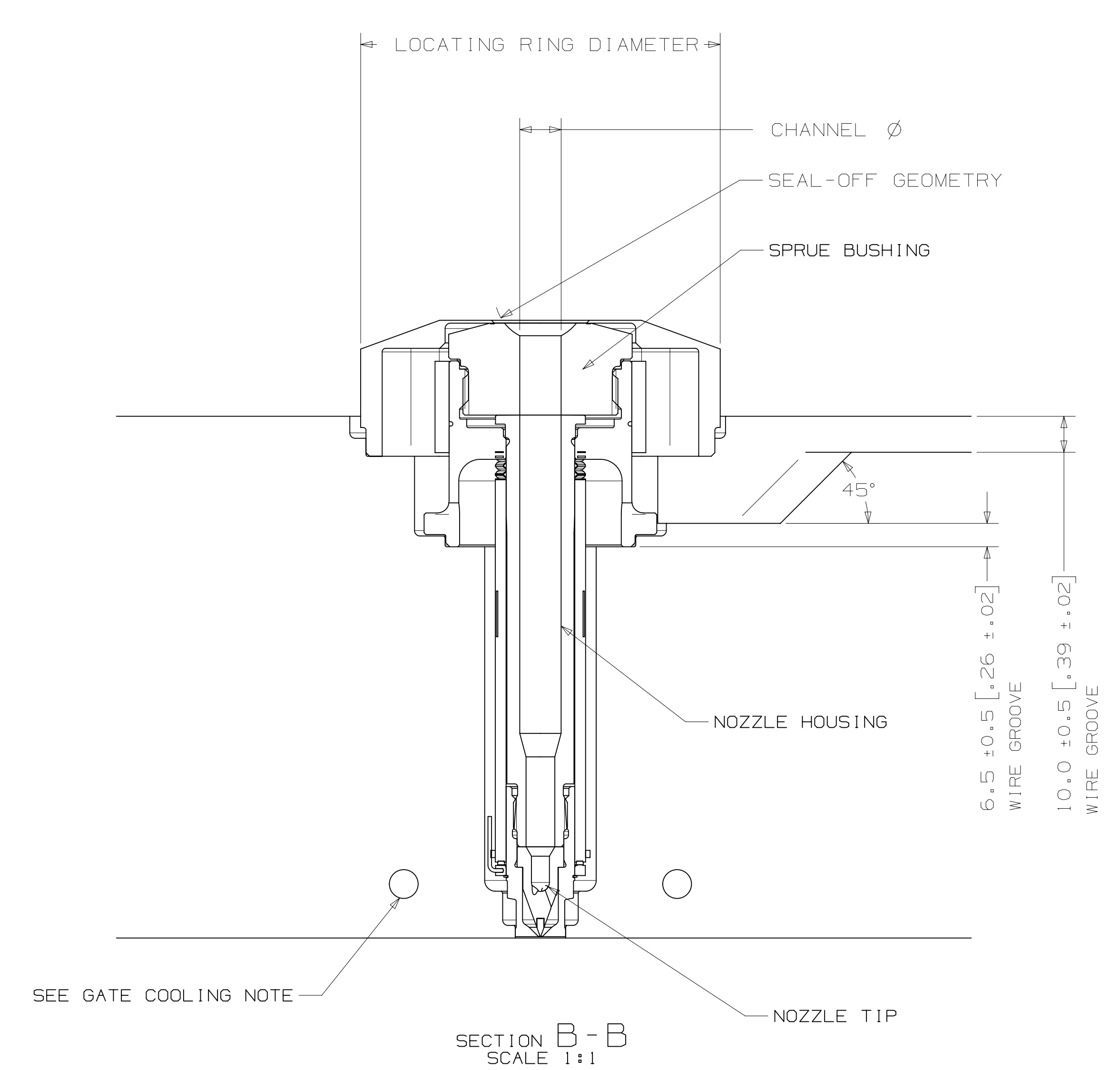
