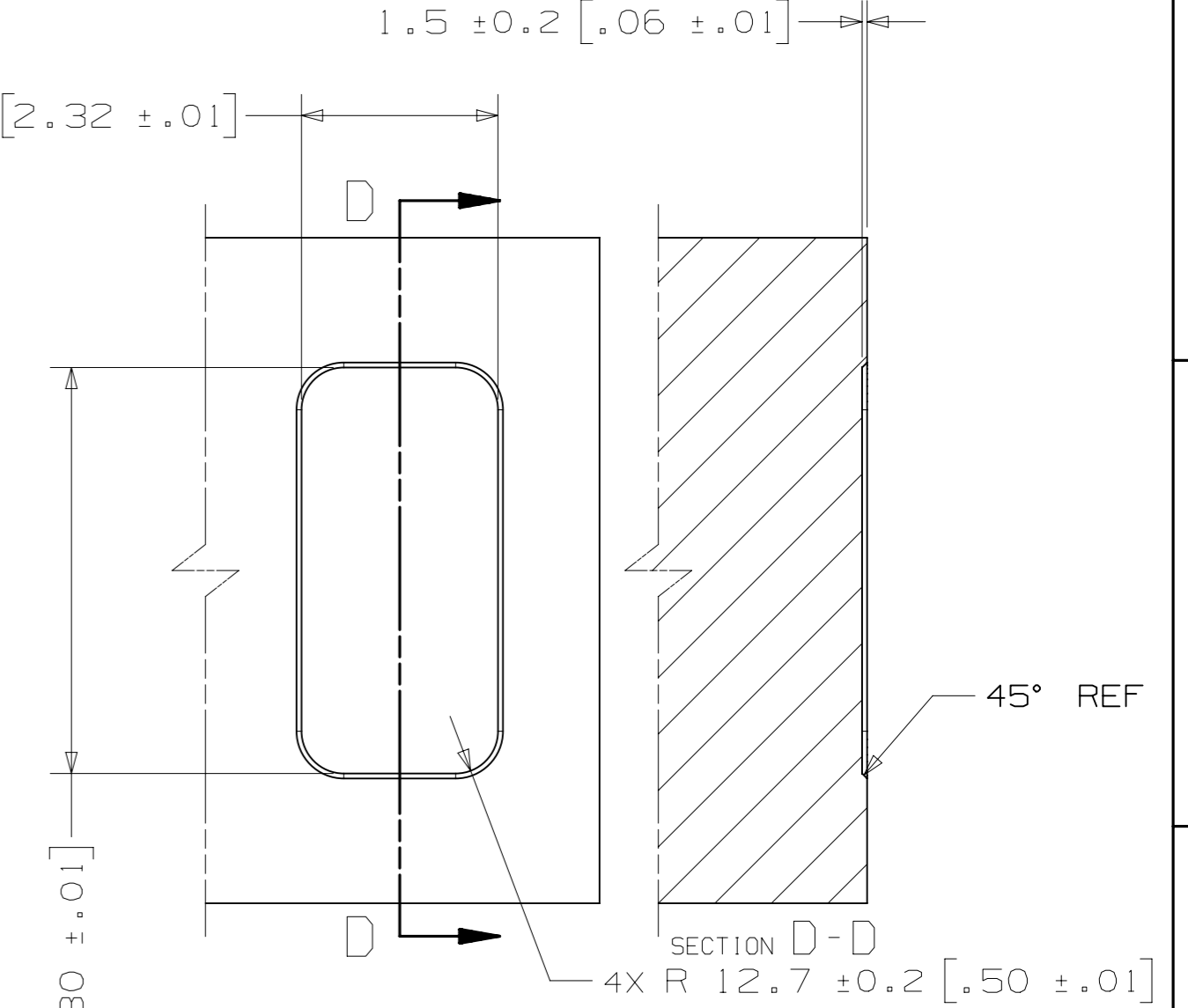
