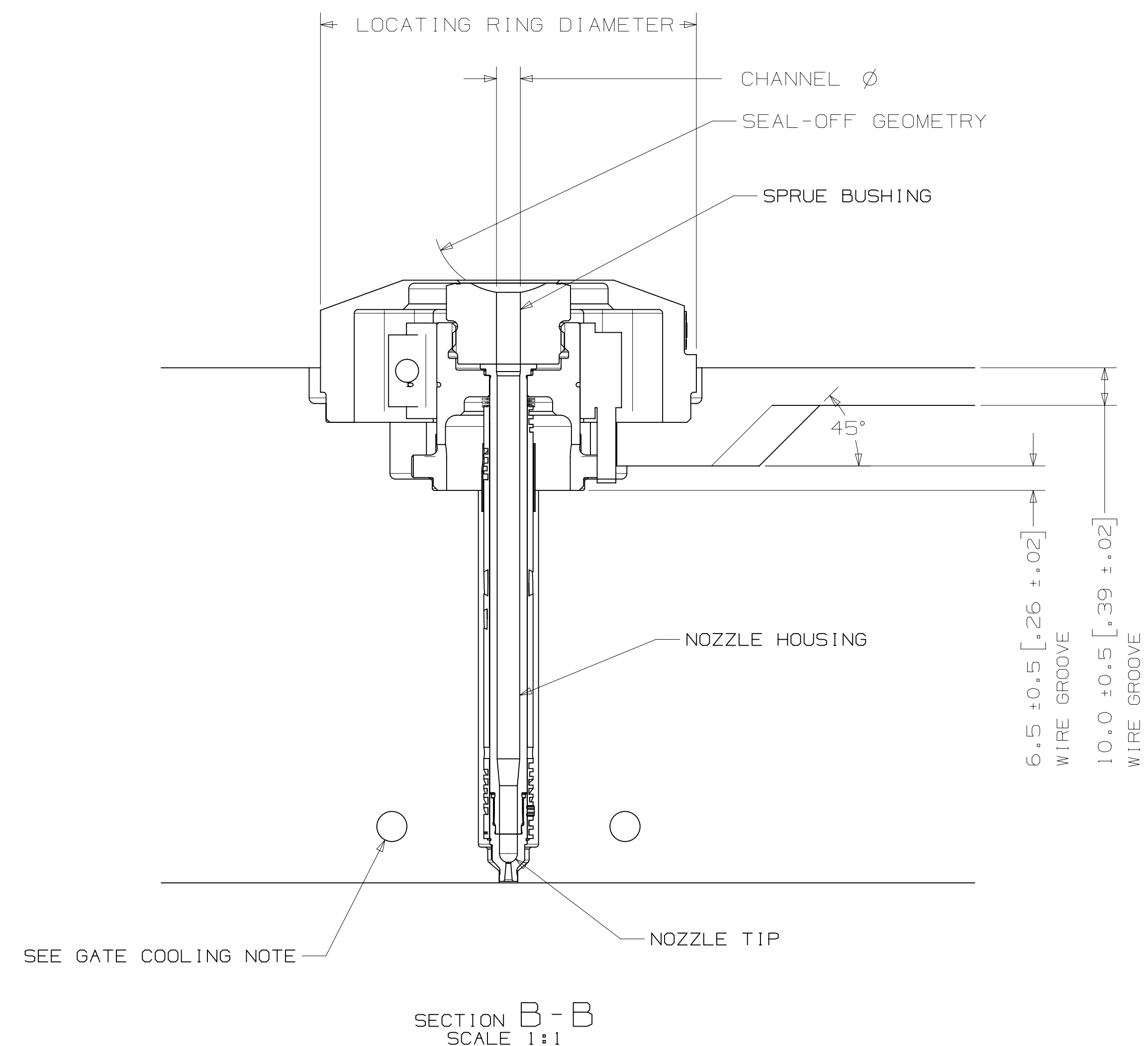
