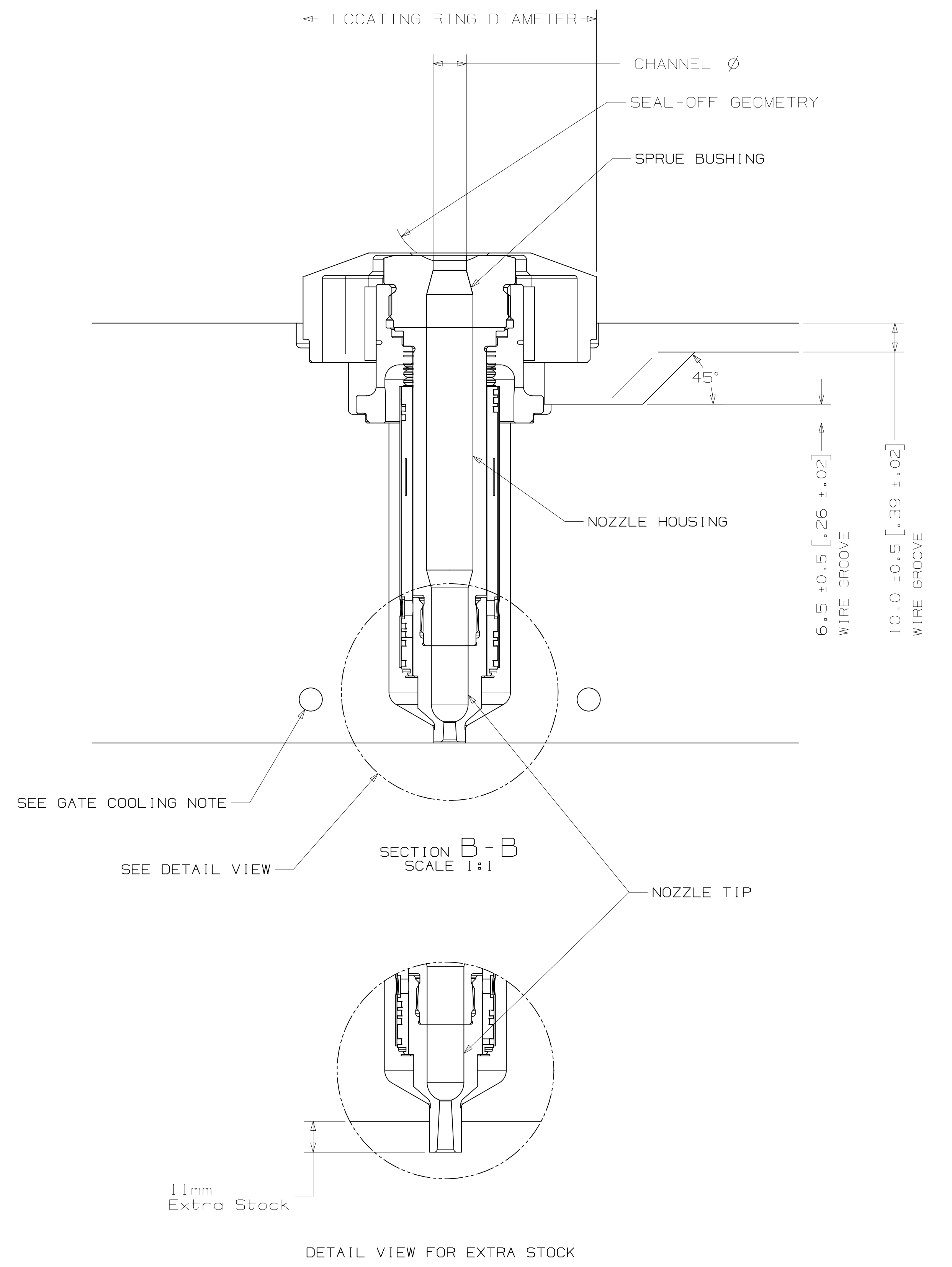
