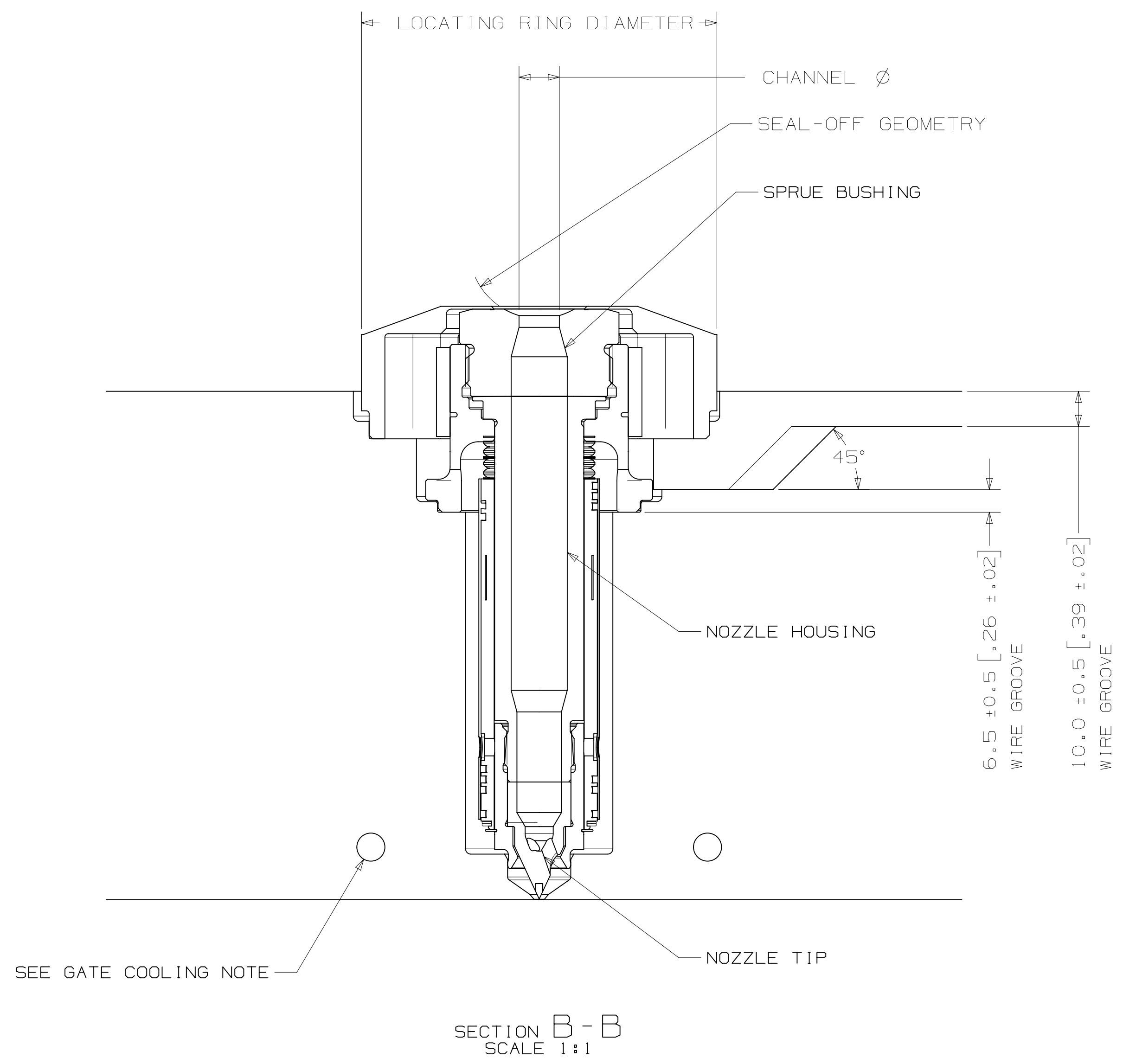
