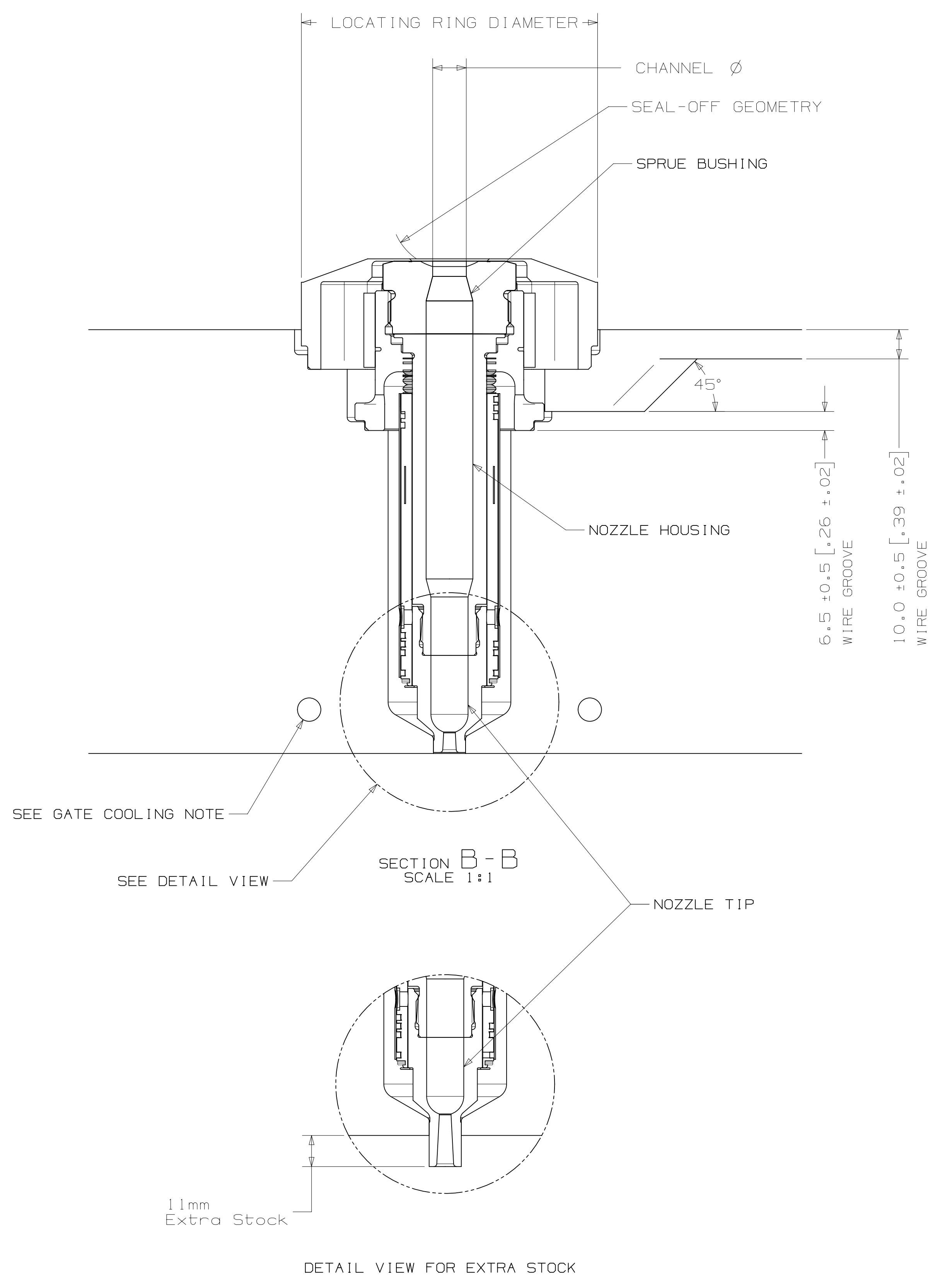
