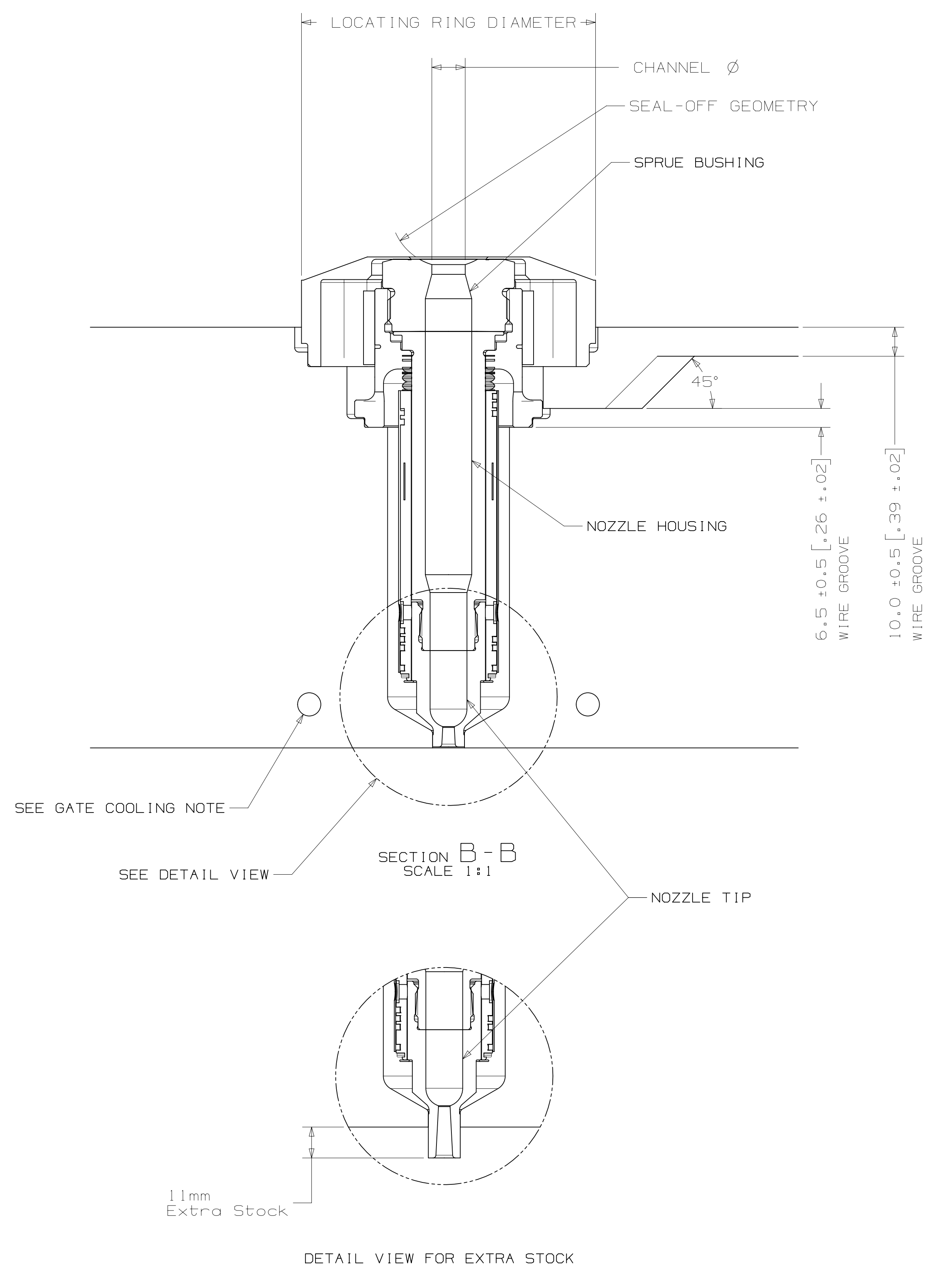
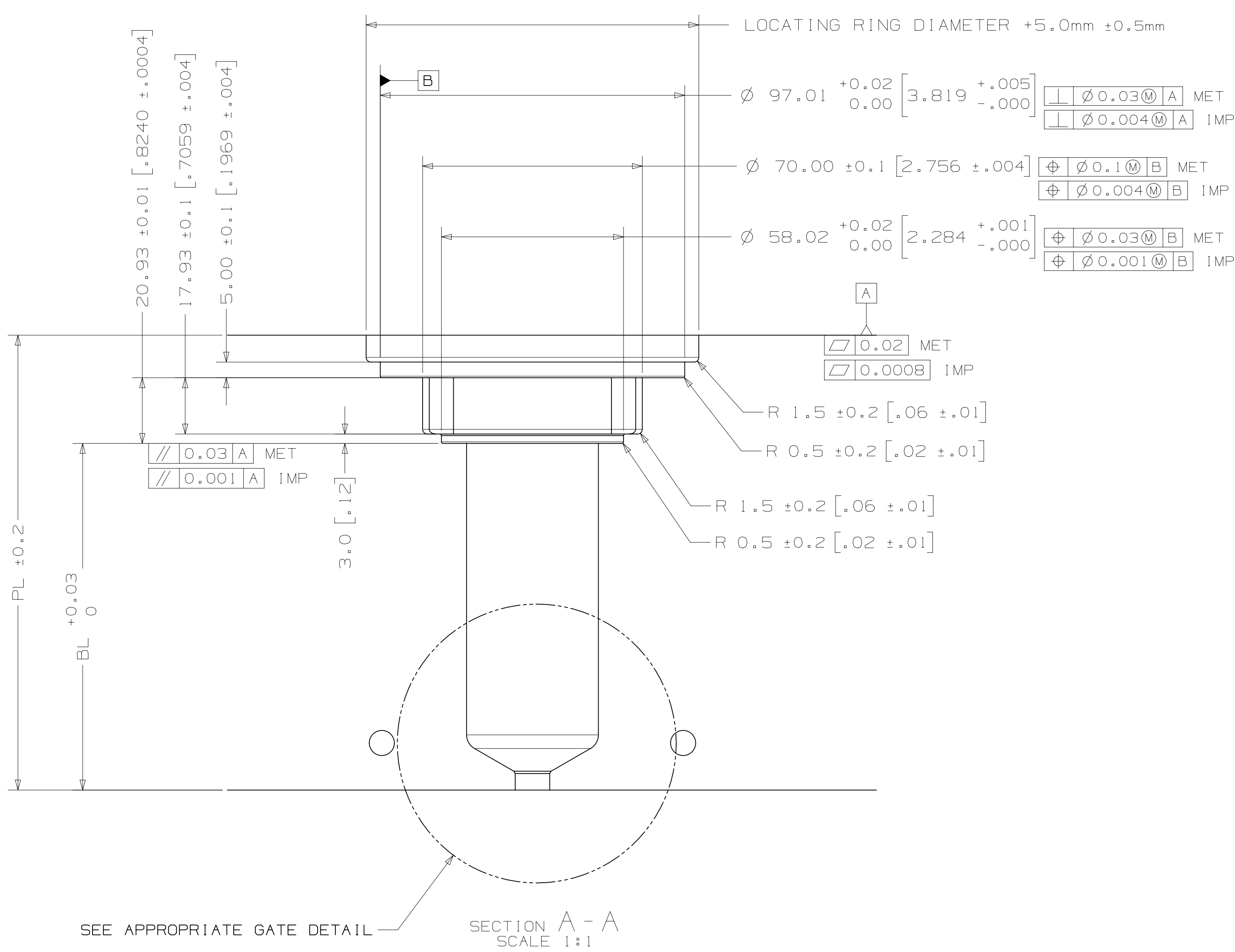
