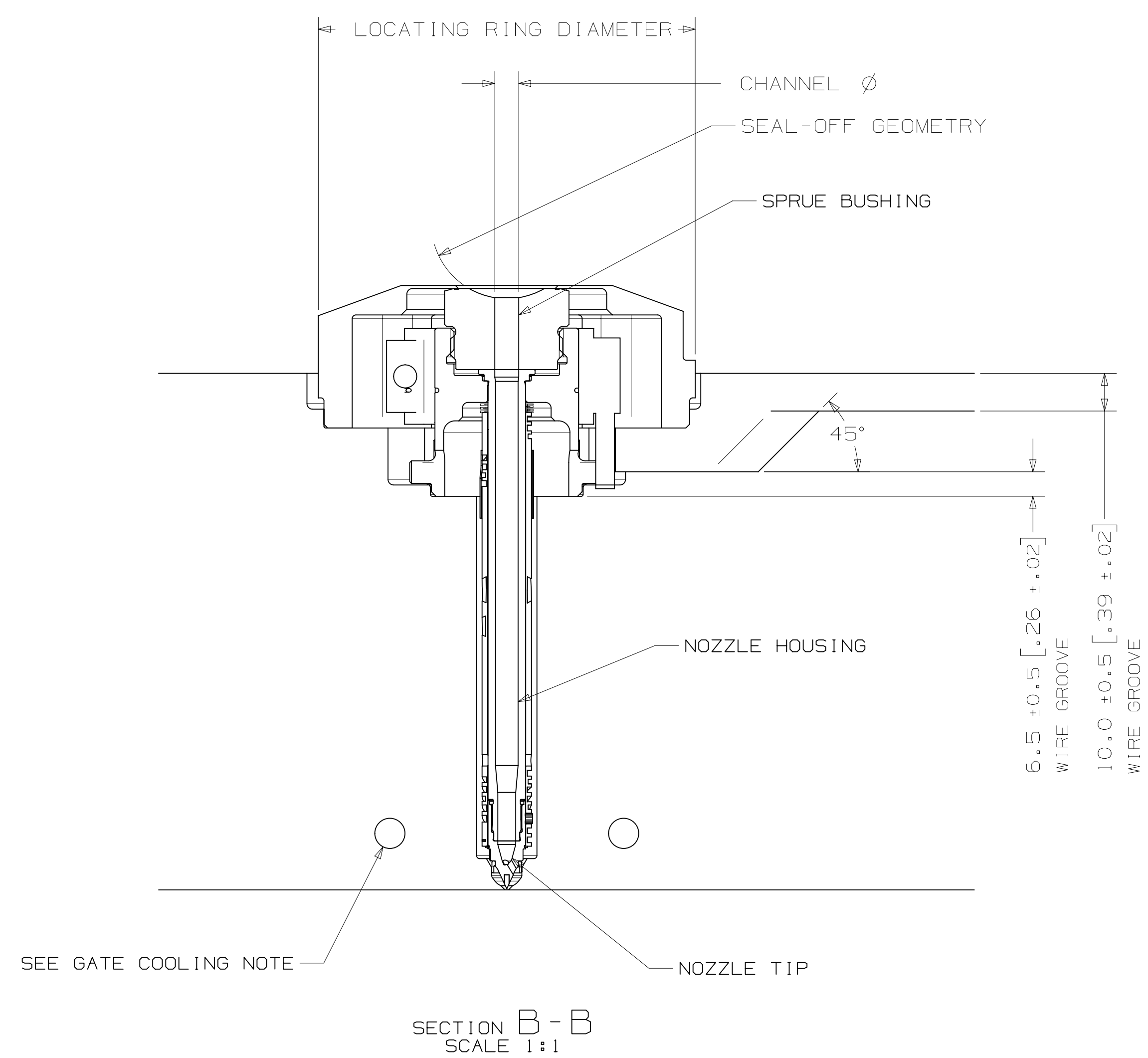
