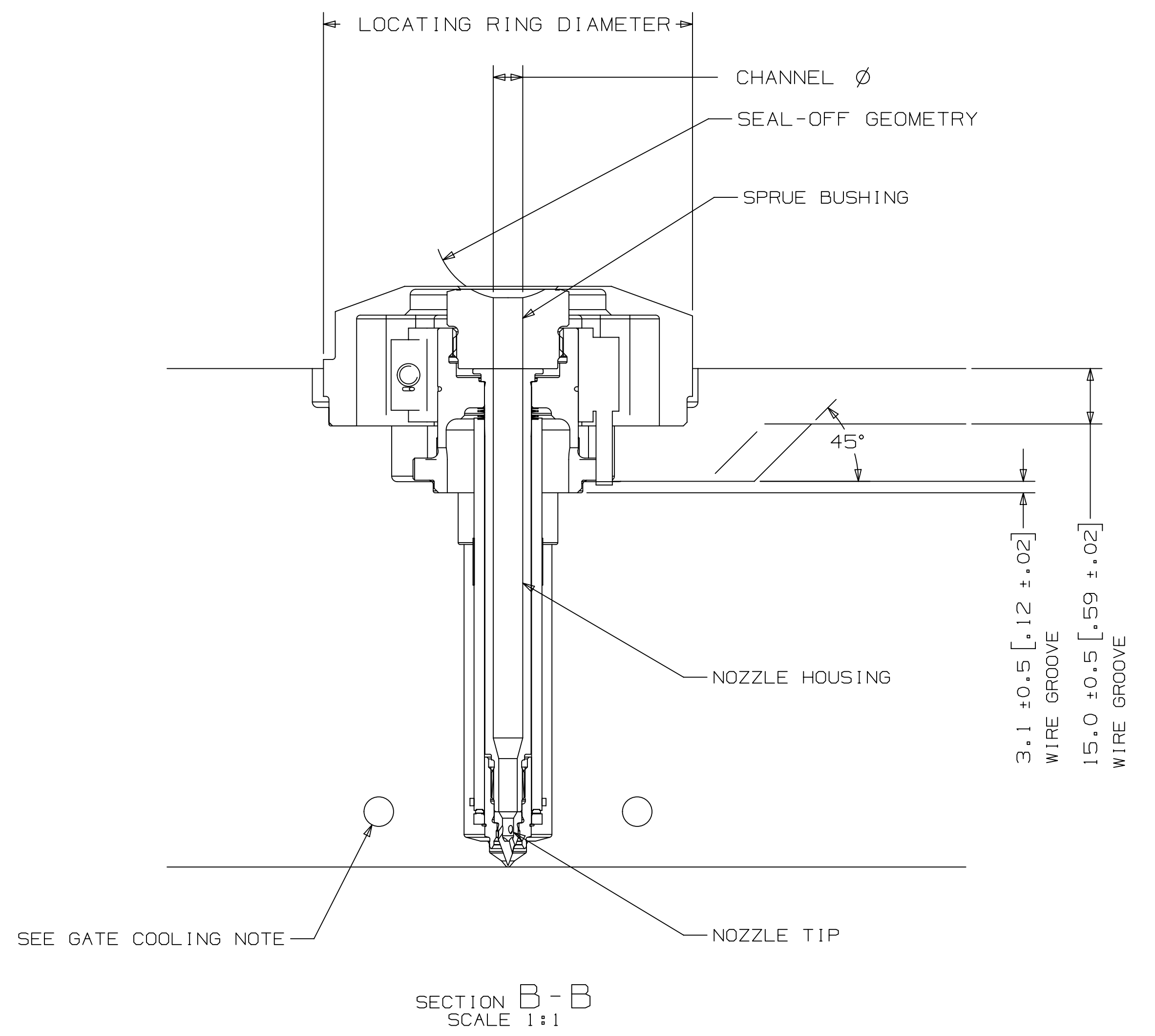