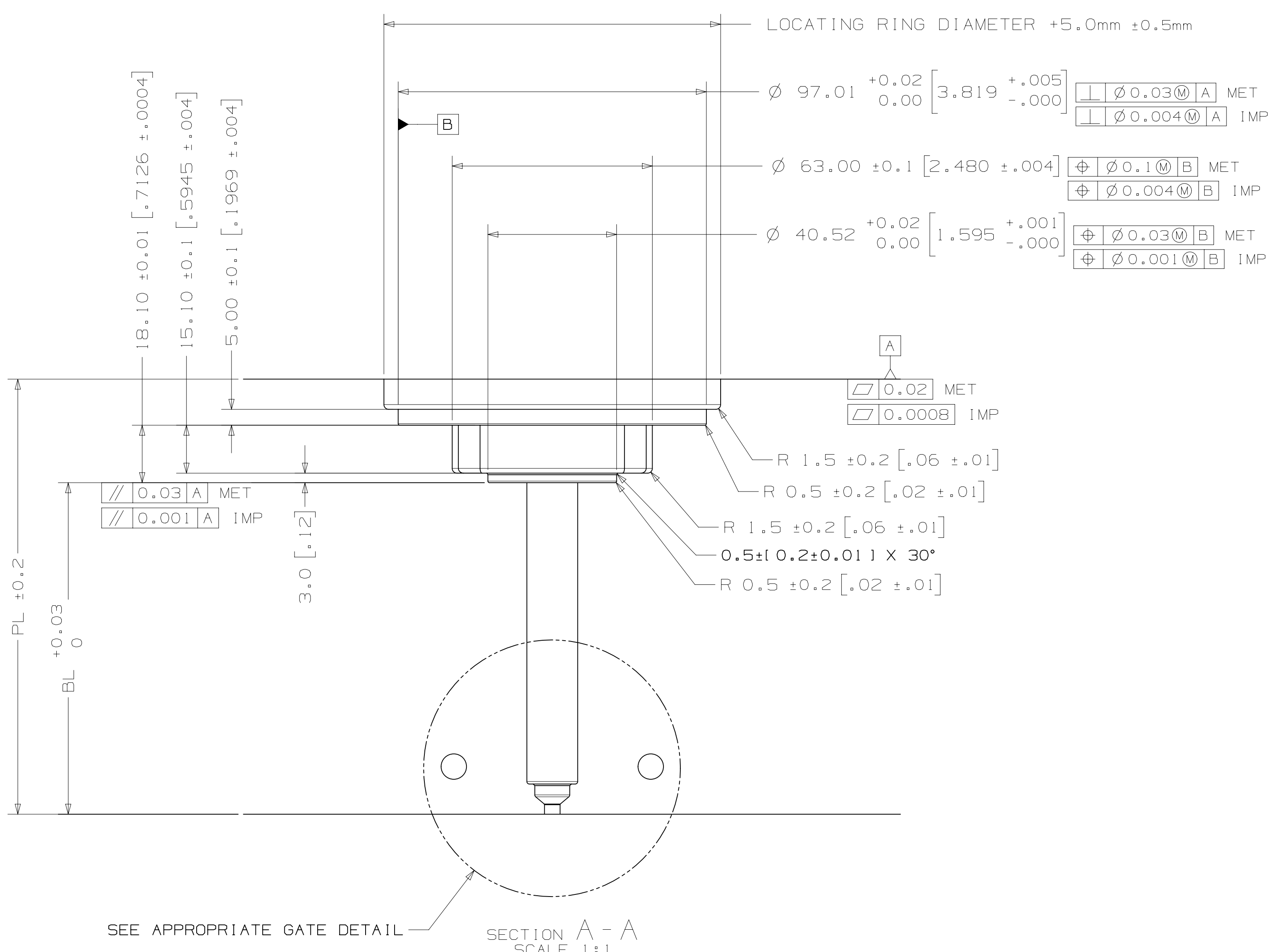