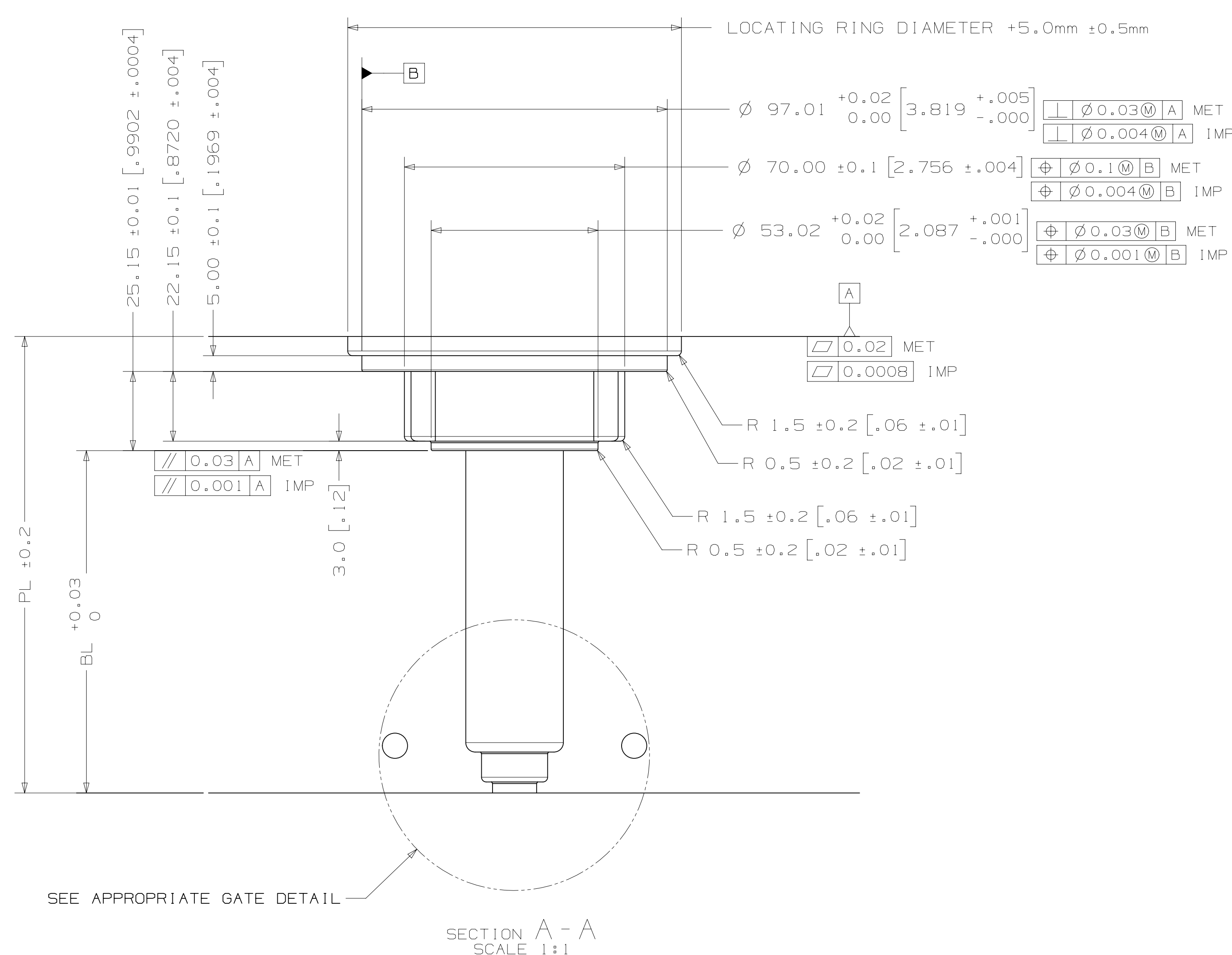
