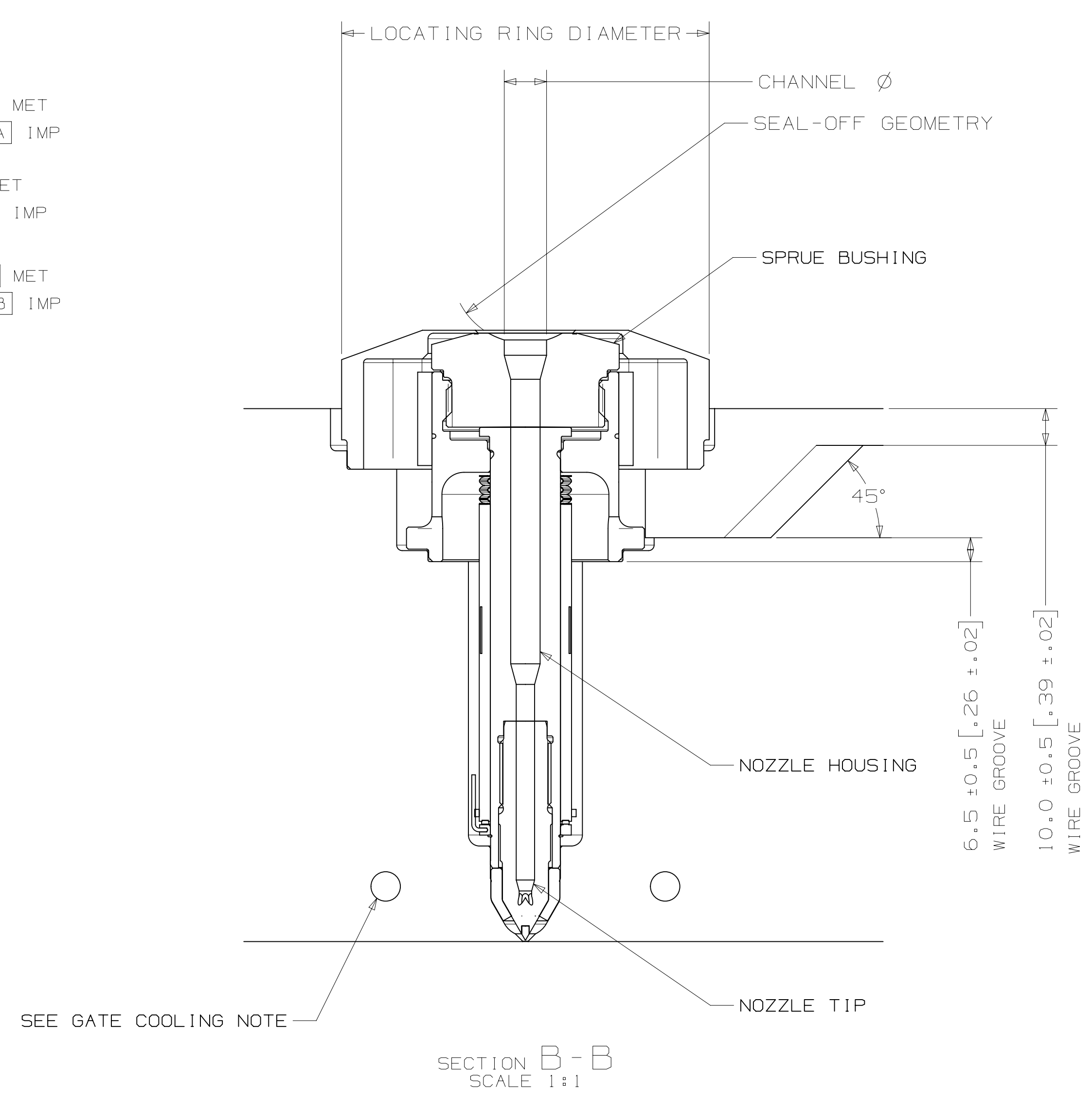