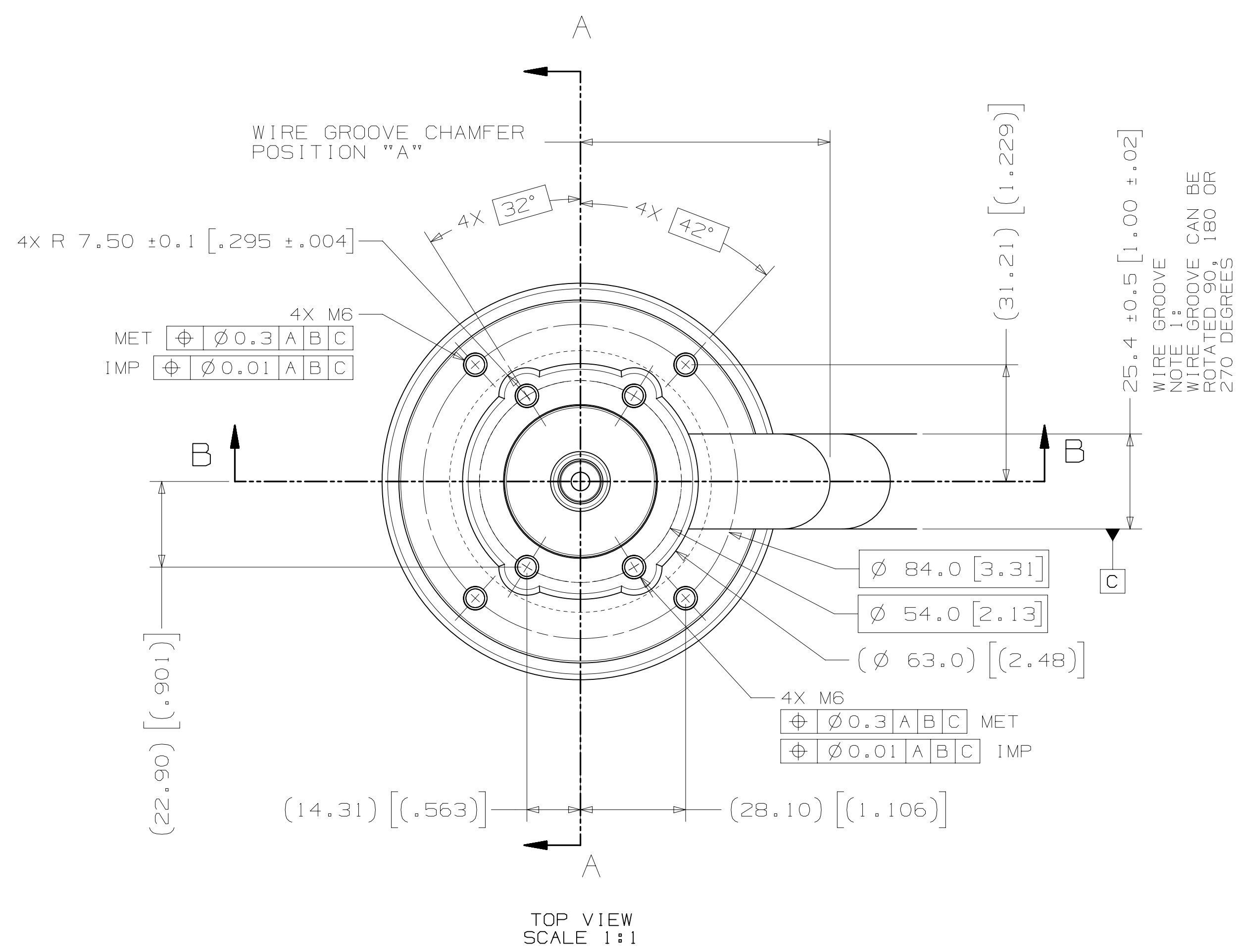


