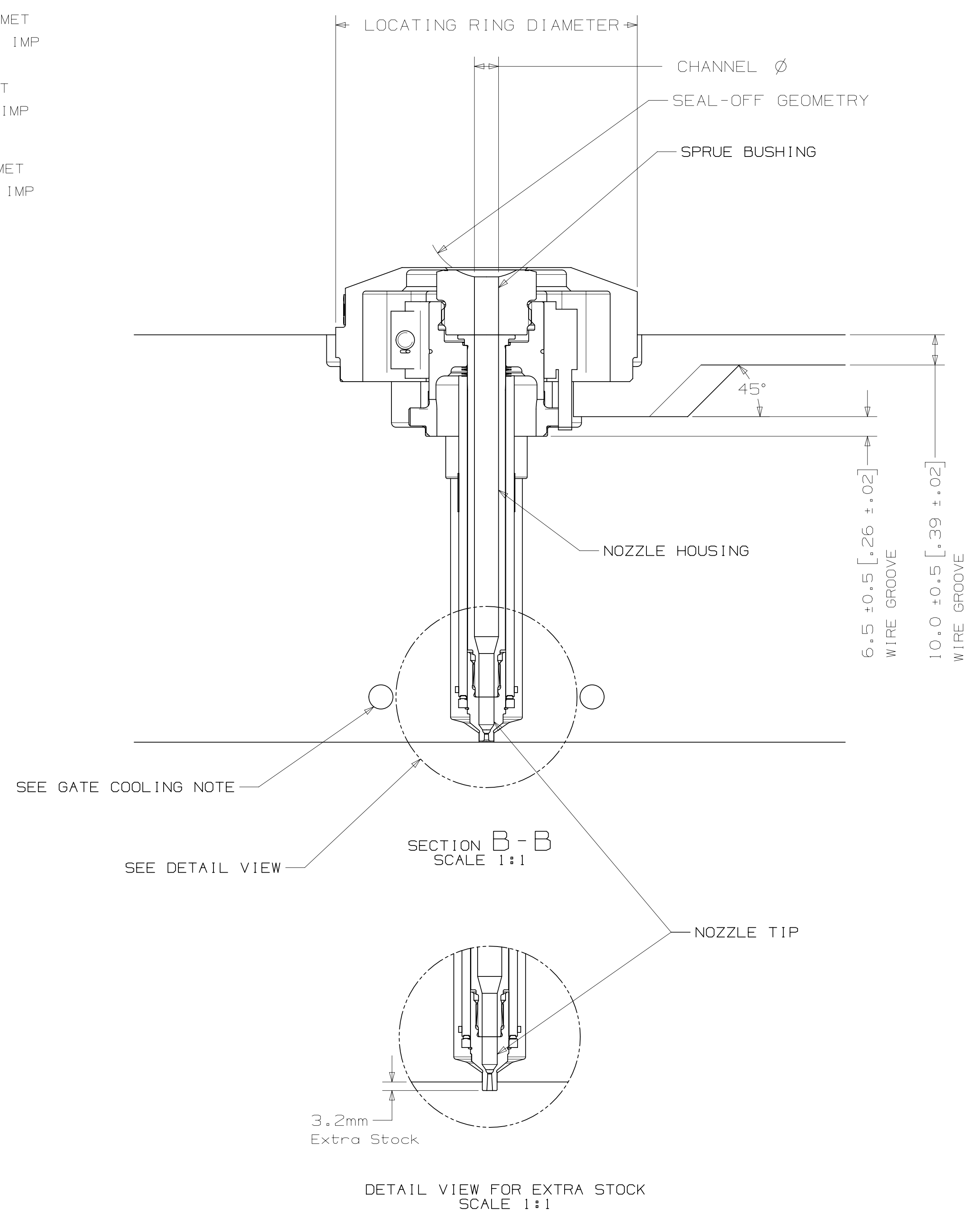
