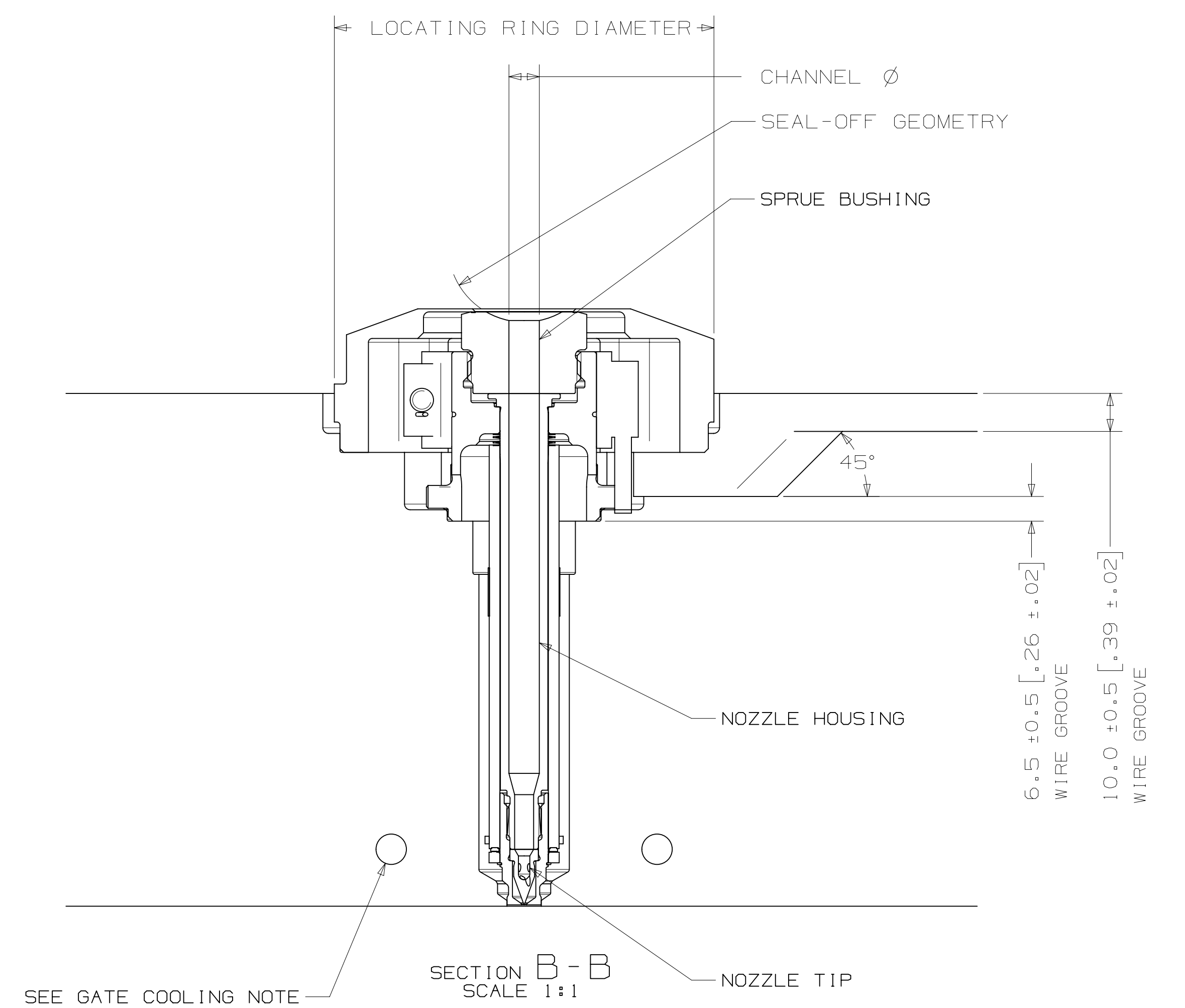
