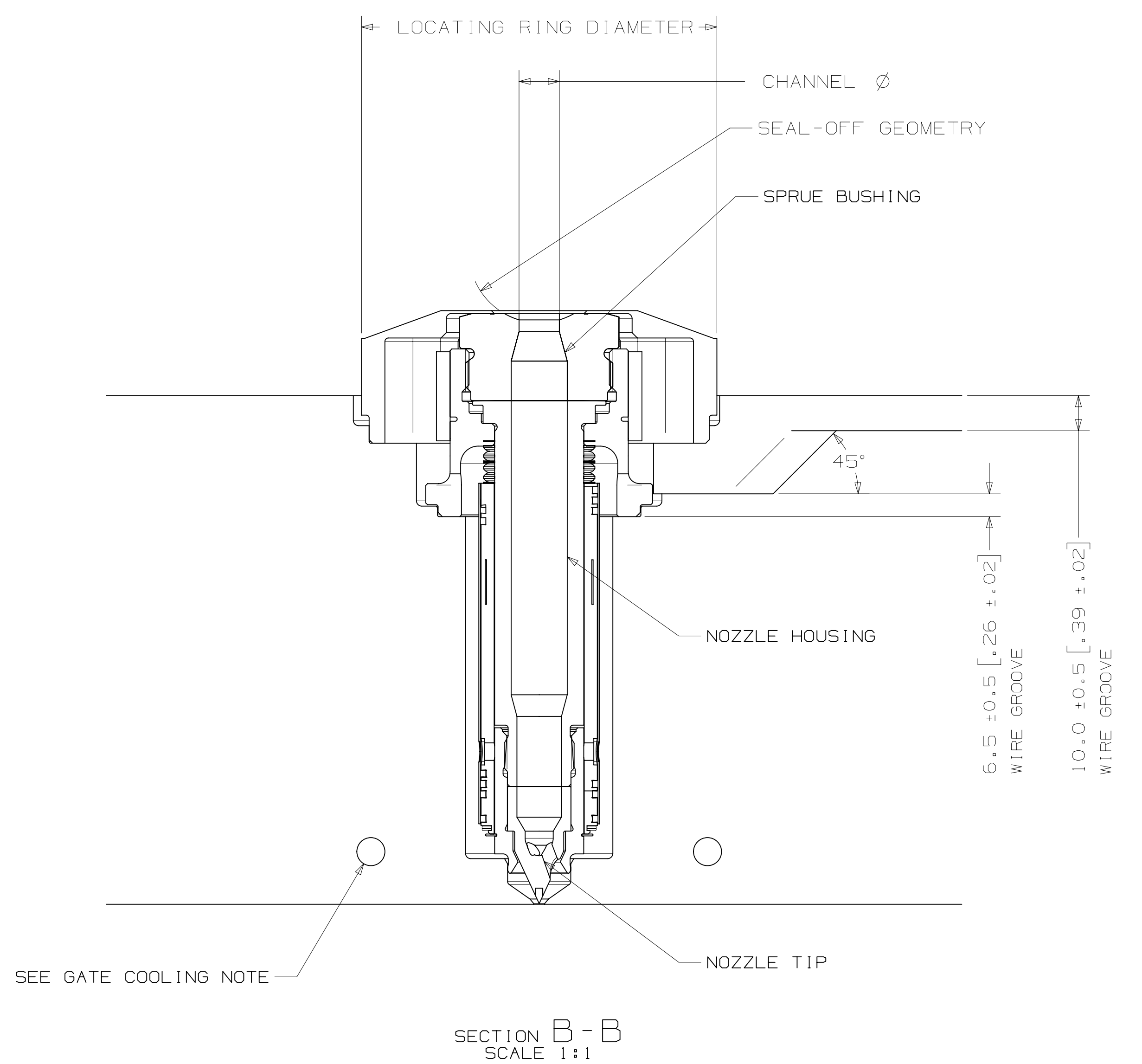