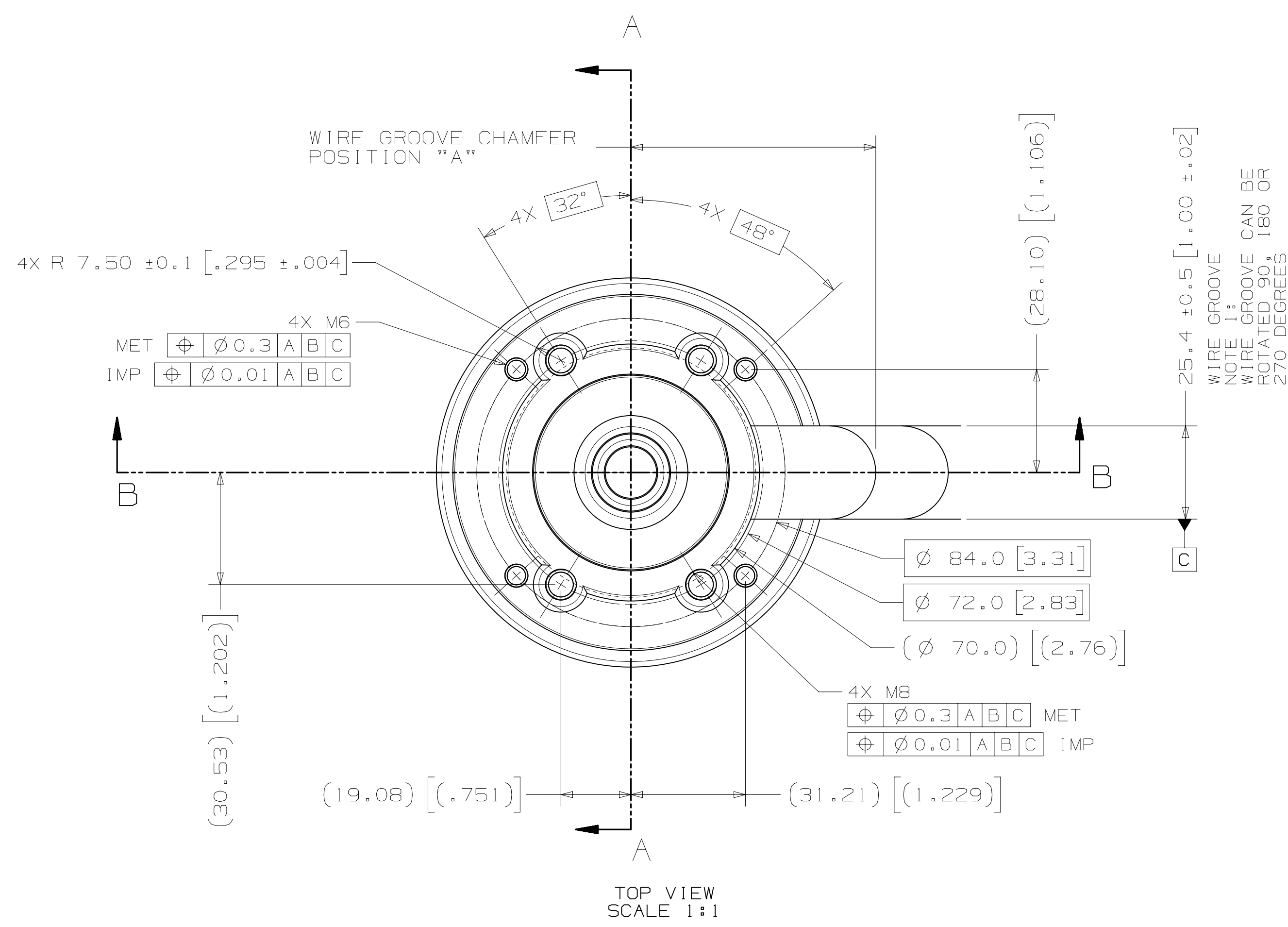


