

Ultra Series Hot Runners

Operator Manual

Issue: v 1.6 — August 2016

Document No.: 5079287

This product manual is intended to provide information for safe operation and/or maintenance. Husky reserves the right to make changes to products in an effort to continually improve the product features and/or performance. These changes may result in different and/or additional safety measures that are communicated to customers through bulletins as changes occur.

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General Information

Telephone Support Numbers

North America	Toll free	1-800-465-HUSKY (4875)
Europe	EC (most countries)	008000 800 4300
	Direct & Non-EC	+ (352) 52115-4300
Asia	Toll Free	800-820-1667
	Direct	+86-21-3849-4520
Latin America	Brazil	+55-11-4589-7200
	Mexico	+52-5550891160 option 5

For non-emergency questions and issues you may also e-mail Husky at techsupport@husky.ca.

Husky Regional Service and Sales Offices

For the location closest to you, please visit www.husky.co.

Product Upgrades

Upgrades are available that can improve your output, reduce cycle times, and add functionality to your Husky equipment.

To see what upgrades are available for your Husky equipment visit www.husky.co or call your nearest Husky Regional Service and Sales Office.

Ordering Spare Parts

All spare parts for Husky equipment can be ordered through your nearest Husky Parts Distribution Center or online at www.husky.co.

Ordering Additional Manuals

Additional copies of this manual and other documentation can be purchased through your nearest Husky Regional Service and Sales office.

Mold Refurbishing

Husky offers services for repairing or modifying any Husky mold or hot runner, and services for retrofitting Husky hot runners. Contact your nearest Husky Regional Service and Sales Office for more information.

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Chapter 1 Introduction

This chapter provides general information about the hot runner assembly, available equipment manuals, and training opportunities.



IMPORTANT!

This manual is intended for hot runner operators and assumes the hot runner has been properly installed.

1.1 Purpose of the Equipment

Husky equipment and systems are designed for injection molding applications only, using approved materials and operating within design guidelines.

Contact your nearest Husky Regional Service and Sales office if you plan to use a Husky product for anything other than its intended use.

1.2 Restrictions of Use

Husky injection molding equipment must never be:

- operated by more than one person
- used for any purpose other than that described in [Section 1.1](#), unless otherwise approved by Husky
- used to extrude any materials not outlined in the scope of the harmonized EN201 standard
- operated or serviced by personnel unfamiliar with the inherent risks and necessary precautions related to injection molding equipment
- operated at temperatures higher than the maximum permissible temperature for plasticizing

1.3 Unauthorized Modifications

Unauthorized modifications or reconstruction of any Husky injection molding system is strictly prohibited. Modifications can be unsafe and/or void warranty.

Contact your nearest Husky Regional Service and Sales office to discuss modifications or requirements for Husky systems.

1.4 Auxiliary Equipment

Husky is only responsible for the interaction of Husky equipment and systems with auxiliary equipment when Husky is the system integrator. If auxiliary equipment is removed, the user must install proper safeguards to prevent access to the hazards.

For information about integrating non-Husky auxiliary equipment, contact your nearest Husky Regional Service and Sales office.

1.5 Nameplate

A nameplate is affixed to the operator side of the hot runner for quick identification of the equipment type, source, and general specifications.



IMPORTANT!

The hot runner nameplate must never be removed. The information on the nameplate is necessary for hot runner selection, setup, parts ordering and troubleshooting.

Immediately order a new nameplate for the hot runner if it is missing or damaged.

Every hot runner nameplate lists the following information:

- the location where the hot runner was manufactured
- the project number
- the resin/filler type the hot runner was designed to be used with
- the melt and mold temperatures
- electrical requirements and specifications

NOTE: Other details and specifications may be required.



IMPORTANT!

Each hot runner is designed to process a specific type and grade of resin/filler based on the customer’s requirements. Use of any other type or grade of resin/filler could affect part quality and/or the performance of the hot runner. Before using a different type or grade of resin/filler, contact Husky.

CAUTION!

Mechanical hazard – risk of damage to the hot runner. Never operate the hot runner outside of the melt and mold temperatures indicated on the nameplate. Internal resin leakage or component damage could occur.