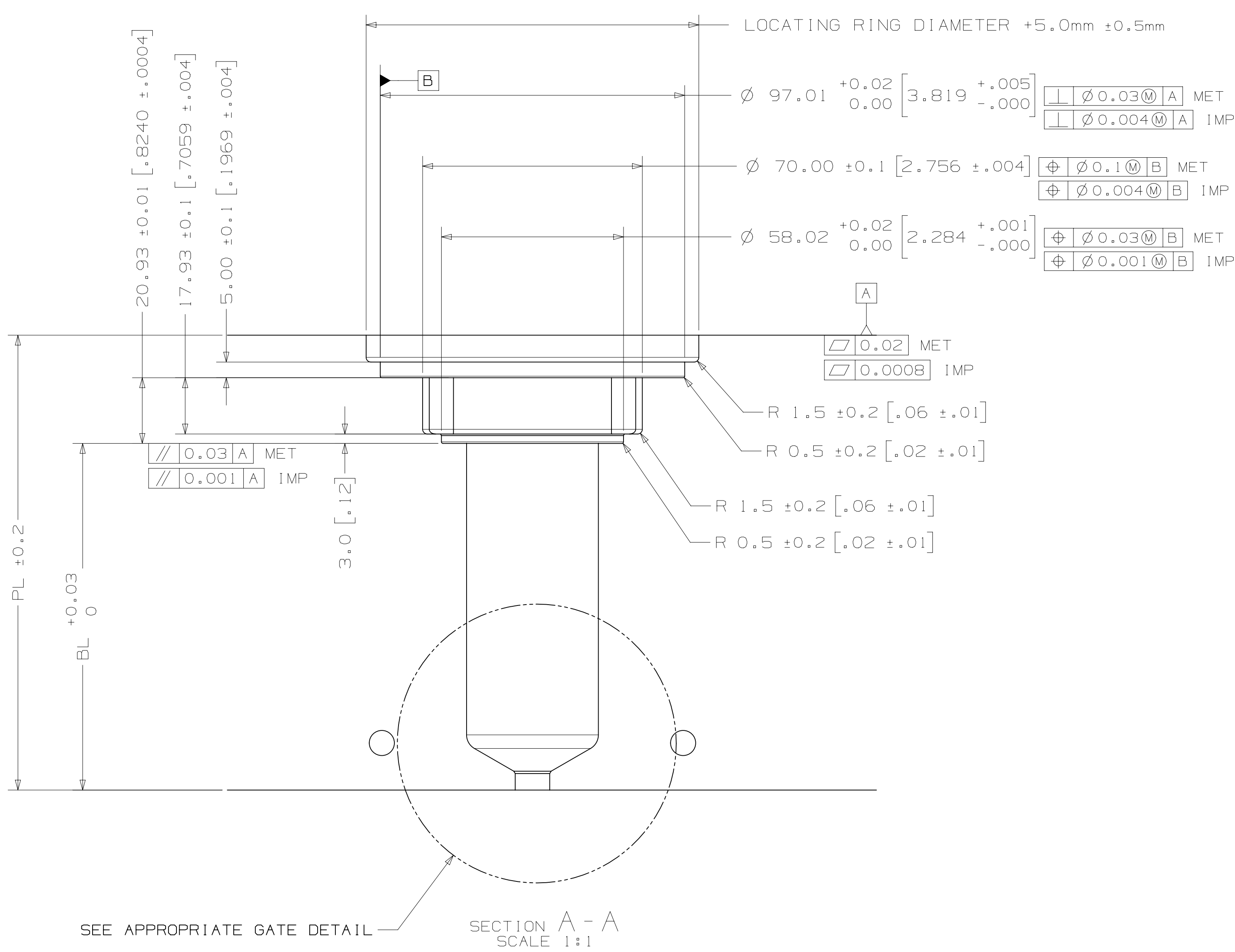
