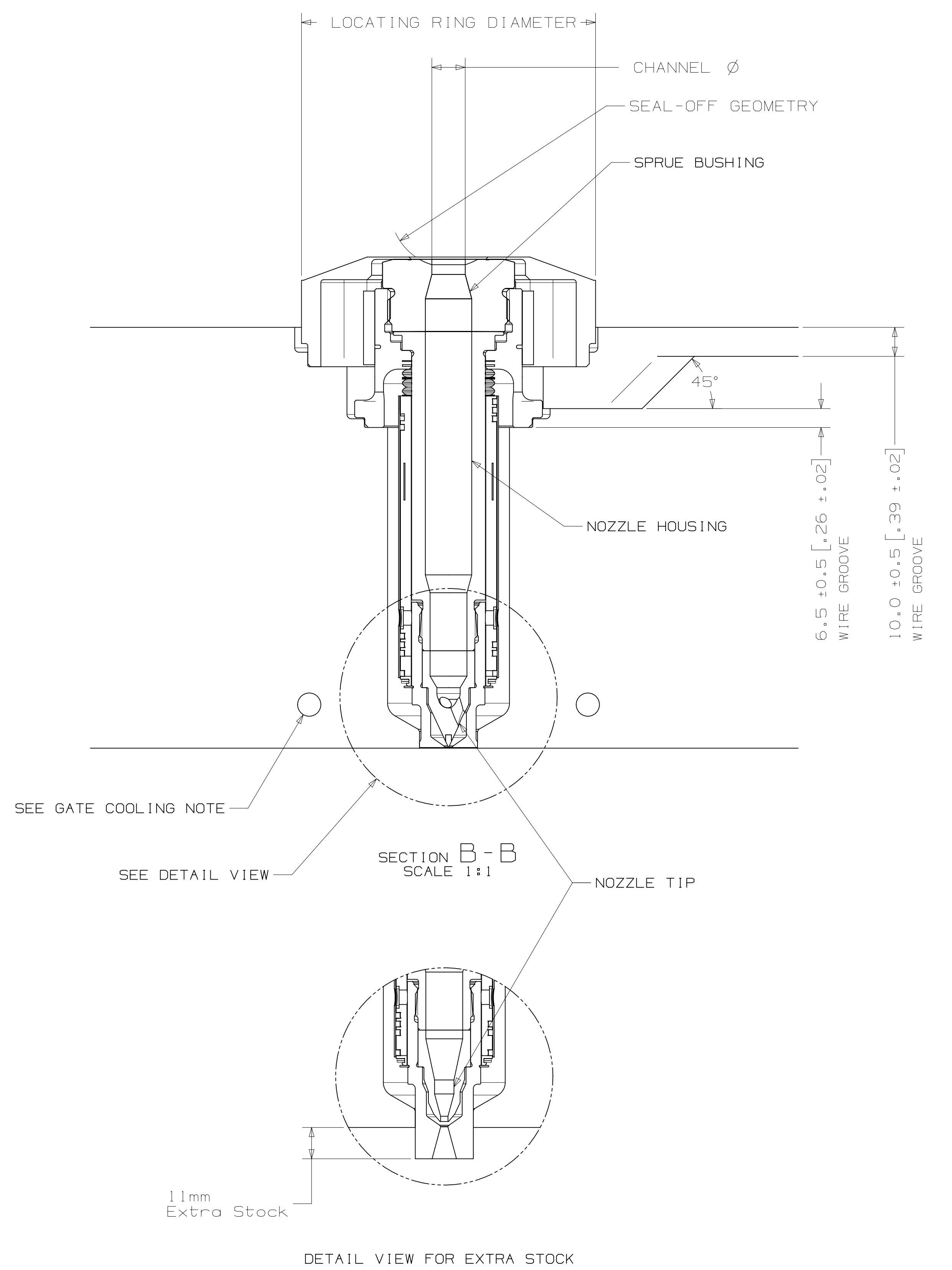
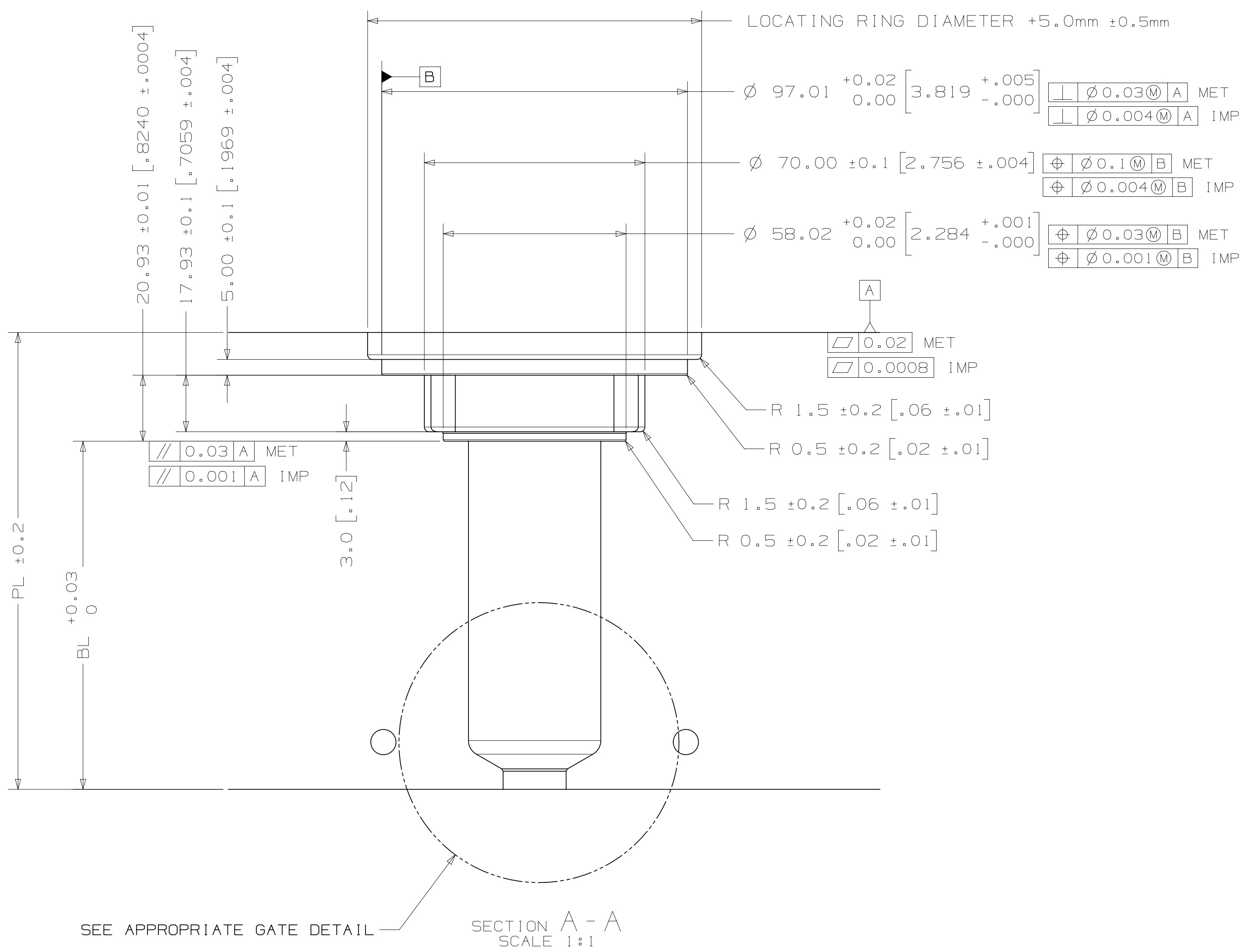
