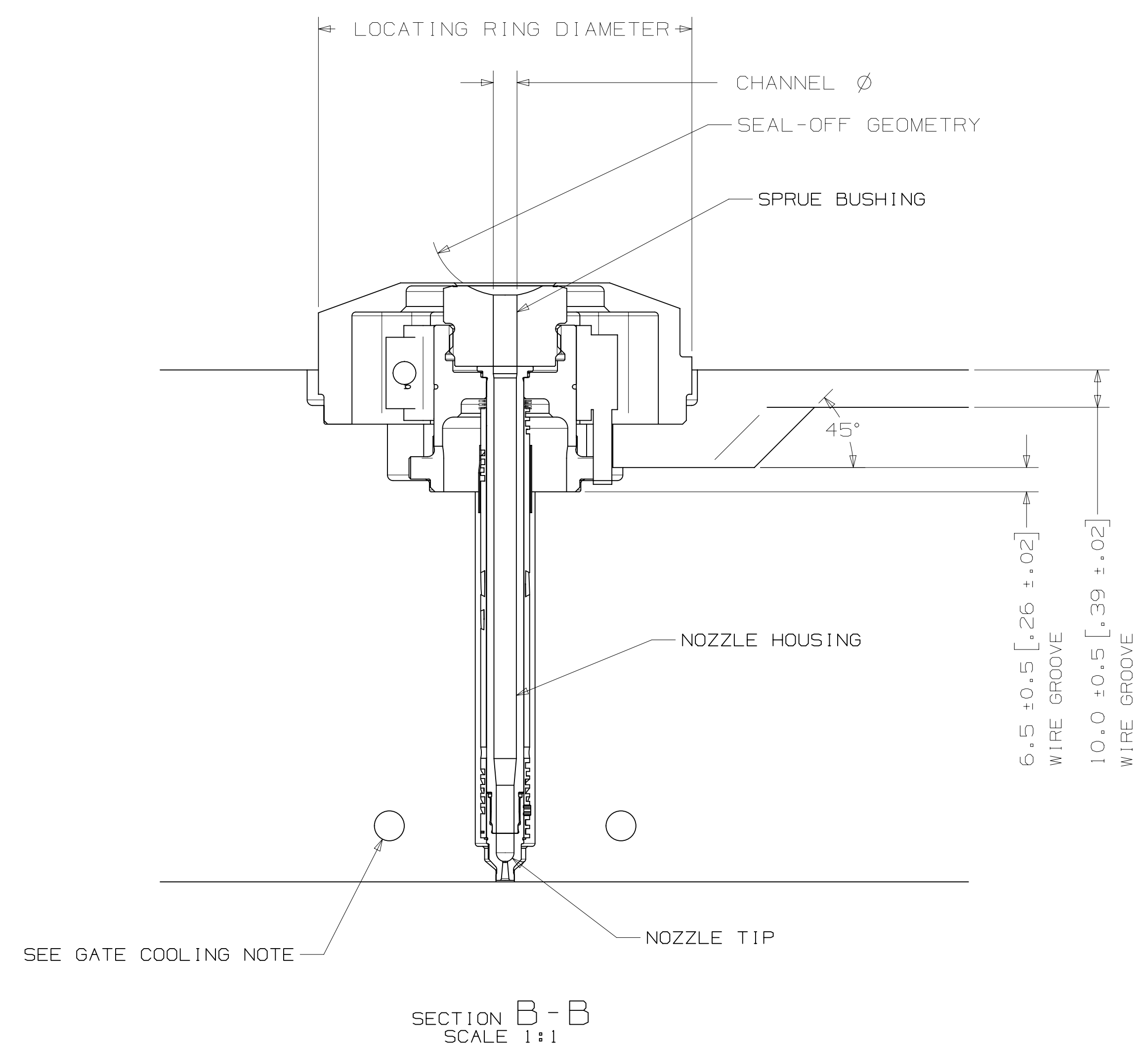