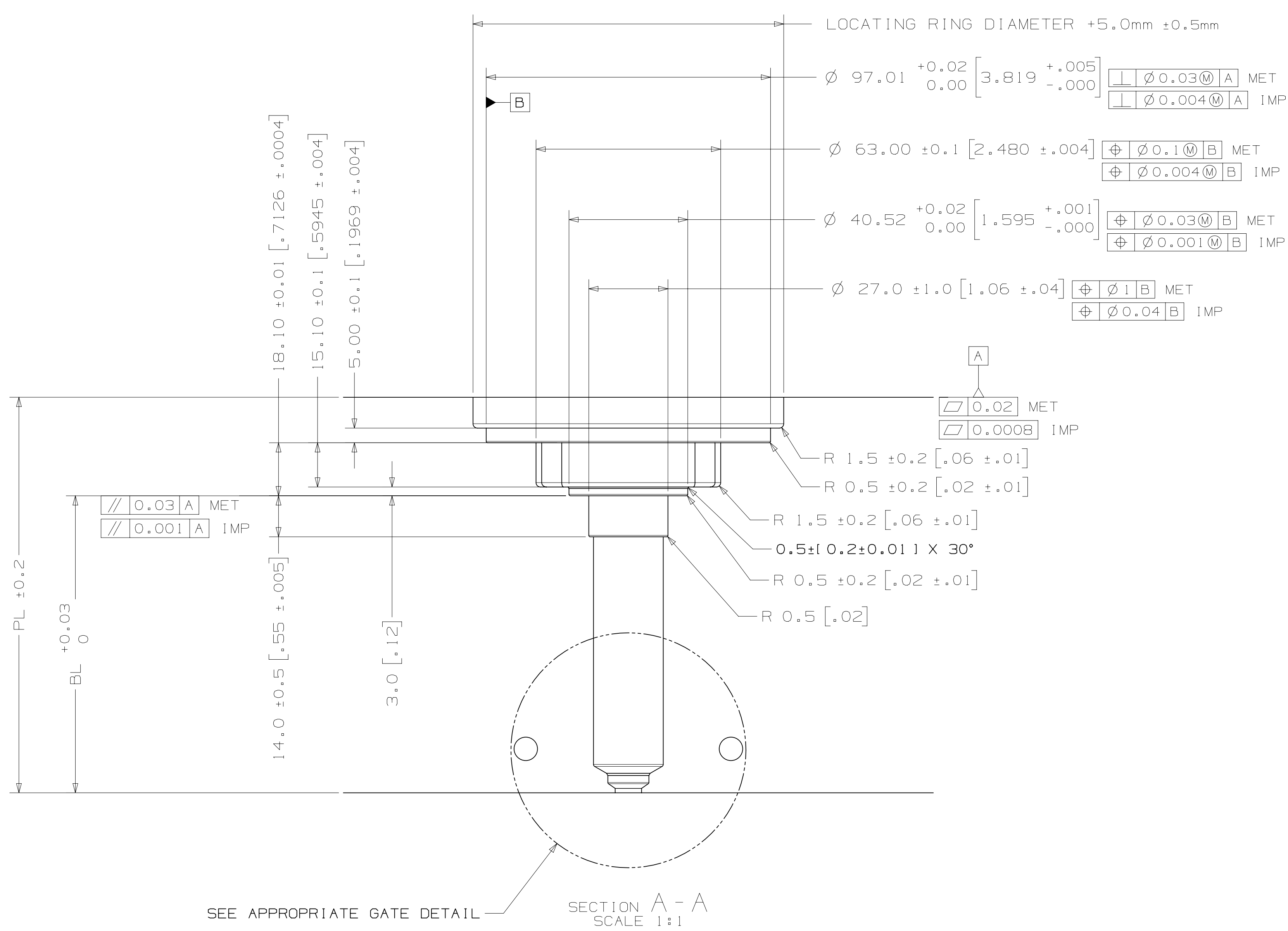