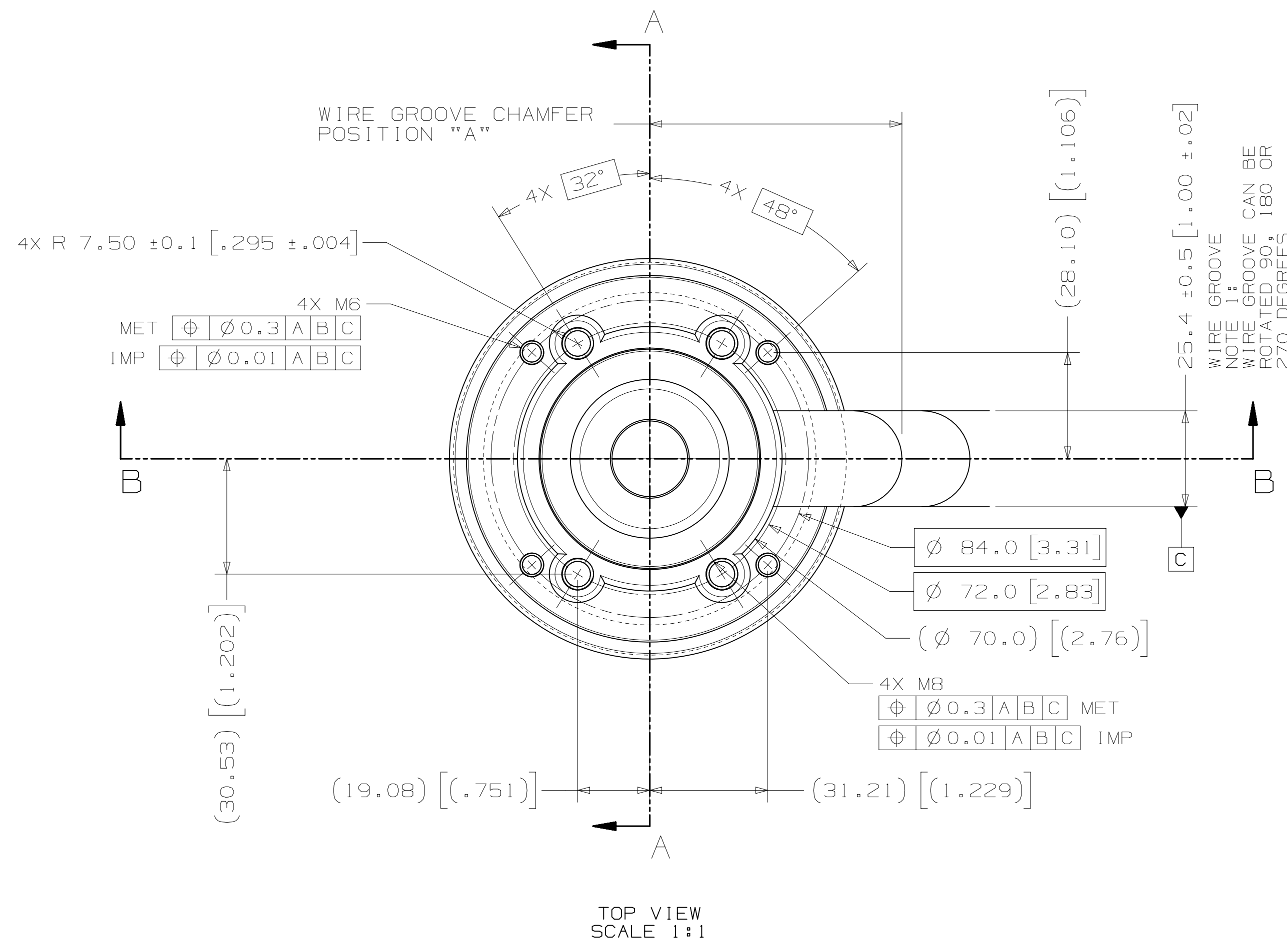


