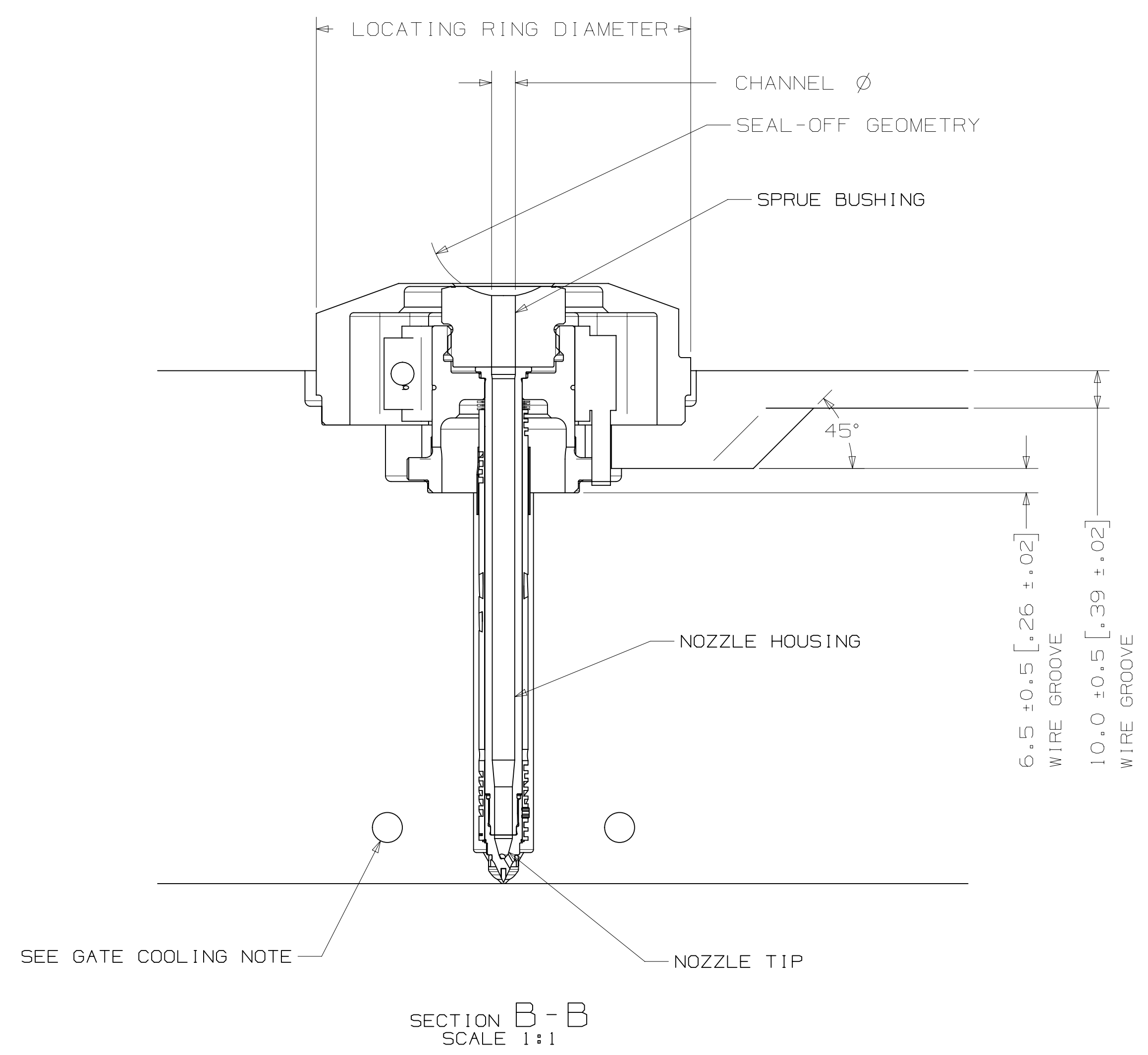