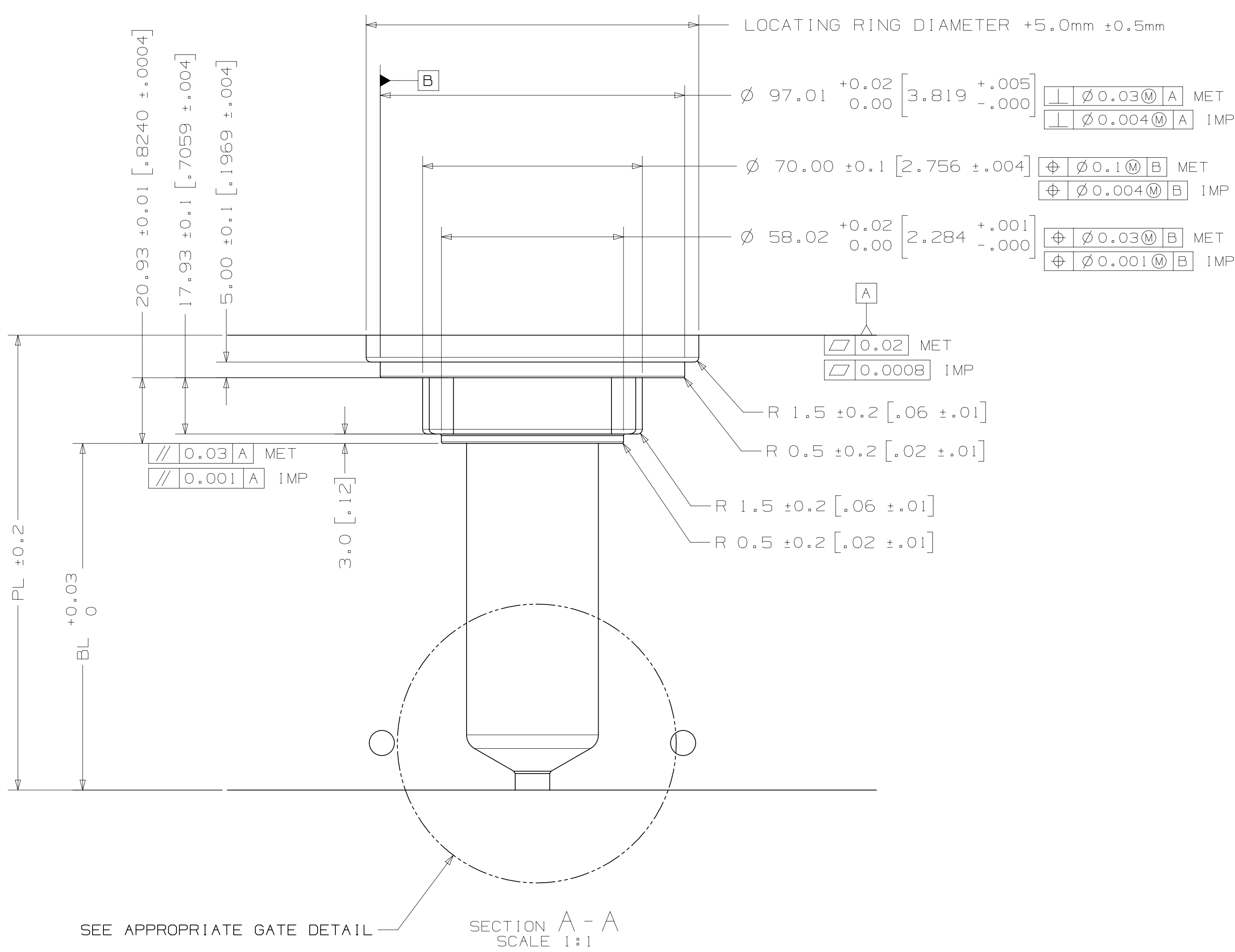