INSTALLATION DRAWING

REV 0
8151196



NOZZLE SERIES	NOZZLE TIP	NOZZLE HOUSING	PL	"BL" AT DELTA TEMP (DELTA TEMP = TEMP OF MELT - TEMP OF MOLD) *															
				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 [392° 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 [538° F-572° F]				
U1000	HT-CAP	70	96	13.780 [113.14.449]	70.38 [2.771]	70.40 [2.772]	70.42 [2.772]	70.43 [2.773]	70.46 [2.774]	70.48 [2.775]	70.50 [2.776]	70.52 [2.776]	70.54 [2.777]	70.56 [2.778]	70.58 [2.779]	70.60 [2.780]			
		90	116	14.567 [133.15.236]	90.39 [3.559]	90.42 [3.560]	90.44 [3.561]	90.46 [3.561]	90.49 [3.563]	90.51 [3.563]	90.54 [3.565]	90.57 [3.566]	90.62 [3.568]	90.65 [3.569]	90.67 [3.570]				
		110	137	15.394 [153.16.024]	110.41 [4.347]	110.44 [4.348]	110.46 [4.349]	110.49 [4.350]	110.52 [4.351]	110.55 [4.352]	110.58 [4.354]	110.61 [4.355]	110.65 [4.356]	110.68 [4.357]	110.71 [4.359]	110.74 [4.360]			
		130	157	16.181 [173.16.811]	130.42 [5.135]	130.46 [5.136]	130.49 [5.137]	130.52 [5.139]	130.56 [5.140]	130.59 [5.141]	130.63 [5.143]	130.66 [5.144]	130.70 [5.146]	130.74 [5.147]	130.78 [5.149]	130.81 [5.150]			
		150	177	16.989 [193.17.588]	150.44 [5.923]	150.48 [5.924]	150.51 [5.926]	150.55 [5.927]	150.59 [5.929]	150.63 [5.930]	150.67 [5.932]	150.71 [5.933]	150.75 [5.935]	150.79 [5.937]	150.84 [5.939]	150.88 [5.940]			
		170	197	17.756 [213.18.386]	170.45 [6.711]	170.50 [6.713]	170.54 [6.714]	170.58 [6.716]	170.63 [6.718]	170.67 [6.719]	170.72 [6.721]	170.76 [6.723]	170.81 [6.725]	170.85 [6.726]	170.91 [6.729]	170.95 [6.730]			
		190	217	18.543 [233.19.173]	190.47 [7.499]	190.52 [7.501]	190.56 [7.502]	190.61 [7.504]	190.66 [7.506]	190.71 [7.508]	190.76 [7.510]	190.81 [7.512]	190.86 [7.514]	190.91 [7.516]	190.97 [7.519]	191.02 [7.520]			

* 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.