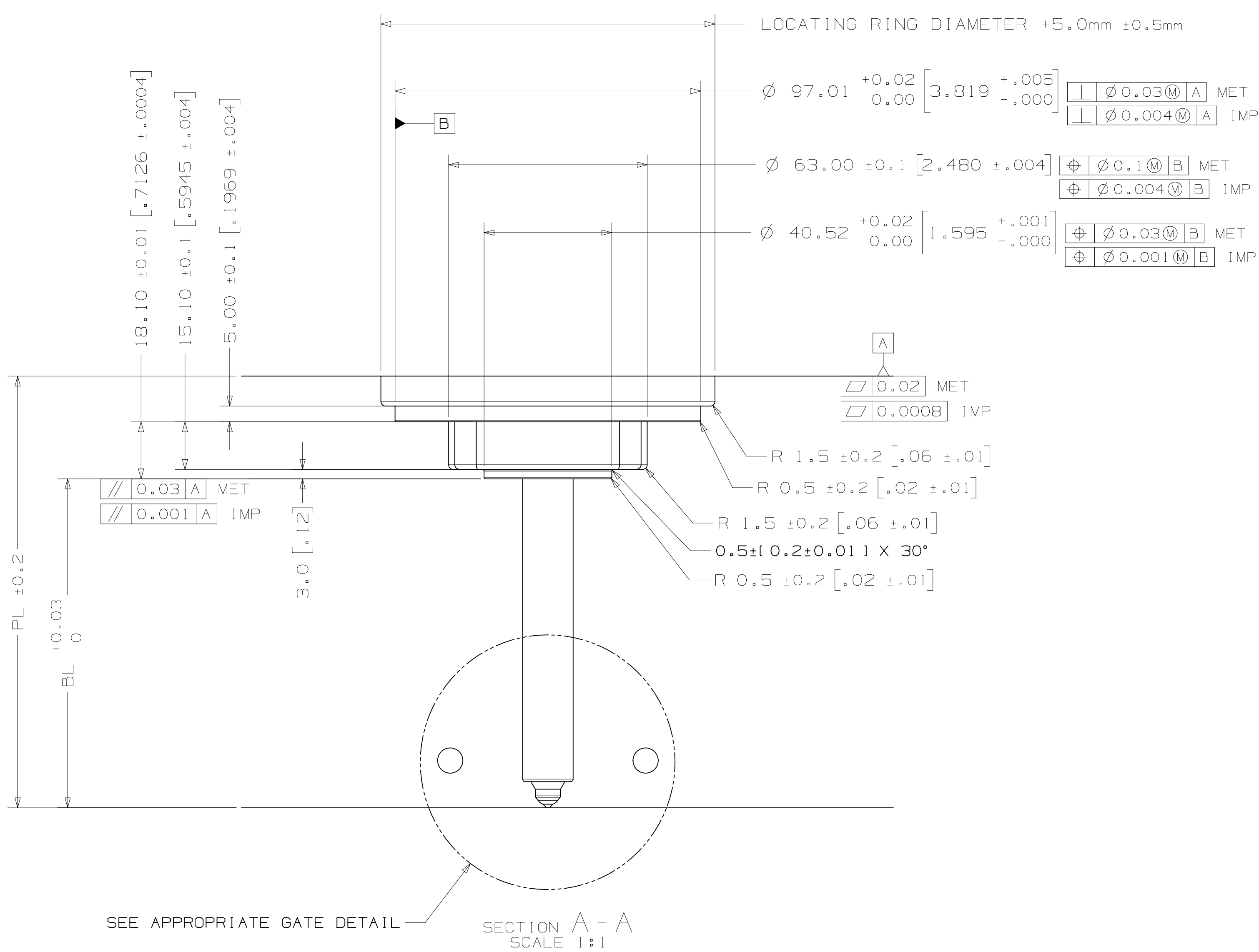