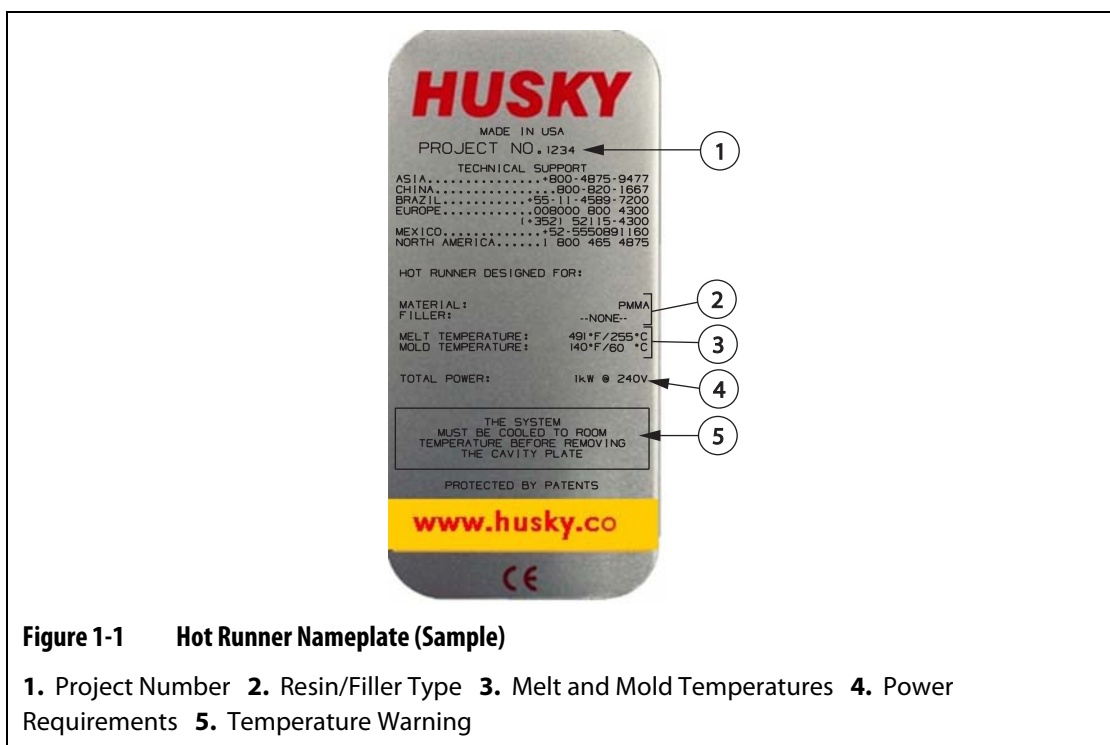


Figure 1-1 Hot Runner Nameplate (Sample)

- 1.** Project Number **2.** Resin/Filler Type **3.** Melt and Mold Temperatures **4.** Power Requirements **5.** Temperature Warning

1.6 Installing and Maintaining the Hot Runner

Full procedures for assembling, installing, maintaining and troubleshooting the hot runner are provided in the hot runner *Service Manual*.

If the hot runner is installed in a Husky machine, also refer to the machine *Service Manual* for additional installation instructions.

1.7 Documentation

A full set of manuals, drawings, schematics, certificates and other documentation are available for every Husky hot runner.

The following describes the documentation provided with each system, along with common conventions all readers should be familiar with.



IMPORTANT!

Keep all manuals in a convenient location for future reference.

1.7.1 Manuals

Husky manuals aid in the safe and proper use of Husky products. Where applicable, the manuals provide instructions on installation, operation and maintenance.

Personnel should thoroughly review all manuals provided with their Husky equipment prior to performing any tasks. Proceed with tasks only if all instructions are understood and always follow applicable workplace safety requirements.



IMPORTANT!

Images in the manuals are for reference only and may not represent specific equipment details. Refer to engineering drawings and schematics for specific details.

The following manuals are available for each hot runner system:

Operator Manual	Describes the basic startup, operation, shut down and daily maintenance of the hot runner
Service Manual	Describes the installation, startup, operation, shut down and maintenance the hot runner NOTE: Refer to the hot runner <i>Service Manual</i> for product specific instructions.

These manuals are available online through www.husky.co.

**IMPORTANT!**

Some manuals may contain addendums that detail new or updated information. Before reading a manual, make sure to review all available addendums located at the end of the manual.

1.7.2 Drawings and Schematics

Each Husky hot runner is provided with a set of drawings and schematics specific to the hot runner. These are used for troubleshooting the hot runner and ordering spare parts.

NOTE: Each drawing and schematic is specific to the hot runner it is provided with.

1.7.3 Safety Alert Conventions

Safety alerts highlight hazardous conditions that may arise during installation, operation or maintenance and describe methods for avoiding personal injury and/or property damage.

Depending on the severity of the hazard, safety alerts start with one of the following signal words: Danger, Warning or Caution.