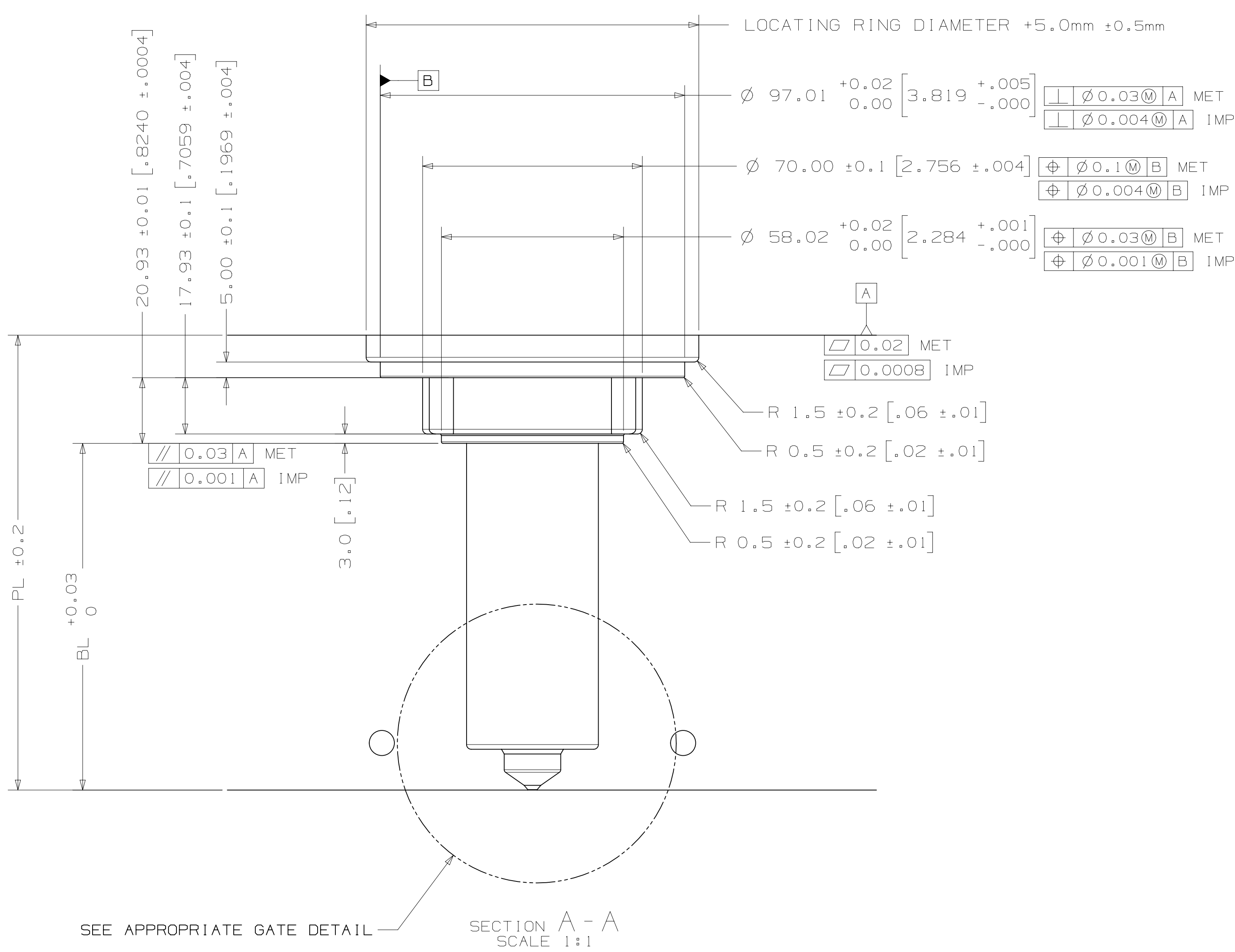