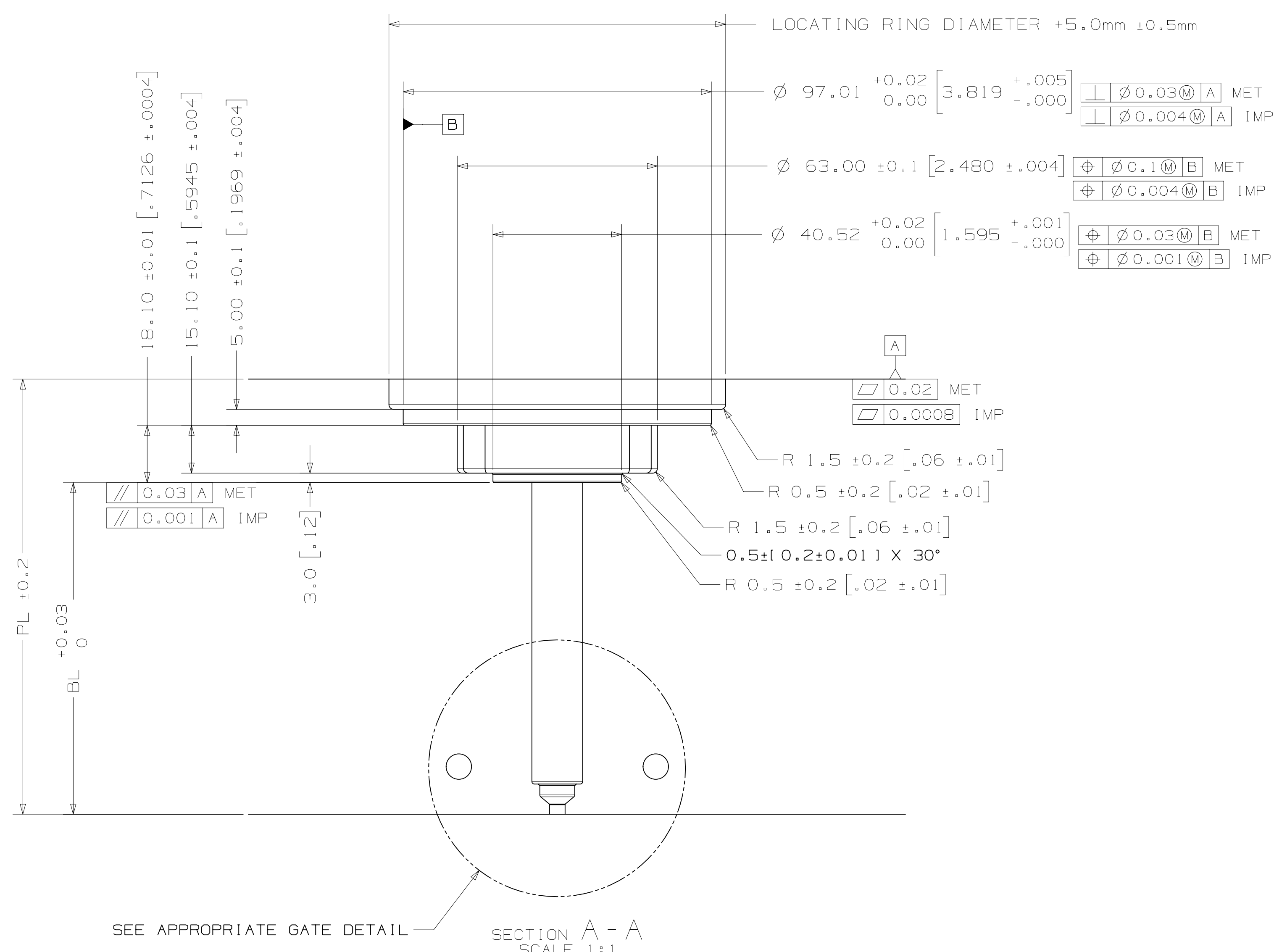
