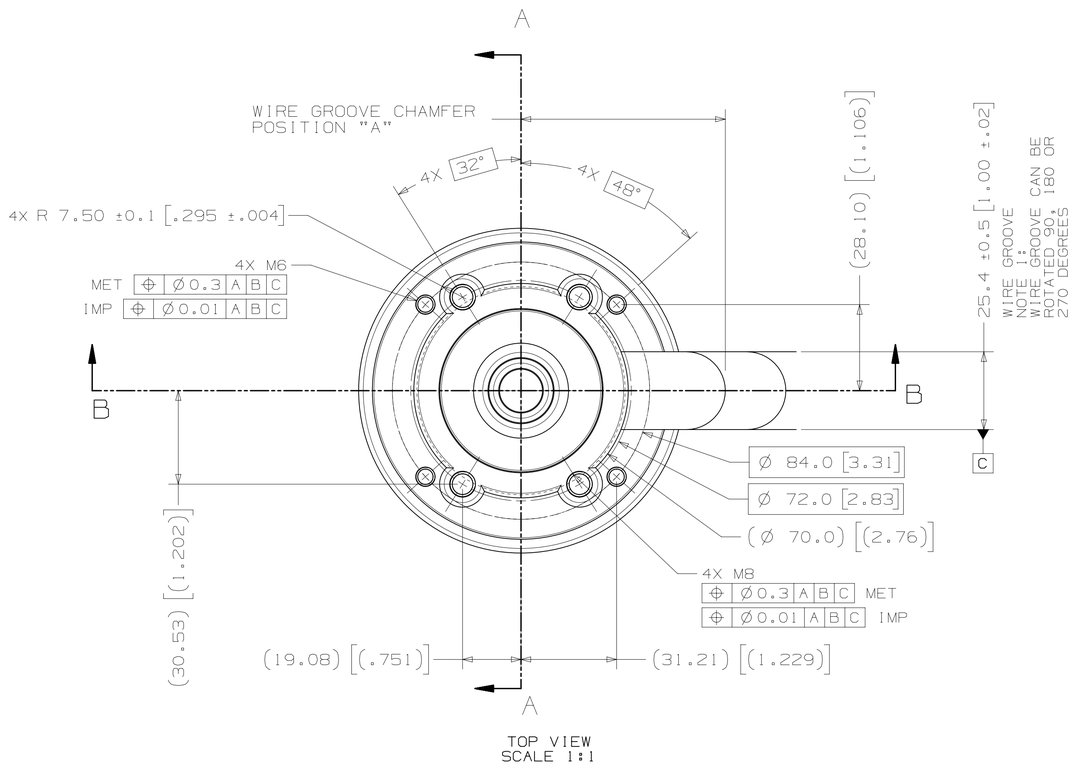
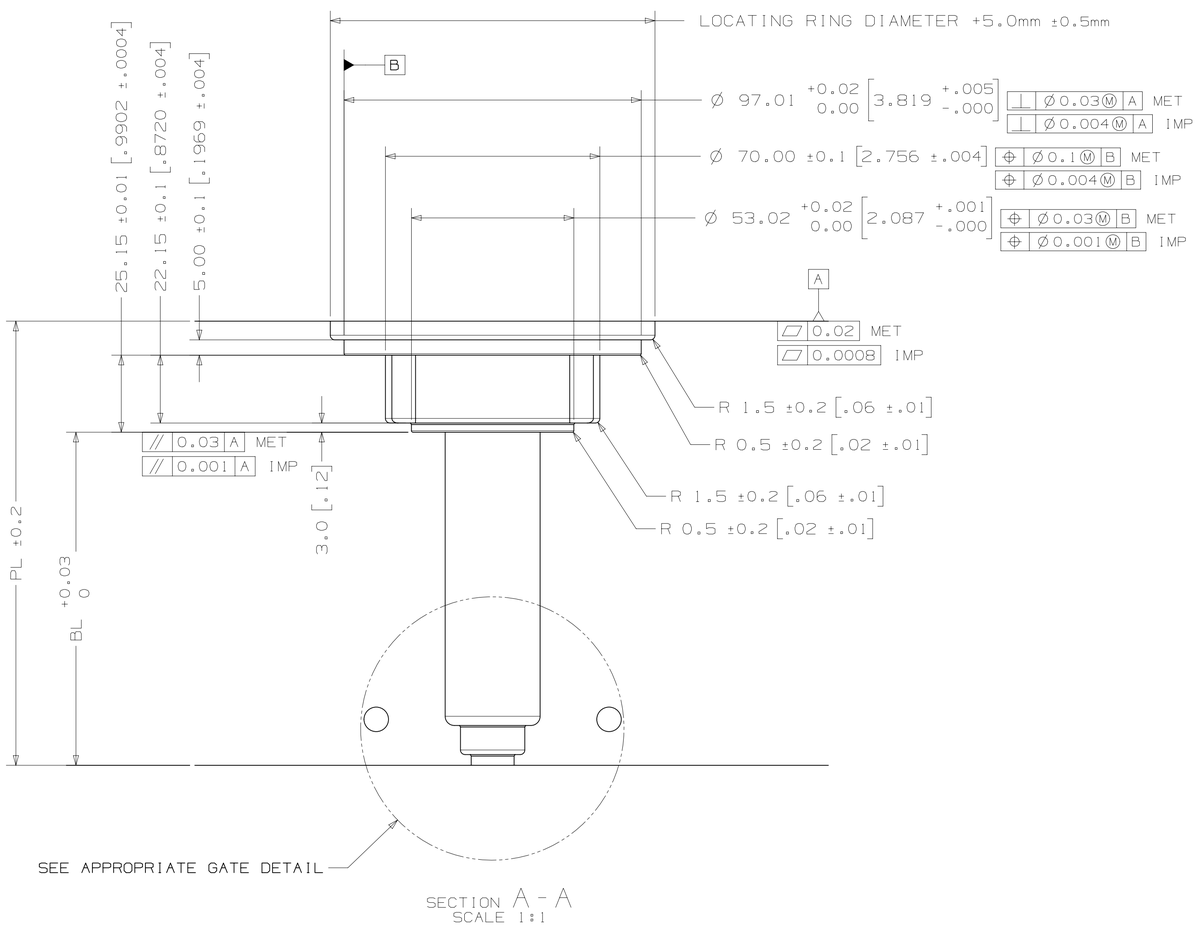
INSTALLATION DRAWING