INSTALLATION DRAWING



NOZZLE SERIES	NOZZLE TIP	NOZZLE HOUSING	PL	"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-428° 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]	38.61 [1.514]	38.63 [1.515]		
		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 [1.914]	48.67 [1.910]	48.70 [1.911]	
		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]	58.71 [2.306]	58.75 [2.307]	58.78 [2.308]
		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 [2.701]	68.61 [2.701]	68.63 [2.702]	68.66 [2.703]	68.68 [2.704]	68.70 [2.705]	68.74 [2.701]	68.78 [2.702]	68.81 [2.703]
		90	109 [4.291]	118 [4.686]	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]	78.78 [3.096]	78.82 [3.097]	78.85 [3.098]
		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]	88.81 [3.491]	88.85 [3.492]	88.88 [3.493]
		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]	98.85 [3.886]	98.89 [3.887]	98.92 [3.888]
		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]	108.88 [4.280]	108.92 [4.281]	108.95 [4.282]
		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]	118.92 [4.676]	118.96 [4.677]	118.99 [4.678]
		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]	128.95 [5.071]	128.99 [5.072]	129.02 [5.073]
		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]	138.99 [5.466]	139.03 [5.467]	139.06 [5.468]
		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]	149.02 [5.861]	149.06 [5.862]	149.09 [5.863]
		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]	159.06 [6.257]	159.10 [6.258]	159.13 [6.259]
		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]	169.09 [6.652]	169.13 [6.653]	169.16 [6.654]
		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]	179.13 [7.047]	179.17 [7.048]	179.20 [7.049]
		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]	189.16 [7.442]	189.19 [7.443]	189.22 [7.444]

* 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.

NOZZLE SERIES	LOCATING RING DIAMETER	WIRE GROOVE CHAMFER POSITION "A"
U750	100mm	66.7
	101.3mm (3.99")	66.7
	125mm	78.7

NOZZLE SERIES	SPRUE BUSHING SEAL-OFF GEOMETRY	CHANNEL Ø IN - OUT
U750	FLAT	4 - 11.5
	FLAT	4 - 11.5
	SEAL-OFF 12.7 (1/2")	11.5 - THRU
	SEAL-OFF 15.5	11.5 - THRU
	SEAL-OFF 19.05 (3/4")	11.5 - THRU

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)

