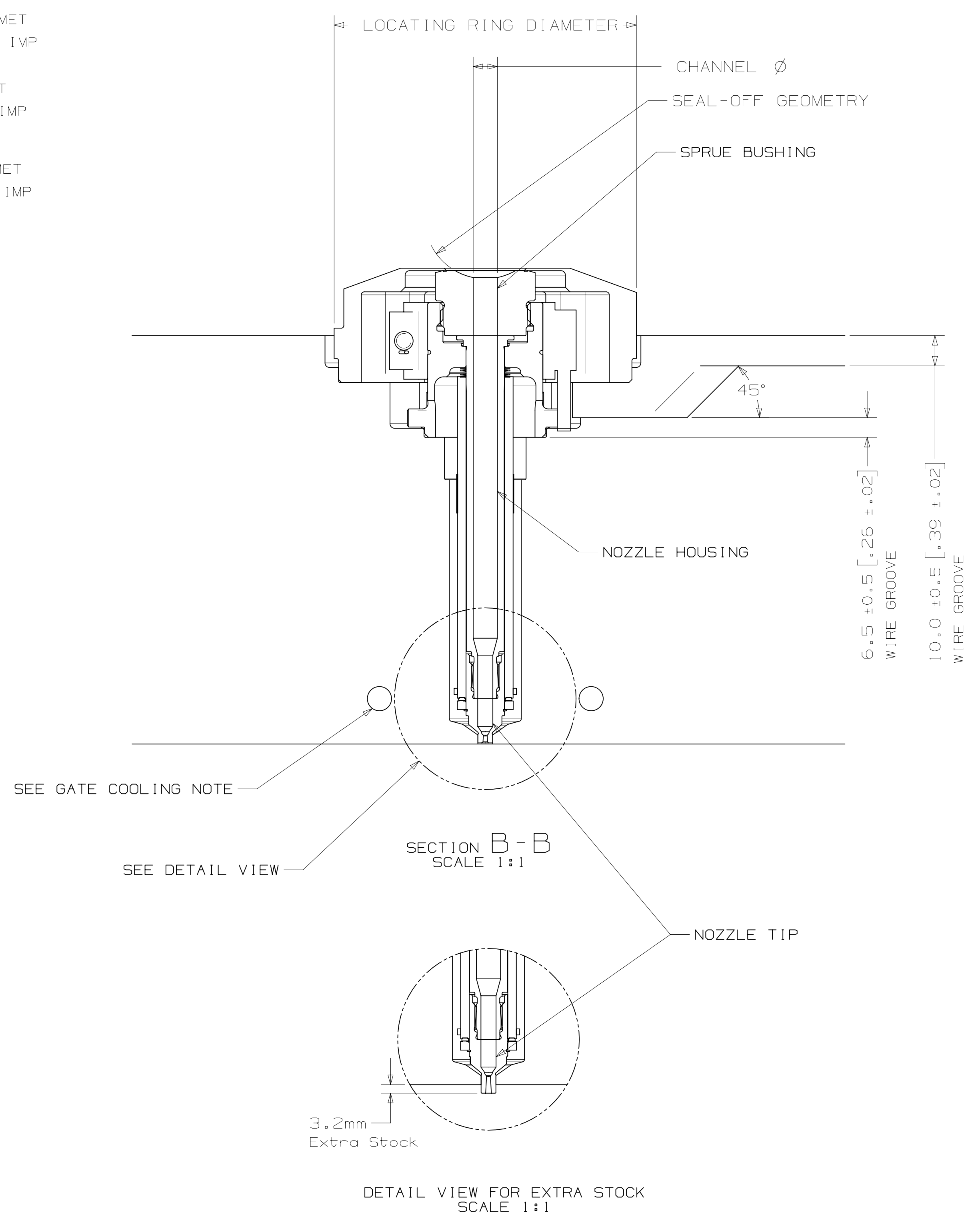
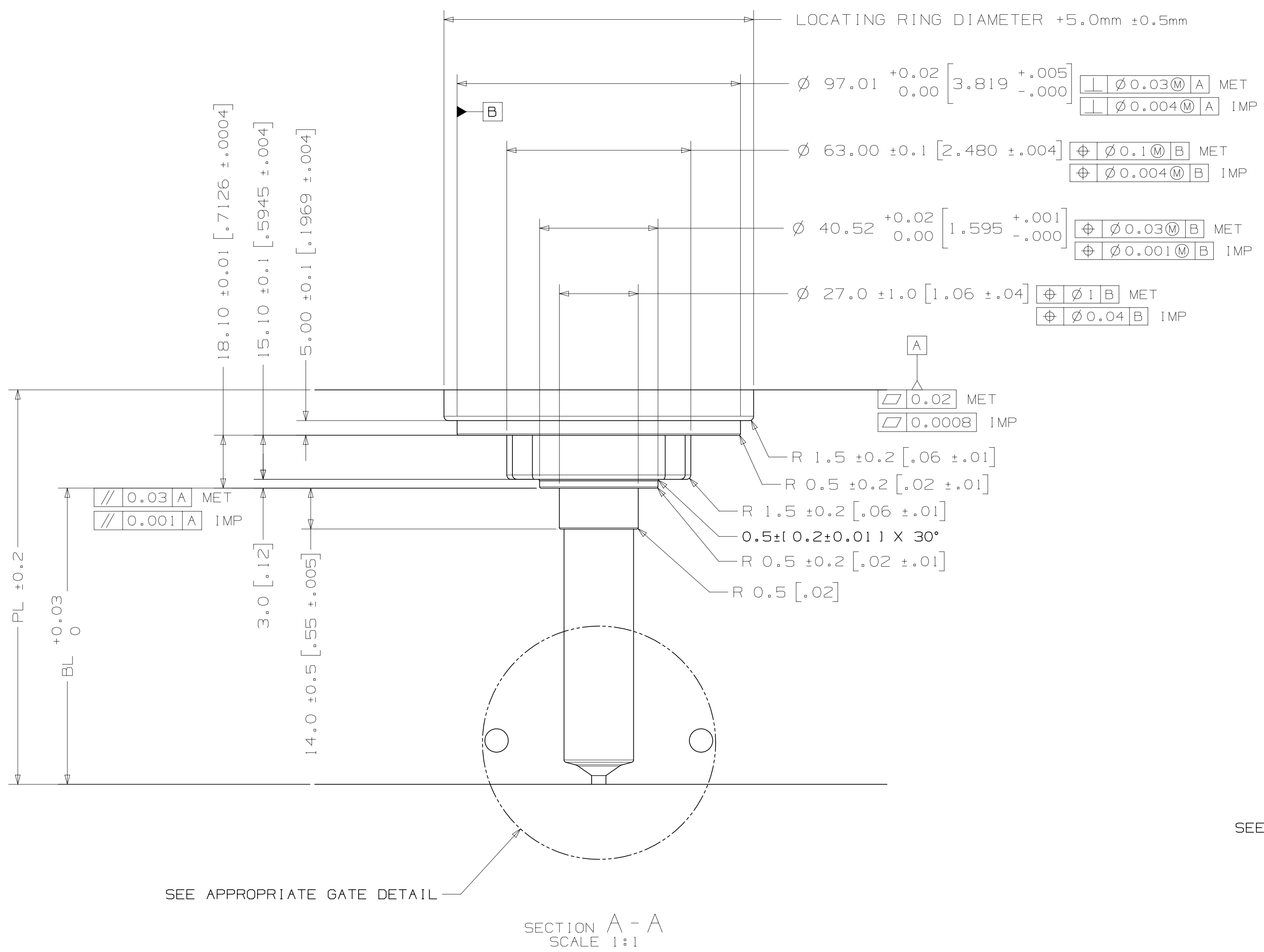