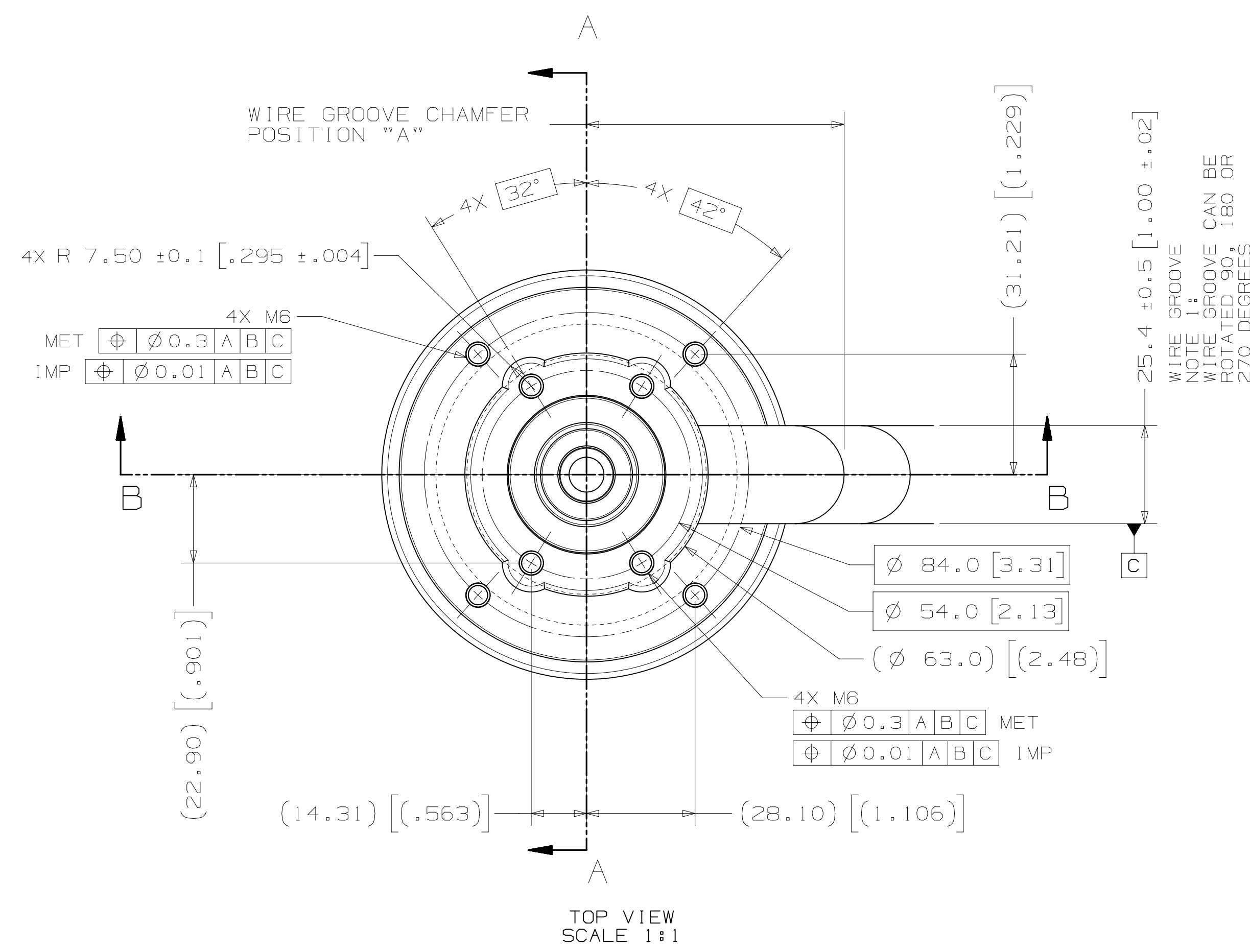