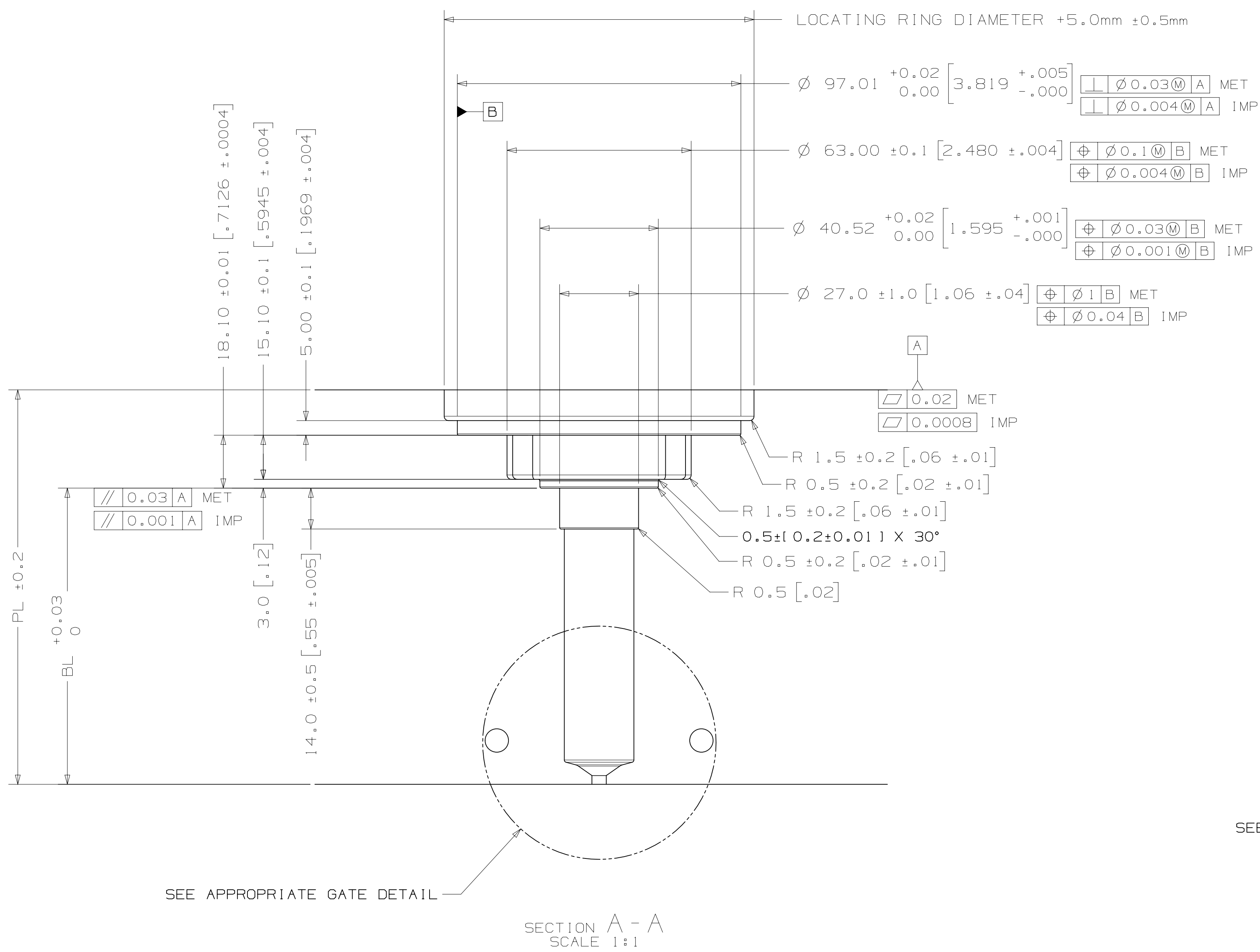