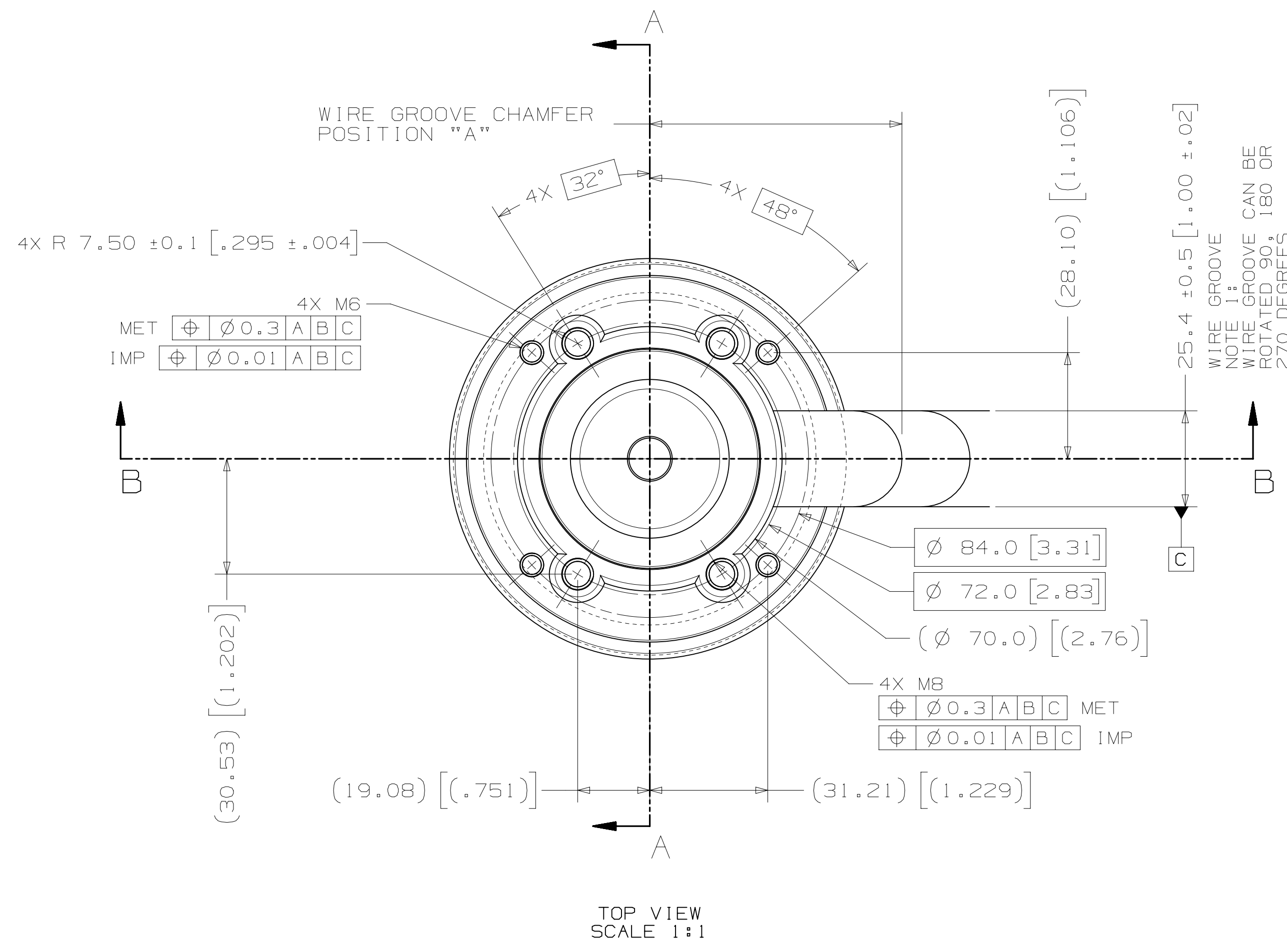


