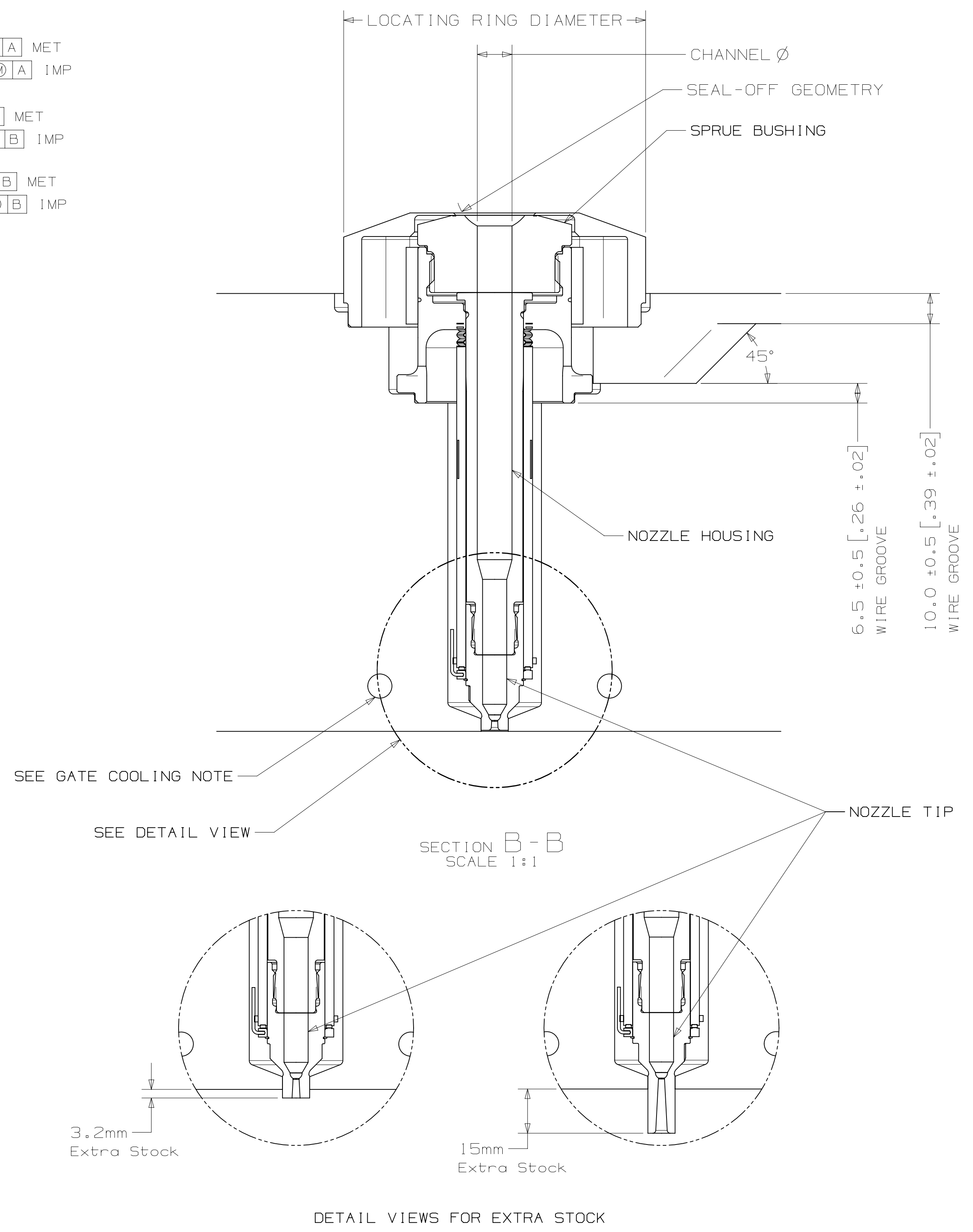
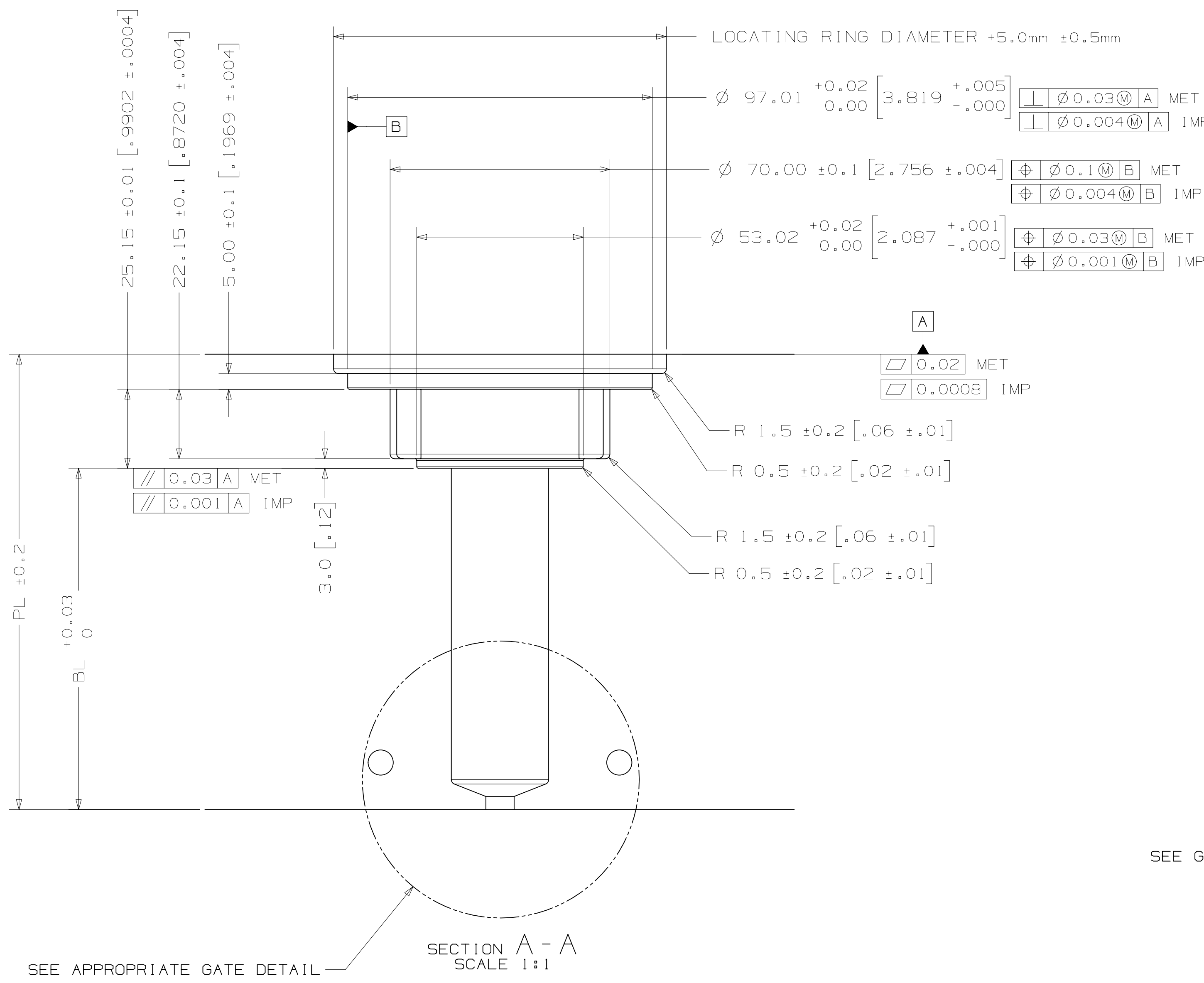
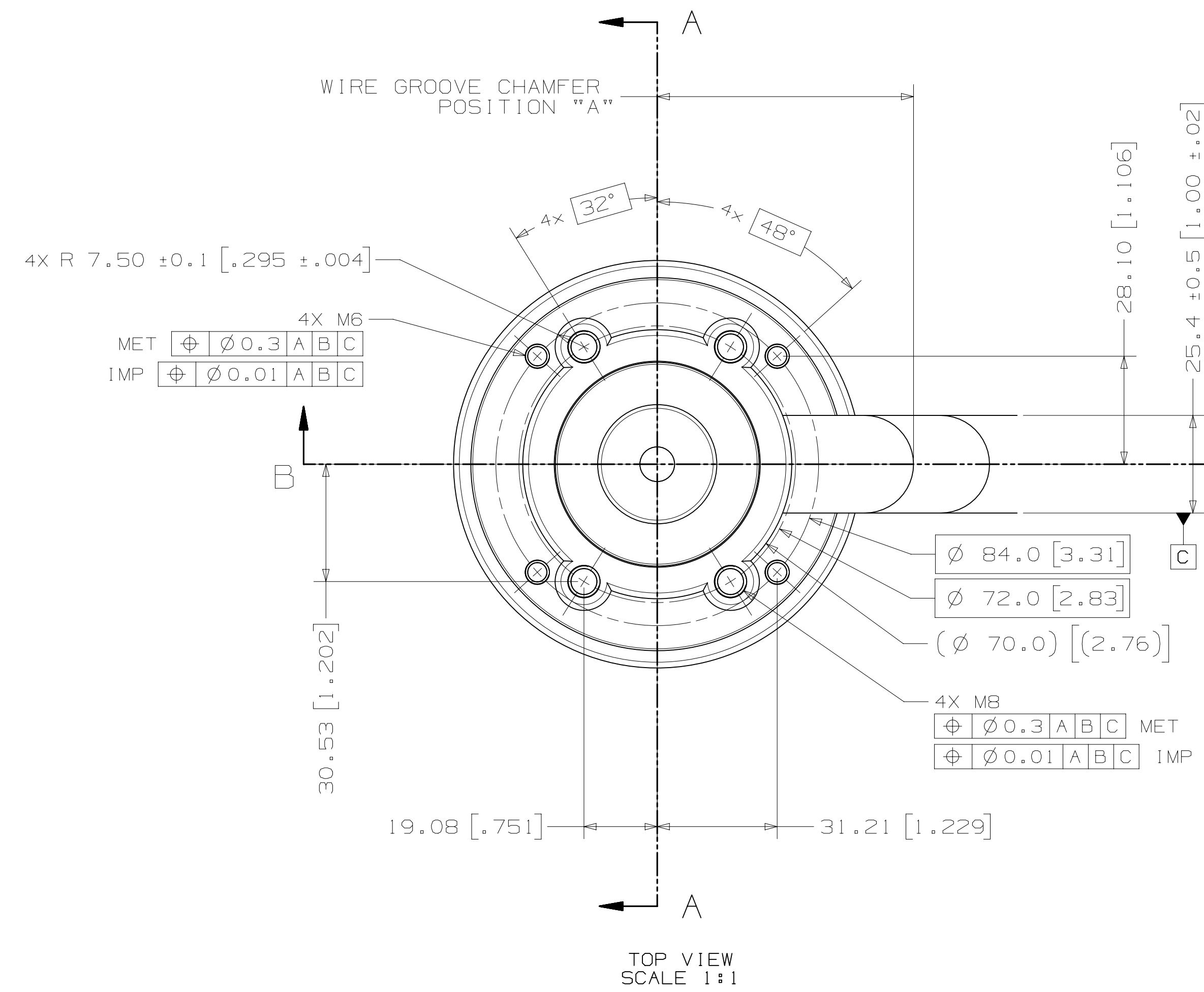


# INSTALLATION DRAWING

REV: 0  
STATUS: 8042693



NOZZLE SERIES	NOZZLE TIP	NOZZLE HOUSING	PL	"BL" AT DELTA TEMP (DELTA TEMP = TEMP OF MELT - TEMP OF MOLD) *															
				60° C-79° F 114° F-114° F	80° C-99° F 118° F-210° F	100° C-119° F 121° F-240° F	120° C-139° F 124° F-282° F	140° C-159° F 128° F-318° F	160° C-179° F 132° F-354° F	180° C-199° F 136° F-390° F	200° C-219° F 132° F-426° F	220° C-239° F 142° F-462° F	240° C-259° F 146° F-498° F	260° C-279° F 150° F-534° F	280° C-300° F 153° F-572° F				
U750	HT-TS	50	69 (2.717) 78 (3.071)	38.43 (1.513)	38.44 (1.513)	38.45 (1.514)	38.47 (1.515)	38.48 (1.515)	38.49 (1.515)	38.51 (1.516)	38.52 (1.517)	38.53 (1.517)	38.55 (1.518)	38.56 (1.518)	38.58 (1.519)				
		60	79 (3.110) 88 (3.465)	48.44 (1.907)	48.45 (1.907)	48.47 (1.908)	48.48 (1.909)	48.50 (1.909)	48.51 (1.910)	48.53 (1.911)	48.54 (1.911)	48.56 (1.912)	48.58 (1.913)	48.59 (1.913)	48.61 (1.914)				