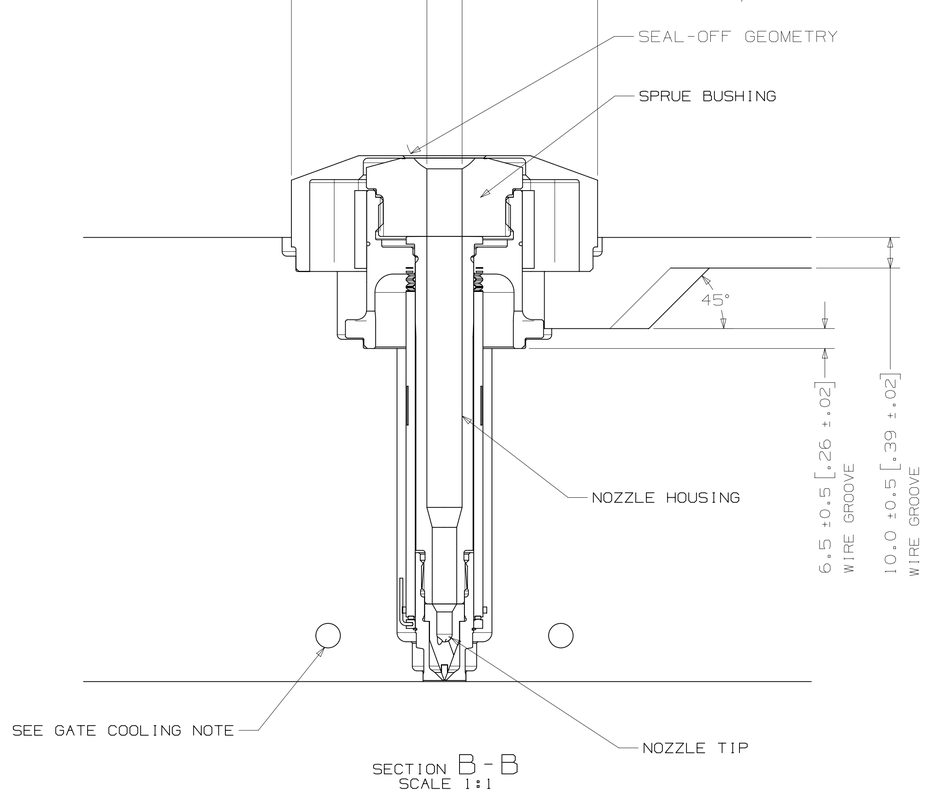
DRAWING 8088142 REV 0



TOP VIEW
SCALE 1:1



SECTION A - A
SCALE 1:1



SECTION B - B
SCALE 1:1

NOZZLE SERIES	NOZZLE TIP	NOZZLE HOUSING LENGTH	PL MIN [INCH]	PL MAX [INCH]	"BL" AT DELTA TEMP (DELTA TEMP = TEMP OF MELT - TEMP OF MOLD)* 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 [536° F-572° F]
U750	HT-CAP	50	69 [2.717]	78 [3.071]	38.45 [1.514]	38.46 [1.514]	38.47 [1.515]	38.49 [1.515]	38.50 [1.516]	38.51 [1.516]	38.53 [1.517]	38.54 [1.517]	38.55 [1.518]	38.57 [1.519]	38.58 [1.519]	38.60 [1.520]
		60	79 [3.110]	88 [3.465]	48.46 [1.908]	48.47 [1.908]	48.49 [1.909]	48.50 [1.909]	48.52 [1.910]	48.53 [1.911]	48.55 [1.911]	48.56 [1.912]	48.58 [1.913]	48.60 [1.913]	48.61 [1.914]	48.63 [1.915]
		70	89 [3.504]	98 [3.858]	58.47 [2.302]	58.48 [2.302]	58.50 [2.303]	58.52 [2.304]	58.53 [2.304]	58.55 [2.305]	58.57 [2.306]	58.59 [2.307]	58.61 [2.307]	58.63 [2.308]	58.65 [2.309]	58.67 [2.310]
		80	99 [3.898]	108 [4.252]	68.47 [2.696]	68.49 [2.696]	68.51 [2.697]	68.53 [2.698]	68.55 [2.699]	68.57 [2.700]	68.59 [2.700]	68.61 [2.701]	68.63 [2.702]	68.66 [2.703]	68.68 [2.704]	68.70 [2.705]
		90	109 [4.291]	118 [4.646]	78.48 [3.090]	78.50 [3.091]	78.52 [3.091]	78.55 [3.093]	78.57 [3.093]	78.59 [3.094]	78.61 [3.095]	78.64 [3.096]	78.66 [3.097]	78.68 [3.098]	78.71 [3.099]	78.74 [3.100]
		100	119 [4.685]	128 [5.039]	88.49 [3.484]	88.51 [3.485]	88.54 [3.486]	88.56 [3.487]	88.59 [3.488]	88.61 [3.489]	88.64 [3.490]	88.66 [3.491]	88.69 [3.492]	88.71 [3.493]	88.74 [3.494]	88.77 [3.495]
		110	129 [5.079]	138 [5.433]	98.50 [3.878]	98.52 [3.879]	98.55 [3.880]	98.58 [3.881]	98.60 [3.882]	98.63 [3.883]	98.66 [3.884]	98.69 [3.885]	98.72 [3.887]	98.74 [3.887]	98.78 [3.889]	98.81 [3.890]