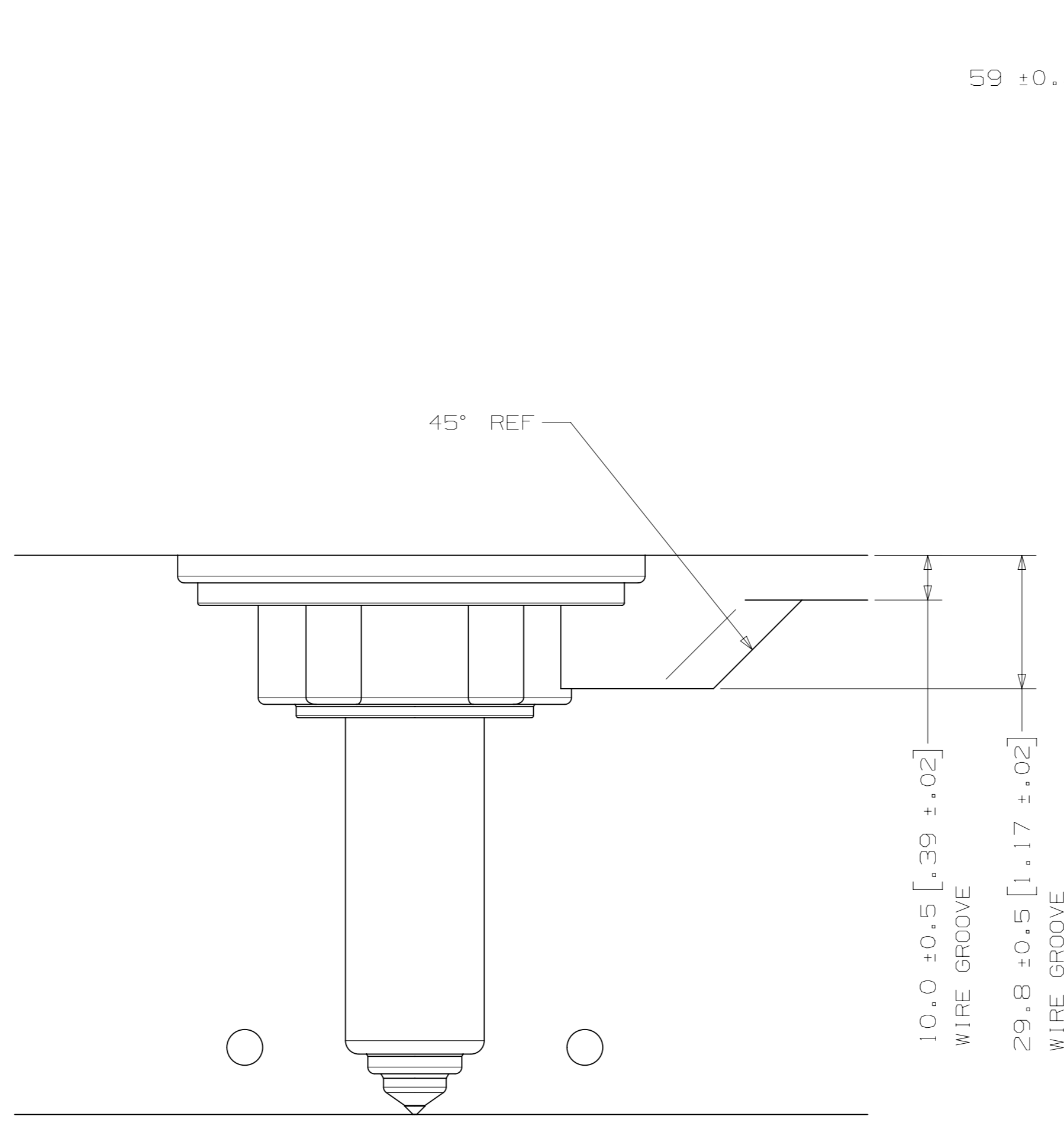