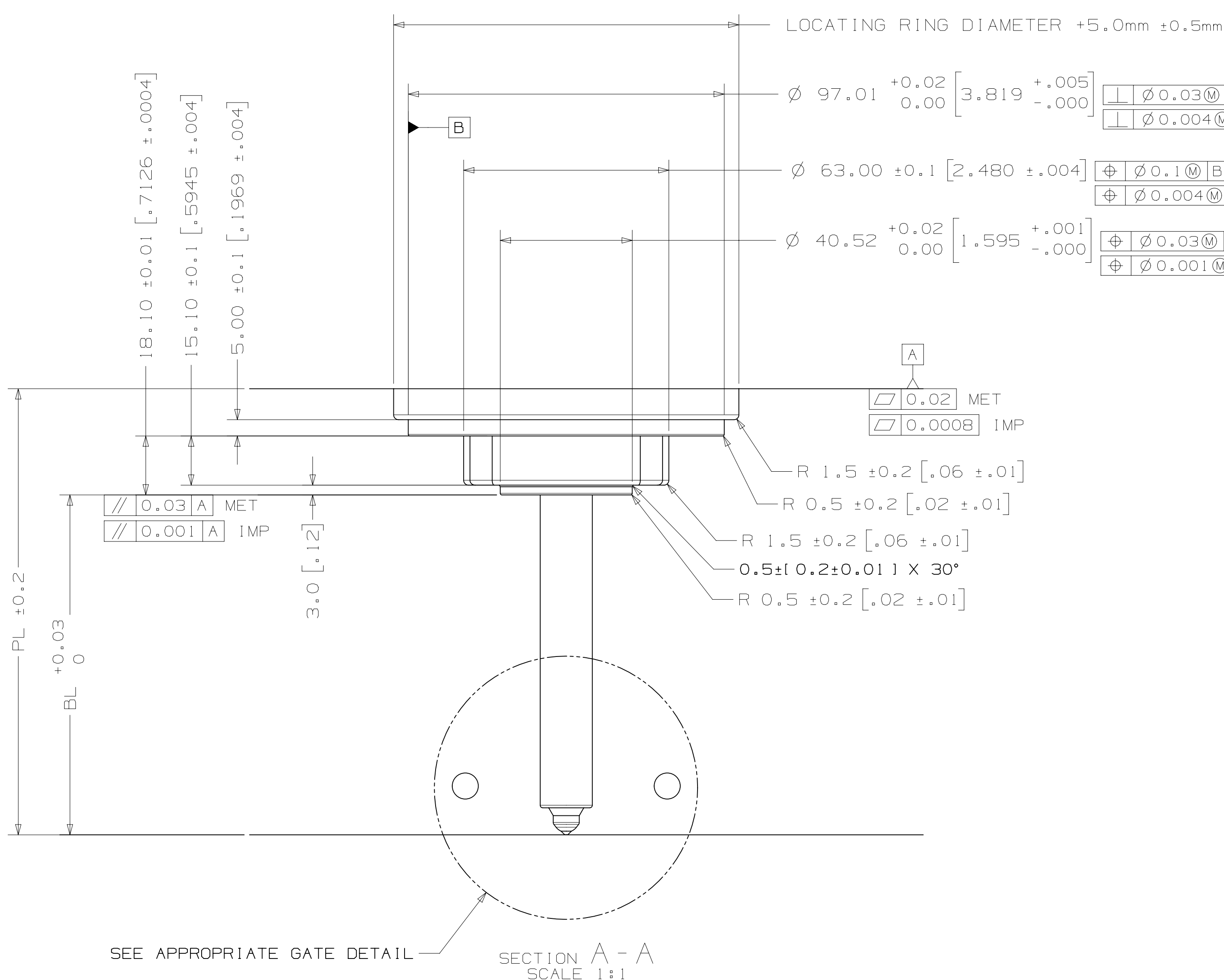
