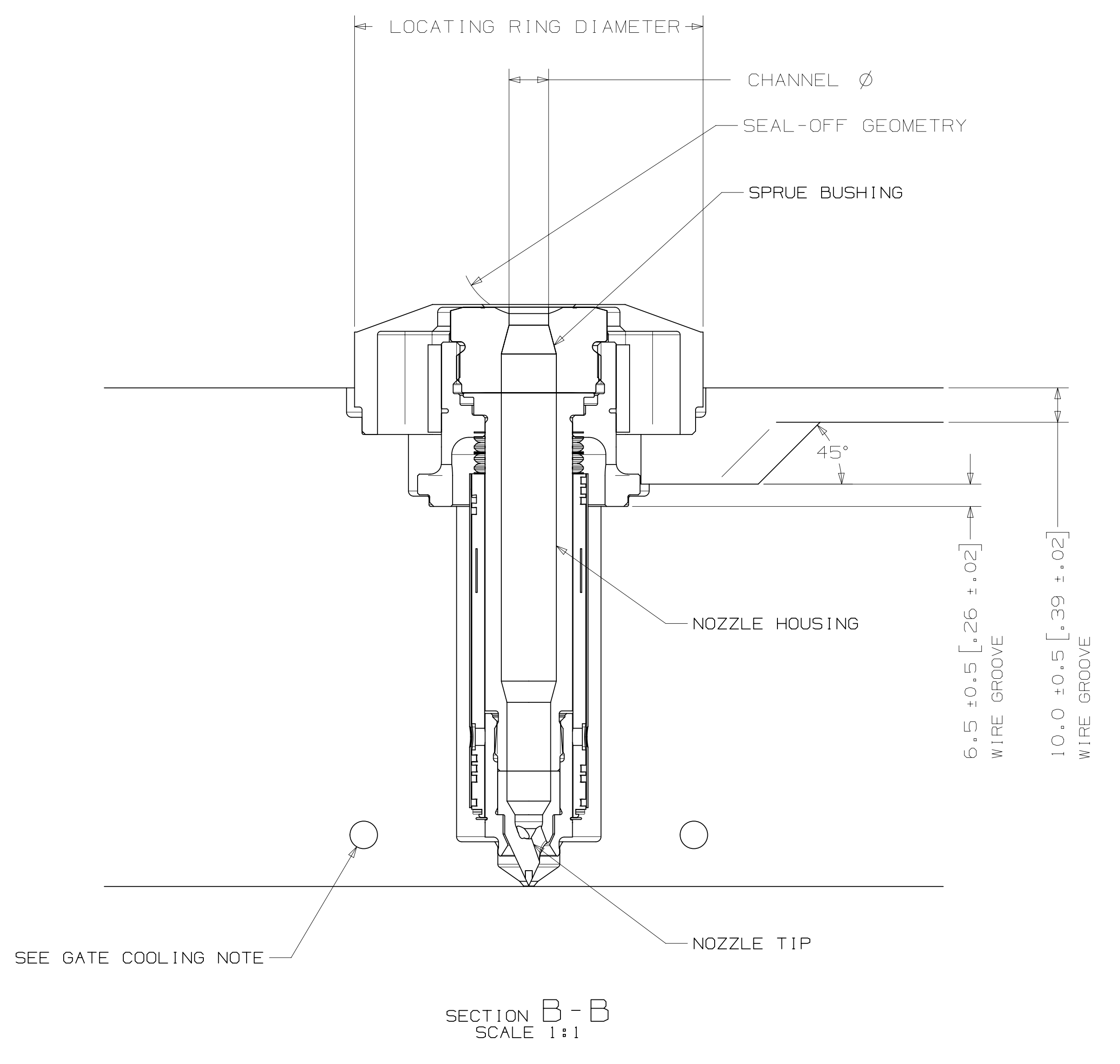
REV 0
STATUS B149425



TOP VIEW
SCALE 1:1



SEE APPROPRIATE GATE DETAIL
SECTION A-A
SCALE 1:1



SECTION B-B
SCALE 1:1

NOZZLE SERIES	NOZZLE TIP	PL RANGE	Approx. BL*
U1000	HT-D	96.27(3.790) - 233.36(9.187)	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 SPHERICAL RADIUS	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"
	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