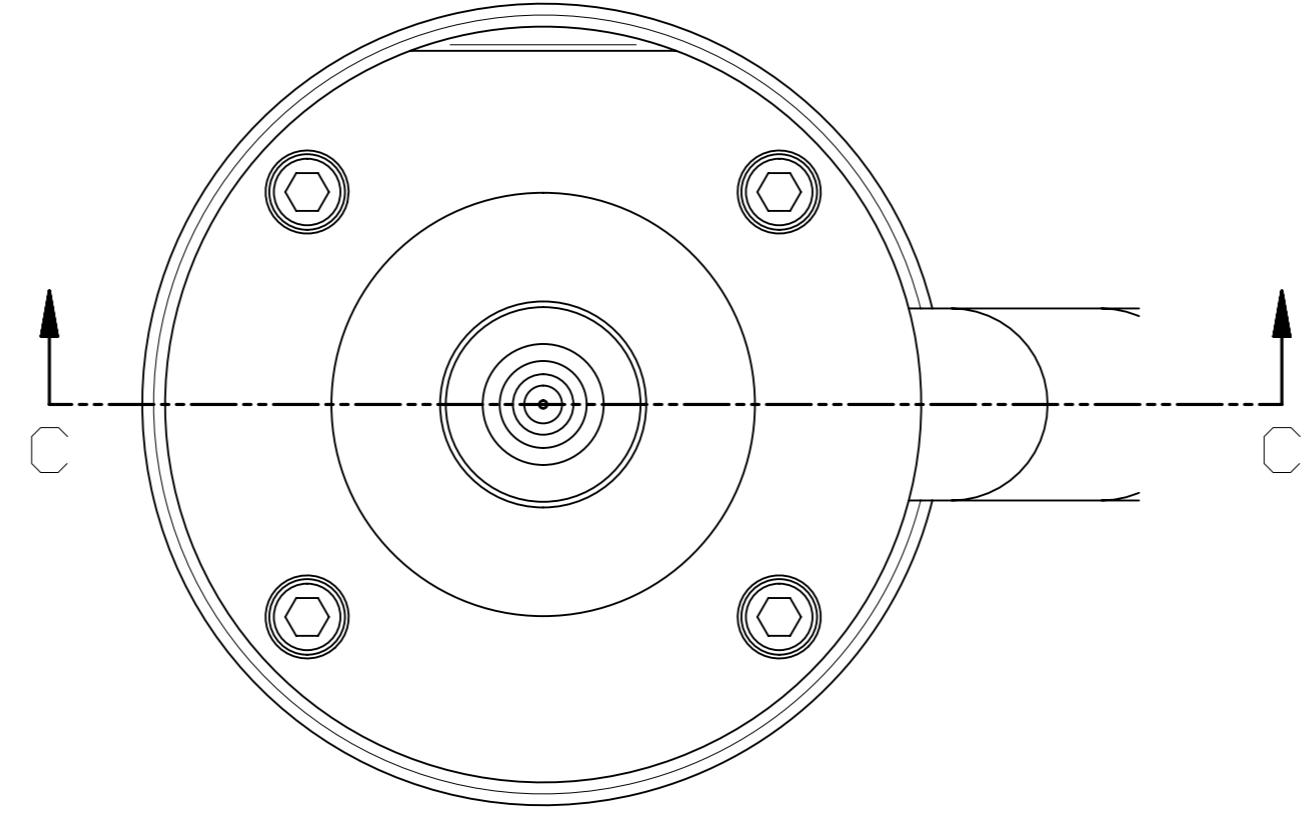