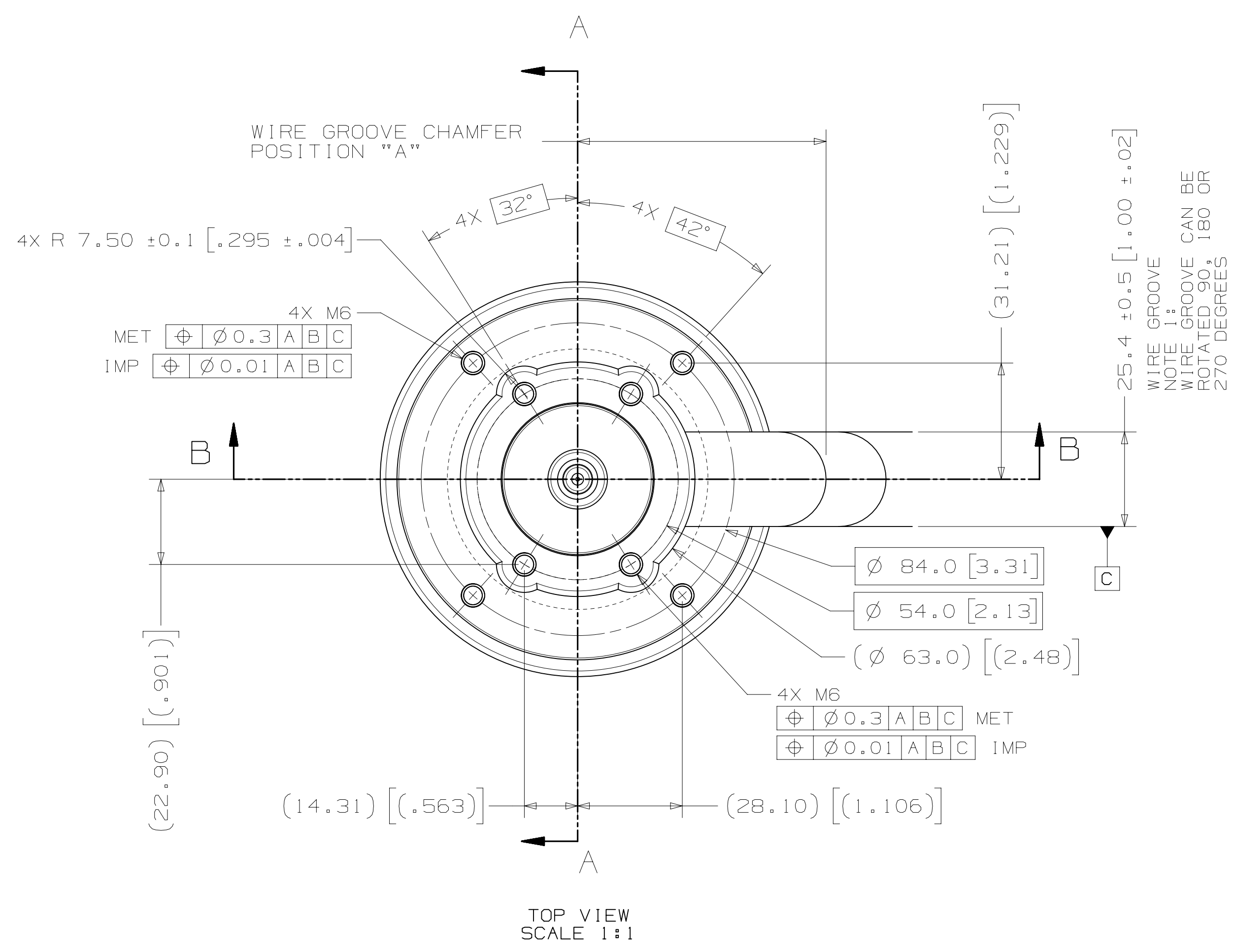