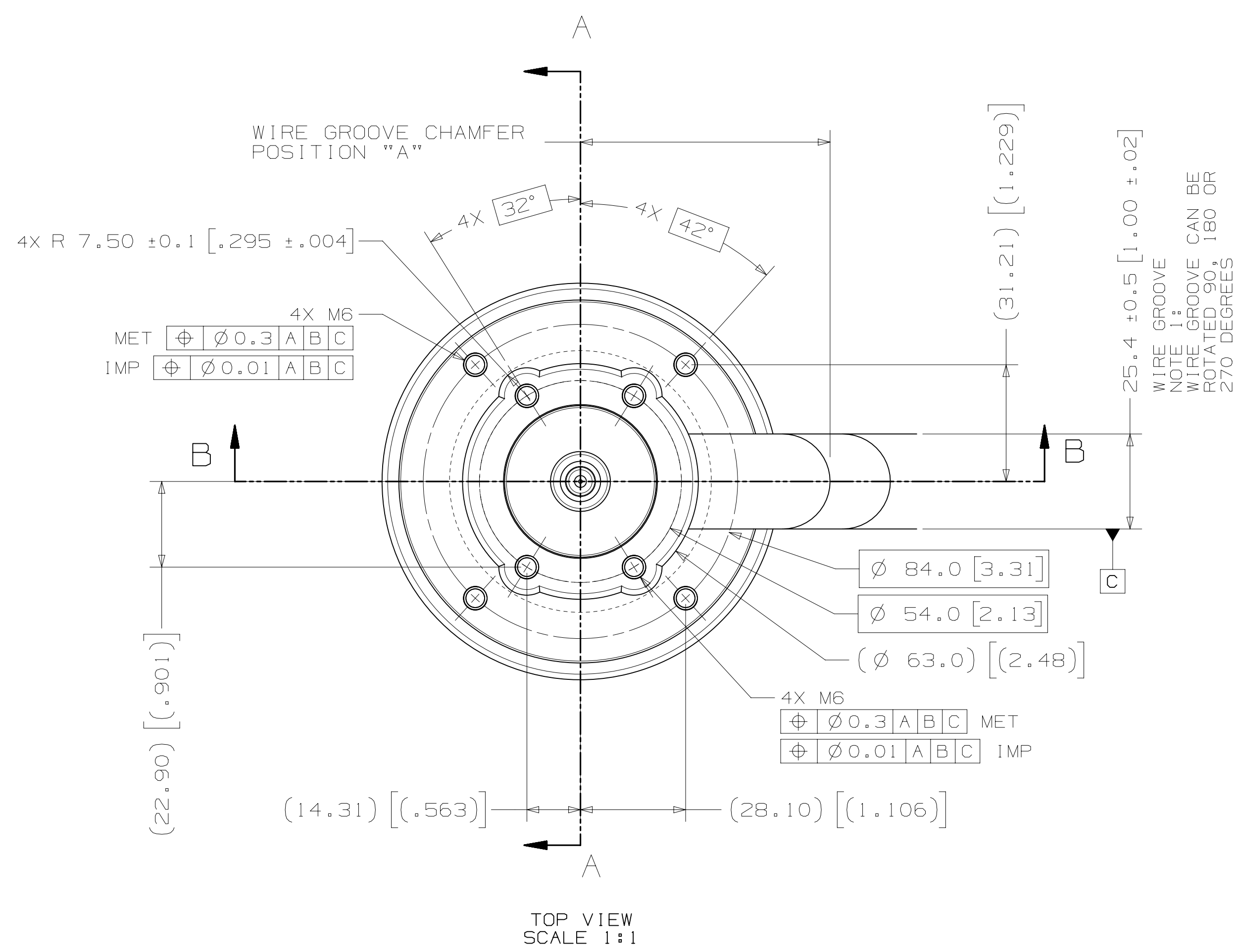