**DANGER!**

The **DANGER** safety alert indicates an imminently hazardous situation that, if not avoided, will result in death or serious injury.

**WARNING!**

The **WARNING** safety alert indicates a potentially hazardous situation that, if not avoided, could result in death or serious injury.

CAUTION!

The **CAUTION** safety alert indicates a potentially hazardous situation that, if not avoided, could result in property damage.

Other non-safety related alert types used in the manuals highlight important information needed by the user to install, operate or maintain the equipment properly. They may also, in some cases, describe best practices, offer an expanded explanation, or reference a related section in the manual.

Non-safety related alerts start with one of the following signal words: Note or Important.

NOTE: The NOTE alert is used to add information to a subject that does not fit within the general flow of the document.

**IMPORTANT!**

The IMPORTANT alert is used to highlight important steps, conditions, or considerations related to the subject.

1.8 Training

All designated operators and maintenance personnel must be fully trained before using or servicing Husky injection molding systems.

If training is required, visit www.husky.co or contact your nearest Husky Regional Service and Sales office to learn more about Husky's training solutions.

**IMPORTANT!**

It is the obligation of the employer to properly train and instruct all personnel in safe methods of operation and maintenance. Manuals and other reference material, which have been prepared by Husky for the operation and maintenance of Husky equipment, do not in any way absolve the employer from fulfilling these obligations and Husky disclaims liability for injury to personnel which is attributable to the employer's failure to do so.

Chapter 2 Safety Summary

This chapter describes the general requirements and conditions for safe operation and maintenance of the hot runner.



IMPORTANT!

Personnel must read, understand and follow all listed safety precautions.



IMPORTANT!

Personnel must follow applicable industry and regulatory safety requirements for safe installation, operation and maintenance of equipment.

2.1 Qualified Personnel

Only fully trained and qualified personnel should be permitted to operate equipment. Qualified personnel must have demonstrated skills and knowledge related to injection molding equipment, as well as training to recognize potential hazards.

2.2 Safety Guidelines

Personnel operating, installing, maintaining or servicing Husky equipment must adhere to safe working practices that are in compliance with the following guidelines:

- Lockout and tag all energy sources before servicing the hot runner or entering the mold area
- Do not operate the hot runner if scheduled preventive maintenance has not been performed
- Do not use a magnetic platen without approval from Husky and the magnetic platen supplier/manufacturer
- Do not operate a hot runner outside the maximum melt and mold temperatures specified on the hot runner nameplate

2.3 Safety Hazards

Some safety hazards associated with injection molding equipment are:

- Mechanical (pinching, shearing, crushing)
- Electrical
- Burn
- High pressure (hydraulic system pressure and molten material spray)
- Slip, trip or fall
- Lifting
- Gas, vapor and dust emissions
- Noise

2.3.1 Mechanical Hazards

- **Worn Hoses and Safety Restraints**
Regularly inspect and replace all flexible hose assemblies and restraints.
- **Cooling Water Hoses**
Cooling water hoses degrade over time and need to be replaced on a yearly basis. Degraded hoses become brittle and can break or separate from the fitting when manipulated. To minimize the risk of failure, inspect the hoses regularly and replace as required.
Wait until the machine has cooled down before servicing cooling water hoses.

2.3.2 High Pressure Hazards



WARNING!

Burn and hot resin spray hazard – risk of death, serious injury and/or damage to the hot runner. All nozzle and sprue heaters (if equipped) must be turned on when manifold heaters are turned on. Failure to do so could result in generation of dangerous pressure levels in the manifold, resulting in component failure and/or sudden release of hot resin.

Pressure inside the hot runner manifold(s) can increase to dangerous levels if the nozzle and sprue heaters (if equipped) are not turned on before or at the same time as the nozzle sprue.

The pressure is generated when the injection nozzle sprue is plugged with frozen resin and the residual resin in the manifold is heated. This pressure can release suddenly causing the resin plug to eject from the sprue and hot resin to spray from the nozzle tips. The risk of serious burn injuries as a result is increased.

Moisture that infiltrates and is trapped in the hot runner molten material can also increase the risks of this potential hazard. If the temperature of the water in the molten material becomes greater than 400 °C (725 °F), the pressure of this trapped water can be significant enough to rupture the metal housing and cause serious injury to personnel.

To avoid this hazard, do the following:

1. Always make sure all nozzle and sprue heaters (if equipped) are turned on any time manifold heaters are turned on outside of the mold. The nozzle and sprue heaters can be turned on independently of the manifold heaters, however, it is recommended that they be heated first or slaved to the manifold heaters so they heat up in unison.
2. Always make sure the nozzle tips are open and the nozzle housings are dry prior to applying heat to the manifold.