CUSTOMER SUPPLIED RESIN INFO	VALUE
PART WEIGHT	1.4 g
AVERAGE WALL THICKNESS	1 mm
POLYMER	PP
TRADENAME	PP RJ 370MO
MANUFACTURER	RJ 370MO
SPECIFIC GRADE	RJ 370MO
MELT FLOW INDEX	0
FILLER	--none--
FILLER CONTENT	--none--
FLAME RETARDANT	NO
MELT TEMPERATURE	240°C [464°F]
MOLD TEMPERATURE	20°C [68°F]
ESTIMATED CYCLE TIME	8.7 sec
ESTIMATED FILL TIME	0.35 sec

DRAWING
REV
8051641
0



SECTION B-B

NAME PLATE INSTALLATION
SCALE 1:2

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

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.

HUSKY PROJECT
0
CUSTOMER MOLD
TBD

CUSTOMER: HUSKY INJECTION MOLDING SYSTEMS LTD.
PART NAME: CARTRIDGE HOLDER
PART NUMBER: Cartridge Holder
PRODUCT: HOT RUNNER
DROPS: 24
NOZZLE SIZE: ULTRA 500
TIP STYLE: VG - GENERAL

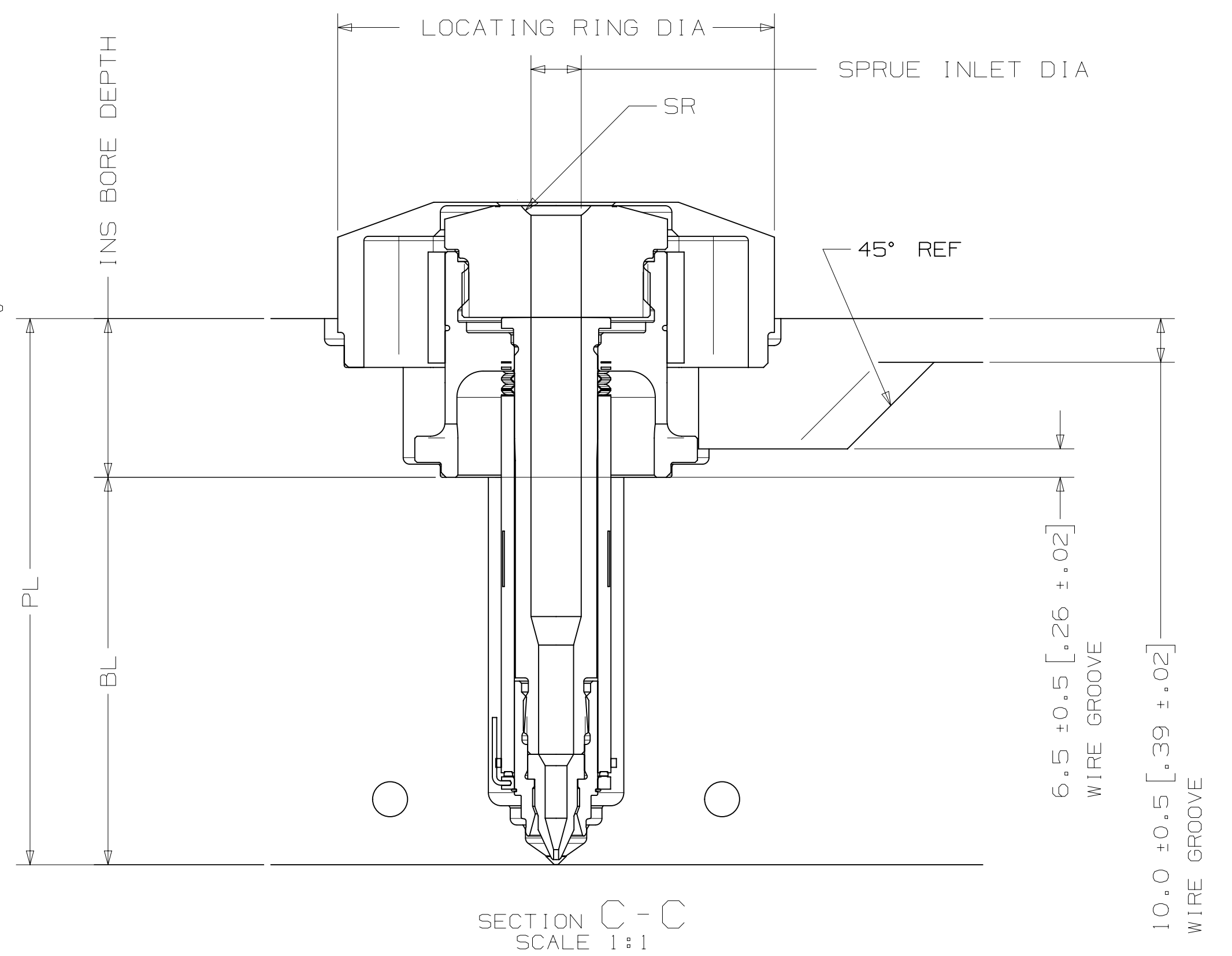
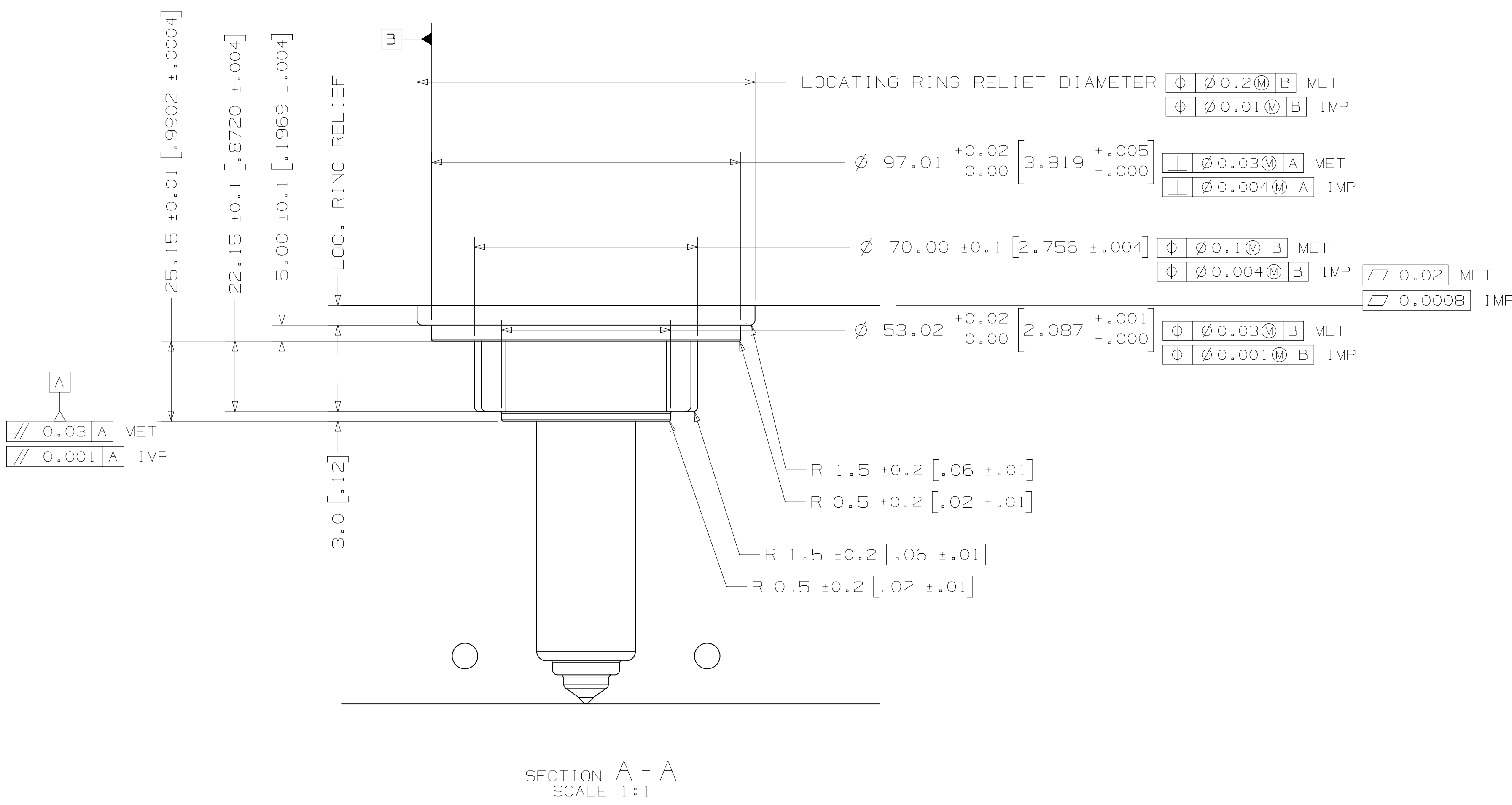
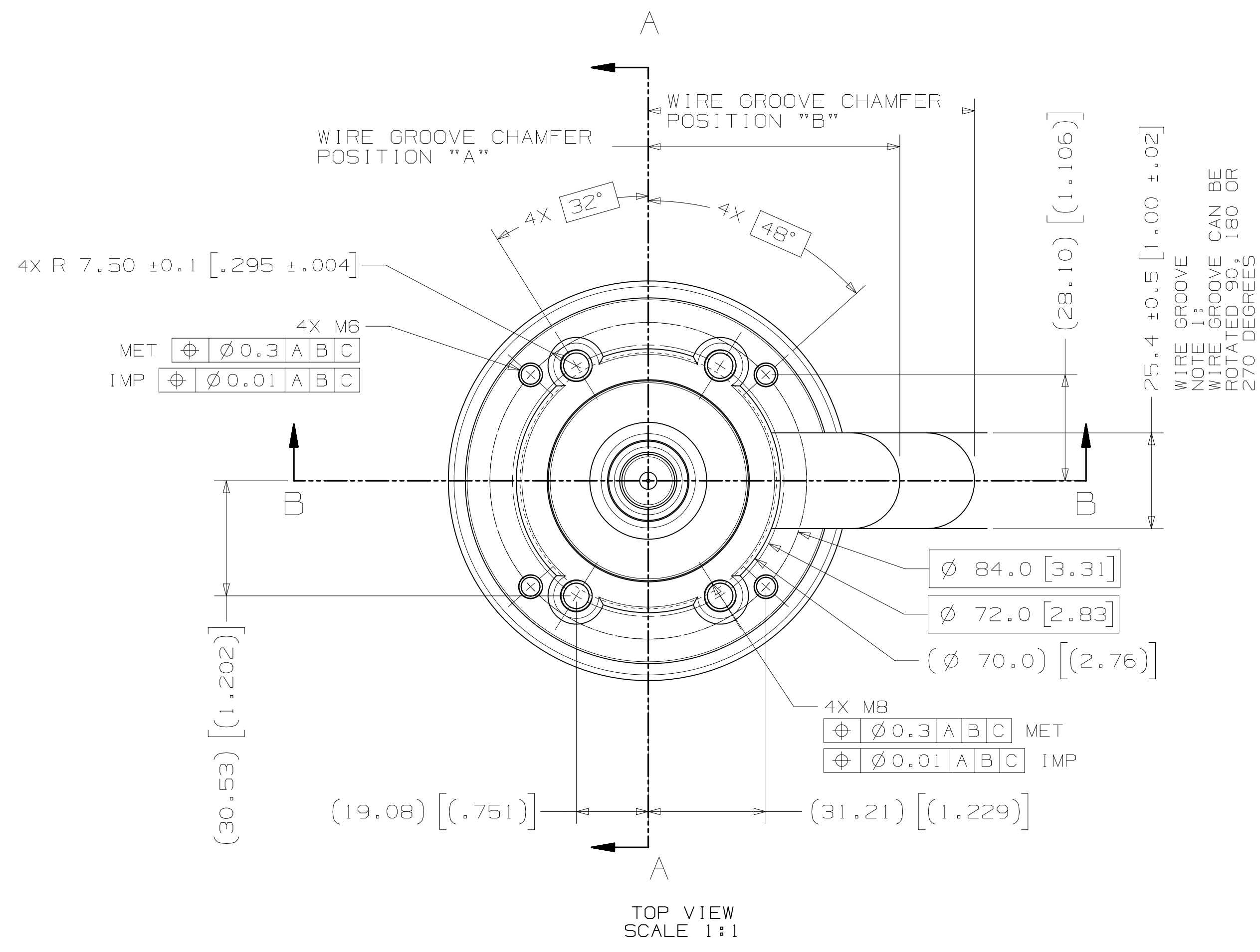
REV	DATE	DESCRIPTION	NAME
		ORIGINAL ISSUE - DESIGNED BY:	