		120	139 [5.472]	148 [5.827]	108.50 [4.272]	108.53 [4.273]	108.56 [4.274]	108.59 [4.275]	108.62 [4.276]	108.65 [4.278]	108.68 [4.279]	108.71 [4.280]	108.74 [4.281]	108.77 [4.282]	108.81 [4.284]	108.84 [4.285]
		130	149 [5.866]	158 [6.220]	118.51 [4.666]	118.54 [4.667]	118.57 [4.668]	118.60 [4.669]	118.64 [4.671]	118.67 [4.672]	118.70 [4.673]	118.74 [4.675]	118.77 [4.676]	118.80 [4.677]	118.84 [4.679]	118.88 [4.680]
		140	159 [6.260]	168 [6.614]	128.52 [5.060]	128.55 [5.061]	128.59 [5.063]	128.62 [5.064]	128.65 [5.065]	128.69 [5.067]	128.72 [5.068]	128.76 [5.069]	128.80 [5.071]	128.83 [5.072]	128.87 [5.074]	128.91 [5.075]
		150	169 [6.654]	178 [7.008]	138.53 [5.454]	138.56 [5.455]	138.60 [5.457]	138.63 [5.458]	138.67 [5.459]	138.71 [5.461]	138.75 [5.463]	138.78 [5.464]	138.82 [5.465]	138.86 [5.467]	138.91 [5.469]	138.95 [5.470]
		160	179 [7.047]	188 [7.402]	148.54 [5.848]	148.57 [5.849]	148.61 [5.851]	148.65 [5.852]	148.69 [5.854]	148.73 [5.856]	148.77 [5.857]	148.81 [5.859]	148.85 [5.860]	148.89 [5.862]	148.94 [5.864]	148.98 [5.865]
		170	189 [7.441]	198 [7.795]	158.54 [6.242]	158.58 [6.243]	158.62 [6.245]	158.66 [6.246]	158.71 [6.248]	158.75 [6.250]	158.79 [6.252]	158.83 [6.253]	158.88 [6.255]	158.92 [6.257]	158.97 [6.259]	159.02 [6.261]
		180	199 [7.835]	208 [8.189]	168.55 [6.636]	168.59 [6.637]	168.64 [6.639]	168.68 [6.641]	168.72 [6.643]	168.77 [6.644]	168.81 [6.646]	168.86 [6.648]	168.90 [6.650]	168.95 [6.652]	169.00 [6.654]	169.05 [6.656]
		190	209 [8.228]	218 [8.583]	178.56 [7.030]	178.60 [7.031]	178.65 [7.033]	178.69 [7.035]	178.74 [7.037]	178.79 [7.039]	178.83 [7.041]	178.88 [7.043]	178.93 [7.044]	178.98 [7.046]	179.04 [7.049]	179.09 [7.051]
		200	219 [8.622]	229 [9.016]	188.57 [7.424]	188.61 [7.426]	188.66 [7.428]	188.71 [7.430]	188.76 [7.431]	188.81 [7.433]	188.86 [7.435]	188.91 [7.437]	188.96 [7.439]	189.01 [7.441]	189.07 [7.444]	189.12 [7.446]