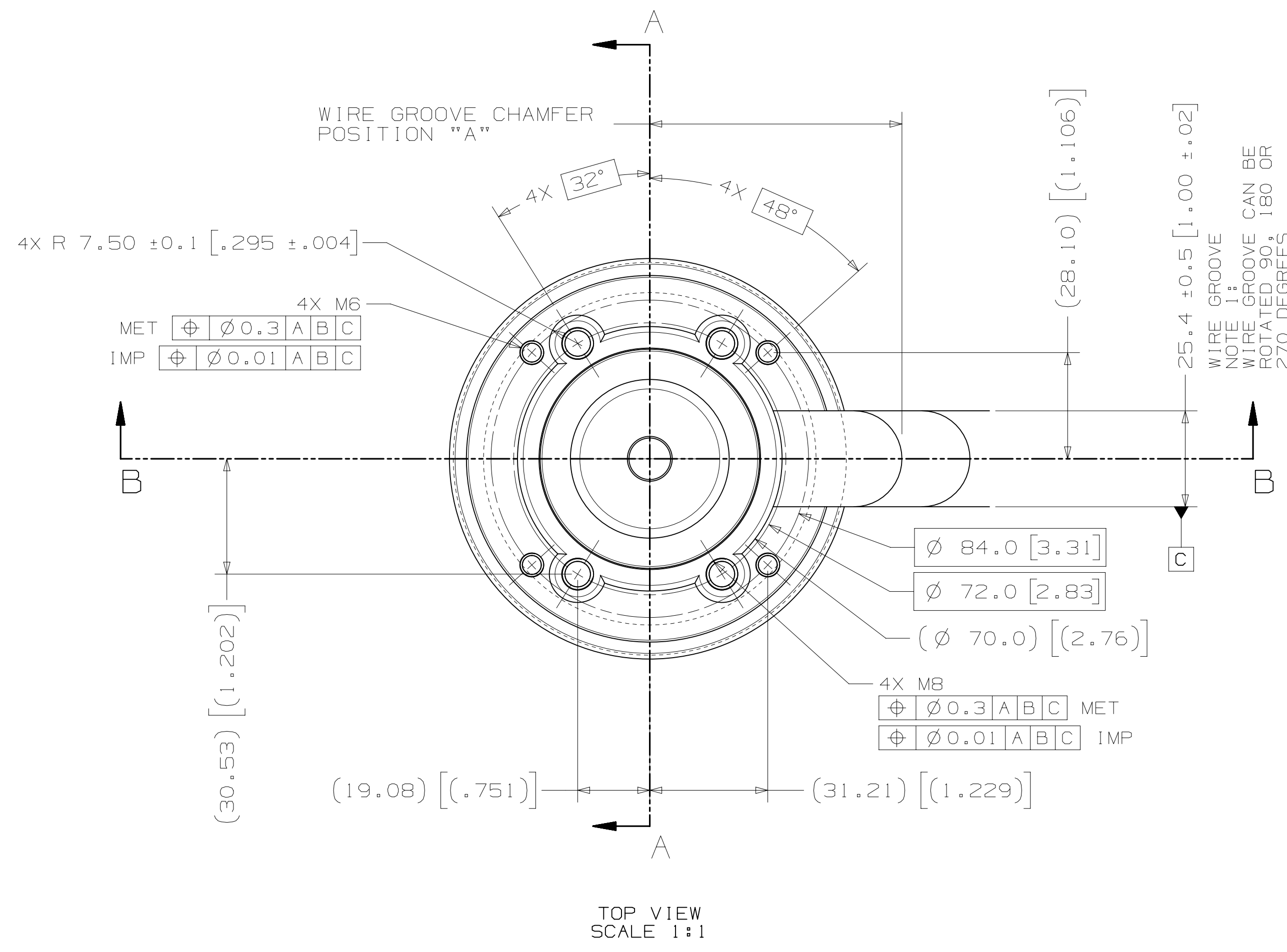