IMPORTANT!

In the event of water leaking onto or into the hot runner, the nozzle tips must be removed (cold) and the plastic in the nozzles drilled out to ensure they are open to atmosphere. This can be done using a standard twist drill with the cutting edges removed to prevent damage to the melt channel.

Replace the cavity plate prior to heating the system.

2.3.3 Burn Hazards

- **Hot Surfaces**
Hot runners have numerous high temperature surfaces. At normal operating temperatures, contact with these surfaces will cause severe skin burns. Wear personal protective equipment (PPE) when working around a hot runner.
- **Molten Material**
Never touch process material purged or otherwise flowing from the nozzle, mold, hot runner or feed throat area. Molten material can appear cool on the surface, but remain very hot on the inside. Wear personal protective equipment when handling purged material.

2.3.4 Electrical Hazards

- **Power Supply**
Molding equipment draws high amperage current at high voltage. The electrical power requirements are indicated on the nameplate and in the electrical schematic. Connect equipment to a suitable power supply as specified in the electrical schematic and in compliance with all applicable local regulations.
- **Water**
Water on the hot runner can be in close proximity to electrical connections and equipment. This can lead to a short circuit, resulting in serious electrical damage to the equipment. Always keep water lines, hoses, and hose fittings in good condition to avoid leaks.

2.3.5 Gas, Vapor, and Dust Emissions

Certain processed materials release harmful gas, vapors or dust. Install an exhaust system according to local codes.

2.3.6 Slip, Trip, or Fall Hazards

Do not walk, stand, climb or sit on machine surfaces not approved for safe access.

Use a safety approved platform or walkway to access areas that are not accessible from the floor.

2.3.7 Lifting Hazards

When lifting the hot runner or hot runner components, use suitable lifting equipment, proper balancing techniques, and designated lifting points. Do not exceed the rated capacity of the lifting equipment.

2.3.8 Pneumatic Hazards

- **Air Supply Hoses**
Make sure air supply hoses connected to the hot runner do not interfere with moving parts of the mold or the machine during operation. All air hoses must be sufficiently long so they will not be strained when the mold halves separate.
Make sure air supply hoses are not routed over edges or where they could rub together, causing motion or vibration damage.
- **Compressed Air**
Never use compressed air to clear valve gates. A piece of resin can fly out and injure a bystander.
Always use a brass tool and vacuum cleaner to clear valve gates.


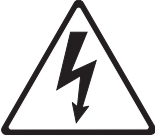







2.4 Safety Signs






Safety signs clearly mark potentially hazardous areas in or around equipment. For the safety of personnel involved in equipment installation, operation and maintenance, use the following guidelines:

- Verify that all signs are in the proper locations. Refer to the drawing package for details.
- Do not alter signs.
- Keep signs clean and visible.
- Order replacement signs when necessary. Refer to the drawing package for part numbers.

The following safety symbols may appear on safety signs:

NOTE: Safety signs may include a detailed explanation of the potential hazard and associated consequences.

Safety Symbol	General Description of Symbol
	<p>General This symbol indicates a potential personal injury hazard. It is usually accompanied by another pictogram or text to describe the hazard.</p>
	<p>Hazardous Voltage This symbol indicates a potential electrical hazard that will cause death or serious injury.</p>
	<p>High Pressure Molten Material This symbol indicates the presence of a high pressure molten material hazard that could cause death or severe burns.</p>
	<p>Lockout/Tagout This symbol identifies an energy source (electrical, hydraulic or pneumatic) that must be de-energized before maintenance is performed.</p>
	<p>Crushing and/or Impact Points This symbol indicates a crushing and/or impact area that could cause serious crushing injury.</p>
	<p>High Pressure This symbol indicates a heated water, steam or gas hazard that could cause severe injury.</p>
	<p>High Pressure Accumulator This symbol indicates the sudden release of high pressure gas or oil could cause death or serious injury.</p>
	<p>Hot Surfaces This symbol identifies the presence of exposed hot surfaces that could cause serious burn injuries.</p>
	<p>Slip, Trip or Fall Hazard This symbol indicates a slip, trip or fall hazard that could cause injury.</p>