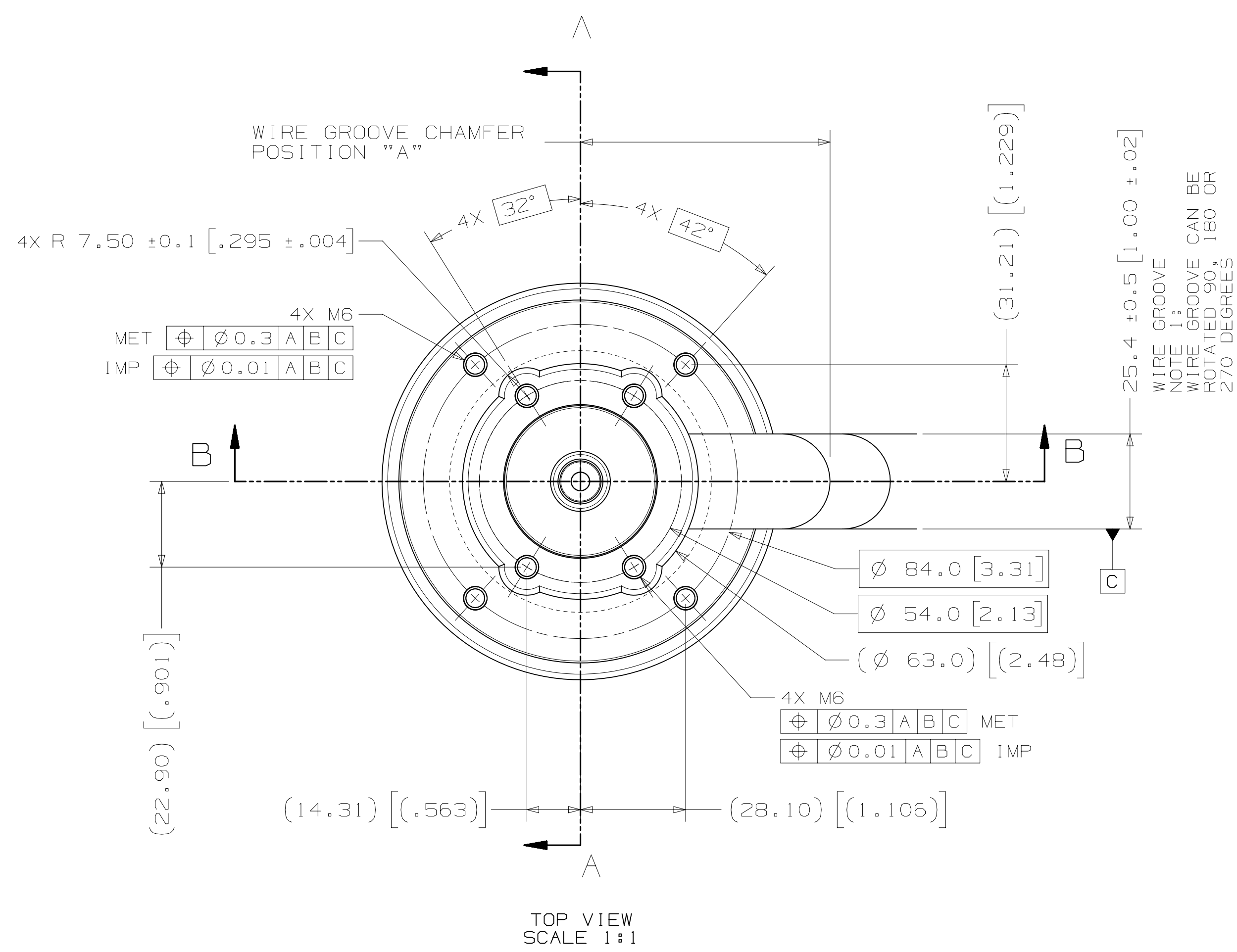