# INSTALLATION DRAWING

REV 0  
8144652



NOZZLE SERIES	NOZZLE TIP	PL RANGE	Approx. BL *
U350	HT-D	57.29(2.256) - 214.43(8.442)	35(1.38) - 174(6.85)

\* 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.

	LOCATING RING OUTER DIAMETER	WIRE GROOVE CHAMFER POSITION "A" (±2.0)
U350	100mm	66.7
	101.3mm (3.99")	66.7
	125mm	78.7

SPRUE BUSHING	
SEAL-OFF GEOMETRY	CHANNEL Ø IN - OUT
FLAT	4 - 6.35
FLAT	
SEAL-OFF 12.7 (1/2")	6.35 - THRU
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-cd.com](http://www.husky-cd.com)

**RECOMMENDED GATE MATERIAL**  
NOTE: THESE MATERIALS MAY NOT OFFER THE DESIRED RESISTANCE TO ABRASIVE AND/OR CORROSIVE RESINS, FILLERS AND/OR ADDITIVES  
AISI H13 (48-51 Rc)  
AISI 420 (48-51 Rc)

**RECOMMENDED GATE MANUFACTURING GUIDELINES**

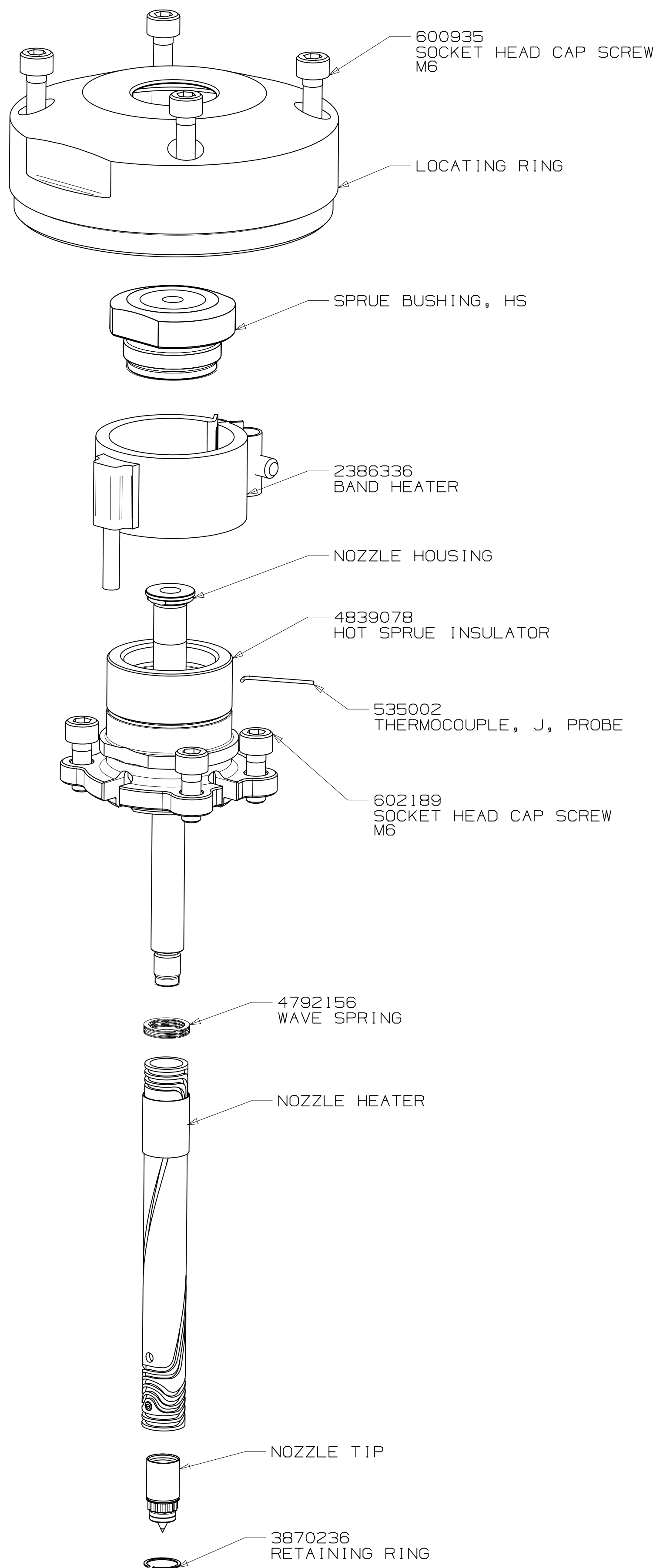
- HARDENED GATE INSERTS (48-51) ARE RECOMMENDED WHEN USING SOFTER CAVITY STEELS. SOFTER CAVITIES MAY BE ACCEPTABLE FOR CERTAIN APPLICATIONS. CONTACT YOUR HUSKY REPRESENTATIVE WITH QUESTIONS.
- EDM'ING THE GATE AREA CAUSES MICRO CRACKS WHICH LEAD TO BRITTLE GATE FAILURES. ALSO - DO NOT EDM THE MOLDING 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	DRWNG	CHKD
5	2020-05-26	TABLE UPDATED PER LATEST CALCULATION	DRWNG DEEBAN N T	CHKD
4	2019-07-09	TEMPLATE VALUES UPDATED AS PER SOL 2.0	DRWNG MURALI DHARAN	CHKD
3	2019-02-05	SINGLE CAVITY NAMEPLATE REMOVED	DRWNG ARJUN	CHKD
2	2018-05-20	DRAWING NAME CHANGED	DRWNG ANUSHAL	CHKD
0	2017-09-11	ORIGINAL ISSUE - DESIGNED BY: DHANANLEYAN	DRWNG DHANANLEYAN	CHKD: PICHLER KLAUS