UNLESS OTHERWISE SPECIFIED:	
GENERAL TOLERANCE:	⓪ 0.4 [7] METRIC ⓪ 0.02 [7] IMPERIAL
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		METRIC		HUSKY	
WEIGHT	- kg	TITLE		Hot Sprue Assembly	
		SCALE 1:1		SIZE	DRAWING
		SHEET 1 OF 2		AIR	8051641
				REV	0

INSTALLATION DRAWING

REV 0051641 0



U750	LOCATING RING OUTER DIAMETER	LOCATING RING RELIEF DIAMETER (±0.5mm)	WIRE GROOVE CHAMFER POSITION "A" (±2.0)	WIRE GROOVE CHAMFER POSITION "B" (±2.0)	SPRUE BUSHING	
					SEAL-OFF TYPE	CHANNEL Ø IN - OUT
	100mm	106.0	66.7	88.5	FLAT	11.5-THRU
	101.3mm (3.99")	106.0	66.7	88.5	SR 12.7	
					SR 15.5	
	125mm	130.0	78.7	100.5	SR 19.05	

NOZZLE	TIP	NOZZLE HOUSING LENGTH	BL AT DELTA TEMP															
			60° - 79°	80° - 99°	100° - 119°	120° - 139°	140° - 159°	160° - 179°	180° - 199°	200° - 219°	220° - 239°	240° - 259°	260° - 279°	280° - 300°				
U750	HT-T	50	38.43		38.46				38.51					38.56			38.61	
		60	48.44		48.48				48.53					48.59			48.64	
		70	58.45		58.49				58.55					58.61			58.67	
		80	68.46		68.50				68.57					68.64			68.71	
		90	78.47		78.52				78.59					78.67			78.74	
		100	88.48		88.53				88.61					88.70			88.78	
		110	98.48		98.54				98.63					98.72			98.81	
		120	108.49		108.56				108.65					108.75			108.85	
		130	118.50		118.57				118.67					118.78			118.88	
		140	128.51		128.58				128.69					128.81			128.92	
		150	138.52		138.60				138.71					138.83			138.95	
		160																
		170																
		180																
		190																
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300																		