INSTALLATION DRAWING

REV 0
8150644



NOZZLE SERIES	NOZZLE TIP	NOZZLE HOUSING LENGTH	PL MIN (INCH) MAX (INCH)	"BL" AT DELTA TEMP (DELTA TEMP = TEMP OF MELT - TEMP OF MOLD) *															
				80° C-79° F	110° C-117° F	120° C-126° F	140° C-154° F	160° C-178° F	180° C-198° F	200° C-212° F	220° C-228° F	240° C-259° F	260° C-279° F	280° C-300° F	300° C-316° F	320° C-338° F	340° C-358° F	360° C-376° F	
U1000	HT-TS	70	96 (3.780) 113 (4.449)	70.24 (2.765)	70.26 (2.766)	70.28 (2.767)	70.29 (2.767)	70.31 (2.768)	70.33 (2.769)	70.36 (2.770)	70.38 (2.771)	70.40 (2.772)	70.42 (2.772)	70.44 (2.773)	70.46 (2.774)	70.48 (2.774)	70.50 (2.775)		
		90	116 (4.567) 133 (5.236)	90.25 (3.553)	90.28 (3.554)	90.30 (3.555)	90.32 (3.556)	90.35 (3.557)	90.37 (3.558)	90.40 (3.559)	90.43 (3.560)	90.45 (3.561)	90.48 (3.562)	90.51 (3.563)	90.53 (3.564)	90.55 (3.564)	90.57 (3.565)	90.59 (3.565)	
		110	136 (5.354) 153 (6.024)	110.27 (4.341)	110.30 (4.343)	110.32 (4.343)	110.35 (4.344)	110.38 (4.346)	110.41 (4.347)	110.44 (4.348)	110.47 (4.349)	110.50 (4.350)	110.54 (4.352)	110.57 (4.353)	110.60 (4.354)	110.63 (4.354)	110.65 (4.355)	110.67 (4.355)	110.69 (4.356)
		130	156 (6.142) 173 (6.811)	130.28 (5.129)	130.32 (5.131)	130.35 (5.132)	130.38 (5.133)	130.42 (5.135)	130.45 (5.136)	130.49 (5.137)	130.52 (5.139)	130.56 (5.140)	130.59 (5.141)	130.64 (5.143)	130.67 (5.144)	130.70 (5.144)	130.72 (5.145)	130.74 (5.145)	130.76 (5.146)
		150	176 (6.929) 193 (7.598)	150.30 (5.917)	150.34 (5.919)	150.37 (5.920)	150.41 (5.922)	150.45 (5.923)	150.49 (5.925)	150.53 (5.926)	150.57 (5.928)	150.61 (5.930)	150.65 (5.931)	150.70 (5.933)	150.74 (5.935)	150.77 (5.935)	150.79 (5.936)	150.81 (5.936)	150.83 (5.937)
		170	196 (7.717) 213 (8.386)	170.31 (6.705)	170.36 (6.707)	170.40 (6.709)	170.44 (6.710)	170.49 (6.712)	170.53 (6.714)	170.57 (6.715)	170.62 (6.717)	170.67 (6.719)	170.71 (6.721)	170.77 (6.723)	170.81 (6.725)	170.84 (6.725)	170.86 (6.726)	170.88 (6.726)	170.90 (6.727)
190	217 (8.543) 233 (9.173)	190.33 (7.493)	190.38 (7.495)	190.42 (7.497)	190.47 (7.499)	190.52 (7.501)	190.57 (7.503)	190.62 (7.505)	190.67 (7.507)	190.72 (7.509)	190.77 (7.511)	190.83 (7.513)	190.88 (7.515)	190.93 (7.517)	190.98 (7.519)	191.03 (7.521)	191.08 (7.523)	191.13 (7.525)	

* 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	78.7

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

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 WITHIN 2mm OF THE GATE HOLE.