Safety Symbol	General Description of Symbol
	<p>Do Not Step This symbol identifies a location that should not be used as a step because it may be a slip, trip or fall hazard and could cause injury.</p>
	<p>Crushing and/or Shearing Hazard This symbol indicates the presence of a crushing and/or shearing hazard at the rotating screw that could cause serious injury.</p>
	<p>Read Manual Before Operation This symbol indicates that qualified personnel should read and understand all instructions in the equipment manuals before working on the equipment.</p>
	<p>Class 2 Laser Beam This symbol indicates a laser beam hazard that could cause personal injury with prolonged exposure.</p>
	<p>Barrel Cover Grounding Strap This symbol indicates an electrical hazard related to the barrel cover grounding strap that could cause death or serious injury.</p>

2.5 Lockout/Tagout

The lockout/tagout procedure must be performed before maintenance and service tasks. Lockout/tagout includes isolation or depletion of stored energy from all integrated auxiliary equipment.







Refer to applicable local codes for more information about performing lockout/tagout.

2.6 Personal Protective Equipment and Safety Equipment

Personal injury can be avoided when personnel wear appropriate protective gear and use special safety equipment. The following describes the safety gear and equipment that should be used when working with the machine and any auxiliary equipment.

2.6.1 Personal Protective Equipment (PPE)

Wear appropriate personal protective equipment when working on or near equipment. Standard personal protective equipment includes:

Item	Description
	<p>Safety Glasses For protecting the eyes from flying objects/particles, heat, sparks, splash from molten material, and more.</p>
	<p>Face Shield For protecting the entire face area from flying objects/particles, heat, sparks, splash from molten material, and more.</p>
	<p>Heat Resistant Gloves For protecting the hands from extreme heats.</p>
	<p>Hearing Protection For protecting the ears from loud ambient noise.</p>
	<p>Safety Shoes For protecting the feet from electrical shocks, crushing hazards, puncture hazards, splash from molten material, and more.</p>
	<p>Non-Melting Natural Fiber Pants and Long Sleeved Shirt For protecting the body from potential splash from molten material.</p>

2.6.2 Safety Equipment

Use appropriate safety equipment when working on or near equipment.

Standard safety equipment includes:

- **Exhaust Fan**
For collecting potentially harmful plastic fumes
- **Purging Container**
For containing hot resin purged from the injection unit
- **Vacuum Cleaner**
For collecting spilled resin pellets and other debris that may create a falling hazard
- **Stairs and Ladders**
For ensuring safe access to areas of the machine
- **Danger Signs**
For warning other personnel to stand clear of a component or area of the machine
- **Locks and Tags**
For preventing the use of specific systems and components
- **Fire Extinguishers**
For the expedient suppression of small fires
- **Telescopic Mirror**
For safely inspecting hot runner nozzle tips from outside the mold area
- **Brass Hammers and Brass Rods**
For safely removing dried resin deposits

2.7 Material Safety Data Sheet (MSDS)



WARNING!

Chemical hazard - Some of the chemicals used with Husky equipment are potentially hazardous and could cause injury and illness. Before storing, handling, or working with any chemical or hazardous material, thoroughly read and understand each applicable Material Safety Data Sheet (MSDS), use recommended personal protective equipment and follow the manufacturer's instructions.

The Material Safety Data Sheet (MSDS) is a technical document which indicates the potential health effects of a hazardous product. It contains safety guidelines to protect personnel, as well as information about use, storage, handling, and emergency procedures.

Always refer to the applicable Material Safety Data Sheet before doing the following:

- handling a chemical product
- disassembling any portion of Husky equipment that may result in exposure to a chemical product

Contact the material supplier to obtain a copy of the MSDS sheet.

2.8 Materials, Parts and Processing

To prevent personal injury or damage to the equipment, make sure of the following:

- The equipment is only used for its intended purpose, as described in the manuals
- The operating temperatures do not exceed the specified permissible maximum value
- The maximum temperature set point is set below the ignition point of the material being processed
- Lubricants, oils, process materials and tools used on equipment meet Husky specifications
- Only authentic Husky parts are used

Chapter 3 Startup and Operation

This chapter describes how to safely startup and operate the hot runner. Follow these instructions along with any in the machine manufacturer's documentation.



IMPORTANT!

Refer to the hot runner *Service Manual* for additional, system-specific startup instructions. If the hot runner is installed in a Husky machine, refer to the machine *Operator Manual* as well.

To startup the hot runner for operation, perform the following procedures in order:

Step	Task	Reference
1	Prepare the hot runner	Section 3.1
2	Heat up the mold, hot runner and machine	Section 3.2
3	Precharge the hot runner with resin	Section 3.3
4	Produce test parts	Section 3.4



IMPORTANT!

The mold and hot runner must be installed properly by qualified personnel before production begins.