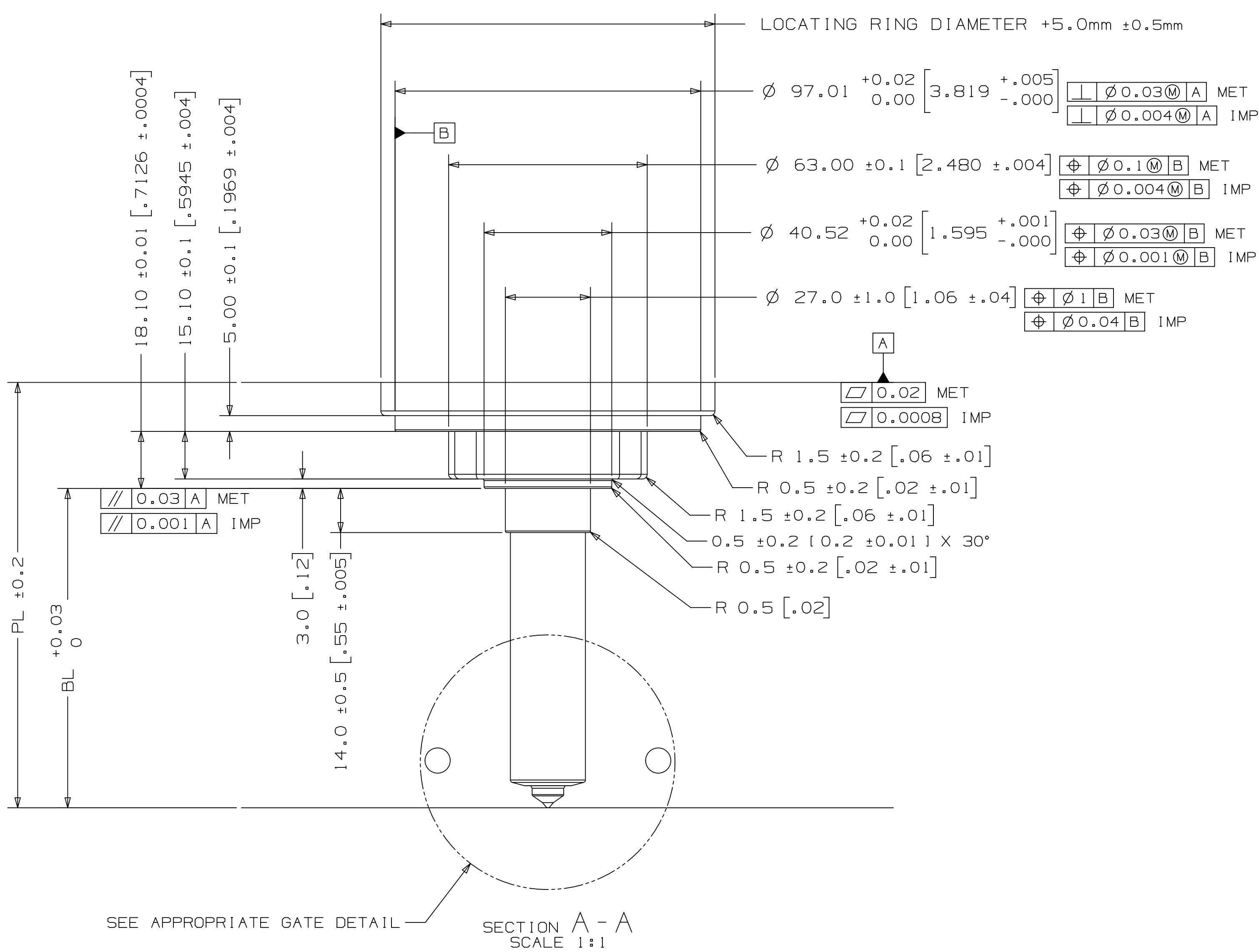