COST PER KGM: 114.50-124.00 AND HEAVY ALUMINUM: 150.00 BASIC DIMENSIONS SPECIFIED CAD MODEL IS BASIC ANY DIMENSIONS CHANGING ARE BASIC GENERAL TOLERANCES: $\pm 0.17$ METRIC $\pm 0.017$ IMPERIAL BROKEN EDGES/CHAMFERS: $1.5 \pm 0.2 \times 45^\circ$ FILLET/RADIUS: R0.8 ± 0.2 R0.03 ± 0.01 SURFACE FINISH: Ra 3.2	FOR TORQUE SPECIFICATIONS, REFER TO HS 252	METRIC  IMPERIAL SCALE: NONE SHEET 1 OF 2 AOR	<b>HUSKY</b> TITLE: HOT SPRUE U350-HT-D SCALE: NONE SIZE: AOR DRAWING: 8144652 REV: 0
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# ASSEMBLY DRAWING

DRAWING 8144652 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 = (-)	
<b>RECOMMENDED GATE COOLING GUIDELINES</b> ADEQUATE COOLING IS ESSENTIAL FOR THE PROPER FUNCTION OF THIS SYSTEM. REFER TO THE HOT RUNNER PRODUCT GUIDE <a href="http://www.husky.cc">www.husky.cc</a> FOR MORE DETAILED GUIDELINES.	
<b>RECOMMENDED GATE MATERIAL</b> 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)	
<b>RECOMMENDED GATE MANUFACTURING GUIDELINES</b> - 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
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0	2017-09-11	ORIGINAL ISSUE - DESIGNED BY: DHANANJAYAN	DRWN: DHANANJAYAN CHKD: PICHLER KLAUS

FOR TORQUE SPECIFICATIONS, REFER TO HS 252

METRIC **HUSKY**  
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TITLE	SCALE	SIZE	DRAWING	REV
HOT SPRUE U350-HT-D	NONE	AIR	8144652	0
SHEET 2 OF 2				