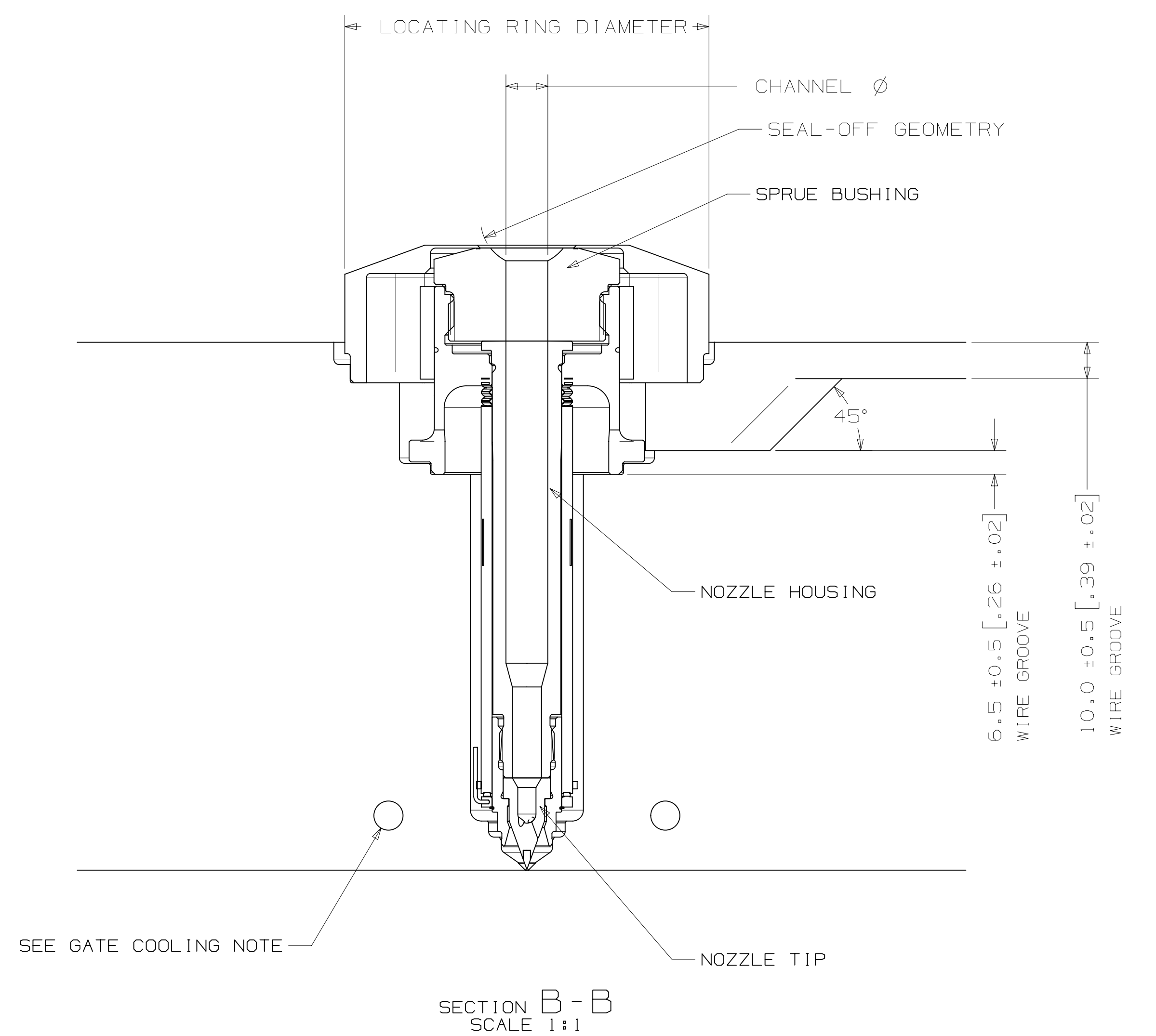