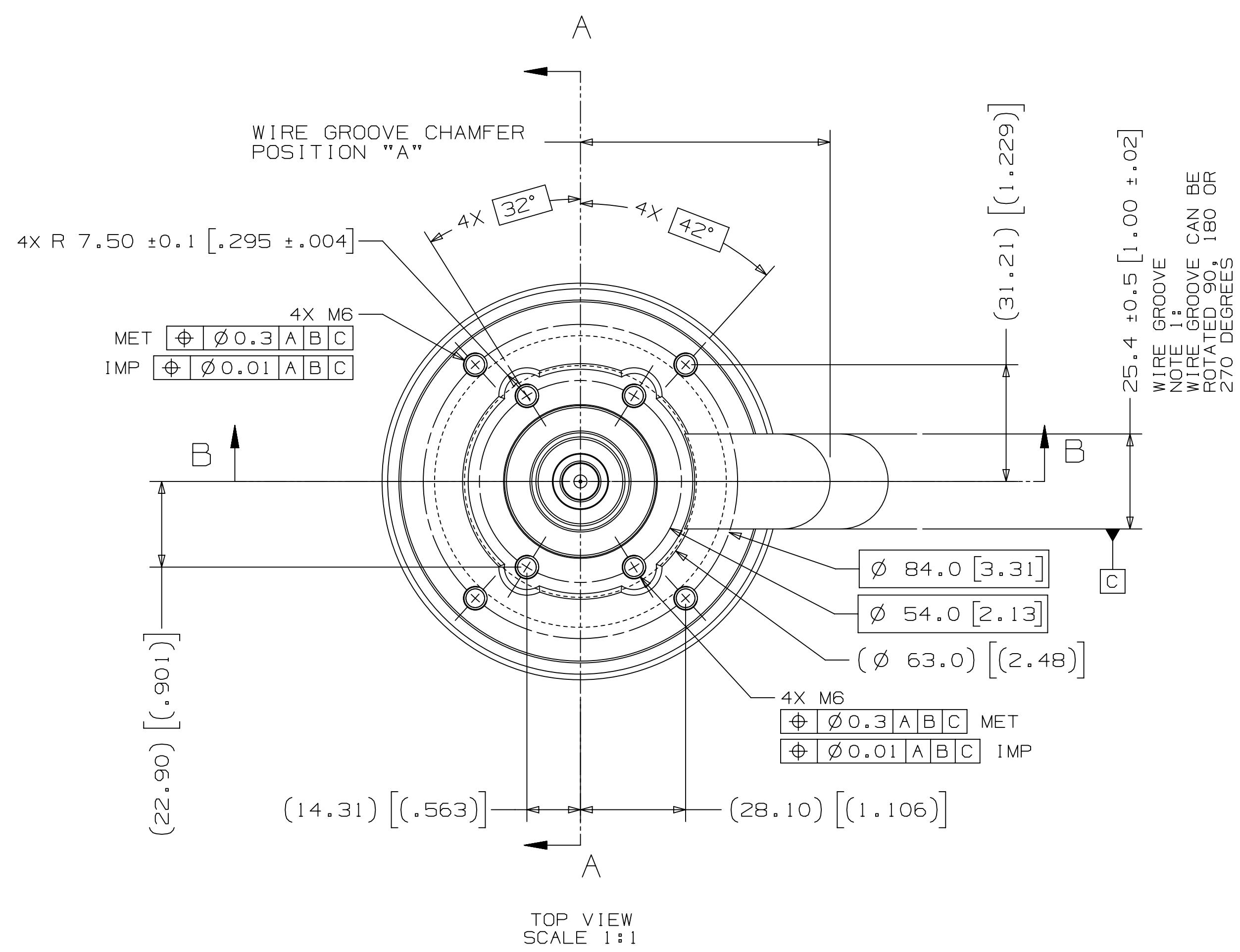