IMPORTANT!

Hot runners may not be put into service in a machine that does not comply with the provisions of Machinery Directive 2006/42/EC, as amended, and with the regulations transposing it into national law.



IMPORTANT!

Some sprue bars are equipped with an anti-drool and/or ball check device to help prevent drool out of the sprue bar. If your system is equipped with this device, then before the operator enters the purge area of the machine during start-up, shutdown, maintenance or servicing they must increase the temperature on the sprue bar zone closest to the machine nozzle and verify the end of the anti-drool bushing and/or ball check is 20°C to 25°C (36°F to 45°F) greater than the melt temperature of the resin as indicated on the nameplate to make sure that free flow is facilitated from the purge end of the sprue bar. This can be verified by the thermocouple reading of the sprue bar zone closest to the machine nozzle on the hot runner controller.

3.1 Preparing the Hot Runner

To prepare the hot runner for startup, do the following:

1. Lock out and tag the machine and controller (if equipped). Refer to [Section 2.5](#) for more information.
2. Make sure the mold and hot runner are installed properly.
3. Make sure the heaters and thermocouples are connected to the machine or a controller.
4. Make sure the resin type in the machine matches the required type indicated on the hot runner nameplate. Refer to [Section 1.5](#) for more information about the nameplate.

CAUTION!

Mechanical hazard – risk of damage to the hot runner. In the event of water leaking into the hot runner, the nozzle heaters could fail. Make sure all water is removed before starting up the hot runner.

5. Using compressed air, remove any water around the nozzle tips and parting lines.
6. If equipped, make sure the maintenance pins are removed.
7. Make sure all safety latches have been removed from the mold and hot runner.
8. Remove all locks and tags. Refer to [Section 2.5](#) for more information.

3.2 Heating Up the Hot Runner, Mold and Machine

To bring the hot runner, mold and machine up to operating temperature, do the following:



IMPORTANT!

The heating procedure is different for systems equipped with sprue bars. For systems without sprue bars, refer to [Section 3.2.2](#). For systems equipped with sprue bars, refer to [Section 3.2.1](#).

3.2.1 Heating Up the Hot Runner, Mold and Machine - Systems Equipped with Sprue Bars

To bring the hot runner, mold and machine up to operating temperature, do the following:

1. If equipped, make sure the dryer is enabled and adjusted to the proper operating temperature.
2. Make sure the water chiller is enabled and adjusted to the proper operating temperature.
3. If equipped, make sure the mold enclosure de-humidifier, air compressor and water tower supplies are enabled.

4. Check the air pressure settings for the machine.
5. Make sure the compressed air for the mold is turned off. If the compressed air is left on as the hot runner heats up, air will leak from the system. This will cool the hot runner and delay the startup.
6. Slowly open the clamp to full shutheight.
7. Turn on the mold/hot runner cooling system.

**WARNING!**

Hot resin spray hazard – risk of death or serious injury. Overheated resin can generate pressurized gas that when suddenly released can cause material to spray out. Do not allow resin to overheat. If the startup process is interrupted, turn off all barrel heaters and retract the injection unit to allow the hot runner to vent between the machine nozzle and the sprue bar. For extended delays, follow the machine manufacturer’s and resin supplier’s procedures for machine shutdown.

8. Turn on the machine barrel heaters and allow them to reach operating temperature.
NOTE: The time required for the machine barrel heaters to reach operating temperature will depend on size of the injection unit.
9. If equipped, turn on the temperature controller.

CAUTION!

Mechanical hazard – risk of damage to the hot runner. The manifold temperature must not exceed 350 °C (662 °F). Exceeding this temperature could result in component failure.

10. Set the temperature of the main manifold heaters, cross manifold heaters (if equipped), and transfer bushing heaters (if equipped) to the melt temperature indicated on the nameplate. Refer to [Section 1.5](#) for more information about the nameplate.
NOTE: The actual resin temperature leaving the barrel should match the temperature on the nameplate.

**WARNING!**

Hot resin spray hazard – risk of death or serious injury. The sprue bar heater must be turned on when the manifold heaters are turned on. Failure to do so could result in the generation of dangerous pressure levels in the manifold, resulting in the sudden release of hot resin.

**WARNING!**

Hot resin spray hazard – risk of death or serious injury. The sprue bar zone closest the machine nozzle must be set 20°C to 25°C (36°F to 45°F) greater than melt temperature indicated on the nameplate. Failure to do so could impede the free flow of plastic and generate dangerous pressure levels in the manifold, resulting in the sudden release of hot resin.