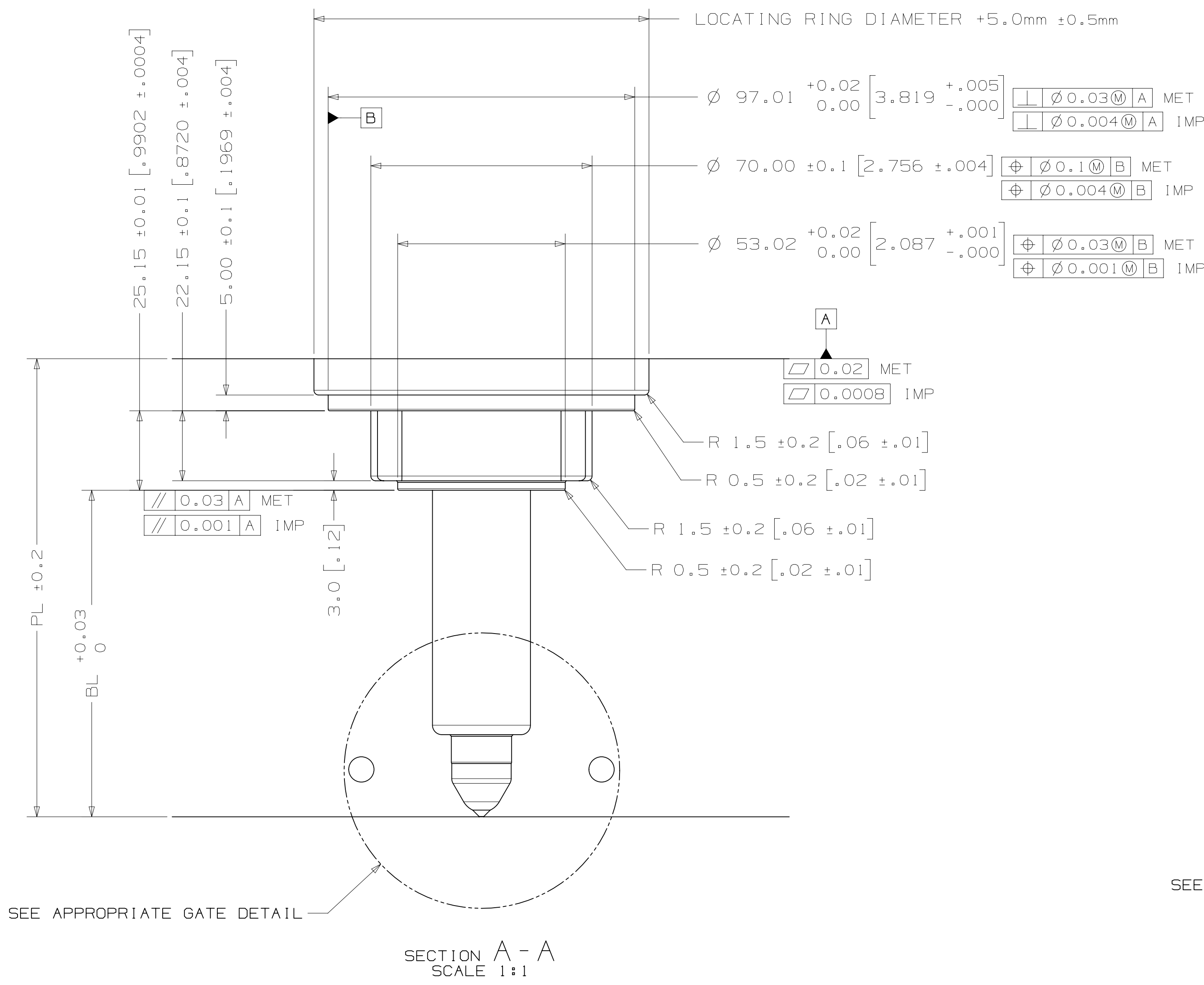