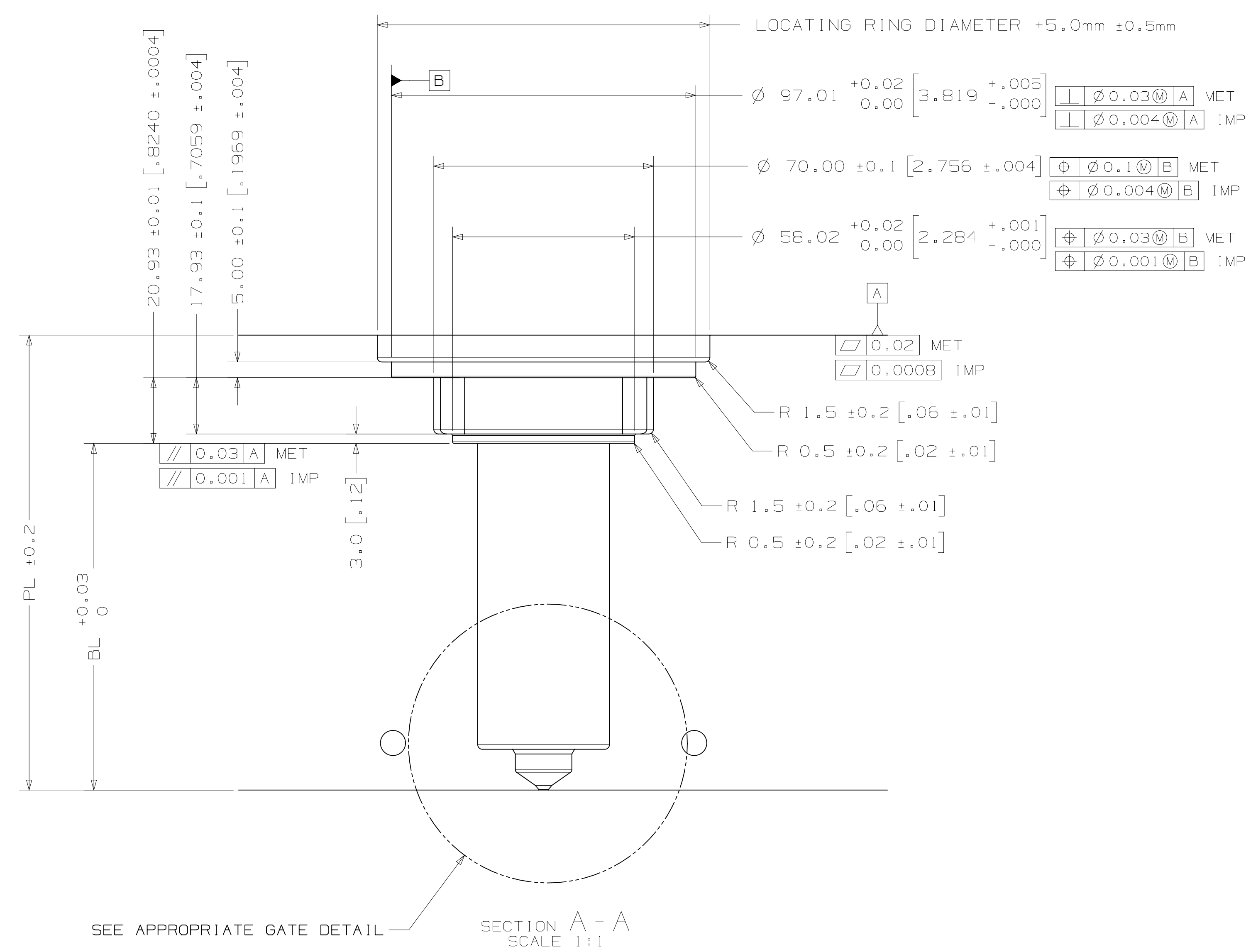