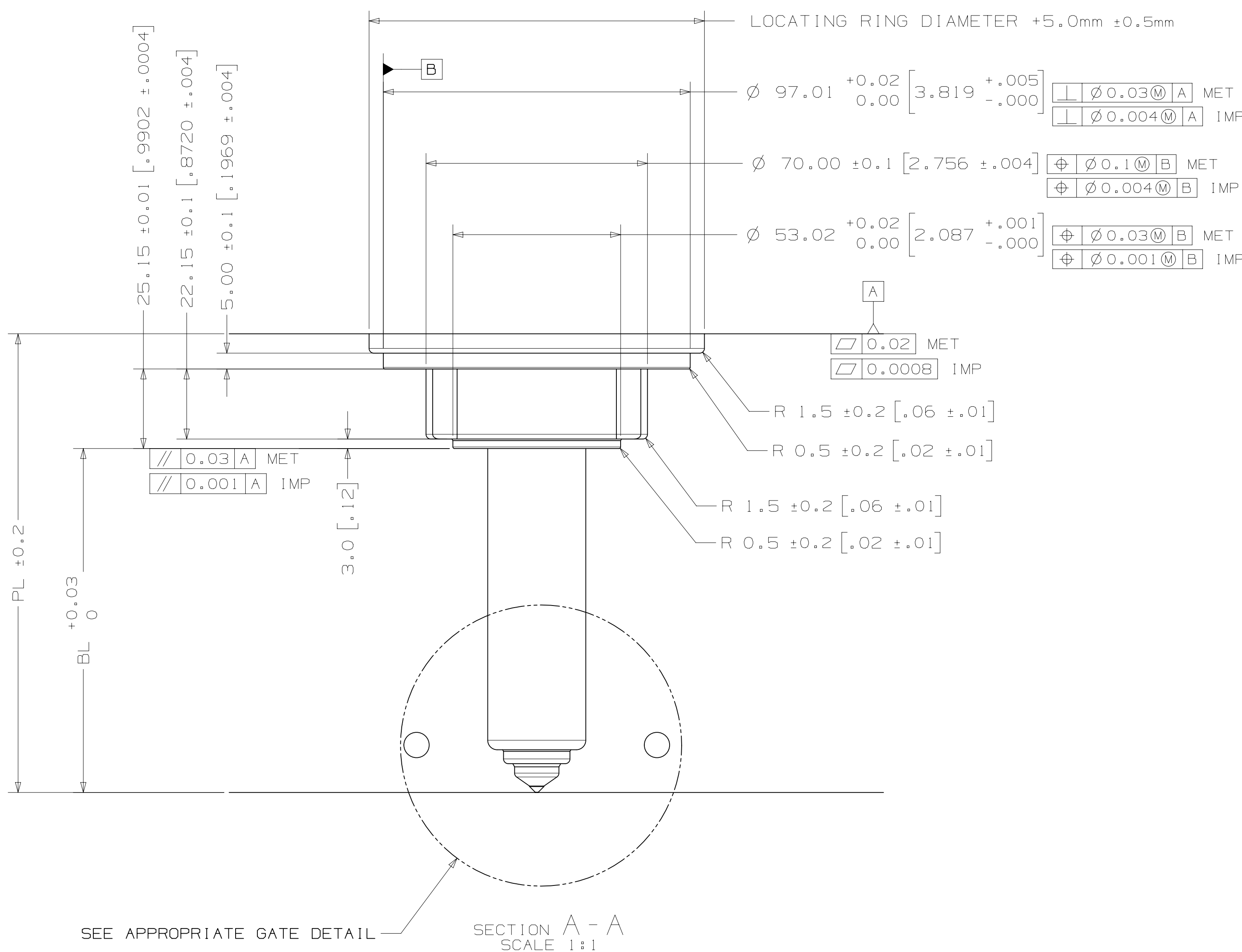