		70	89 (3.504) 98 (3.858)	58.45 (2.301)	58.46 (2.302)	58.48 (2.302)	58.50 (2.303)	58.51 (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)				
		80	99 (3.898) 108 (4.252)	68.45 (2.695)	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)				
		90	109 (4.291) 118 (4.646)	78.46 (3.089)	78.48 (3.090)	78.50 (3.091)	78.53 (3.092)	78.55 (3.093)	78.57 (3.093)	78.59 (3.094)	78.62 (3.095)	78.64 (3.096)	78.66 (3.097)	78.69 (3.098)	78.72 (3.099)				
		100	119 (4.685) 128 (5.039)	88.47 (3.483)	88.49 (3.484)	88.52 (3.485)	88.54 (3.486)	88.57 (3.487)	88.59 (3.488)	88.62 (3.489)	88.64 (3.490)	88.67 (3.491)	88.69 (3.492)	88.72 (3.493)	88.75 (3.494)				
		110	129 (5.079) 138 (5.433)	98.48 (3.877)	98.50 (3.878)	98.53 (3.879)	98.56 (3.880)	98.58 (3.881)	98.61 (3.882)	98.64 (3.883)	98.67 (3.885)	98.70 (3.886)	98.72 (3.887)	98.76 (3.888)	98.79 (3.889)				
		120	139 (5.472) 148 (5.827)	108.48 (4.271)	108.51 (4.272)	108.54 (4.273)	108.57 (4.274)	108.60 (4.276)	108.63 (4.277)	108.66 (4.278)	108.69 (4.279)	108.72 (4.280)	108.75 (4.281)	108.79 (4.283)	108.82 (4.284)				