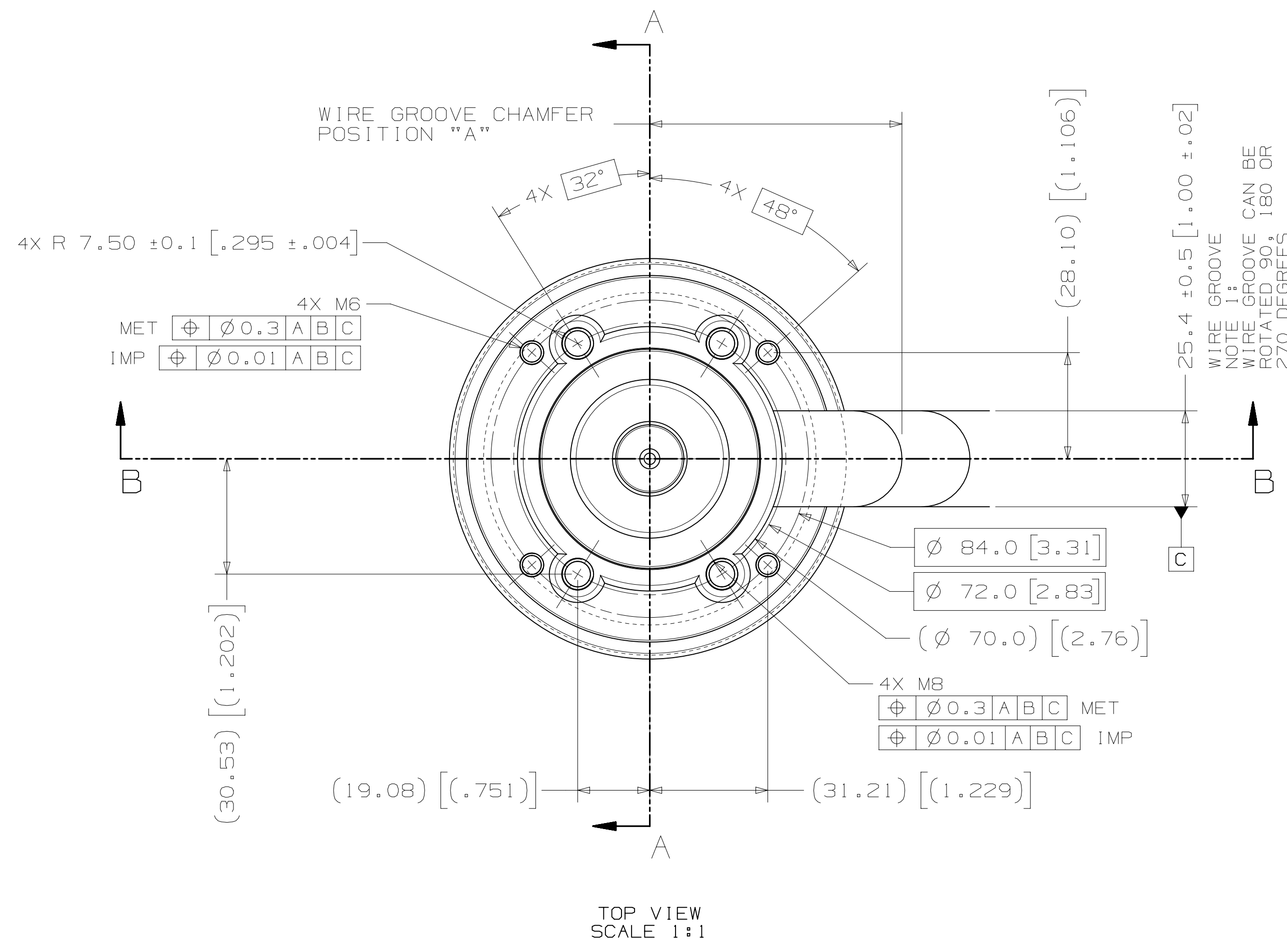