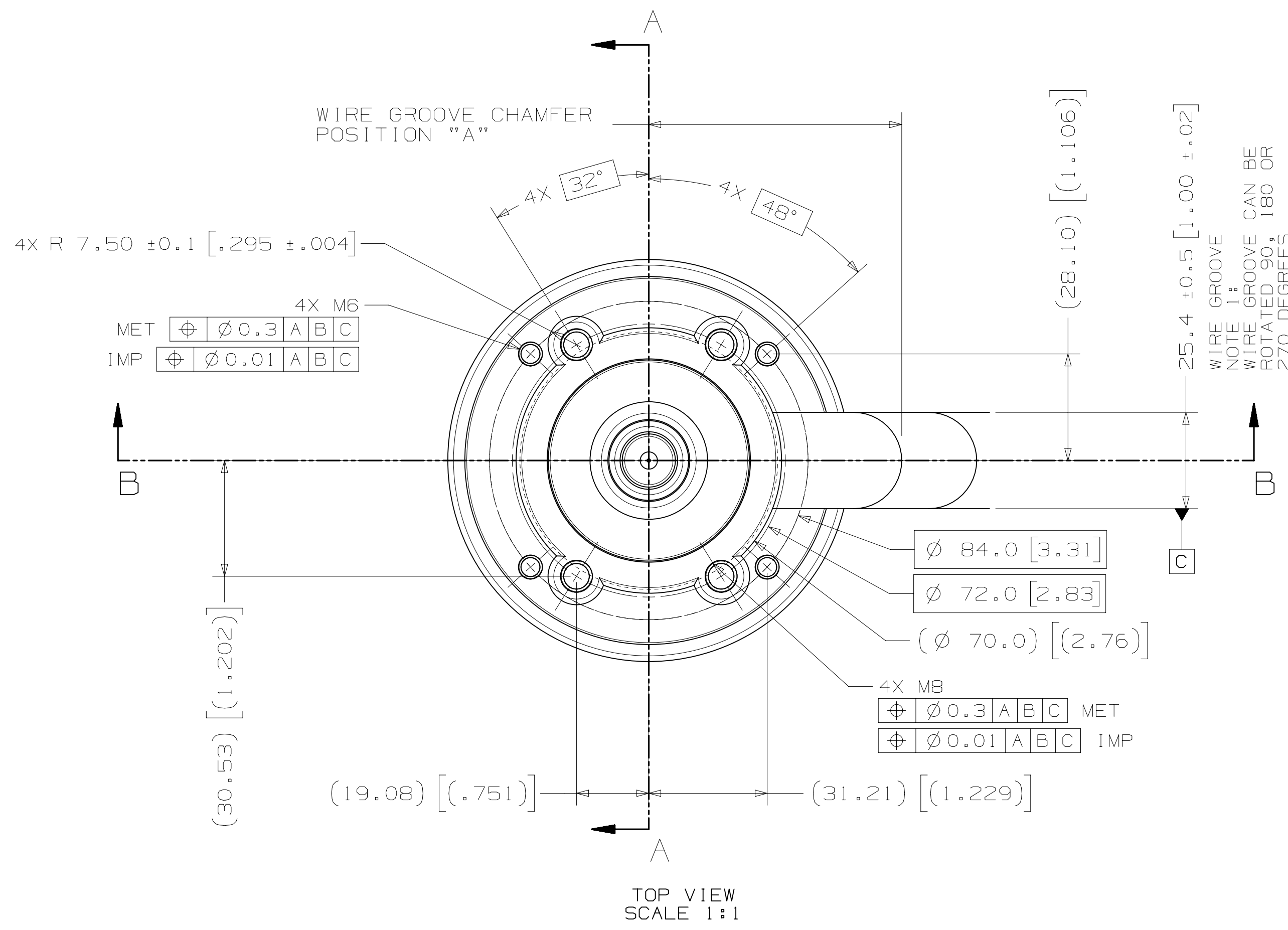