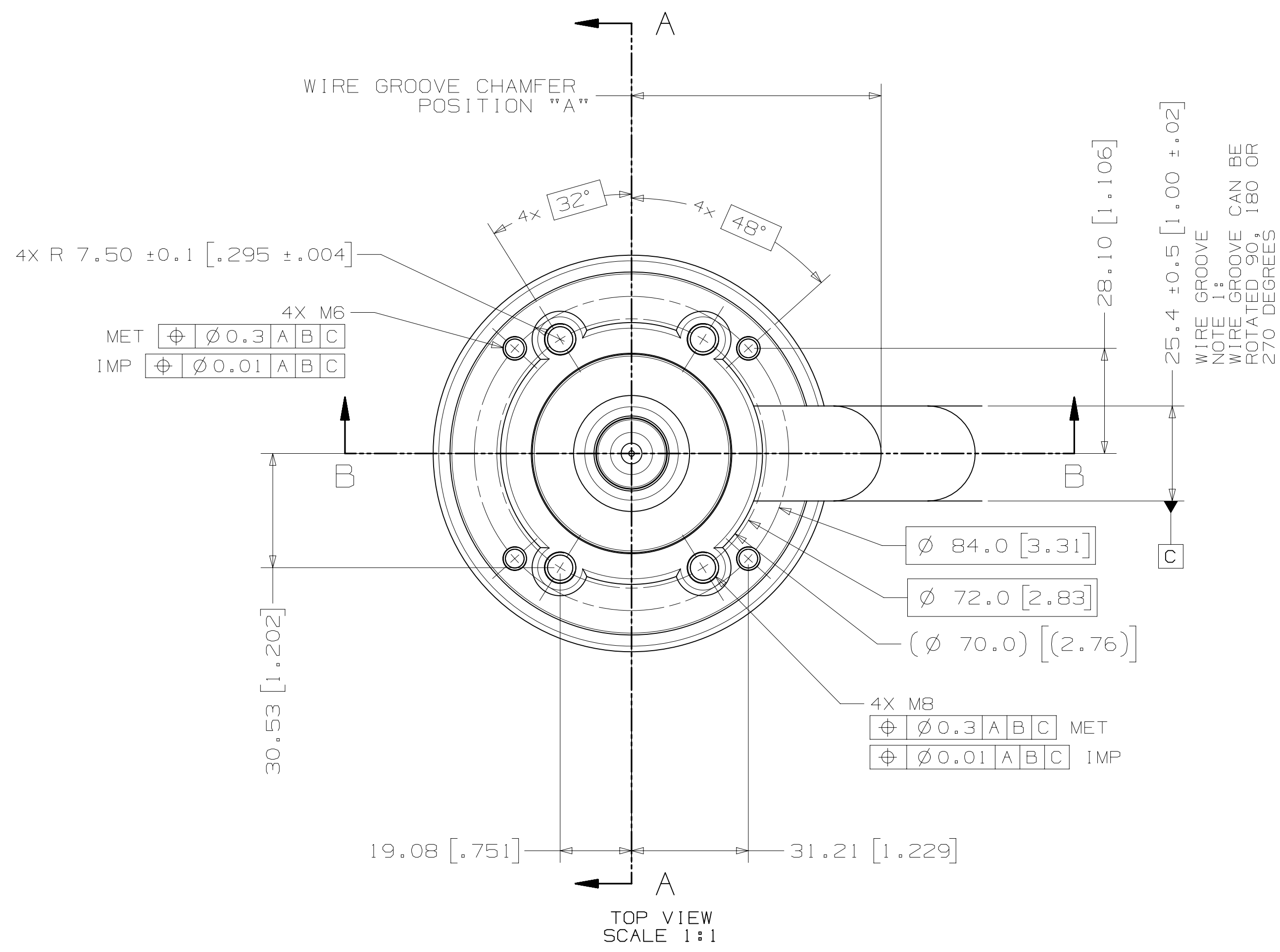