INSTALLATION DRAWING

REV 0
STATUS B149425



NOZZLE SERIES	NOZZLE TIP	NOZZLE HOUSING		PL		"BL" AT DELTA TEMP (DELTA TEMP = TEMP OF MELT - TEMP OF MOLD) *															
		LENGTH	MIN INCH	MAX INCH	60° C-79° C 140° F-174° F	80° C-99° C 176° F-210° F	100° C-119° C 212° F-246° F	120° C-139° C 248° F-282° F	140° C-159° C 284° F-318° F	160° C-179° C 320° F-354° F	180° C-199° C 356° F-390° F	200° C-219° C 382° F-428° F	220° C-239° C 428° F-462° F	240° C-259° C 464° F-498° F	260° C-279° C 500° F-534° F	280° C-300° C 536° F-572° F					
U1000	HT-D	70	96 (3.780)	113 (4.449)	70.21 (2.764)	70.23 (2.765)	70.25 (2.766)	70.28 (2.767)	70.30 (2.768)	70.33 (2.769)	70.35 (2.770)	70.38 (2.771)	70.40 (2.772)	70.43 (2.773)	70.46 (2.774)	70.49 (2.775)					
		90	116 (4.567)	133 (5.236)	90.22 (3.552)	90.25 (3.553)	90.28 (3.554)	90.31 (3.556)	90.33 (3.556)	90.36 (3.557)	90.39 (3.559)	90.43 (3.560)	90.46 (3.561)	90.49 (3.563)	90.53 (3.564)	90.56 (3.565)					
		110	136 (5.354)	153 (6.024)	110.24 (4.340)	110.27 (4.341)	110.30 (4.343)	110.33 (4.344)	110.37 (4.345)	110.40 (4.346)	110.44 (4.348)	110.47 (4.349)	110.51 (4.351)	110.55 (4.352)	110.59 (4.354)	110.63 (4.356)					
		130	156 (6.142)	173 (6.811)	130.25 (5.128)	130.29 (5.130)	130.33 (5.131)	130.36 (5.132)	130.40 (5.134)	130.44 (5.135)	130.48 (5.137)	130.52 (5.139)	130.56 (5.140)	130.61 (5.142)	130.66 (5.144)	130.70 (5.146)					
		150	176 (6.929)	193 (7.598)	150.27 (5.916)	150.31 (5.918)	150.35 (5.919)	150.39 (5.921)	150.44 (5.923)	150.48 (5.924)	150.53 (5.926)	150.57 (5.928)	150.62 (5.930)	150.66 (5.931)	150.72 (5.934)	150.77 (5.936)					
		170	196 (7.717)	213 (8.386)	170.28 (6.704)	170.33 (6.706)	170.38 (6.708)	170.42 (6.709)	170.47 (6.711)	170.52 (6.713)	170.57 (6.715)	170.62 (6.717)	170.67 (6.719)	170.72 (6.721)	170.79 (6.724)	170.84 (6.726)					
		190	217 (8.543)	233 (9.173)	190.30 (7.492)	190.35 (7.494)	190.40 (7.496)	190.45 (7.498)	190.51 (7.500)	190.56 (7.502)	190.61 (7.504)	190.67 (7.507)	190.73 (7.509)	190.78 (7.511)	190.85 (7.514)	190.91 (7.516)					

* BL VALUES IN THE TABLE ARE REFERENCES WHICH CAN DEVIATE BY +/- 0.03mm
FINAL BL VALUE CAN BE FOUND ON GATE DETAIL DRAWING AND 3D AFTER FINISHED DESIGN.

U1000	LOCATING RING DIAMETER	WIRE GROOVE CHAMFER POSITION "A" (±2.0)
	100mm	66.7
	101.3mm [3.99"]	66.7
	125mm	76.7

U1000	SPRUE BUSHING	
	SEAL-OFF GEOMETRY SPHERICAL RADIUS	CHANNEL Ø IN - OUT
	FLAT	6.5 - 16
	FLAT	
	SEAL-OFF 12.7 [1/2"]	11.5 - 16.00
	SEAL-OFF 15.5	
	SEAL-OFF 19.05 [3/4"]	
	SEAL-OFF 20	
	SEAL-OFF 40	

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
A151 H13 (49-51 Rc)
A151 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.