# INSTALLATION DRAWING

REV 0  
7930972



NOZZLE SERIES	NOZZLE TIP	NOZZLE HOUSING	PL		"BL" AT DELTA TEMP (DELTA TEMP = TEMP OF MELT - TEMP OF MOLD) *																									
			LENGTH	MIN (INCH)	MAX (INCH)	60° C-79° F	114° F-114° F	180° C-99° F	117° F-210° F	100° C-119° F	121° F-246° F	120° C-139° F	124° F-282° F	140° C-159° F	128° F-318° F	160° C-179° F	130° F-354° F	180° C-199° F	156° F-390° F	200° C-219° F	132° F-428° F	220° C-239° F	142° F-482° F	240° C-259° F	144° F-514° F	260° C-279° F	150° F-531° F	280° C-300° F	153° F-572° F	
U750	HT-D	50	69	12.717	78	13.071	38.43	(1.513)	38.44	(1.513)	38.46	(1.514)	38.47	(1.515)	38.49	(1.515)	38.51	(1.516)	38.52	(1.517)	38.54	(1.517)	38.56	(1.518)	38.58	(1.519)	38.60	(1.520)	38.61	(1.520)
		60	79	13.110	88	13.465	48.44	(1.907)	48.45	(1.907)	48.47	(1.908)	48.49	(1.909)	48.51	(1.910)	48.53	(1.911)	48.55	(1.911)	48.57	(1.912)	48.59	(1.913)	48.61	(1.914)	48.63	(1.915)	48.65	(1.915)
		70	89	13.504	98	13.858	58.44	(2.301)	58.46	(2.302)	58.48	(2.302)	58.50	(2.303)	58.53	(2.304)	58.55	(2.305)	58.57	(2.306)	58.59	(2.307)	58.61	(2.307)	58.63	(2.308)	58.66	(2.309)	58.68	(2.310)
		80	99	13.898	108	14.252	68.45	(2.695)	68.47	(2.696)	68.50	(2.697)	68.52	(2.698)	68.54	(2.698)	68.57	(2.700)	68.59	(2.700)	68.62	(2.702)	68.64	(2.702)	68.66	(2.703)	68.69	(2.704)	68.72	(2.706)
		90	109	14.291	118	14.646	78.46	(3.089)	78.48	(3.090)	78.51	(3.091)	78.53	(3.092)	78.56	(3.093)	78.59	(3.094)	78.61	(3.095)	78.64	(3.096)	78.67	(3.097)	78.69	(3.098)	78.73	(3.100)	78.75	(3.100)
		100	119	14.685	128	15.039	88.47	(3.483)	88.49	(3.484)	88.52	(3.485)	88.55	(3.486)	88.58	(3.487)	88.61	(3.489)	88.63	(3.489)	88.66	(3.491)	88.69	(3.492)	88.72	(3.493)	88.76	(3.494)	88.79	(3.496)
		110	129	15.079	138	15.433	98.47	(3.877)	98.50	(3.878)	98.53	(3.879)	98.56	(3.880)	98.59	(3.881)	98.63	(3.883)	98.66	(3.884)	98.69	(3.885)	98.72	(3.887)	98.75	(3.888)	98.79	(3.889)	98.82	(3.891)