11. Set the temperature for the sprue bar zone closest to manifold to melt temperature indicated on the nameplate. Set the temperature for the sprue bar zone closest to machine nozzle 20°C to 25°C (36°F to 45°F) greater than melt temperature indicated on the nameplate. For more information, refer to [Section 1.5](#).
12. For sprue bars equipped with an anti-drool and/or ball check device: Verify the end of the anti-drool bushing and/or ball check is 20°C to 25°C (36°F to 45°F) greater than the melt temperature of the resin as indicated on the nameplate by the thermocouple reading of the sprue bar zone closest to the machine nozzle on the hot runner controller.
13. Once the barrel heats have reached the set point temperature, turn on the sprue bar zones. The temperature of the sprue bar closest to the machine nozzle should be 20°C to 25°C (36°F to 45°F) hotter than the resin melt temperature to facilitate startup process.



WARNING!

Hot resin spray hazard – risk of death or serious injury. A blocked sprue bar can release molten plastic violently and unexpectedly. Do not attempt to clear sprue bar blockage by using heat or pressure. Do not open the purge guard area. Allow the system to cool down, then repeat [step 1](#) through [step 13](#). If blockage persists contact Husky.

14. Once the sprue bar has reached the set point temperature, slowly close the mold and mate the radius of the machine nozzle up to the radius of the anti-drool/ball check on the end of the sprue bar.
15. Once the mold is closed, turn on the main manifold and cross manifold (if equipped) zones. The temperature of the manifolds should match the resin melt temperature.
16. If equipped with transfer bushings, once the main manifolds and cross manifolds have reached the set point temperature, turn on the transfer bushing heaters to reduce the risk of wear between the cross manifold and transfer bushing interface,
17. Once the main manifolds, cross manifolds (if equipped) and transfer bushings (if equipped) have reached the set point temperature, wait an additional 20 minutes or more of soak time.
18. Open the process material feed. Refer to the machine manufacturer's documentation for more information.

3.2.2 Heating Up the Hot Runner, Mold and Machine - Systems Not Equipped With Sprue Bars

To bring the hot runner, mold and machine up to operating temperature, do the following:

1. If equipped, make sure the dryer is enabled and adjusted to the proper operating temperature.
2. Make sure the water chiller is enabled and adjusted to the proper operating temperature.
3. If equipped, make sure the mold enclosure de-humidifier, air compressor and water tower supplies are enabled.
4. Make sure the compressed air for the mold is turned off. If the compressed air is left on as the hot runner heats up, air will leak from the system. This will cool the hot runner and delay the startup.

5. Slowly open the clamp to full shutheight.
6. Turn on the hot runner cooling system.



WARNING!

Hot resin spray hazard – risk of serious injury. Overheated resin can generate pressurized gas that when suddenly released can cause material to spray out. Do not allow resin to overheat. If the startup process is interrupted, turn off all barrel heaters and retract the injection unit to allow the hot runner to vent between the machine nozzle and the sprue bushing. For extended delays, follow the machine manufacturer’s and resin supplier’s procedures for machine shutdown.

7. Turn on the machine barrel heaters and allow them approximately 1/2 to 1 1/2 hours to reach operating temperature, depending on the size of the injection unit.
8. If equipped, turn on the controller.

CAUTION!

Mechanical hazard – risk of damage to the hot runner. The manifold temperature must not exceed 350 °C (662 °F). Exceeding this temperature could result in component failure.

9. Set the temperature of the main manifold heaters, cross manifold heaters (if equipped) and sprue heater (if equipped) to the melt temperature indicated on the nameplate. Refer to [Section 1.5](#) for more information about the nameplate.



WARNING!

Hot resin spray hazard – risk of serious injury. The sprue heater (if equipped) must be turned on when the manifold heaters are turned on. Failure to do so could result in the generation of dangerous pressure levels in the manifold, resulting in the sudden release of hot resin.

10. Turn on the main manifold heaters, cross manifold heaters (if equipped) and sprue heater (if equipped) zones. Wait an additional 10 minutes or more of soak time to make sure the resin has reached the operating temperature.
11. Make sure the main manifold heaters and the cross manifold heaters (if equipped) reach the set temperature.
12. Turn on the transfer bushing heaters (if equipped) zones. Wait for the heaters to reach the operating temperature and then wait an additional 10 minutes or more of soak time to make sure the resin has reached the operating temperature.
13. Open the process material feed. Refer to the machine manufacturer’s documentation more information.

3.3 Precharging the Hot Runner

To precharge the hot runner with resin, do the following:

1. Close the clamp and apply tonnage.



WARNING!