		130	149 (5.866) 158 (6.220)	118.49 (4.665)	118.52 (4.666)	118.55 (4.667)	118.58 (4.669)	118.62 (4.670)	118.65 (4.671)	118.68 (4.672)	118.72 (4.674)	118.75 (4.675)	118.78 (4.676)	118.82 (4.678)	118.86 (4.680)				
		140	159 (6.260) 168 (6.614)	128.50 (5.059)	128.53 (5.060)	128.57 (5.062)	128.60 (5.063)	128.63 (5.064)	128.67 (5.066)	128.70 (5.067)	128.74 (5.069)	128.78 (5.070)	128.81 (5.071)	128.85 (5.073)	128.89 (5.074)				
		150	169 (6.654) 178 (7.008)	138.51 (5.453)	138.54 (5.454)	138.58 (5.456)	138.61 (5.457)	138.65 (5.459)	138.69 (5.460)	138.73 (5.462)	138.76 (5.463)	138.80 (5.465)	138.84 (5.466)	138.89 (5.468)	138.93 (5.470)				
		160	179 (7.047) 188 (7.402)	148.52 (5.847)	148.55 (5.848)	148.59 (5.850)	148.63 (5.852)	148.67 (5.853)	148.71 (5.855)	148.75 (5.856)	148.79 (5.858)	148.83 (5.859)	148.87 (5.861)	148.92 (5.863)	148.96 (5.865)				