# INSTALLATION DRAWING

REV: 0  
STATUS: 8093686



NOZZLE SERIES	NOZZLE TIP	NOZZLE HOUSING	PL		"BL" AT DELTA TEMP (DELTA TEMP = TEMP OF MELT - TEMP OF MOLD) *																			
			LENGTH	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							
U500	HT-CAP	50	54 (2.126)	63 (2.480)	31.09 (1.224)	31.10 (1.224)	31.12 (1.225)	31.13 (1.226)	31.14 (1.226)	31.15 (1.226)	31.16 (1.227)	31.17 (1.227)	31.18 (1.228)	31.20 (1.228)	31.21 (1.229)	31.22 (1.229)								
		60	64 (2.520)	73 (2.874)	41.10 (1.618)	41.11 (1.619)	41.13 (1.619)	41.14 (1.620)	41.15 (1.620)	41.17 (1.621)	41.18 (1.621)	41.20 (1.622)	41.21 (1.622)	41.23 (1.623)	41.24 (1.624)	41.26 (1.624)								
		70	74 (2.913)	83 (3.268)	51.11 (2.012)	51.12 (2.013)	51.14 (2.013)	51.16 (2.014)	51.17 (2.015)	51.19 (2.015)	51.20 (2.016)	51.22 (2.017)	51.24 (2.017)	51.26 (2.018)	51.28 (2.019)	51.29 (2.019)								
		80	84 (3.307)	93 (3.661)	61.12 (2.406)	61.13 (2.407)	61.15 (2.407)	61.17 (2.408)	61.19 (2.409)	61.21 (2.410)	61.23 (2.411)	61.25 (2.411)	61.27 (2.412)	61.28 (2.413)	61.31 (2.414)	61.33 (2.415)								
		90	94 (3.701)	103 (4.055)	71.12 (2.800)	71.14 (2.801)	71.16 (2.802)	71.19 (2.803)	71.21 (2.804)	71.23 (2.804)	71.25 (2.805)	71.27 (2.806)	71.29 (2.807)	71.31 (2.807)	71.34 (2.809)	71.36 (2.809)								
		100	104 (4.094)	113 (4.449)	81.13 (3.194)	81.15 (3.195)	81.18 (3.196)	81.20 (3.197)	81.22 (3.198)	81.25 (3.199)	81.27 (3.200)	81.30 (3.201)	81.32 (3.202)	81.34 (3.202)	81.37 (3.204)	81.40 (3.205)								
		110	114 (4.488)	123 (4.843)	91.14 (3.588)	91.16 (3.589)	91.19 (3.590)	91.21 (3.591)	91.24 (3.592)	91.27 (3.593)	91.29 (3.594)	91.32 (3.595)	91.35 (3.596)	91.37 (3.597)	91.41 (3.599)	91.43 (3.600)								
		120	124 (4.882)	133 (5.236)	101.15 (3.982)	101.17 (3.983)	101.20 (3.984)	101.23 (3.985)	101.26 (3.987)	101.29 (3.988)	101.31 (3.989)	101.34 (3.990)	101.37 (3.991)	101.40 (3.992)	101.44 (3.994)	101.47 (3.995)								
		130	134 (5.276)	143 (5.630)	111.16 (4.376)	111.18 (4.377)	111.21 (4.378)	111.24 (4.380)	111.27 (4.381)	111.31 (4.382)	111.34 (4.383)	111.37 (4.385)	111.40 (4.386)	111.43 (4.387)	111.47 (4.389)	111.50 (4.390)								
		140	144 (5.669)	153 (6.024)	121.16 (4.770)	121.19 (4.771)	121.23 (4.773)	121.26 (4.774)	121.29 (4.775)	121.33 (4.777)	121.36 (4.778)	121.39 (4.779)	121.43 (4.781)	121.46 (4.782)	121.50 (4.783)	121.54 (4.785)								
		150	154 (6.063)	163 (6.417)	131.17 (5.164)	131.20 (5.165)	131.24 (5.167)	131.27 (5.168)	131.31 (5.170)	131.34 (5.171)	131.38 (5.172)	131.42 (5.174)	131.45 (5.175)	131.49 (5.177)	131.54 (5.179)	131.57 (5.180)								
160	164 (6.457)	174 (6.850)	141.18 (5.558)	141.21 (5.559)	141.25 (5.561)	141.29 (5.563)	141.33 (5.564)	141.36 (5.565)	141.40 (5.567)	141.44 (5.569)	141.48 (5.570)	141.52 (5.572)	141.57 (5.574)	141.61 (5.575)										
170	175 (6.890)	184 (7.244)	151.19 (5.952)	151.23 (5.954)	151.26 (5.955)	151.30 (5.957)	151.34 (5.958)	151.38 (5.960)	151.42 (5.961)	151.47 (5.963)	151.51 (5.965)	151.55 (5.967)	151.60 (5.969)	151.64 (5.970)										
180	185 (7.283)	194 (7.638)	161.19 (6.346)	161.24 (6.348)	161.28 (6.350)	161.32 (6.351)	161.36 (6.353)	161.40 (6.354)	161.45 (6.356)	161.49 (6.358)	161.54 (6.360)	161.58 (6.361)	161.63 (6.363)	161.68 (6.365)										
190	195 (7.677)	204 (8.031)	171.20 (6.740)	171.25 (6.742)	171.29 (6.744)	171.33 (6.745)	171.38 (6.747)	171.42 (6.749)	171.47 (6.751)	171.52 (6.753)	171.56 (6.754)	171.61 (6.756)	171.66 (6.758)	171.71 (6.760)										
200	205 (8.071)	215 (8.465)	181.21 (7.134)	181.26 (7.136)	181.30 (7.138)	181.35 (7.140)	181.39 (7.141)	181.44 (7.143)	181.49 (7.145)	181.54 (7.147)	181.59 (7.149)	181.64 (7.151)	181.70 (7.154)	181.75 (7.156)										