* BL VALUES IN THE TABLE ARE REFERENCES WHICH CAN DEVIATE BY +/-0.03mm
FINAL BL VALUE CAN BE FIND ON GATE DETAIL DRAWING AND 3D AFTER FINISHED DESIGN.

	LOCATING RING DIAMETER	WIRE GROOVE CHAMFER POSITION "A" (±2.0)
U750	100mm	66.7
	101.3mm [3.99"]	66.7
	125mm	78.7

	SPRUE BUSHING	
	SEAL-OFF GEOMETRY SPHERICAL RADIUS	CHANNEL Ø IN - OUT
U750	FLAT	4 - 11.5
	FLAT	11.5-THRU
	SEAL-OFF 12.7 [1/2"]	
	SEAL-OFF 15.5	
	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 www.husky.ca 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

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
			DRWN:
			CHKD:
			DRWN:
			CHKD:
			DRWN:
			CHKD:
			DRWN:
			CHKD:
0	2017-09-04	ORIGINAL ISSUE - DESIGNED BY: DHANANJEYAN	DRWN: DHANANJEYAN
			CHKD: PICHLER KLAUS

GD&T PER ASME Y14.5M-1994 AND HUSKY ADDENDUM - HS254
UNLESS OTHERWISE SPECIFIED:
CAD MODEL IS BASIC. NON-TOLERANCED DIMENSIONS ARE BASIC.

	METRIC	IMPERIAL
GENERAL TOLERANCE:	±0.4 ?	±0.02 ?
BROKEN EDGE/CHAMFER:	1 ±0.2 X 45°	0.04 ±0.01 X 45°
FILLET/ROUND:	R0.8 ±0.2	R0.03 ±0.01
SURFACE FINISH:	6.3	