		170	189 (7.441) 198 (7.795)	158.52 (6.241)	158.56 (6.243)	158.60 (6.244)	158.64 (6.246)	158.69 (6.248)	158.73 (6.249)	158.77 (6.251)	158.81 (6.252)	158.86 (6.254)	158.90 (6.256)	158.95 (6.258)	159.00 (6.260)				
		180	199 (7.835) 208 (8.189)	168.53 (6.635)	168.57 (6.637)	168.62 (6.639)	168.66 (6.640)	168.70 (6.642)	168.75 (6.644)	168.79 (6.645)	168.84 (6.647)	168.88 (6.649)	168.93 (6.651)	168.98 (6.653)	169.03 (6.655)				
		190	209 (8.228) 218 (8.583)	178.54 (7.029)	178.58 (7.031)	178.63 (7.033)	178.67 (7.034)	178.72 (7.036)	178.77 (7.038)	178.81 (7.040)	178.86 (7.042)	178.91 (7.044)	178.96 (7.046)	179.02 (7.048)	179.07 (7.050)				
		200	219 (8.622) 229 (9.016)	188.55 (7.423)	188.59 (7.425)	188.64 (7.427)	188.69 (7.429)	188.74 (7.431)	188.79 (7.433)	188.84 (7.435)	188.89 (7.437)	188.94 (7.439)	188.99 (7.441)	189.05 (7.443)	189.10 (7.445)				

\* 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)
U750 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	4 - 11.5
SEAL-OFF 12.7 (1/2")	11.5-THRU
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.  