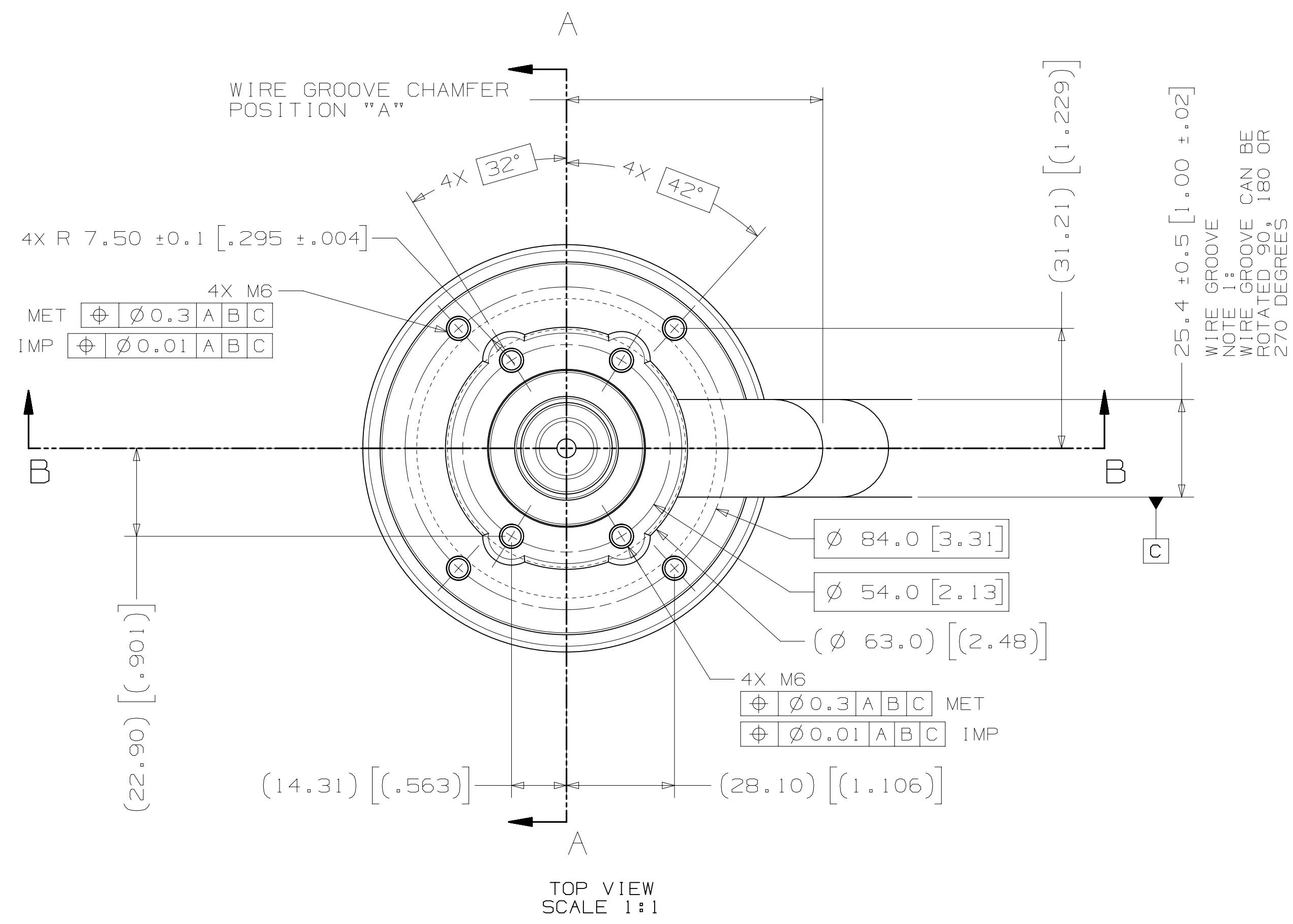