FOR TORQUE SPECIFICATIONS, REFER TO HS 252

WEIGHT
- kg

METRIC

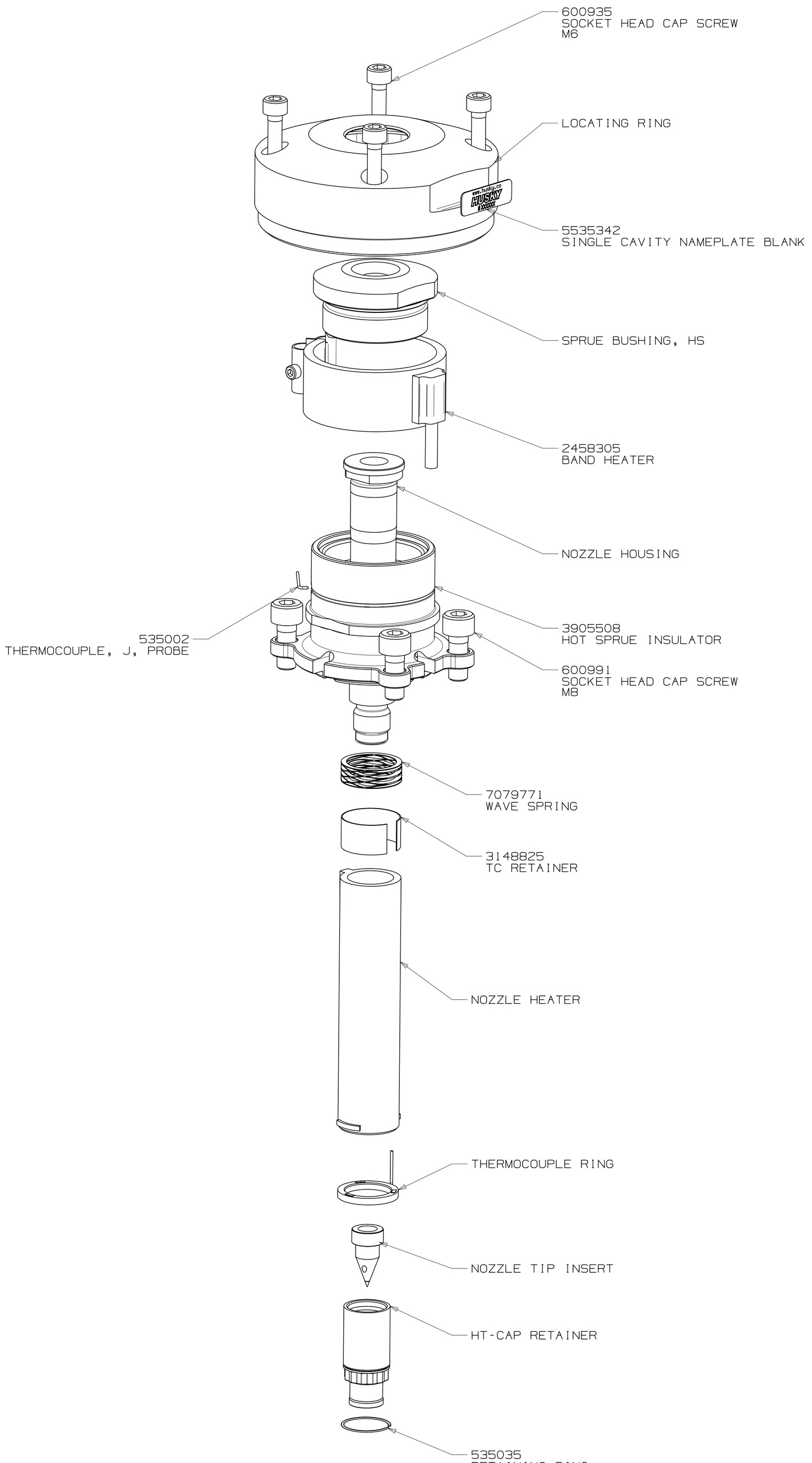
HUSKY

TITLE
HOT SPRUE
U750-HT-CAP

SCALE	SIZE	DRAWING	REV
NONE	A0R	8088142	0
SHEET 1 OF 2			

ASSEMBLY DRAWING

DRAWING 8088142 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 www.husky.ca 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

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
			DRWN:
			CHKD:
			DRWN:
			CHKD:
			DRWN:
			CHKD:
			DRWN:
			CHKD:
0	2017-09-04	ORIGINAL ISSUE - DESIGNED BY: DHANANJEYAN	DRWN: DHANANJEYAN
			CHKD: PICHLER KLAUS

FOR TORQUE SPECIFICATIONS, REFER TO HS 252

WEIGHT - kg

METRIC

HUSKY

TITLE
HOT SPRUE
U750-HT-CAP

SCALE	SIZE	DRAWING	REV
NONE	A1R	8088142	0

SHEET 2 OF 2