		120	139	15.472	148	15.827	108.48	(4.271)	108.51	(4.272)	108.55	(4.274)	108.58	(4.275)	108.61	(4.276)	108.64	(4.277)	108.68	(4.279)	108.71	(4.280)	108.75	(4.281)	108.78	(4.283)	108.82	(4.284)	108.86	(4.286)
		130	149	15.866	158	16.220	118.49	(4.665)	118.52	(4.666)	118.56	(4.668)	118.59	(4.669)	118.63	(4.670)	118.66	(4.672)	118.70	(4.673)	118.74	(4.675)	118.77	(4.676)	118.81	(4.678)	118.86	(4.680)	118.89	(4.681)
		140	159	16.260	168	16.614	128.50	(5.059)	128.53	(5.060)	128.57	(5.062)	128.61	(5.063)	128.65	(5.065)	128.68	(5.066)	128.72	(5.068)	128.76	(5.069)	128.80	(5.071)	128.84	(5.072)	128.89	(5.074)	128.93	(5.078)
		150	169	16.654	178	17.008	138.51	(5.453)	138.54	(5.454)	138.58	(5.456)	138.62	(5.457)	138.66	(5.459)	138.70	(5.461)	138.74	(5.462)	138.79	(5.464)	138.83	(5.466)	138.87	(5.467)	138.92	(5.469)	138.96	(5.471)
		160	179	17.047	188	17.402	148.51	(5.847)	148.55	(5.848)	148.60	(5.850)	148.64	(5.852)	148.68	(5.854)	148.72	(5.855)	148.77	(5.857)	148.81	(5.859)	148.86	(5.861)	148.90	(5.862)	148.95	(5.864)	149.00	(5.866)
		170	189	17.441	198	17.795	158.52	(6.241)	158.56	(6.243)	158.61	(6.244)	158.65	(6.246)	158.70	(6.248)	158.74	(6.250)	158.79	(6.252)	158.84	(6.254)	158.88	(6.255)	158.93	(6.257)	158.99	(6.259)	159.03	(6.261)
		180	199	17.835	208	18.189	168.53	(6.635)	168.57	(6.637)	168.62	(6.639)	168.67	(6.641)	168.71	(6.642)	168.76	(6.644)	168.81	(6.646)	168.86	(6.648)	168.91	(6.650)	168.96	(6.652)	169.02	(6.654)	169.07	(6.656)
		190	209	18.228	218	18.583	178.54	(7.029)	178.58	(7.031)	178.63	(7.033)	178.68	(7.035)	178.73	(7.037)	178.78	(7.039)	178.83	(7.041)	178.88	(7.043)	178.94	(7.045)	178.99	(7.047)	179.05	(7.049)	179.11	(7.052)
		200	219	18.622	229	19.016	188.54	(7.423)	188.59	(7.425)	188.64	(7.427)	188.70	(7.429)	188.75	(7.431)	188.80	(7.433)	188.85	(7.435)	188.91	(7.437)	188.96	(7.439)	189.02	(7.442)	189.08	(7.444)	189.14	(7.446)