INSTALLATION DRAWING

REV: 0093478 0



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-248° 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-380° F)	200° C-219° C (392° F-428° 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-TS	50	54 (2.126)	63 (2.480)	31.09 (1.224)	31.11 (1.225)	31.12 (1.225)	31.13 (1.226)	31.14 (1.226)	31.15 (1.226)	31.16 (1.227)	31.18 (1.228)	31.19 (1.228)	31.20 (1.228)	31.22 (1.229)	31.23 (1.230)	31.23 (1.230)		
		60	64 (2.520)	73 (2.874)	41.10 (1.618)	41.12 (1.619)	41.13 (1.619)	41.14 (1.620)	41.16 (1.620)	41.17 (1.621)	41.19 (1.622)	41.20 (1.622)	41.22 (1.623)	41.23 (1.623)	41.25 (1.624)	41.27 (1.625)	41.27 (1.625)		
		70	74 (2.913)	83 (3.268)	51.11 (2.012)	51.13 (2.013)	51.14 (2.013)	51.16 (2.014)	51.17 (2.015)	51.19 (2.015)	51.21 (2.016)	51.23 (2.017)	51.24 (2.017)	51.26 (2.018)	51.28 (2.019)	51.30 (2.020)	51.30 (2.020)		
		80	84 (3.307)	93 (3.661)	61.12 (2.406)	61.14 (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)	61.29 (2.413)	61.32 (2.414)	61.34 (2.415)	61.34 (2.415)		
		90	94 (3.701)	103 (4.055)	71.13 (2.800)	71.15 (2.801)	71.17 (2.802)	71.19 (2.803)	71.21 (2.804)	71.23 (2.804)	71.25 (2.805)	71.28 (2.806)	71.30 (2.807)	71.32 (2.808)	71.35 (2.809)	71.37 (2.810)	71.37 (2.810)		
		100	104 (4.094)	113 (4.449)	81.13 (3.194)	81.16 (3.195)	81.18 (3.196)	81.20 (3.197)	81.23 (3.198)	81.25 (3.199)	81.27 (3.200)	81.30 (3.201)	81.32 (3.202)	81.35 (3.203)	81.38 (3.204)	81.41 (3.205)	81.41 (3.205)		
		110	114 (4.488)	123 (4.843)	91.14 (3.588)	91.17 (3.589)	91.19 (3.590)	91.22 (3.591)	91.24 (3.592)	91.27 (3.593)	91.30 (3.594)	91.32 (3.595)	91.35 (3.596)	91.38 (3.598)	91.41 (3.599)	91.44 (3.600)	91.44 (3.600)		
		120	124 (4.882)	133 (5.236)	101.15 (3.982)	101.18 (3.983)	101.20 (3.984)	101.23 (3.985)	101.26 (3.987)	101.29 (3.988)	101.32 (3.989)	101.35 (3.990)	101.38 (3.991)	101.41 (3.993)	101.44 (3.994)	101.48 (3.995)	101.48 (3.995)		
		130	134 (5.276)	143 (5.630)	111.16 (4.376)	111.19 (4.378)	111.22 (4.379)	111.25 (4.380)	111.28 (4.381)	111.31 (4.382)	111.34 (4.383)	111.37 (4.385)	111.41 (4.386)	111.44 (4.387)	111.48 (4.389)	111.51 (4.390)	111.51 (4.390)		
		140	144 (5.669)	153 (6.024)	121.16 (4.770)	121.20 (4.772)	121.23 (4.773)	121.26 (4.774)	121.29 (4.775)	121.33 (4.777)	121.36 (4.778)	121.40 (4.780)	121.43 (4.781)	121.47 (4.782)	121.51 (4.784)	121.55 (4.785)	121.55 (4.785)		