INSTALLATION DRAWING



| NOZZLE SERIES | NOZZLE TIP | PL RANGE | Approx. BL* |
|---------------|------------|--------------------------------|------------------------|
| U500 | HT-D | 54.25 (2.136) - 221.42 (8.717) | 32 (1.26) - 181 (7.13) |

*Approx. BL VALUES IN THE TABLE ARE REFERENCES WHICH CAN DEVIATE BY +/-1mm. FINAL BL VALUE CAN BE FOUND ON GATE DETAIL DRAWING AND 3D AFTER FINISHED DESIGN. BL AVAILABLE IN THE INCREMENT OF 10mm WITHIN RANGE.

| SPRUE BUSHING | | |
|---------------|----------------------|--------------------|
| U500 | SEAL-OFF GEOMETRY | CHANNEL Ø IN - OUT |
| | FLAT | |
| U500 | FLAT | 6.35 - 8 |
| | SEAL-OFF 12.7 (1/2) | |
| | SEAL-OFF 15.5 | |
| | SEAL-OFF 19.05 (3/4) | |
| U500 | SEAL-OFF 20 | 8 - THRU |
| | SEAL-OFF 40 | |

| U500 | LOCATING RING OUTER DIAMETER | WIRE GROOVE CHAMFER POSITION "A" (±2.0) |
|------|------------------------------|---|
| U500 | 100 | 66.7 |
| | 101.3 (3.991) | 66.7 |
| | 125 | 78.7 |

DIMENSIONS SHOWN AS: millimeters (inches)

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.ca

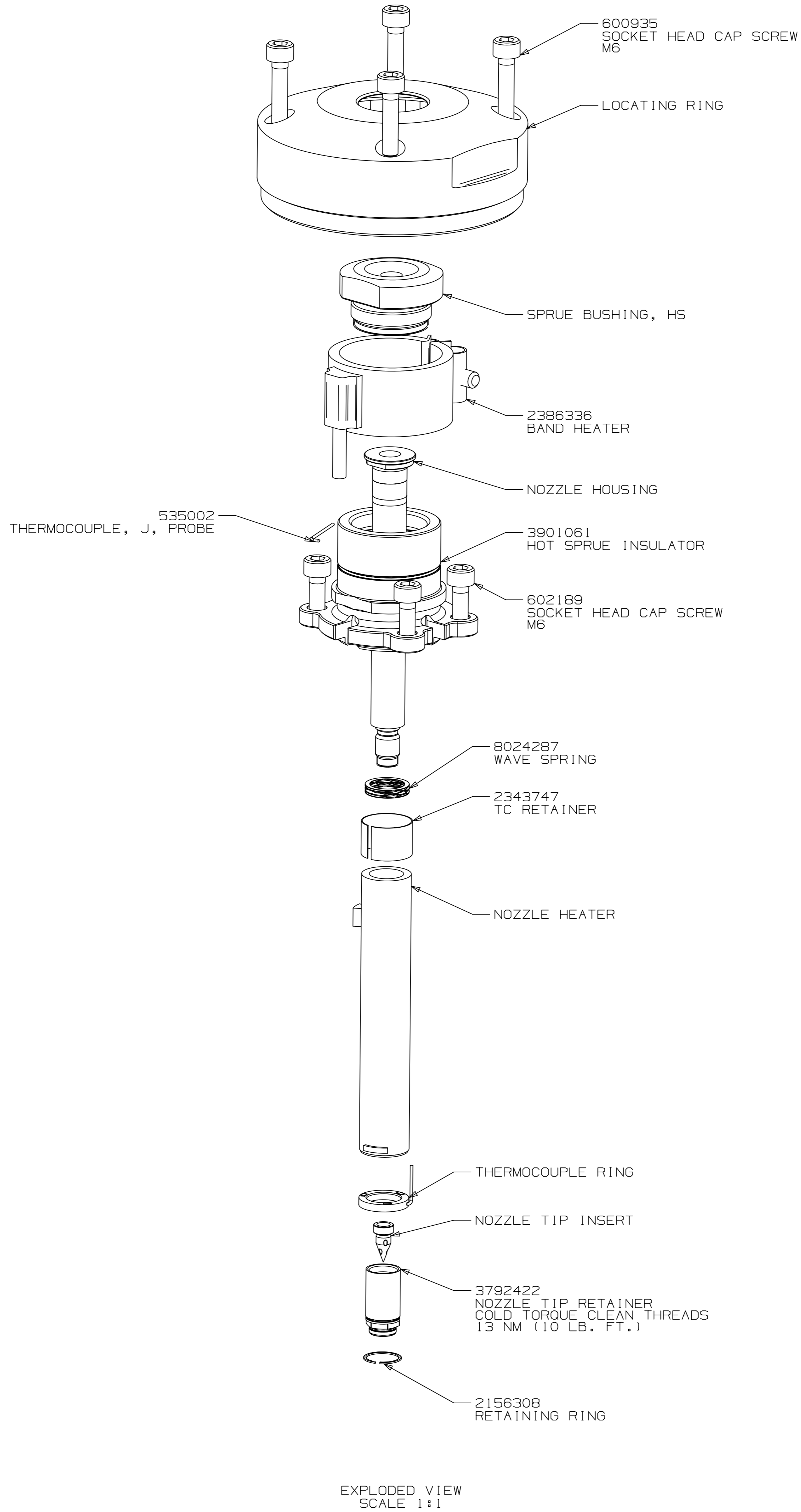
RECOMMENDED GATE MATERIAL
 NOTE: THESE MATERIALS MAY NOT OFFER THE DESIRED RESISTANCE TO ABRASIVE AND/OR CORROSIVE RESINS, FILLERS AND/OR ADDITIVES
 A1S1 H13 (48-51 Rc)
 A1S1 420 (48-51 Rc)