\* 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"	WIRE GROOVE POSITION "A"
100mm	66.7	
101.3mm [3.99"]	66.7	
125mm	78.7	

SPRUE BUSHING	
SEAL-OFF GEOMETRY SPHERICAL RADIUS	CHANNEL Ø IN - OUT
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 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 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.

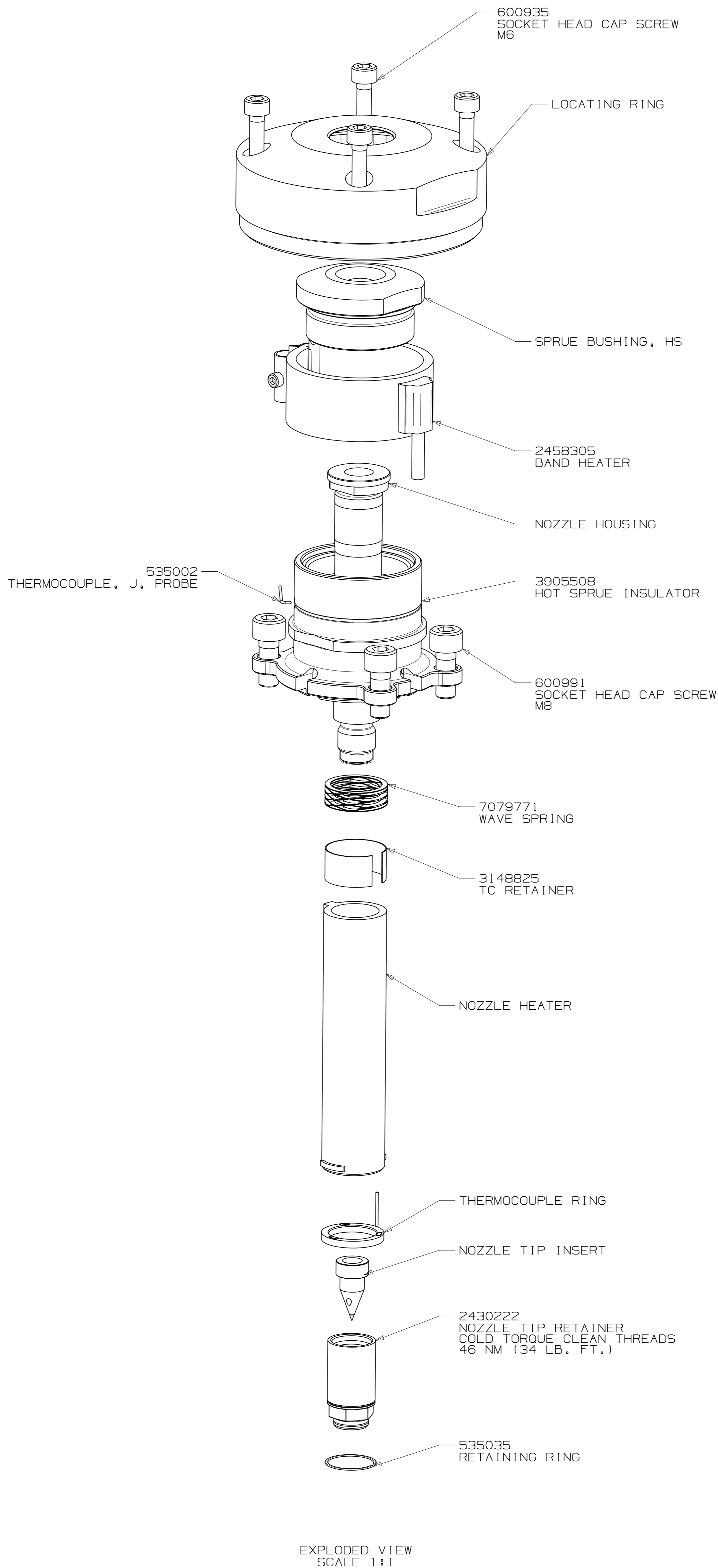
REV	DATE	DESCRIPTION	DRWN	CHKD	APPD
0	2017-09-06	ORIGINAL ISSUE - DESIGNED BY DHANALEYAN	DRWN: DHANALEYAN	CHKD: PICHLER KLAUS	

FOR TORQUE SPECIFICATIONS, REFER TO HS 252		METRIC	IMPERIAL	WEIGHT	
BROKEN EDGE/CHAMFER	0.2 X 45°	0.04 ± 0.01 X 45°			
FILLET/RADIUS	R0.5 ± 0.2	R0.03 ± 0.01			
SURFACE FINISH	1.2	1.2			

**HUSKY**  
HOT SPRUE  
U750-HT-D  
SCALE: NONE  
SIZE: AOR  
DRAWING: 7930972  
REV: 0

# ASSEMBLY DRAWING

REV 0  
DRAWING 7930972



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](http://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)

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
0	2017-09-06	ORIGINAL ISSUE - DESIGNED BY: DHANANJAYAN	DRWN: DHANANJAYAN CHKD: PICHLER, KLAUS

FOR TORQUE SPECIFICATIONS, REFER TO HS 252		METRIC	HUSKY	
		TITLE HOT SPRUE U750-HT-D		
WEIGHT	- kg	SCALE	NONE	SIZE
		SHEET	2 OF 2	DRAWING
				7930972
				REV
				0