# INSTALLATION DRAWING

REV 0  
8150644



NOZZLE SERIES	NOZZLE TIP	NOZZLE HOUSING	PL	"BL" AT DELTA TEMP (DELTA TEMP = TEMP OF MELT - TEMP OF MOLD) *															
				MIN ( INCH )	MAX ( INCH )	80° 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-426° 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-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]			
		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]			
		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]			
		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]			
		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]			
		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]			
		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]			

\* 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	
	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.  
[www.husky-co.com](http://www.husky-co.com)

**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 DHANALEYAN	DRWN: DHANALEYAN	CHKD: PICHLER KLAUS

GENERAL TOLERANCES	METRIC	IMPERIAL
UNLESS OTHERWISE SPECIFIED	ISO 2768	ASME Y14.5
FINISHES	0.01	0.001
ROUNDED EDGES/CHAMFERS	R0.2 X 45°	R0.01 X 45°
FILLET/RADIUS	R0.5 ± 0.2	R0.03 ± 0.01
SURFACE FINISH	1.6	32

FOR TORQUE SPECIFICATIONS, REFER TO HS 252
WEIGHT - kg

METRIC	IMPERIAL	TITLE	SCALE	NO	SIZE	DRAWING	REV
		HOT SPRUE	AOR	1	2	8150644	0