[www.husky-co.com](http://www.husky-co.com)

**RECOMMENDED GATE MATERIAL**  
NOTE: THESE MATERIALS MAY NOT OFFER THE RESISTANCE TO BRITTLE GATE FAILURES WHICH LEAD TO BRITTLE GATE FAILURES. ALSO - DO NOT EDM THE MOLDING SURFACE WITHIN 2mm OF THE GATE HOLE.  
AISI H13 (48-51) Rc1  
AISI 420 (48-51) Rc1

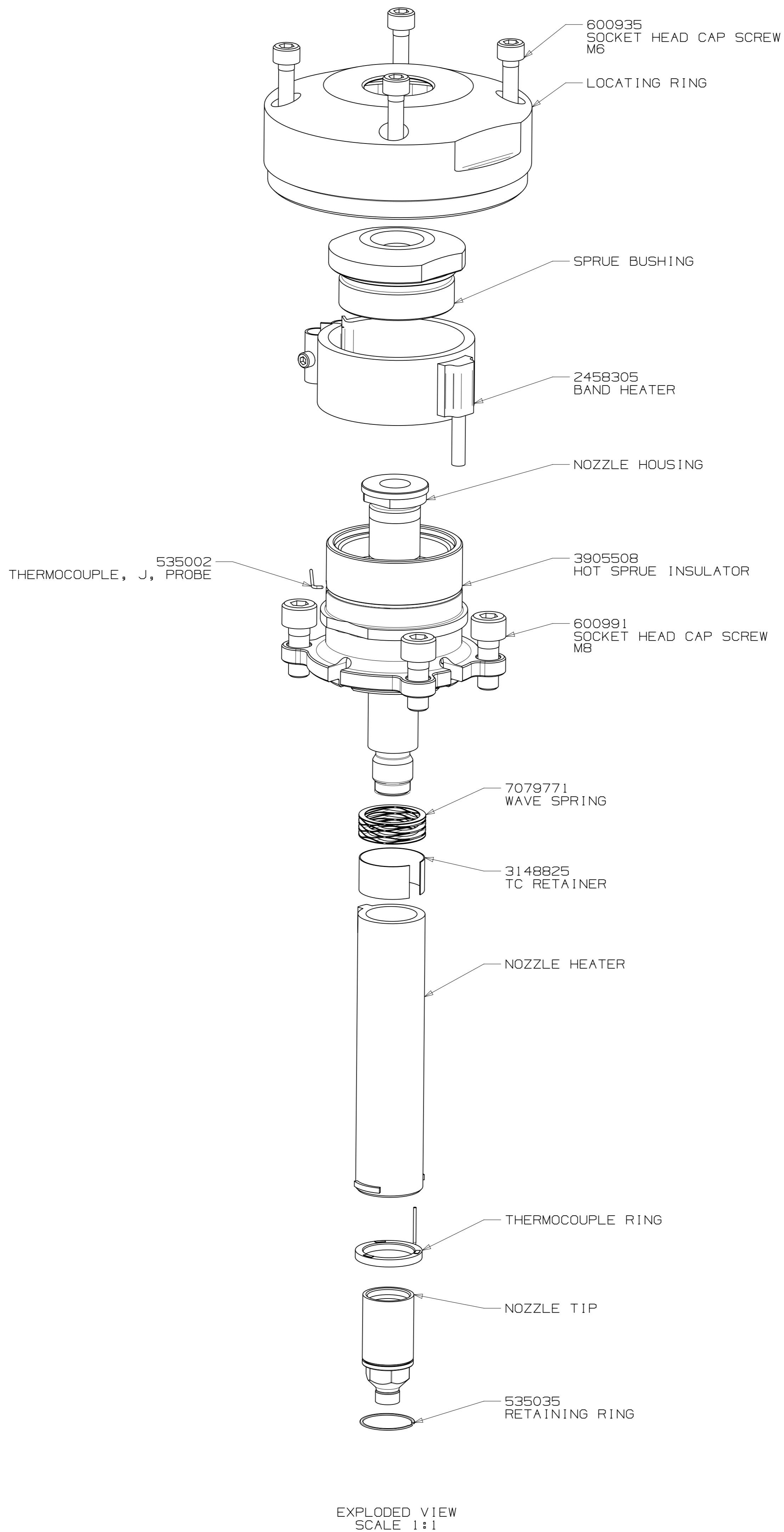
**RECOMMENDED GATE MANUFACTURING GUIDELINES**  
- HARDENED GATE INSERTS (48-51) ARE RECOMMENDED WHEN USING SOFTER CAVITY STEELS. SOFTER CAVITIES MAY BE ACCEPTABLE FOR CERTAIN APPLICATIONS. CONTACT YOUR HUSKY REPRESENTATIVE WITH QUESTIONS.  
- EDM'ING THE GATE AREA CAUSES MICRO CRACKS WHICH LEAD TO BRITTLE 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	2017-09-07	ORIGINAL ISSUE - DESIGNED BY: DHANALEKIAN	DRWN: DHANALEKIAN	CHKD: PICHLER KLAUS

<p>FOR TORQUE SPECIFICATIONS, REFER TO HS 252</p> <p>WEIGHT - kg</p>	<p><b>HUSKY</b></p> <p>TITLE: HOT SPRUE U750_HT_TS</p> <p>SCALE: NONE</p> <p>SHEET 1 OF 2</p>