Hot resin spray hazard – risk of serious injury. Molten resin under high pressure can suddenly release and spray out from the machine nozzle. Before purging the injection unit, clear the area of all non-essential personnel and wear Personal Protective Equipment (PPE) consisting of a heat-resistant coat, heat-resistant gloves and a full face shield over safety glasses.

2. For systems equipped with sprue bars: Move the machine nozzle to the purge position making sure the machine nozzle is away from the sprue bar.
3. Purge the injection unit. Refer to the machine manufacturer's documentation for more information.
4. Clean the machine nozzle, stationary platen and purge guard of any resin deposits. Refer to the machine manufacturer's documentation for more information.
5. Make sure the machine nozzle is firmly seated against the sprue bushing.
6. Turn on the nozzle heaters and allow them approximately 5 to 7 minutes before mold operation to reach operating temperature.

CAUTION!

Mechanical hazard – risk of damage to equipment. Do not allow the nozzle tips to stay energized for more than 10 minutes without injecting resin. Resin residing in the nozzle tip area will degrade.

7. While the nozzle heaters are reaching operating temperature, do the following:
 - a. Turn on the extruder screw to start plasticizing the resin.
 - b. Repeat [step 3](#) to [step 4](#).
8. Make sure the valve gates are in the open position or open automatically during injection.
9. Move the machine nozzle forward until it is firmly seated against the sprue bushing.

NOTE: The hot runner channels are properly filled with resin when the injection piston stops before making contact with the injection housing.
10. Slowly inject resin into the hot runner until the injection piston stops. The piston must stop before it makes contact with the injection housing. If the piston makes contact with the injection housing, inject resin again.
11. Once the injection piston stops, start the extruder screw and make sure it retracts fully.

3.4 Producing Test Parts

To produce test parts that will verify the settings and functions for the hot runner and machine, do the following:

- 1.** Make sure the nozzle heaters have not timed out. If the nozzle heaters have timed out, do the following:
 - a.** Enable the heaters and allow them approximately 5 to 7 minutes to reach operating temperature.
 - b.** Purge the injection unit. Refer to the machine manufacturer's documentation for more information.
 - c.** Clean the machine nozzle, stationary platen and purge guard of any resin deposits. Refer to the machine manufacturer's documentation for more information.
- 2.** Close the clamp and apply tonnage.
- 3.** Make sure the machine nozzle is firmly seated against the sprue bushing.
- 4.** Reduce the injection pressure to 70 bar (1000 psi).
- 5.** Disable all ejector functions to prevent the machine from automatically ejecting parts.
- 6.** Cycle the machine once in normal mode to produce a set of parts.
- 7.** Check that all parts have been properly molded.
- 8.** Manually control the ejector functions to eject the parts.
- 9.** If all cavities are producing parts, reset the injection pressure to the recommended value.
- 10.** Cycle the machine four times in normal mode to produce parts. This will remove any air trapped in the resin.
- 11.** Visually inspect the last set of parts to verify the part quality. Repeat [step 10](#) until the part quality is satisfactory.
- 12.** Enable the ejector functions.
- 13.** If equipped, enable the product handling equipment.
- 14.** Cycle the machine 10 times in semi-cycle mode. During each cycle, if equipped, make sure the product handling equipment properly transfers the parts to the conveyor.
- 15.** Enable the auto-cycle mode for the machine and begin production.
- 16.** For systems equipped with sprue bars: Once running in auto-cycle, reduce the sprue bar zone closest to the machine nozzle to the temperature indicated on the nameplate. For more information, refer to the hot runner *Service Manual*.

Chapter 4 Maintenance

As part of a preventive maintenance program, the following is a list of standard maintenance tasks that should be performed on a regular basis. Some tasks may not be applicable to all hot runners. Refer to the hot runner *Service Manual* for a list of specific maintenance tasks, as well as detailed instructions on how to perform each task.



WARNING!

Chemical hazard - Some of the chemicals used with Husky equipment are potentially hazardous and could cause injury and illness. Before storing, handling, or working with any chemical or hazardous material, thoroughly read and understand each applicable Material Safety Data Sheet (MSDS), use recommended personal protective equipment and follow the manufacturer's instructions.

Interval	Cycles	Task Description	Reference
Every 6 Months	800,000	Test the hot runner heaters	<i>Service Manual</i>
Every 12 Months	1,600,000	Inspect the valve stem and piston assemblies	<i>Service Manual</i>
Every 18 Months	2,000,000	Replace the double delta seals	<i>Service Manual</i>