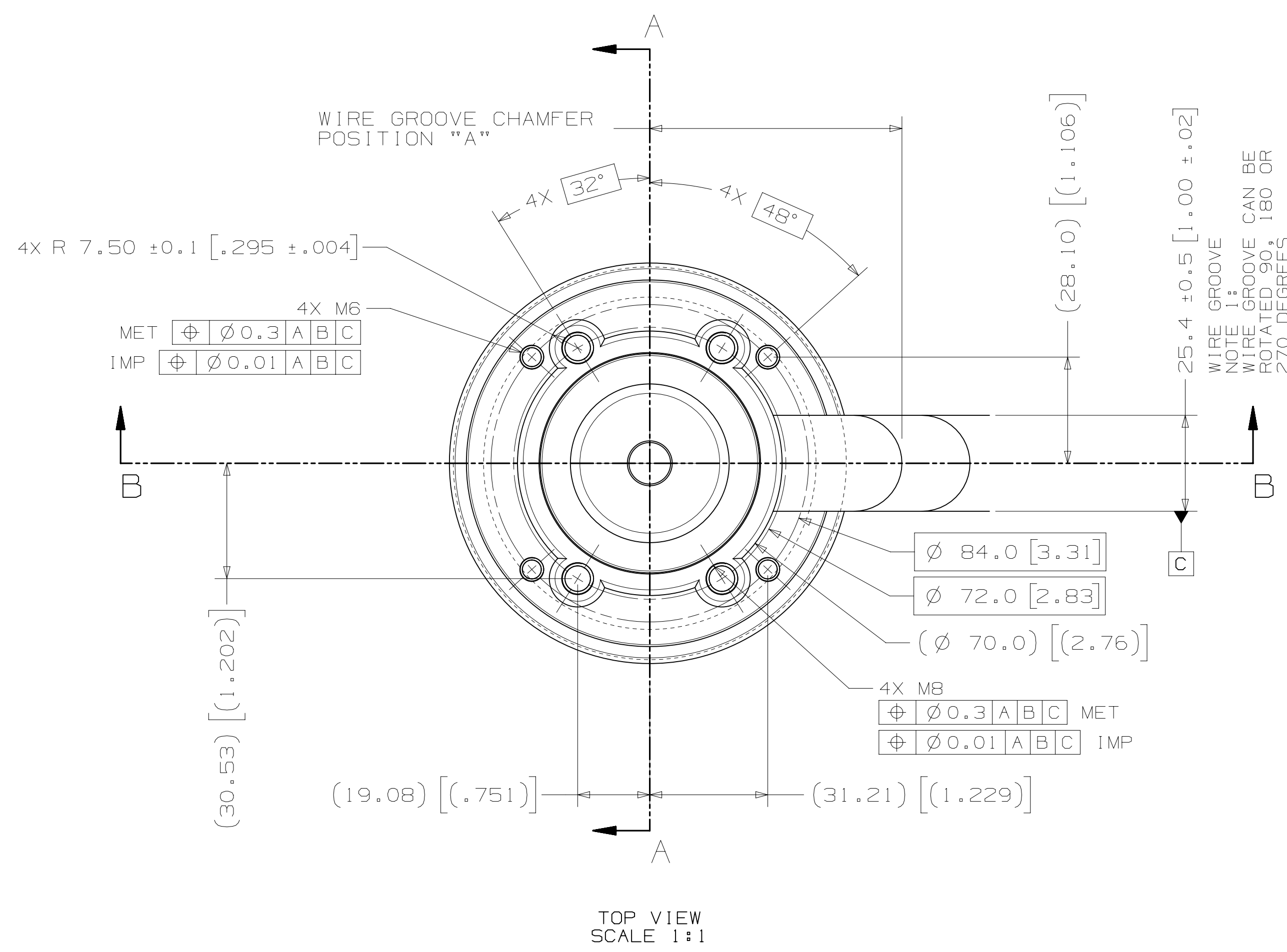