\* 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.

LOCATING RING DIAMETER	WIRE GROOVE CHAMFER POSITION "A" (±2.0)	PL
U500	100mm	66.7
	101.3mm (3.99")	66.7
	125mm	78.7

SPRUE BUSHING		CHANNEL Ø IN - OUT
U500	SEAL-OFF GEOMETRY SPHERICAL RADIUS	4 - 8.00
	FLAT	
	SEAL-OFF 12.7 (1/2")	
	SEAL-OFF 15.5	6.35 - 8
	SEAL-OFF 19.05 (3/4")	8 - THRU
	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 RESINS, FILLERS AND/OR ADDITIVES  
A1S1 H13 (48-51 Rc)  
A1S1 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	2017-09-07	ORIGINAL ISSUE - DESIGNED BY: DHANANLEYAN		
1				
2				

NO.	DESCRIPTION	DATE
1	DRWG: DHANANLEYAN	
2	CHKD: PICHLER KLAUS	

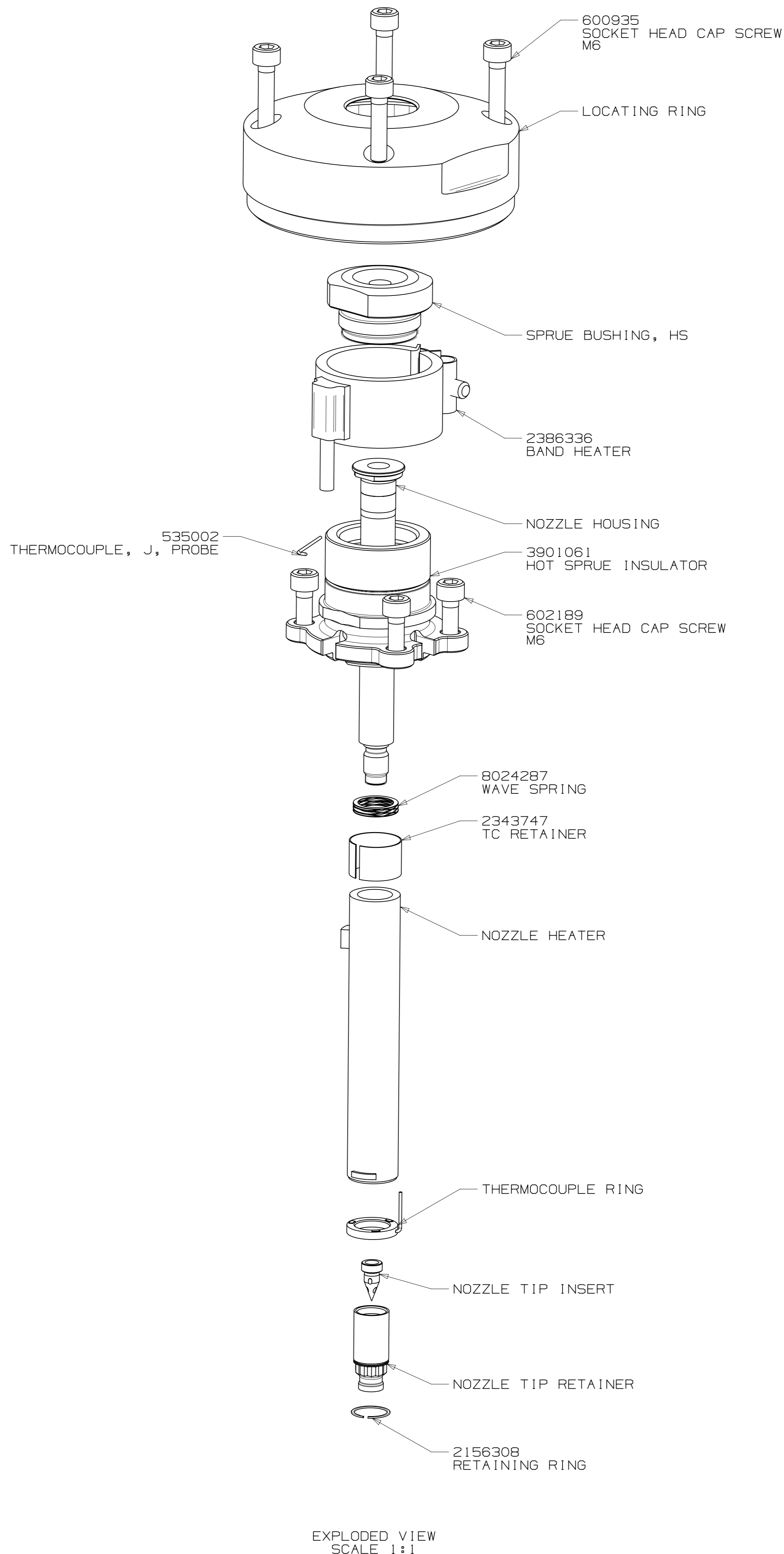
PROPERTY	UNIT	VALUE
DRY WEIGHT	g	10.2
DRY WEIGHT	oz	0.36
DRY WEIGHT	lb	0.025