# INSTALLATION DRAWING

DRAWING NO. 8091885 0



NOZZLE SERIES	NOZZLE TIP	NOZZLE HOUSING		"BL" AT DELTA TEMP (DELTA TEMP = TEMP OF MELT - TEMP OF MOLD) *															
		LENGTH	MIN ( INCH )	MAX ( INCH )	60° C-79° C (149° 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-189° C (352° F-390° F)	200° C-219° C (382° F-426° F)	220° C-239° C (422° 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)			
U750	HT-S	60	73 (2.874)	82 (3.228)	43.03 (1.694)	43.05 (1.695)	43.08 (1.696)	43.10 (1.697)	43.12 (1.698)	43.14 (1.699)	43.16 (1.699)	43.19 (1.700)	43.21 (1.701)	43.23 (1.702)	43.26 (1.703)	43.28 (1.704)			
		70	83 (3.268)	92 (3.622)	53.04 (2.088)	53.06 (2.089)	53.09 (2.090)	53.11 (2.091)	53.14 (2.092)	53.16 (2.093)	53.18 (2.094)	53.21 (2.095)	53.24 (2.096)	53.26 (2.097)	53.29 (2.098)	53.32 (2.099)			
		80	93 (3.661)	102 (4.016)	63.05 (2.482)	63.07 (2.483)	63.10 (2.484)	63.13 (2.485)	63.15 (2.486)	63.18 (2.487)	63.21 (2.489)	63.23 (2.489)	63.26 (2.491)	63.29 (2.492)	63.32 (2.493)	63.35 (2.494)			
		90	103 (4.055)	112 (4.409)	73.06 (2.876)	73.08 (2.877)	73.11 (2.878)	73.14 (2.880)	73.17 (2.881)	73.20 (2.882)	73.23 (2.883)	73.26 (2.884)	73.29 (2.885)	73.32 (2.887)	73.36 (2.888)	73.39 (2.889)			
		100	113 (4.449)	122 (4.803)	83.06 (3.270)	83.09 (3.271)	83.12 (3.272)	83.16 (3.274)	83.19 (3.275)	83.22 (3.276)	83.25 (3.278)	83.28 (3.279)	83.32 (3.280)	83.35 (3.281)	83.39 (3.283)	83.42 (3.284)			
		110	123 (4.843)	132 (5.197)	93.07 (3.664)	93.10 (3.665)	93.14 (3.667)	93.17 (3.668)	93.20 (3.669)	93.24 (3.671)	93.27 (3.672)	93.31 (3.674)	93.34 (3.675)	93.38 (3.676)	93.42 (3.678)	93.46 (3.680)			
		120	133 (5.236)	142 (5.591)	103.08 (4.058)	103.11 (4.059)	103.15 (4.061)	103.18 (4.062)	103.22 (4.064)	103.26 (4.065)	103.29 (4.067)	103.33 (4.068)	103.37 (4.070)	103.41 (4.071)	103.45 (4.073)	103.49 (4.074)			
		130	143 (5.630)	152 (5.984)	113.09 (4.452)	113.12 (4.454)	113.16 (4.455)	113.20 (4.457)	113.24 (4.458)	113.28 (4.460)	113.32 (4.461)	113.36 (4.463)	113.40 (4.465)	113.44 (4.466)	113.49 (4.468)	113.53 (4.470)			
		140	153 (6.024)	162 (6.378)	123.10 (4.846)	123.13 (4.848)	123.17 (4.849)	123.21 (4.851)	123.26 (4.853)	123.30 (4.854)	123.34 (4.856)	123.38 (4.857)	123.42 (4.859)	123.47 (4.861)	123.52 (4.863)	123.56 (4.865)			
		150	163 (6.417)	173 (6.811)	133.10 (5.240)	133.14 (5.242)	133.19 (5.244)	133.23 (5.245)	133.27 (5.247)	133.32 (5.249)	133.36 (5.250)	133.41 (5.252)	133.45 (5.254)	133.50 (5.256)	133.55 (5.258)	133.60 (5.260)			
		160	174 (6.850)	183 (7.205)	143.11 (5.634)	143.15 (5.636)	143.20 (5.638)	143.24 (5.639)	143.29 (5.641)	143.34 (5.643)	143.38 (5.645)	143.43 (5.647)	143.48 (5.649)	143.53 (5.651)	143.58 (5.653)	143.63 (5.655)			
		170	184 (7.244)	193 (7.598)	153.12 (6.028)	153.16 (6.030)	153.21 (6.032)	153.26 (6.034)	153.31 (6.036)	153.36 (6.038)	153.40 (6.039)	153.46 (6.042)	153.51 (6.044)	153.56 (6.046)	153.62 (6.048)	153.67 (6.050)			
180	194 (7.638)	203 (7.992)	163.13 (6.422)	163.18 (6.424)	163.22 (6.426)	163.27 (6.428)	163.32 (6.430)	163.37 (6.432)	163.43 (6.434)	163.48 (6.436)	163.53 (6.438)	163.59 (6.441)	163.65 (6.443)	163.70 (6.445)					
190	204 (8.031)	213 (8.386)	173.13 (6.816)	173.19 (6.819)	173.24 (6.820)	173.29 (6.822)	173.34 (6.824)	173.39 (6.826)	173.45 (6.829)	173.50 (6.831)	173.56 (6.833)	173.62 (6.835)	173.68 (6.838)	173.74 (6.840)					
200	214 (8.425)	224 (8.819)	183.14 (7.210)	183.20 (7.213)	183.25 (7.215)	183.30 (7.217)	183.36 (7.219)	183.41 (7.221)	183.47 (7.223)	183.53 (7.226)	183.59 (7.228)	183.65 (7.230)	183.71 (7.233)	183.77 (7.235)					