		150	154 (6.063)	163 (6.417)	131.17 (5.164)	131.21 (5.166)	131.24 (5.167)	131.28 (5.169)	131.31 (5.170)	131.35 (5.171)	131.38 (5.172)	131.42 (5.174)	131.46 (5.176)	131.50 (5.177)	131.54 (5.179)	131.58 (5.180)	131.58 (5.180)		
		160	164 (6.457)	174 (6.850)	141.18 (5.558)	141.22 (5.560)	141.25 (5.561)	141.29 (5.563)	141.33 (5.564)	141.37 (5.566)	141.41 (5.567)	141.45 (5.569)	141.49 (5.570)	141.53 (5.572)	141.57 (5.574)	141.62 (5.576)	141.62 (5.576)		
		170	175 (6.890)	184 (7.244)	151.19 (5.952)	151.23 (5.954)	151.27 (5.956)	151.30 (5.957)	151.35 (5.959)	151.39 (5.960)	151.43 (5.962)	151.47 (5.963)	151.51 (5.965)	151.56 (5.967)	151.61 (5.969)	151.65 (5.970)	151.65 (5.970)		
		180	185 (7.283)	194 (7.638)	161.20 (6.346)	161.24 (6.348)	161.28 (6.350)	161.32 (6.351)	161.36 (6.353)	161.41 (6.355)	161.45 (6.356)	161.50 (6.358)	161.54 (6.360)	161.59 (6.362)	161.64 (6.364)	161.69 (6.366)	161.69 (6.366)		
		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)	171.43 (6.749)	171.47 (6.751)	171.52 (6.753)	171.57 (6.755)	171.62 (6.757)	171.67 (6.759)	171.72 (6.761)	171.72 (6.761)		
		200	205 (8.071)	215 (8.465)	181.21 (7.134)	181.26 (7.136)	181.30 (7.138)	181.35 (7.140)	181.40 (7.142)	181.45 (7.144)	181.49 (7.145)	181.54 (7.147)	181.59 (7.149)	181.65 (7.152)	181.70 (7.154)	181.76 (7.156)	181.76 (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.

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

U500	SPRUE BUSHING	
	SEAL-OFF GEOMETRY	CHANNEL Ø IN - OUT
	FLAT	4 - 8
	FLAT	
	SEAL-OFF 12.7 (1/2")	6.35 - 8
	SEAL-OFF 15.5	8 - THRU
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-co.com

RECOMMENDED GATE MATERIAL
 NOTE: THESE MATERIALS MAY NOT OFFER THE DESIRED RESISTANCE TO ABRASIVE AND/OR CORROSIVE RESINS, FILLERS AND/OR ADDITIVES
 A151 H13 (49-51 Rc)
 A151 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.

REV	DATE	DESCRIPTION	DRWN	CHKD
0	2017-09-08	ORIGINAL ISSUE - DESIGNED BY: DHANALEKIAN		

COST PER ASM: 114.50 (134) AND HUSKY ADDRESS: HUSKY GATE SYSTEMS SPECIFICATION: CMO MODEL TO BOM; NEW TOLERANCES SPECIFICATIONS ARE BASIC. GENERAL TOLERANCES: 0.1 (0.017) 0.2 (0.031) BROKEN EDGES/CHAMFERS: 1.0 (0.2) X 45° 0.04 (0.01) X 45° FILLET/RADIUS: R0.8 (0.2) R0.03 (0.01) SURFACE FINISH: Ra 3.2	FOR TORQUE SPECIFICATIONS, REFER TO HS 252	METRIC IMPERIAL HUSKY TITLE: HOT SPRUE U500-HT-TS SCALE: NONE SIZE: AOR SHEET: 1 OF 2	WEIGHT: - kg DRAWING: 8093478 REV: 0
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