DRY WEIGHT	kg	0.011
DRY WEIGHT	oz	0.36
DRY WEIGHT	lb	0.025
DRY WEIGHT	kg	0.011

FOR TORQUE SPECIFICATIONS, REFER TO HS 252	METRIC	IMPERIAL	WEIGHT
	0.04 ± 0.01 X 45°	0.015 ± 0.004 X 1.5°	10.2 g
	0.04 ± 0.01 X 45°	0.015 ± 0.004 X 1.5°	10.2 g

TITLE	SCALE	NO.	SIZE	DRAWING	REV
HOT SPRUE	AOR	1	A4	8093686	0

# ASSEMBLY DRAWING

DRAWING 8093686 REV 0



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

AISI H13 (49-51 Rc)  
AISI 420 (49-51 Rc)

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REV	DATE	DESCRIPTION	NAME
0	2017-09-07	ORIGINAL ISSUE - DESIGNED BY: DHANANJEYAN	DRWN: DHANANJEYAN CHKD: PICHLER, KLAUS

FOR TORQUE SPECIFICATIONS, REFER TO HS 252		METRIC		HUSKY	
WEIGHT		TITLE		SCALE	
- kg		HOT SPRUE		NONE	
		U500-HT-CAP		SIZE	
				DRAWING	
				8093686	
				REV	
				0	