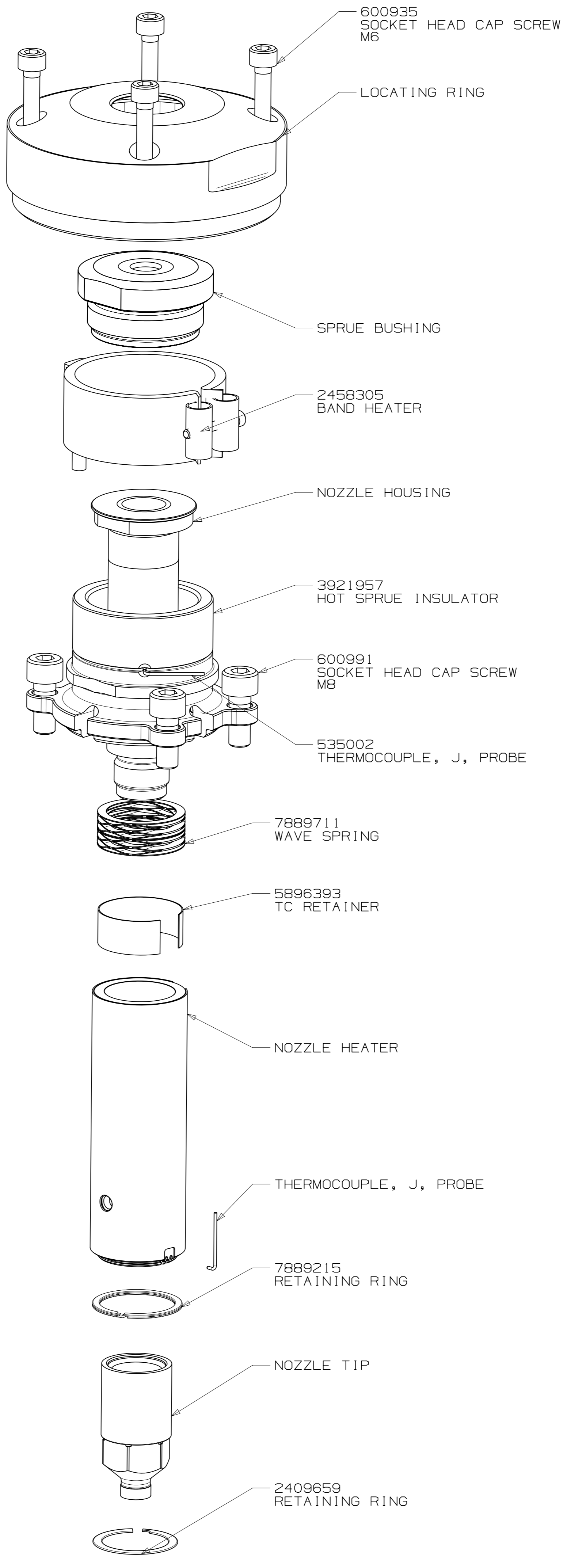
RECOMMENDED GATE MANUFACTURING GUIDELINES
- HARDENED GATE INSERTS (49-51) ARE RECOMMENDED WHEN USING SOFTER CAVITY STEELS. SOFTER CAVITIES MAY BE ACCEPTABLE FOR CERTAIN APPLICATIONS. CONTACT YOUR HUSKY REPRESENTATIVE WITH QUESTIONS.
- EDM'ING THE GATE AREA CAUSES MICRO CRACKS WHICH LEAD TO BRITTLE GATE 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	2017-09-14	ORIGINAL ISSUE - DESIGNED BY DHANALEYAN	DRWN: DHANALEYAN	CHKD: PICHLER KLAUS

<p>FOR TORQUE SPECIFICATIONS, REFER TO HS 252</p> <p>WEIGHT - kg</p>	<p>HUSKY</p> <p>TITLE: HOT SPRUE U1000-HT-TS</p> <p>SCALE: NONE</p> <p>SHEET 1 OF 2</p>
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ASSEMBLY DRAWING

REV 0
DRAWING 8150644



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

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		DRWN:	
		CHKD:	
		DRWN:	
		CHKD:	
		DRWN:	
		CHKD:	
0	2017-09-14	ORIGINAL ISSUE - DESIGNED BY: DHANANJAYAN	DRWN: DHANANJAYAN
			CHKD: PICHLER, KLAUS
REV	DATE	DESCRIPTION	NAME

FOR TORQUE SPECIFICATIONS, REFER TO HS 252	METRIC	HUSKY	TITLE HOT SPRUE U1000-HT-TS
WEIGHT - kg	SCALE NONE	SIZE AIR	DRAWING 8150644 REV 0
	SHEET 2 OF 2		