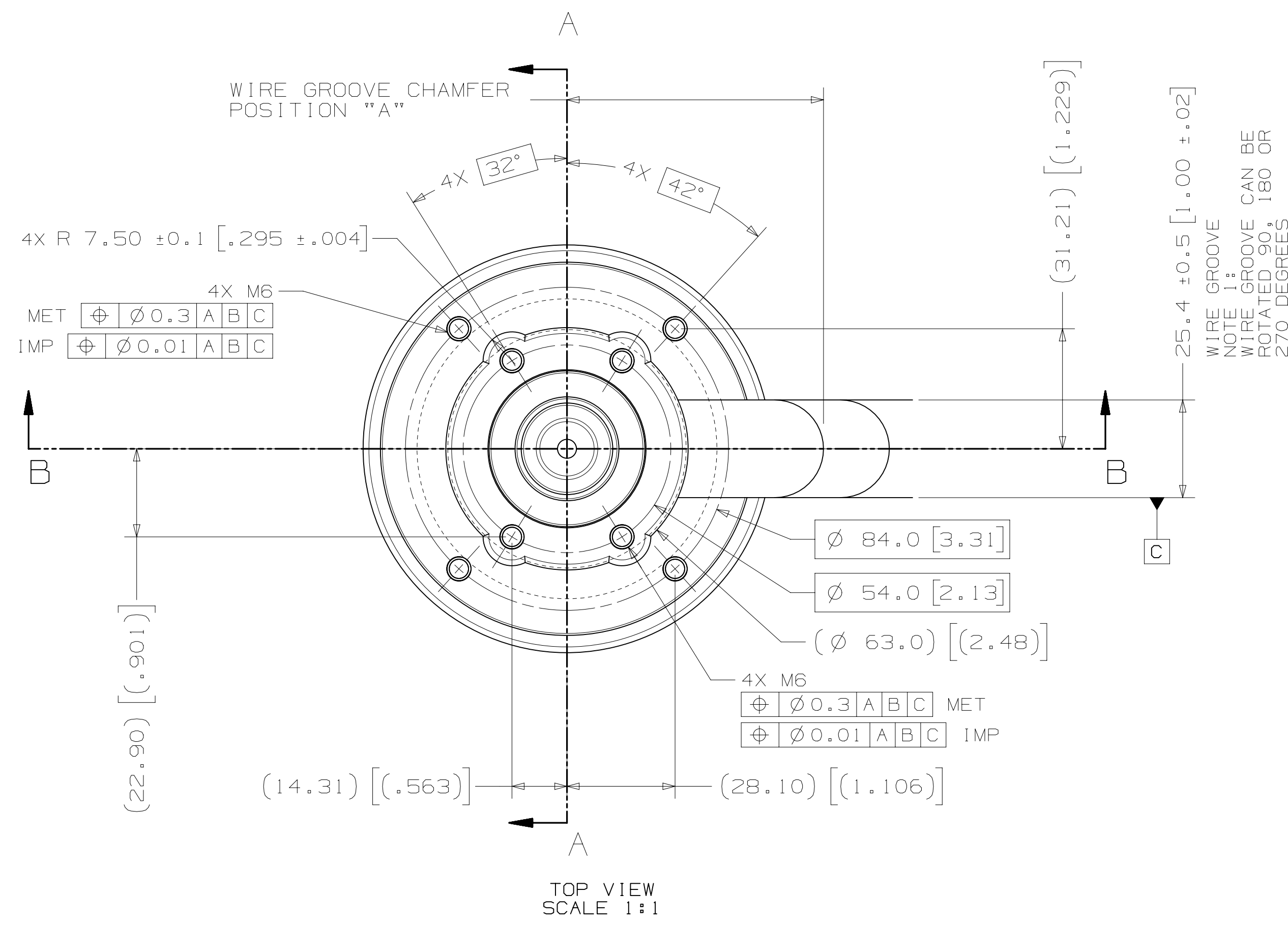