RECOMMENDED GATE MANUFACTURING GUIDELINES
 - HARDENED GATE INSERTS 148-511 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. SOFTENING THE AREA AROUND THE WELD AND CAN CAUSE GATE FAILURES.

| | | |
|--|--|---|
| GOST PER ANNE 114.94-1154 AND HEAT TREATING - H154 UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS DIMENSIONS IN PARENTHESES ARE IN INCHES GENERAL TOLERANCES ARE: METRIC: 0.15, 0.1, 0.05, 0.025, 0.015, 0.01 IMPERIAL: 0.005, 0.0025, 0.0015, 0.001, 0.0005, 0.00025, 0.00015, 0.0001 BROKEN EDGES/CHAMFERS: 1.0 ± 0.2 X 45° SURFACE FINISH: 0.8 ± 0.2 SURFACE FINISH: 0.2 | FOR TORQUE SPECIFICATIONS, REFER TO HS 252 WEIGHT: - kg | HUSKY TITLE: HOT SPRUE U500-HT-D SCALE: 1:1 SHEET: 1 OF 2 AOR: 8093162 REV: 1 |
|--|--|---|

ASSEMBLY DRAWING

REV 1
DRAWING 8093162



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 | 4.8 | 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 = (-)

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ADEQUATE COOLING IS ESSENTIAL FOR THE PROPER FUNCTION OF THIS SYSTEM. REFER TO THE HOT RUNNER PRODUCT GUIDE FOR MORE DETAILED GUIDELINES.
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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.
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| | | | | | | | | | |
|--|--------|--------------|-----------|-----------|-----|---------|---------|-----|---|
| FOR TORQUE SPECIFICATIONS, REFER TO HS 252 | METRIC | HUSKY | TITLE | HOT SPRUE | | | | | |
| | | | U500-HT-D | | | | | | |
| WEIGHT | - kg | SCALE | NONE | SIZE | AIR | DRAWING | 8093162 | REV | 1 |
| | | SHEET 2 OF 2 | | | | | | | |

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