# INSTALLATION DRAWING

STATUS: 8146354 0



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 FOUND 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	FLAT	4 - 6.35
	SEAL-OFF 12.7 [1/2"]	FLAT	6.35 - THRU
	SEAL-OFF 15.5	FLAT	
	SEAL-OFF 19.05 [3/4"]	FLAT	
	SEAL-OFF 20	FLAT	
	SEAL-OFF 40	FLAT	

**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

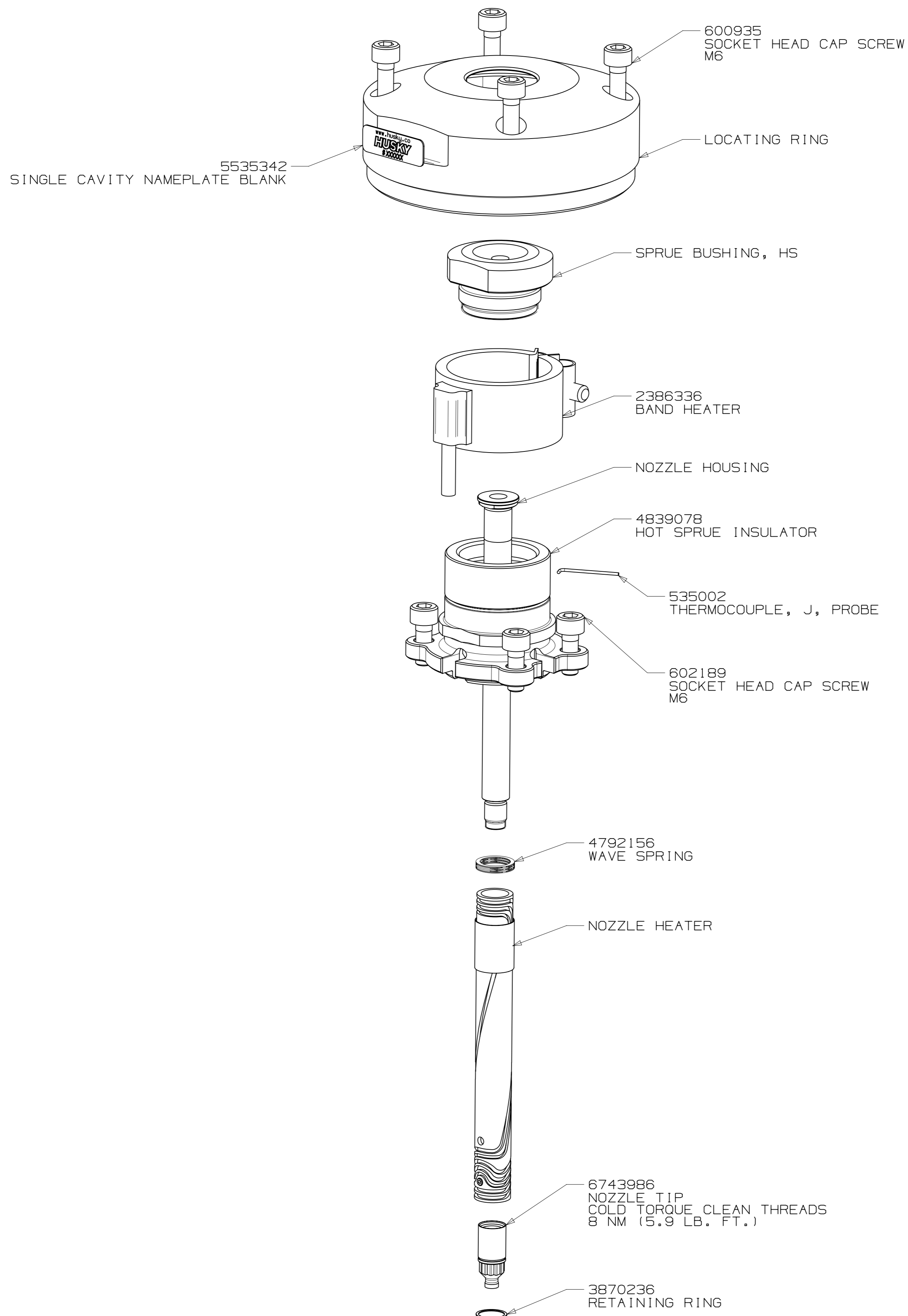
GENERAL TOLERANCES	METRIC	IMPERIAL
ISO 1101	0.15, 0.3, 0.6, 1.2, 2.5, 5, 10, 20, 40, 80, 150, 300, 600, 1200, 2500, 5000, 10000	0.004, 0.008, 0.015, 0.03, 0.06, 0.12, 0.25, 0.5, 1, 2, 5, 10, 20, 50, 100, 200, 500, 1000

FOR TORQUE SPECIFICATIONS, REFER TO HS 252
WEIGHT - kg

METRIC	HUSKY	TITLE	SCALE	NO	SIZE	DRAWING	REV
		HOT SPRUE	1:1	U350-HT-TS	AOR	8146354	0

# ASSEMBLY DRAWING

REV 0  
DRAWING 8146354



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.  
[www.husky.cc](http://www.husky.cc)

RECOMMENDED GATE MATERIAL  
NOTE: THESE MATERIALS MAY NOT OFFER THE DESIRED RESISTANCE TO ABRASIVE AND/OR CORROSIVE RESINS, FILLERS AND/OR ADDITIVES  
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- WELDING THE GATE AREA INCREASES STRESSES AT THE GATE, SOFTENS THE AREA AROUND THE WELD AND CAN CAUSE GATE FAILURES.

REV	DATE	DESCRIPTION	NAME
0	2017-09-12	ORIGINAL ISSUE - DESIGNED BY: DHANANJEYAN	DRWN: DHANANJEYAN CHKD: PICHLER, KLAUS

FOR TORQUE SPECIFICATIONS, REFER TO HS 252		METRIC		<b>HUSKY</b>	
WEIGHT - kg		TITLE HOT SPRUE U350-HT-TS		SCALE NONE SIZE AIR DRAWING 8146354 REV 0	
		SHEET 2 OF 2			