INSTALLATION DRAWING

REV: 0
STATUS: 8093478



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 (382° F-424° 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.

LOCATING RING DIAMETER	WIRE GROOVE CHAMFER POSITION "A" (±2.0)	SPRUE BUSHING	
		SEAL-OFF GEOMETRY SPHERICAL RADIUS	CHANNEL Ø IN - OUT
U500	100mm	FLAT	4 - 8
		FLAT	4 - 8
	101.3mm (3.99")	SEAL-OFF 12.7 (1/2")	6.35 - 8
		SEAL-OFF 15.5	
125mm	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
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	2017-09-08	ORIGINAL ISSUE - DESIGNED BY: DHANALEKIAN		
			DRWN: DHANALEKIAN	CHKD: PICHLER KLAUS

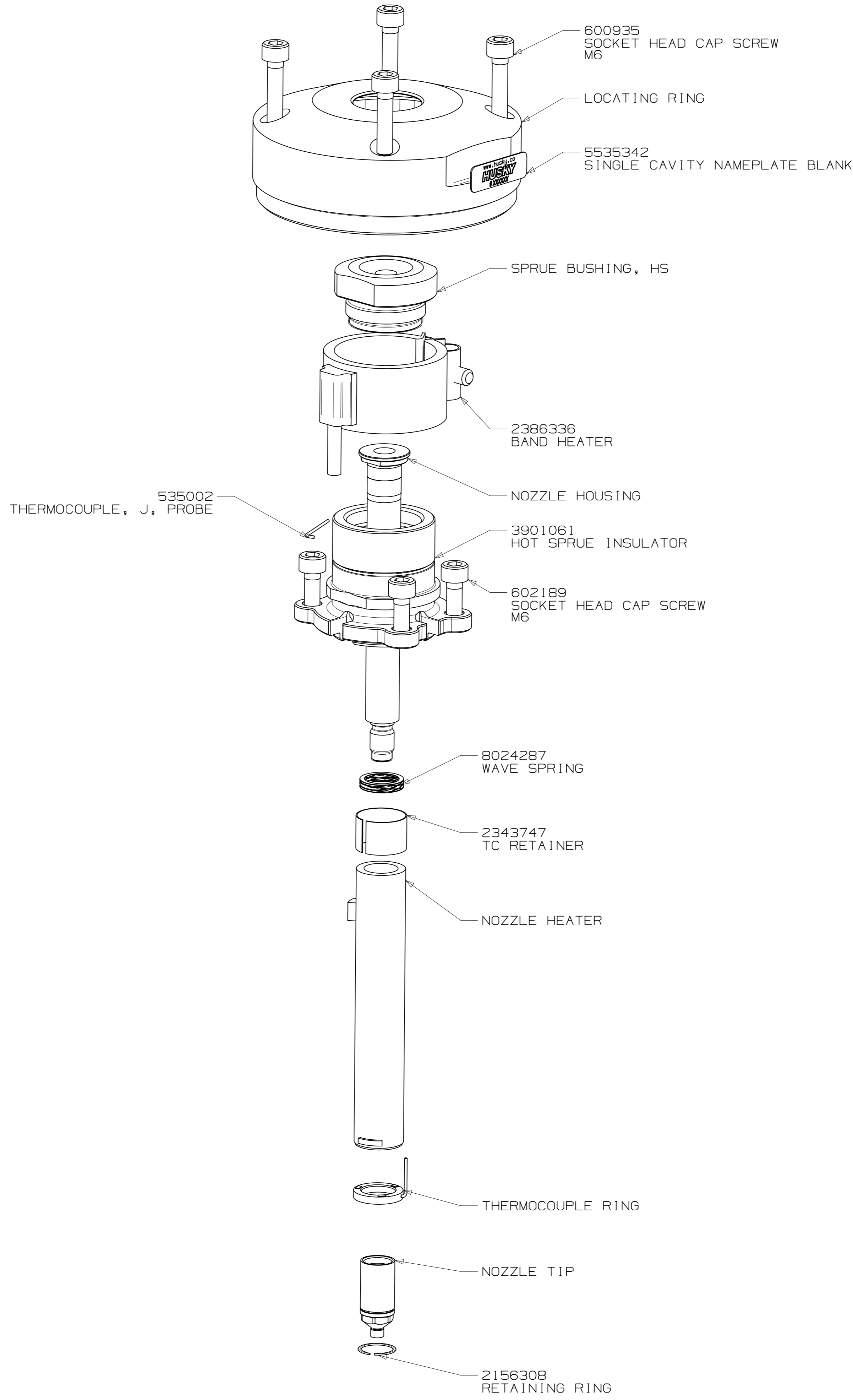
GENERAL TOLERANCES	METRIC	IMPERIAL
ISO 2768	ISO 2768	ISO 2768
BROKEN EDGES/CHAMFERS	1:0.2 X 45°	0.04 ± 0.01 X 45°
FILLET/RADIUS	R0.8 ± 0.2	R0.03 ± 0.01
SURFACE FINISH	1.6	3.2

FOR TORQUE SPECIFICATIONS, REFER TO HS 252
WEIGHT

METRIC	HUSKY	TITLE	SCALE	NO	SIZE	DRAWING	REV
		HOT SPRUE	AOR	U500-HT-TS		8093478	0

ASSEMBLY DRAWING

DRAWING 8093478 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. 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)	
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	NAME
0	2017-09-08	ORIGINAL ISSUE - DESIGNED BY: DHANANJEYAN	DRWN: DHANANJEYAN CHKD: PICHLER, KLAUS

FOR TORQUE SPECIFICATIONS, REFER TO HS 252	METRIC	HUSKY	TITLE HOT SPRUE U500-HT-TS
WEIGHT - kg	SCALE NONE	SIZE AIR	DRAWING 8093478 REV 0
SHEET 2 OF 2			