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# ASSEMBLY DRAWING

DRAWING 8042693 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 = (-)	
RECOMMENDED GATE COOLING GUIDELINES ADEQUATE COOLING IS ESSENTIAL FOR THE PROPER FUNCTION OF THIS SYSTEM. REFER TO THE HOT RUNNER PRODUCT GUIDE <a href="http://www.husky.cc">www.husky.cc</a> 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
0	2017-09-07	ORIGINAL ISSUE - DESIGNED BY: DHANANJEYAN	DRWN: DHANANJEYAN CHKD: PICHLER, KLAUS

FOR TORQUE SPECIFICATIONS, REFER TO HS 252	METRIC	<b>HUSKY</b>
THIS DRAWING AND INFORMATION CONTAINED WITHIN IS CONFIDENTIAL AND/OR PROPRIETARY TO HUSKY INJECTION MOLDING SYSTEMS LTD. OR ONE OF ITS SUBSIDIARIES. IT IS NOT TO BE COPIED, REPRODUCED OR USED, IN WHOLE OR IN PART, WITHOUT THE PRIOR WRITTEN CONSENT OF HUSKY.		TITLE HOT SPRUE U750-HT-TS
WEIGHT - kg	NO INTELLECTUAL PROPERTY RIGHTS ARE GRANTED INCLUDING ANY LICENSE IMPLIED OR OTHERWISE. ALL RIGHTS RESERVED. COPYRIGHT 2017 HUSKY.	SCALE NONE SIZE AIR DRAWING 8042693 REV 0 SHEET 2 OF 2