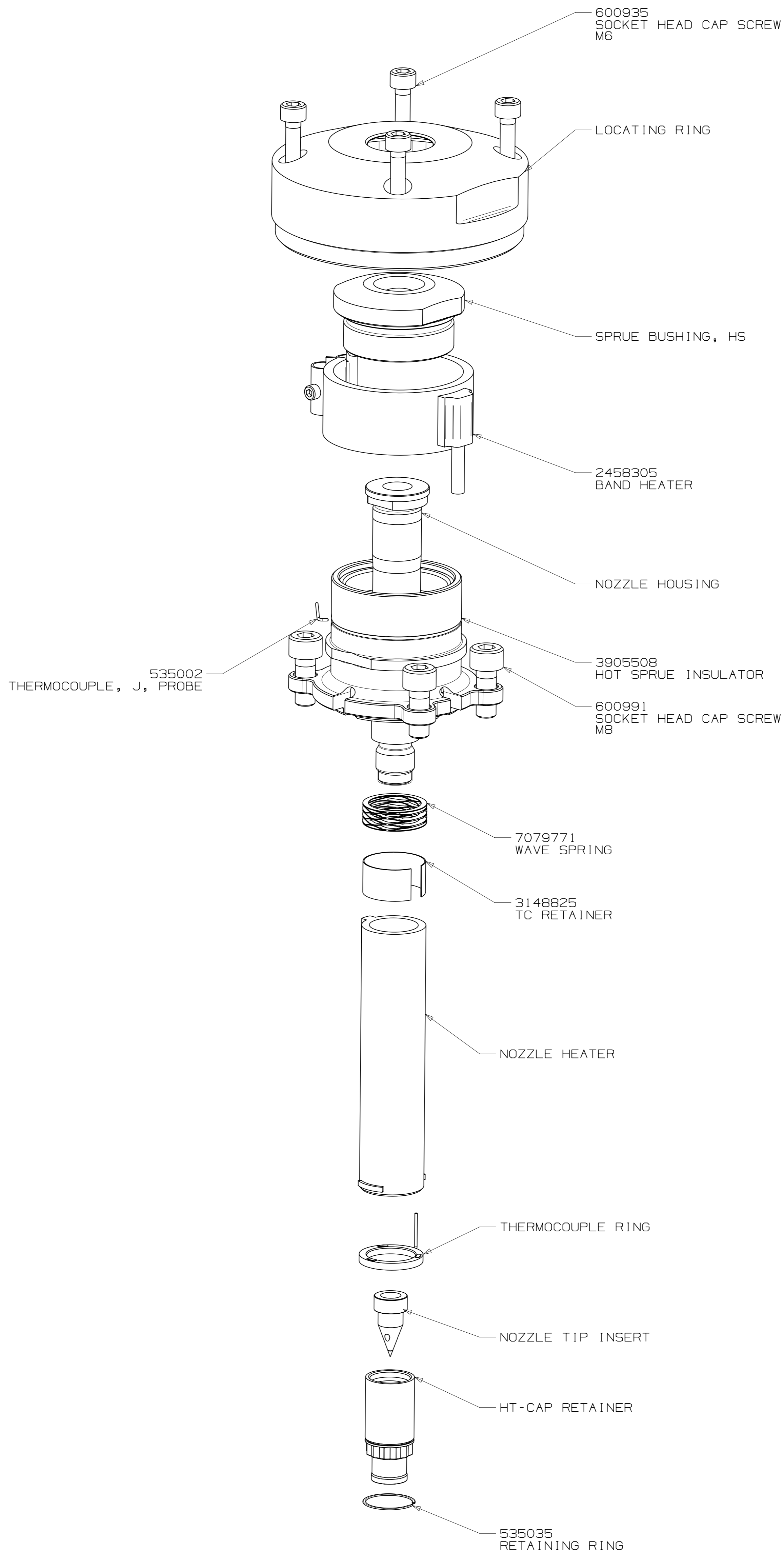
RECOMMENDED GATE MANUFACTURING GUIDELINES
- HARDENED GATE INSERTS (48-51) ARE RECOMMENDED WHEN USING SOFTER CAVITY STEELS. SOFTER CAVITIES MAY BE ACCEPTABLE FOR CERTAIN APPLICATIONS. CONTACT YOUR HUSKY REPRESENTATIVE WITH QUESTIONS.
- EDM'ING THE GATE AREA CAUSES MICRO CRACKS WHICH LEAD TO BRITTLE GATE 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	2017-09-04	ORIGINAL ISSUE - DESIGNED BY DHANALEYAN	DRWN: DHANALEYAN	CHKD: PICHLER KLAUS

<p>FOR TORQUE SPECIFICATIONS, REFER TO HS 252</p> <p>WEIGHT - kg</p>	<p>HUSKY</p> <p>HOT SPRUE U750-HT-CAP</p>
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ASSEMBLY DRAWING

REV 0
DRAWING 8088142



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)

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REV	DATE	DESCRIPTION	NAME
0	2017-09-04	ORIGINAL ISSUE - DESIGNED BY: DHANANJEYAN	DRWN: DHANANJEYAN CHKD: PICHLER KLAUS

FOR TORQUE SPECIFICATIONS, REFER TO HS 252		METRIC		HUSKY	
WEIGHT - kg		TITLE HOT SPRUE U750-HT-CAP		SCALE NONE SIZE AIR DRAWING 8088142 REV 0	
		SHEET 2 OF 2			