# INSTALLATION DRAWING

REV: 0  
STATUS: 8144652



NOZZLE SERIES	NOZZLE TIP	NOZZLE HOUSING	PL		"BL" AT DELTA TEMP (DELTA TEMP = TEMP OF MELT - TEMP OF MOLD) *																									
			MIN	INCH	MAX	INCH	60° C-79° C	110° F-174° F	80° C-99° C	110° F-210° F	100° C-119° C	212° F-245° 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	504° F-534° F	280° C-300° C	538° F-572° F
U350	HT-D	55	57	2.244	66	2.598	34.09	1.342	34.10	1.343	34.12	1.343	34.13	1.344	34.14	1.344	34.16	1.345	34.17	1.345	34.19	1.346	34.20	1.346	34.22	1.347	34.23	1.348	34.25	1.348
		65	67	2.638	76	2.992	44.10	1.736	44.11	1.737	44.13	1.737	44.14	1.738	44.16	1.739	44.18	1.739	44.19	1.740	44.21	1.741	44.23	1.741	44.24	1.742	44.27	1.743	44.28	1.743
		75	77	3.031	86	3.386	54.11	2.130	54.12	2.131	54.14	2.131	54.16	2.132	54.18	2.133	54.20	2.133	54.22	2.135	54.24	2.135	54.25	2.136	54.27	2.137	54.30	2.138	54.32	2.139
		85	87	3.425	96	3.780	64.11	2.524	64.13	2.525	64.15	2.526	64.17	2.526	64.19	2.527	64.22	2.528	64.24	2.529	64.26	2.530	64.28	2.531	64.30	2.531	64.33	2.533	64.35	2.533
		95	97	3.819	106	4.173	74.12	2.918	74.14	2.919	74.17	2.920	74.19	2.921	74.21	2.922	74.24	2.923	74.26	2.924	74.28	2.924	74.31	2.926	74.33	2.926	74.36	2.928	74.39	2.929
		105	107	4.213	116	4.567	84.13	3.312	84.15	3.313	84.18	3.314	84.20	3.315	84.23	3.316	84.26	3.317	84.28	3.318	84.31	3.319	84.34	3.320	84.36	3.321	84.40	3.323	84.42	3.324
		115	117	4.606	126	4.961	94.14	3.706	94.16	3.707	94.19	3.708	94.22	3.709	94.25	3.711	94.27	3.711	94.30	3.713	94.33	3.714	94.36	3.715	94.39	3.716	94.43	3.718	94.46	3.719
		125	127	5.000	136	5.354	104.14	4.100	104.17	4.101	104.20	4.102	104.23	4.104	104.26	4.105	104.29	4.106	104.33	4.107	104.36	4.109	104.39	4.110	104.42	4.111	104.46	4.113	104.49	4.114
		135	137	5.394	146	5.748	114.15	4.494	114.18	4.495	114.22	4.497	114.25	4.498	114.28	4.499	114.31	4.500	114.35	4.502	114.38	4.503	114.42	4.505	114.45	4.506	114.49	4.507	114.53	4.509
		145	147	5.787	156	6.142	124.16	4.888	124.19	4.889	124.23	4.891	124.26	4.892	124.30	4.894	124.33	4.895	124.37	4.898	124.41	4.899	124.44	4.899	124.48	4.901	124.53	4.903	124.56	4.904
		155	157	6.181	166	6.535	134.17	5.282	134.20	5.283	134.24	5.285	134.28	5.287	134.32	5.288	134.35	5.289	134.39	5.291	134.43	5.293	134.47	5.294	134.51	5.296	134.56	5.298	134.60	5.299
		165	167	6.575	177	6.969	144.18	5.676	144.21	5.678	144.25	5.679	144.29	5.681	144.33	5.682	144.37	5.684	144.41	5.685	144.46	5.687	144.50	5.689	144.54	5.691	144.59	5.693	144.63	5.694
		175	178	7.008	187	7.362	154.18	6.070	154.22	6.072	154.26	6.073	154.31	6.075	154.35	6.077	154.39	6.078	154.44	6.080	154.48	6.082	154.52	6.083	154.57	6.085	154.62	6.087	154.67	6.089
		185	188	7.402	197	7.756	164.19	6.464	164.23	6.466	164.28	6.468	164.32	6.469	164.37	6.471	164.41	6.473	164.46	6.475	164.50	6.476	164.55	6.478	164.60	6.480	164.65	6.482	164.70	6.484
195	198	7.795	208	8.189	174.20	6.858	174.24	6.860	174.29	6.862	174.34	6.864	174.38	6.865	174.43	6.867	174.48	6.869	174.53	6.871	174.58	6.873	174.63	6.875	174.69	6.878	174.74	6.880		

\* BL VALUES IN THE TABLE ARE REFERENCES WHICH CAN DEVIATE BY +/- 0.03mm  
FINAL BL VALUE CAN BE FOUND ON GATE DETAIL DRAWINGS AND 3D AFTER FINISHED DESIGN.

NOZZLE SERIES	LOCATING RING OUTER DIAMETER	WIRE GROOVE CHAMFER POSITION "A" (±2.0)	SPRUE BUSHING	
			SEAL-OFF GEOMETRY SPHERICAL RADIUS	CHANNEL Ø IN - OUT
U350	100mm	66.7	FLAT	4 - 6.35
	101.3mm [3.99"]	66.7	SEAL-OFF 12.7 [1/2"] SEAL-OFF 15.5	6.35 - THRU
	125mm	78.7	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.

**RECOMMENDED GATE MATERIAL**  
NOTE: THESE MATERIALS MAY NOT OFFER THE DESIRED RESISTANCE TO ABRASIVE AND/OR CORROSIVE RESISTANCE. CONTACT YOUR HUSKY REPRESENTATIVE WITH QUESTIONS.  
A151 H13 (48-5) Rc1  
A151 420 (48-5) Rc1