REV	DATE	DESCRIPTION	DRWN	CHKD
0	2017-09-13	ORIGINAL ISSUE - DESIGNED BY DHANALEYAN	DRWN: DHANALEYAN	CHKD: PICHLER KLAUS

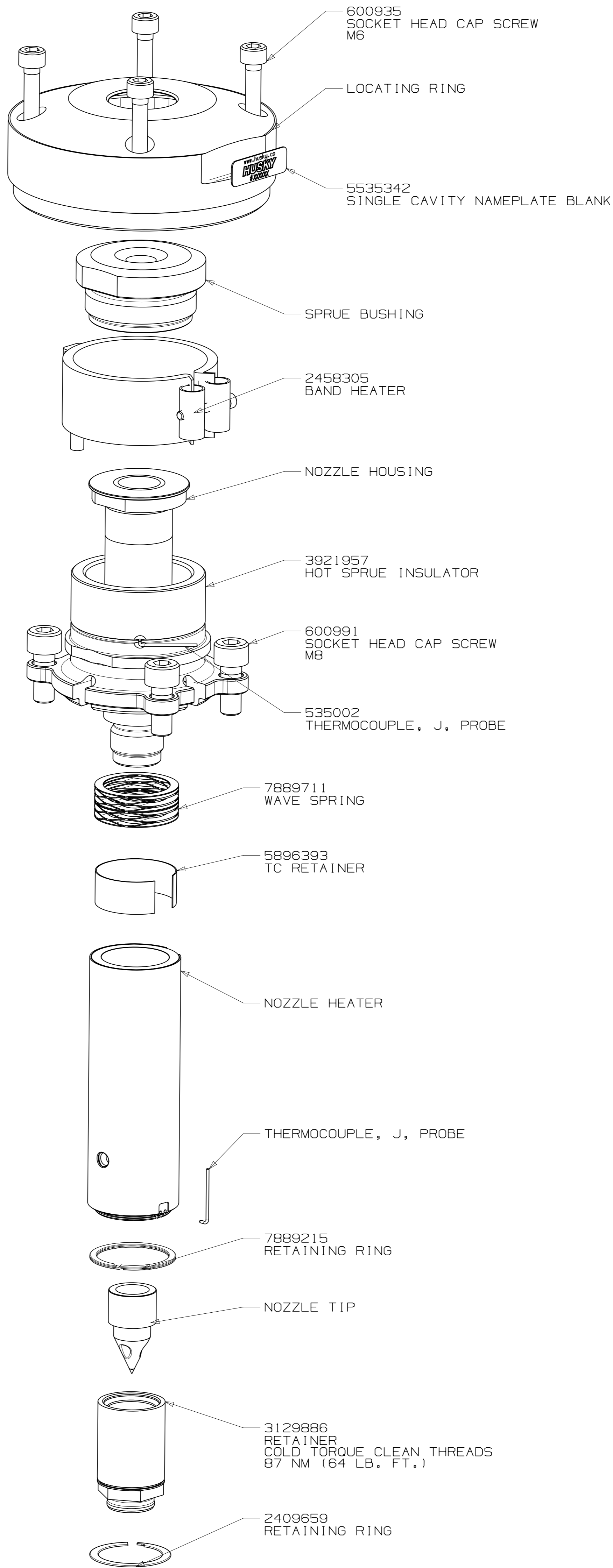
GENERAL TOLERANCES	METRIC	IMPERIAL
BROKEN EDGES/CHAMFERS	± 0.2 X 45°	0.04 ± 0.01 X 45°
FILLET/RADIUS	R0.8 ± 0.2	R0.03 ± 0.01
SURFACE FINISH	1.2	3.2

FOR TORQUE SPECIFICATIONS, REFER TO HS 252
WEIGHT - kg

METRIC	HUSKY	TITLE	SCALE	NO	SIZE	DRAWING	REV
		HOT SPRUE	1:1	AOR	8149425	U1000-HT-D	0

ASSEMBLY DRAWING

REV 0
DRAWING 8149425



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 = (-)

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www.husky.cc

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REV	DATE	DESCRIPTION	NAME
0	2017-09-13	ORIGINAL ISSUE - DESIGNED BY: DHANANJEYAN	DRWN: DHANANJEYAN CHKD: PICHLER, KLAUS

FOR TORQUE SPECIFICATIONS, REFER TO HS 252	METRIC	HUSKY
THIS DRAWING AND INFORMATION CONTAINED WITHIN IS CONFIDENTIAL AND/OR PROPRIETARY TO HUSKY INJECTION MOLDING SYSTEMS LTD. OR ONE OF ITS SUBSIDIARIES. IT IS NOT TO BE COPIED, DISCLOSED OR USED, IN WHOLE OR IN PART, WITHOUT THE PRIOR WRITTEN CONSENT OF HUSKY.		TITLE HOT SPRUE U1000-HT-D
WEIGHT - kg	SCALE NONE	SIZE AIR
SHEET 2 OF 2		DRAWING 8149425
		REV 0