INSTALLATION DRAWING

REV: 0
STATUS: 8146354



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 (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)		
U350	HT-TS	55	57 (2.244)	66 (2.598)	34.09 (1.342)	34.10 (1.343)	34.11 (1.343)	34.12 (1.343)	34.14 (1.344)	34.15 (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)			
		65	67 (2.638)	76 (2.992)	44.09 (1.736)	44.11 (1.737)	44.12 (1.737)	44.14 (1.738)	44.15 (1.738)	44.17 (1.739)	44.18 (1.739)	44.20 (1.740)	44.21 (1.741)	44.23 (1.741)	44.25 (1.742)	44.27 (1.743)			
		75	77 (3.031)	86 (3.386)	54.10 (2.130)	54.12 (2.131)	54.13 (2.131)	54.15 (2.132)	54.17 (2.133)	54.19 (2.133)	54.20 (2.134)	54.22 (2.135)	54.24 (2.135)	54.26 (2.136)	54.28 (2.137)	54.30 (2.138)			
		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)	64.21 (2.528)	64.23 (2.529)	64.25 (2.530)	64.27 (2.530)	64.29 (2.531)	64.31 (2.532)	64.34 (2.533)			
		95	97 (3.819)	106 (4.173)	74.12 (2.918)	74.14 (2.919)	74.16 (2.920)	74.18 (2.920)	74.20 (2.921)	74.23 (2.922)	74.25 (2.923)	74.27 (2.924)	74.30 (2.925)	74.32 (2.926)	74.35 (2.927)	74.37 (2.928)			
		105	107 (4.213)	116 (4.567)	84.13 (3.312)	84.15 (3.313)	84.17 (3.314)	84.20 (3.315)	84.22 (3.316)	84.25 (3.317)	84.27 (3.318)	84.30 (3.319)	84.32 (3.320)	84.35 (3.321)	84.38 (3.322)	84.41 (3.323)			
		115	117 (4.606)	126 (4.961)	94.13 (3.708)	94.16 (3.707)	94.18 (3.708)	94.21 (3.709)	94.24 (3.710)	94.26 (3.711)	94.29 (3.712)	94.32 (3.713)	94.35 (3.715)	94.38 (3.716)	94.41 (3.717)	94.44 (3.718)			
		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)	104.28 (4.106)	104.31 (4.107)	104.35 (4.108)	104.38 (4.109)	104.41 (4.111)	104.44 (4.112)	104.48 (4.113)			
		135	137 (5.394)	146 (5.748)	114.15 (4.494)	114.18 (4.495)	114.21 (4.496)	114.24 (4.498)	114.27 (4.499)	114.30 (4.500)	114.34 (4.502)	114.37 (4.503)	114.40 (4.504)	114.44 (4.506)	114.48 (4.507)	114.51 (4.508)			
		145	147 (5.787)	156 (6.142)	124.16 (4.888)	124.19 (4.889)	124.22 (4.891)	124.25 (4.892)	124.29 (4.893)	124.32 (4.894)	124.36 (4.896)	124.39 (4.897)	124.43 (4.899)	124.47 (4.900)	124.51 (4.902)	124.55 (4.904)			
		155	157 (6.181)	166 (6.535)	134.16 (5.282)	134.20 (5.283)	134.23 (5.285)	134.27 (5.286)	134.31 (5.288)	134.34 (5.289)	134.38 (5.291)	134.42 (5.292)	134.46 (5.294)	134.50 (5.295)	134.54 (5.297)	134.58 (5.298)			
		165	167 (6.575)	177 (6.969)	144.17 (5.676)	144.21 (5.678)	144.25 (5.679)	144.28 (5.680)	144.32 (5.682)	144.36 (5.683)	144.40 (5.685)	144.44 (5.687)	144.48 (5.688)	144.53 (5.690)	144.57 (5.692)	144.62 (5.694)			
		175	178 (7.008)	187 (7.362)	154.18 (6.070)	154.22 (6.072)	154.26 (6.073)	154.30 (6.075)	154.34 (6.076)	154.38 (6.078)	154.42 (6.080)	154.47 (6.081)	154.51 (6.083)	154.55 (6.085)	154.61 (6.087)	154.65 (6.089)			
		185	188 (7.402)	197 (7.756)	164.19 (6.464)	164.23 (6.466)	164.27 (6.467)	164.31 (6.469)	164.36 (6.471)	164.40 (6.472)	164.45 (6.474)	164.49 (6.476)	164.54 (6.478)	164.58 (6.480)	164.64 (6.482)	164.69 (6.484)			
195	198 (7.795)	208 (8.189)	174.20 (6.858)	174.24 (6.860)	174.28 (6.861)	174.33 (6.863)	174.38 (6.865)	174.42 (6.867)	174.47 (6.869)	174.52 (6.871)	174.57 (6.873)	174.61 (6.874)	174.67 (6.877)	174.72 (6.879)					

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

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

NOZZLE SERIES	SEAL-OFF GEOMETRY SPHERICAL RADIUS	CHANNEL Ø IN - OUT
U350	FLAT	4 - 6.35
	FLAT	6.35 - THRU
	SEAL-OFF 12.7 (1/2")	
	SEAL-OFF 15.5	
	SEAL-OFF 19.05 (3/4")	

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 (48-51 Rc)
A151 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	DRWN	CHKD
0	2017-09-12	ORIGINAL ISSUE - DESIGNED BY DHANALEYAN	DRWN: DHANALEYAN	CHKD: PICHLER KLAUS

GENERAL TOLERANCES	METRIC	IMPERIAL
UNLESS OTHERWISE SPECIFIED	ISO 2768	ASME Y14.5
FINISHES	RA 1.6	RA 32

FOR TORQUE SPECIFICATIONS, REFER TO HS 252
WEIGHT

METRIC	IMPERIAL	TITLE	SCALE	NO. OF SHEETS	SHEET NO.	DATE	REV
		HOT SPRUE	1:1	2	2	0	0