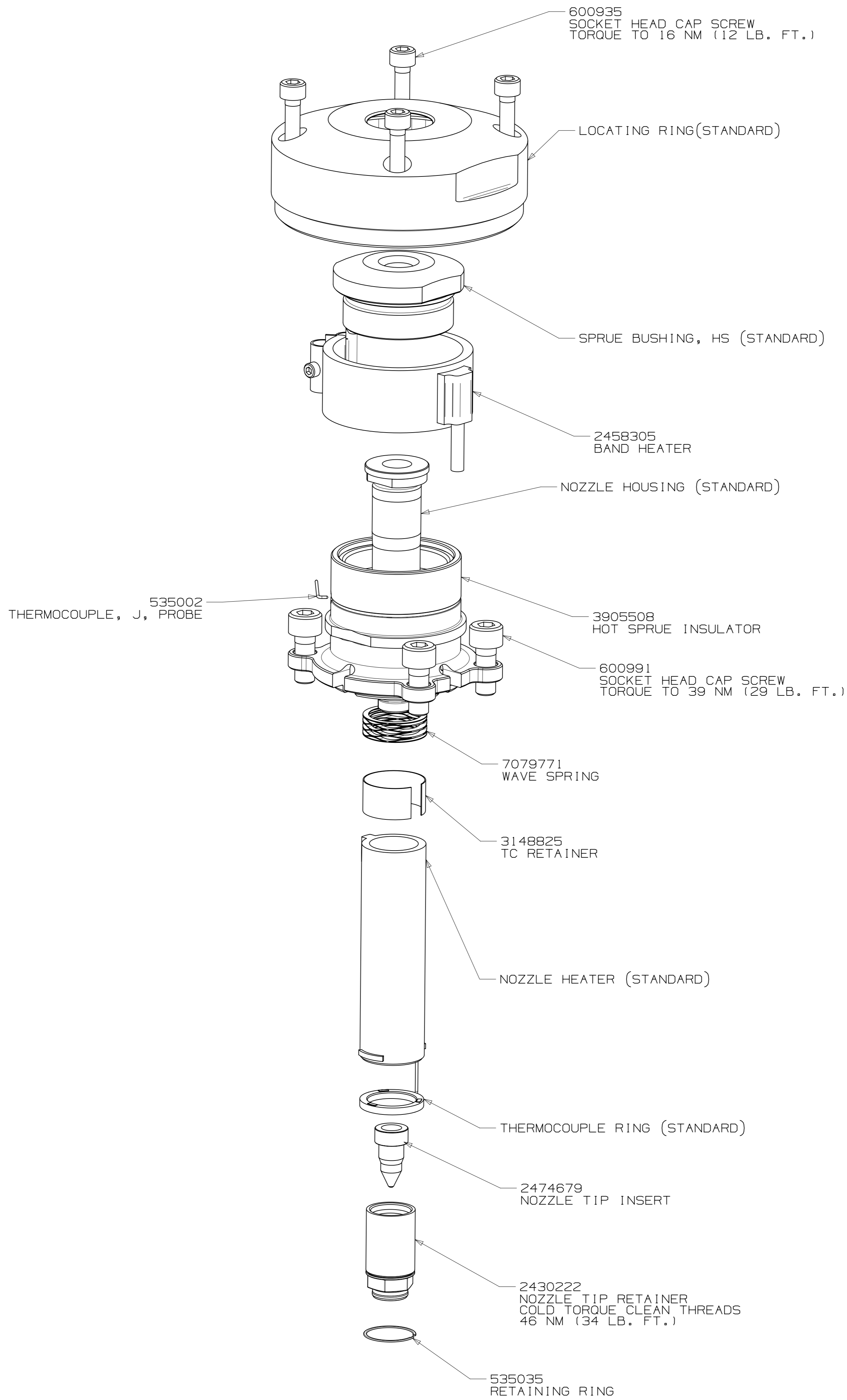
DELTA TEMP = TEMP OF MELT - TEMP OF MOLD

REV	DATE	DESCRIPTION	DRWN	CHKD

FOR TORQUE SPECIFICATIONS, REFER TO HS 252	METRIC	TITLE Hot Sprue Assembly U750 HT T
WEIGHT - kg	SCALE 1:1	SIZE AOR
	SHEET 2 OF 2	REV 0051641 0

ASSEMBLY DRAWING

DRAWING REV 8051641 0



COMP_EXPLODED VIEW
SCALE 1:1

REV	DATE	DESCRIPTION	NAME	DRWN:	
				CHKD:	
				DRWN:	
				CHKD:	
				DRWN:	
				CHKD:	
				DRWN:	
				CHKD:	
				DRWN:	
				CHKD:	

FOR TORQUE SPECIFICATIONS, REFER TO HS 252			
		TITLE Hot Sprue Assembly U750 HT T	
WEIGHT	- kg	SCALE 1:1	SIZE AIR
		SHEET 2 OF 2	DRAWING 8051641
			REV 0