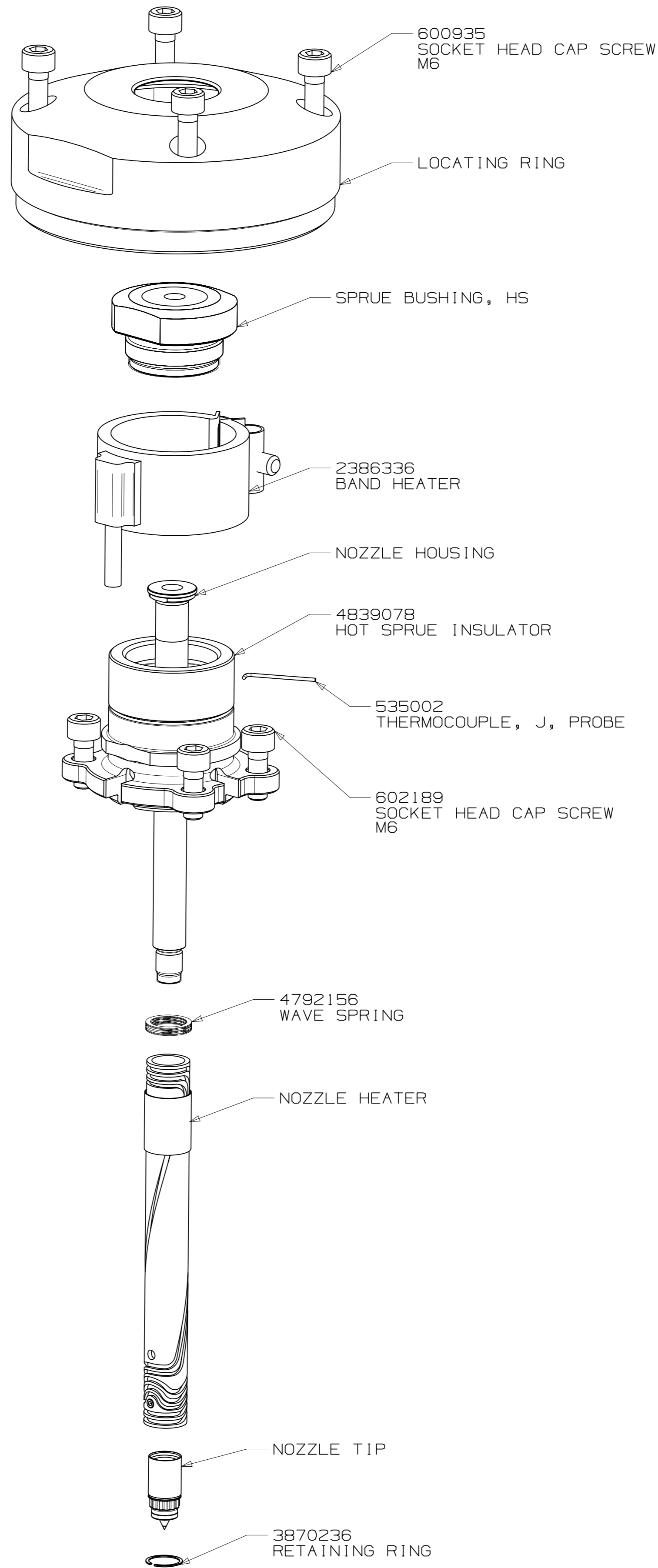
**RECOMMENDED GATE MANUFACTURING GUIDELINES**  
- HARDENED GATE INSERTS (48-5) ARE RECOMMENDED WHEN USING SOFTER CAVITY STEELS. SOFTER CAVITIES MAY BE ACCEPTABLE FOR CERTAIN APPLICATIONS. CONTACT YOUR HUSKY REPRESENTATIVE WITH QUESTIONS.  
- EDM'ING THE GATE AREA CAUSES MICRO CRACKS WHICH LEAD TO BRITTLE 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	2017-09-11	ORIGINAL ISSUE - DESIGNED BY DHANALEYAN	DRWN: DHANALEYAN	CHKD: PICHLER KLAUS

<p>FOR TORQUE SPECIFICATIONS, REFER TO HS 252</p> <p>WEIGHT - kg</p>	<p>METRIC</p> <p>SCALE NONE</p> <p>SIZE AOR</p> <p>DRAWING 8144652</p> <p>REV 0</p>
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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 = (-)	
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)	
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.	

DRWN:	
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DRWN:	
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DRWN:	
CHKD:	
DRWN:	
CHKD:	
DRWN:	
CHKD:	
0	2017-09-11 ORIGINAL ISSUE - DESIGNED BY: DHANANJEYAN
REV	DATE DESCRIPTION NAME

FOR TORQUE SPECIFICATIONS, REFER TO HS 252		METRIC		<b>HUSKY</b>	
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, DISCLOSED OR USED, IN WHOLE OR IN PART, WITHOUT THE PRIOR WRITTEN CONSENT OF HUSKY.		TITLE		HOT SPRUE U350-HT-D	
WEIGHT	- kg	SCALE	NONE	SIZE	AIR
		SHEET	2 OF 2	DRAWING	8144652
				REV	0