# INSTALLATION DRAWING

REV 0  
8150644



NOZZLE SERIES	NOZZLE TIP	PL RANGE	Approx. BL*
U750	HT-TS	96.3(3.791) - 233.4(9.189)	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	
	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	

U1000	LOCATING RING DIAMETER	WIRE GROOVE CHAMFER POSITION "A" (±2.0)
	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  
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.
- DERESSED 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	2020-05-28	TABLE UPDATED PER LATEST CALCULATION	DRWNG 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 ANUSHLAL
0	2017-09-14	ORIGINAL ISSUE - DESIGNED BY: DHANANLEYAN	DRWNG DHANANLEYAN
			DRWNG PICHLER KLAUS

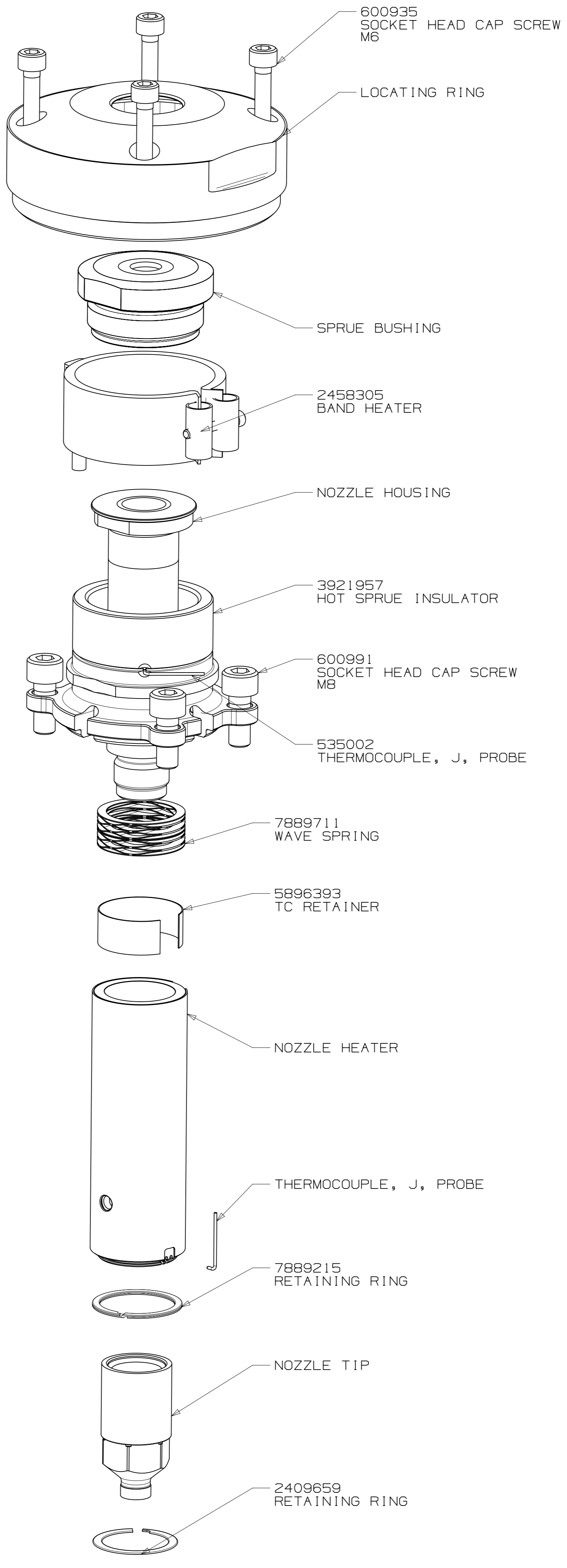
GENERAL TOLERANCES	METRIC	IMPERIAL
FINISH	±0.17	±0.007
FORM	±0.27	±0.011
POSITION	±0.41	±0.016
ANGULAR	±0.51	±0.020
FREE STATE	±0.63	±0.025
FREE STATE	±0.76	±0.030
FREE STATE	±0.91	±0.036
FREE STATE	±1.27	±0.050
FREE STATE	±1.58	±0.063
FREE STATE	±2.00	±0.080
FREE STATE	±2.54	±0.100
FREE STATE	±3.18	±0.125
FREE STATE	±4.00	±0.157
FREE STATE	±5.08	±0.200
FREE STATE	±6.35	±0.250
FREE STATE	±8.00	±0.315
FREE STATE	±10.00	±0.394
FREE STATE	±12.50	±0.492
FREE STATE	±16.00	±0.630
FREE STATE	±20.00	±0.787
FREE STATE	±25.00	±0.984
FREE STATE	±31.50	±1.238
FREE STATE	±40.00	±1.575
FREE STATE	±50.00	±1.969
FREE STATE	±63.00	±2.480
FREE STATE	±80.00	±3.150
FREE STATE	±100.00	±3.937
FREE STATE	±125.00	±4.921
FREE STATE	±160.00	±6.300
FREE STATE	±200.00	±7.874
FREE STATE	±250.00	±9.843
FREE STATE	±315.00	±12.407
FREE STATE	±400.00	±15.748
FREE STATE	±500.00	±19.685
FREE STATE	±630.00	±24.803
FREE STATE	±800.00	±31.500
FREE STATE	±1000.00	±39.370

FOR TORQUE SPECIFICATIONS, REFER TO HS 252	METRIC	IMPERIAL
GENERAL TOLERANCES	±0.17	±0.007
FORM	±0.27	±0.011
POSITION	±0.41	±0.016
ANGULAR	±0.51	±0.020
FREE STATE	±0.63	±0.025
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TITLE	SCALE	NO	SIZE	DRAWING	REV
HOT SPRUE	AOR	1	AOR	8150644	0

# ASSEMBLY DRAWING

DRAWING 8150644 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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0	2017-09-14	ORIGINAL ISSUE - DESIGNED BY: DHANANJEYAN	DRWN: DHANANJEYAN CHKD: PICHLER KLAUS

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. NO INTELLECTUAL PROPERTY RIGHTS ARE GRANTED INCLUDING ANY LICENSE IMPLIED OR OTHERWISE. ALL RIGHTS RESERVED. COPYRIGHT 2017 HUSKY.	TITLE HOT SPRUE U1000-HT-TS		
WEIGHT - kg	SCALE NONE	SIZE AIR	DRAWING 8150644	REV 0
SHEET 2 OF 2				