\* 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)
100mm	66.7
101.3mm (3.99")	66.7
125mm	78.7

SEAL-OFF GEOMETRY	CHANNEL Ø IN - OUT
FLAT	4 - 8
FLAT	4 - 8
SEAL-OFF 12.7 (1/2")	11.5 - 8
SEAL-OFF 15.5	11.5 - 8
SEAL-OFF 19.05 (3/4")	11.5 - 8
SEAL-OFF 20	11.5 - 8
SEAL-OFF 40	11.5 - 8

**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  
A1S1 H13 (48-5) Rc1  
A1S1 420 (48-5) Rc1

**RECOMMENDED GATE MANUFACTURING GUIDELINES**

- HARDENED GATE INSERTS (48-5) 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.

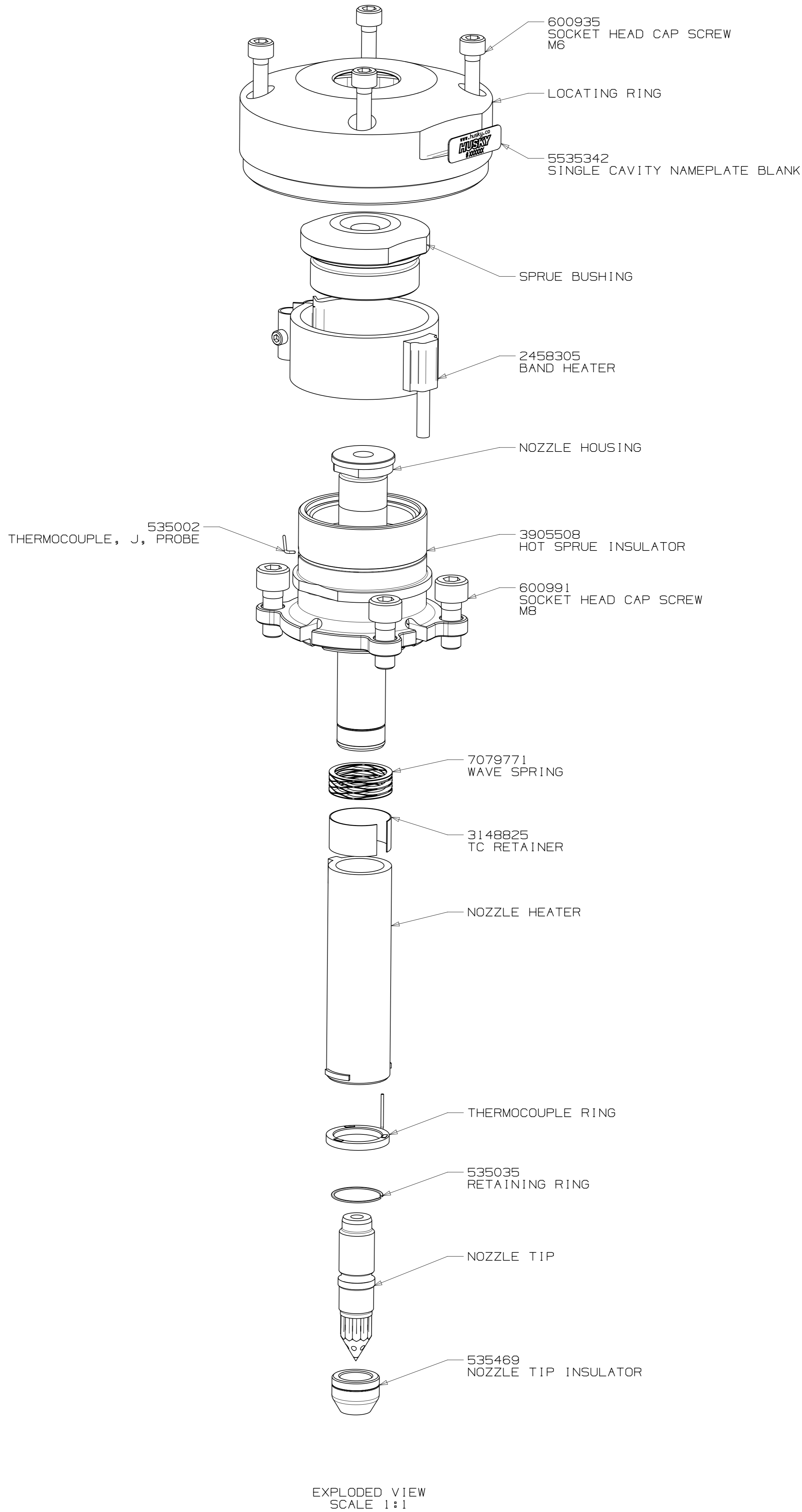
REV	DATE	DESCRIPTION	DRWN	CHKD
0	2017-09-07	ORIGINAL ISSUE - DESIGNED BY DHANALEYAN	DRWN: DHANALEYAN	CHKD: PICHLER KLAUS