NOZZLE SERIES	LOCATING RING DIAMETER	WIRE GROOVE CHAMFER POSITION "A" (±2.0)
U1000	100mm	66.7
	101.3mm [3.99"]	66.7
	125mm	78.7

NOZZLE SERIES	SPRUE BUSHING	
	SEAL-OFF GEOMETRY SPHERICAL RADIUS	CHANNEL Ø IN - OUT
U1000	FLAT	6.5 - 16
	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 (49-5) Rc
A151 420 (49-5) Rc

RECOMMENDED GATE MANUFACTURING GUIDELINES
- HARDENED GATE INSERTS (49-5) 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	DRWN	CHKD
0	2017-09-14	ORIGINAL ISSUE - DESIGNED BY DHANANLEYAN	DRWN: DHANANLEYAN	CHKD: PICHLER KLAUS

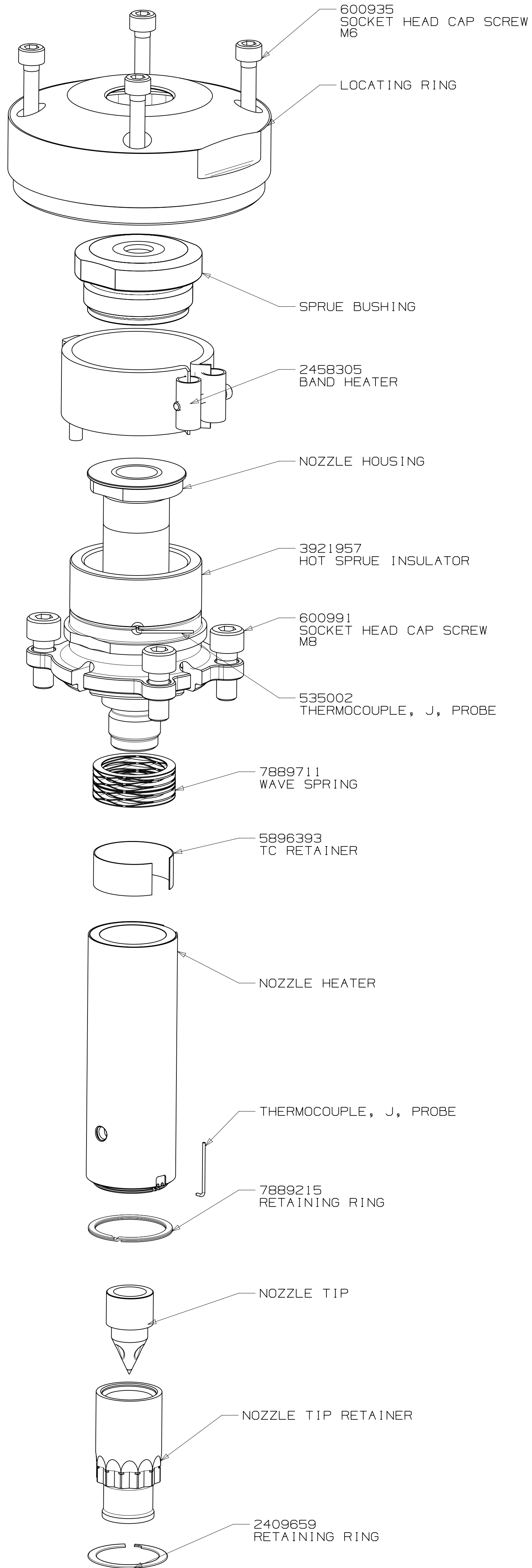
GENERAL TOLERANCES	METRIC	IMPERIAL
BROKEN EDGES/CHAMFERS	0.5 (0.2)	0.005 (0.02)
FILLET/RADIUS	R0.5 (0.2)	R0.03 (0.01)
SURFACE FINISH	1.6 (3.2)	3.2 (6.3)

FOR TORQUE SPECIFICATIONS, REFER TO HS 252	
WEIGHT	- kg

METRIC	IMPERIAL	TITLE	SCALE	NO	SIZE	DRAWING	REV
		HOT SPRUE	1:1	AOR	8151196	0	

ASSEMBLY DRAWING

DRAWING 8151196 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. - 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	NAME
0	2017-09-14	ORIGINAL ISSUE - DESIGNED BY: DHANANJEYAN	DRWN: DHANANJEYAN CHKD: PICHLER, KLAUS

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