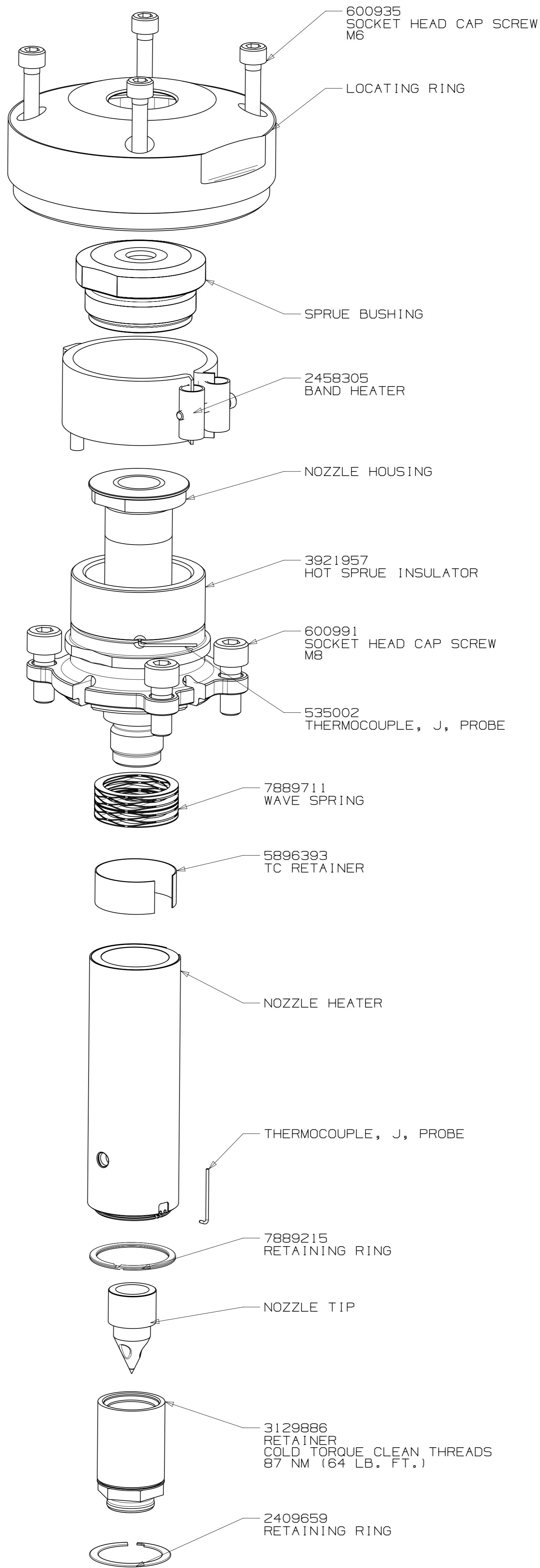
- HARDENED GATE INSERTS (48-5) ARE RECOMMENDED WHEN USING SOFTER CAVITY STEELS. SOFTER CAVITIES MAY BE ACCEPTABLE FOR CERTAIN APPLICATIONS. CONTACT YOUR HUSKY REPRESENTATIVE WITH QUESTIONS.
- EDM'ING THE GATE AREA CAUSES MICRO CRACKS WHICH LEAD TO BRITTLE GATE FAILURES. ALSO - DO NOT EDM THE MOLDING 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 DEEBAN N T
5	2020-05-27	TABLE UPDATED PER LATEST CALCULATION	CHKD: DEEBAN N T
4	2019-07-09	TEMPLATE VALUES UPDATED AS PER SOL 2.0	DRWNG MURALIDHARAN
3	2019-02-05	SINGLE CAVITY NAMEPLATE REMOVED	DRWNG ARJUN
2	2018-05-20	DRAWING NAME CHANGED	DRWNG ANUSHAL
0	2017-09-13	ORIGINAL ISSUE - DESIGNED BY: DHANANLEYAN	DRWNG DHANANLEYAN
			CHKD: PICHLER KLAUS

COST PER AUM: 114.50/134 AND HSN# 9999999999 MASS OPERATING SPECIFIED CAD MODEL TO BE USED ANY TOLERANCE DIMENSIONS ARE SHOWN GENERAL TOLERANCES: METRIC IMPERIAL BROKEN EDGE/CHAMFER: 1 ± 0.2 X 45° 0.04 ± 0.01 X 45° FILLET/RADIUS: R0.8 ± 0.2 R0.5 ± 0.01 SURFACE FINISH: Ra 3.2	FOR TORQUE SPECIFICATIONS, REFER TO HS 252	METRIC HUSKY TITLE: HOT SPRUE U1000-HT-D	SCALE: NONE SIZE: AOR SHEET: 1 OF 2 REV: 0
WEIGHT: - kg		ALL RIGHTS RESERVED. COPYRIGHT © 2019 HUSKY.	

ASSEMBLY DRAWING

DRAWING
8149425
REV 0



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
ADEQUATE COOLING IS ESSENTIAL FOR THE PROPER FUNCTION OF THIS SYSTEM. REFER TO THE HOT RUNNER PRODUCT GUIDE FOR MORE DETAILED GUIDELINES.
www.husky.cc

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.
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REV	DATE	DESCRIPTION	NAME
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2	2018-06-20	DRAWING NAME CHANGED	DRWN: ANUSHLAL CHKD:
0	2017-09-13	ORIGINAL ISSUE - DESIGNED BY: DHANANJEYAN	DRWN: DHANANJEYAN CHKD: PICHLER KLAUS

FOR TORQUE SPECIFICATIONS, REFER TO HS 252

METRIC
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HUSKY		TITLE	SCALE	SIZE	DRAWING	REV
		HOT SPRUE U1000-HT-D	NONE	AIR	8149425	0
		SHEET 2 OF 2				