FOR TORQUE SPECIFICATIONS, REFER TO HS 252	METRIC	IMPERIAL
0.5 ± 0.02	0.04 ± 0.01 X 45°	0.04 ± 0.01 X 45°
0.04 ± 0.02	0.04 ± 0.01 X 45°	0.04 ± 0.01 X 45°
0.04 ± 0.02	0.04 ± 0.01 X 45°	0.04 ± 0.01 X 45°

TITLE	SCALE	SIZE	DRAWING	REV
HOT SPRUE	SCALE N02	SIZE AOR	DRAWING 8091885	REV 0

# ASSEMBLY DRAWING

DRAWING 8091885 REV 0



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 = (-)	
<b>RECOMMENDED GATE COOLING GUIDELINES</b> ADEQUATE COOLING IS ESSENTIAL FOR THE PROPER FUNCTION OF THIS SYSTEM. REFER TO THE HOT RUNNER PRODUCT GUIDE FOR MORE DETAILED GUIDELINES. <a href="http://www.husky.cc">www.husky.cc</a>	
<b>RECOMMENDED GATE MATERIAL</b> 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)	
<b>RECOMMENDED GATE MANUFACTURING GUIDELINES</b> <ul style="list-style-type: none"> <li>- 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.</li> <li>- 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.</li> <li>- MACHINE THE GATE HOLE AFTER HARDENING TO AVOID EXCESSIVE QUENCH IN THE THIN SECTION DURING HEAT TREAT &amp; RESULTING OVERHARDENING IN THE GATE AREA.</li> <li>- RECESSED GATES ON THE PRODUCT REDUCE THE GATE AREA STRENGTH LEADING TO GATE FAILURES.</li> <li>- WELDING THE GATE AREA INCREASES STRESSES AT THE GATE, SOFTENS THE AREA AROUND THE WELD AND CAN CAUSE GATE FAILURES.</li> </ul>	

REV	DATE	DESCRIPTION	NAME
0	2017-09-07	ORIGINAL ISSUE - DESIGNED BY: DHANANJEYAN	DRWN: DHANANJEYAN CHKD: PICHLER KLAUS

FOR TORQUE SPECIFICATIONS, REFER TO HS 252					
WEIGHT		TITLE		REV	
- kg		HOT SPRUE U750-HT-S		0	
		SCALE NONE		DRAWING	
		SHEET 2 OF 2		8091885	