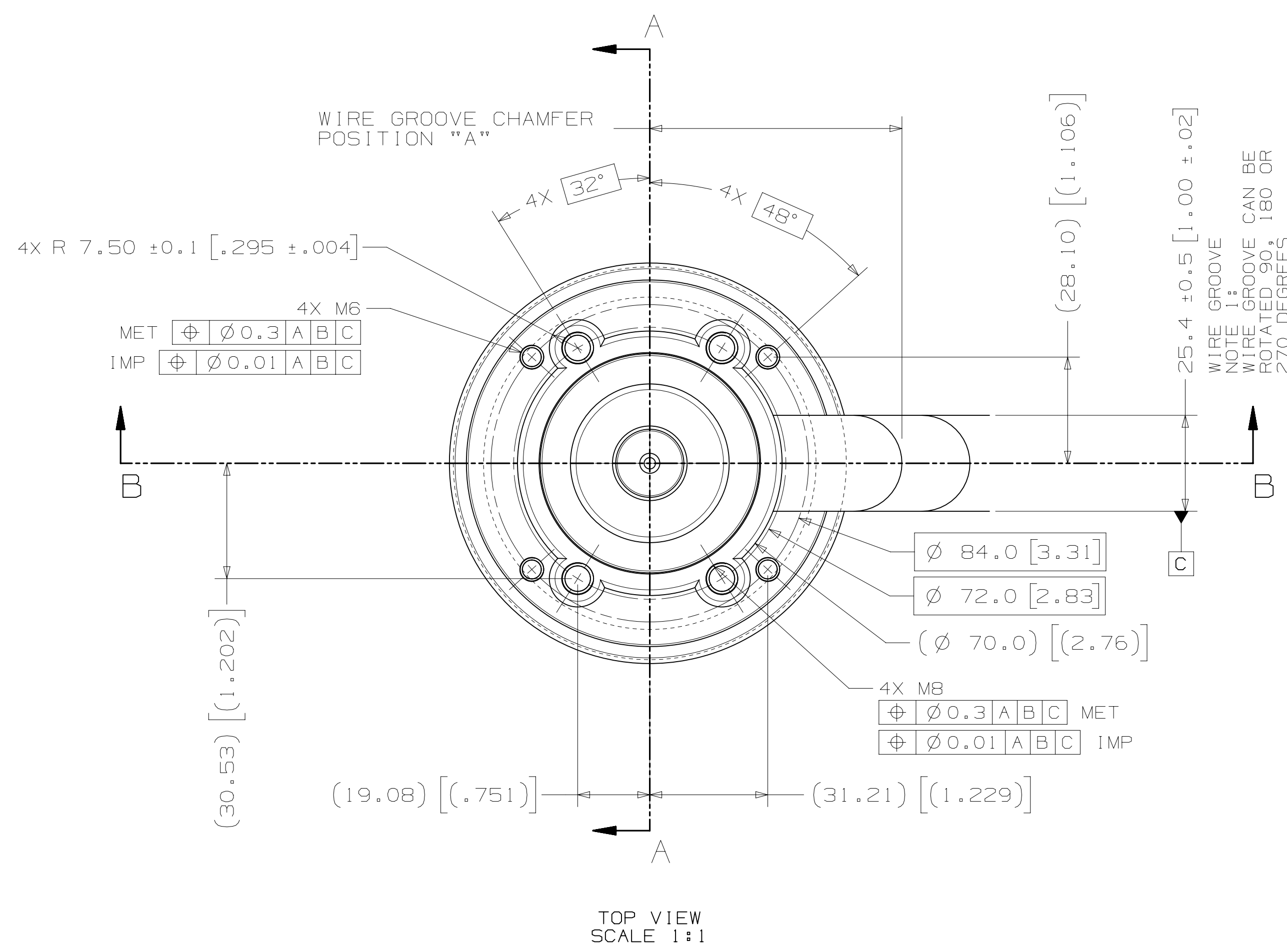


# INSTALLATION DRAWING

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.

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
	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	11.5 - 16.00	
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

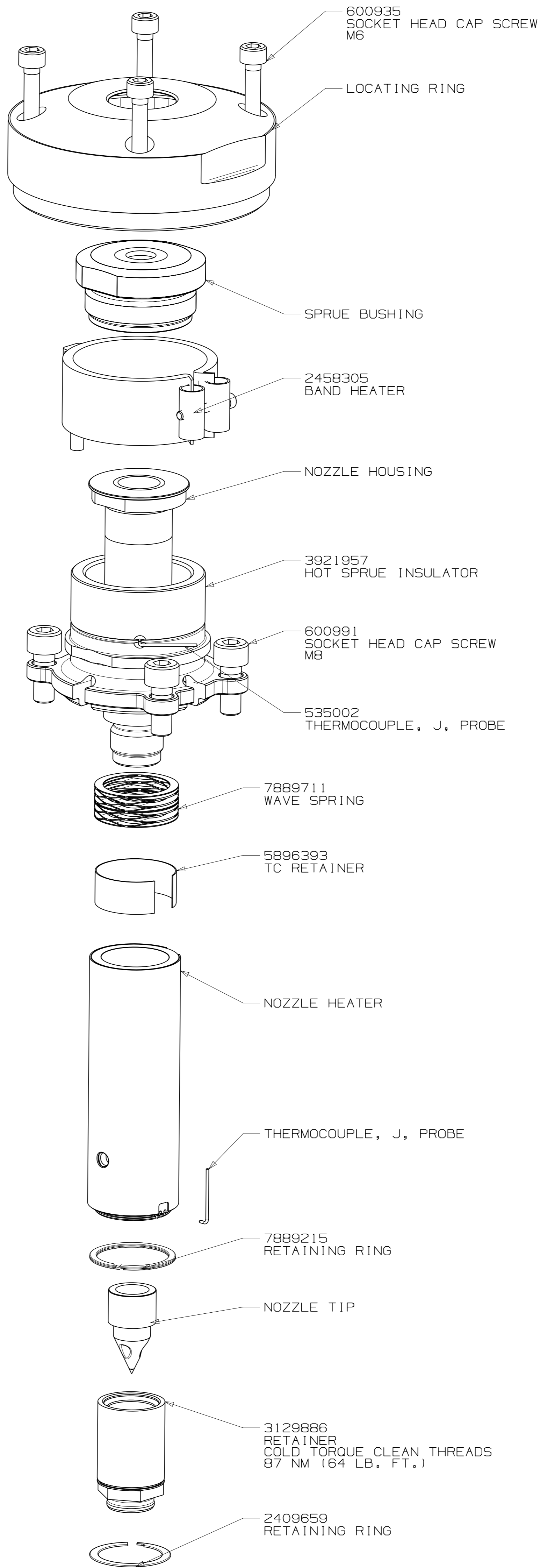
GENERAL TOLERANCES	METRIC	IMPERIAL
FILLET/RADIUS	R0.8 ± 0.2	R0.031 ± 0.01
SURFACE FINISH	1.6	32

FOR TORQUE SPECIFICATIONS, REFER TO HS 252	
WEIGHT	- kg

HUSKY		TITLE	SCALE	SIZE	DRAWING	REV
HOT SPRUE		U1000-HT-D	1:1	AOR	B149425	0

# 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. <a href="http://www.husky.cc">www.husky.cc</a>	
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)	
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<ul style="list-style-type: none"> <li>- 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.</li> <li>- 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.</li> <li>- MACHINE THE GATE HOLE AFTER HARDENING TO AVOID EXCESSIVE QUENCH IN THE THIN SECTION DURING HEAT TREAT &amp; RESULTING OVERHARDENING IN THE GATE AREA.</li> <li>- RECESSED GATES ON THE PRODUCT REDUCE THE GATE AREA STRENGTH LEADING TO GATE FAILURES.</li> <li>- WELDING THE GATE AREA INCREASES STRESSES AT THE GATE, SOFTENS THE AREA AROUND THE WELD AND CAN CAUSE GATE FAILURES.</li> </ul>	

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

FOR TORQUE SPECIFICATIONS, REFER TO HS 252		METRIC  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, REPRODUCED OR USED, IN WHOLE OR IN PART, WITHOUT THE PRIOR WRITTEN CONSENT OF HUSKY. ALL RIGHTS RESERVED. COPYRIGHT 2017 HUSKY.	<b>HUSKY</b> TITLE HOT SPRUE U1000-HT-D						
WEIGHT	- kg	SCALE	NONE	SIZE	AIR	DRAWING	8149425	REV	0
		SHEET	2 OF 2						