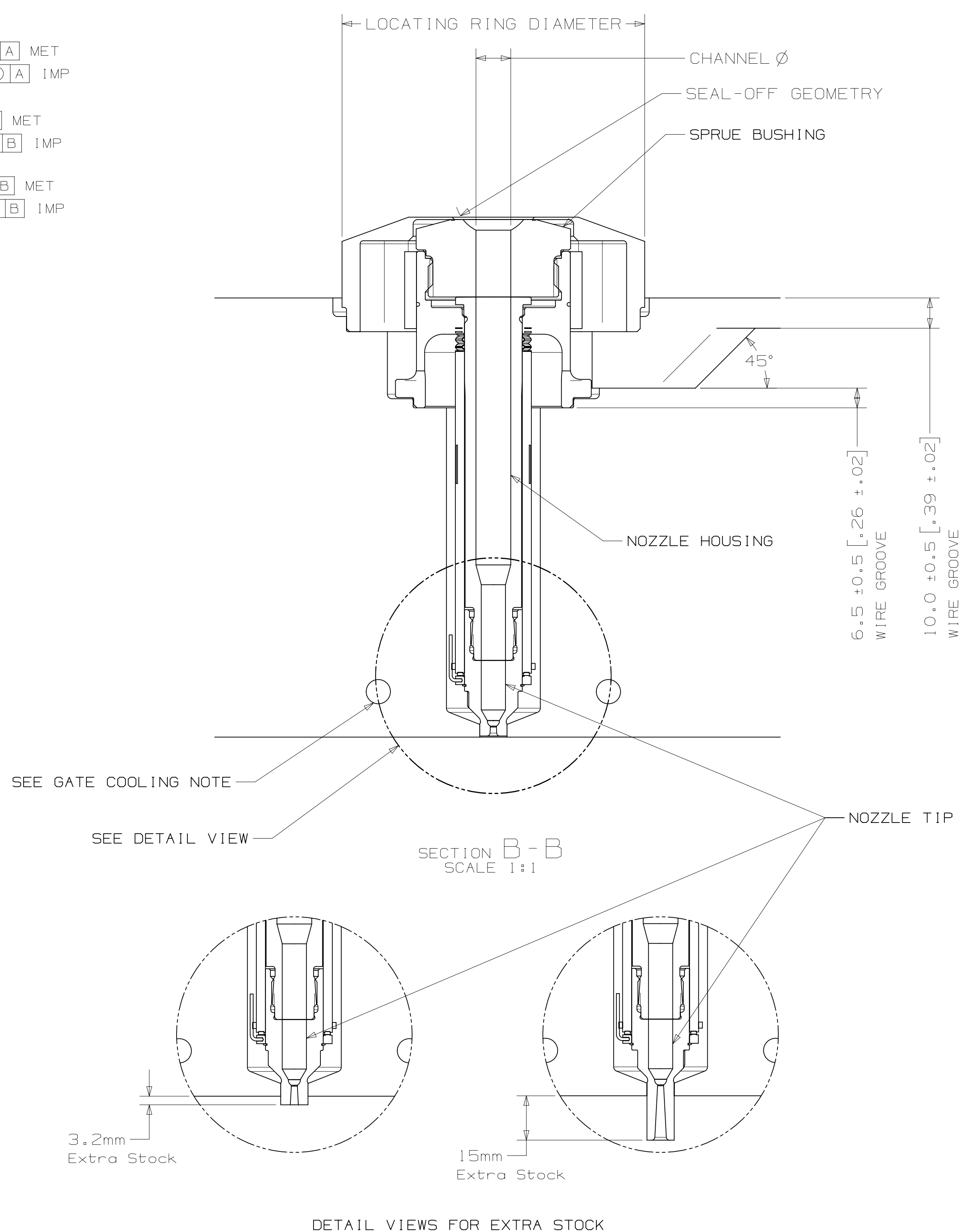
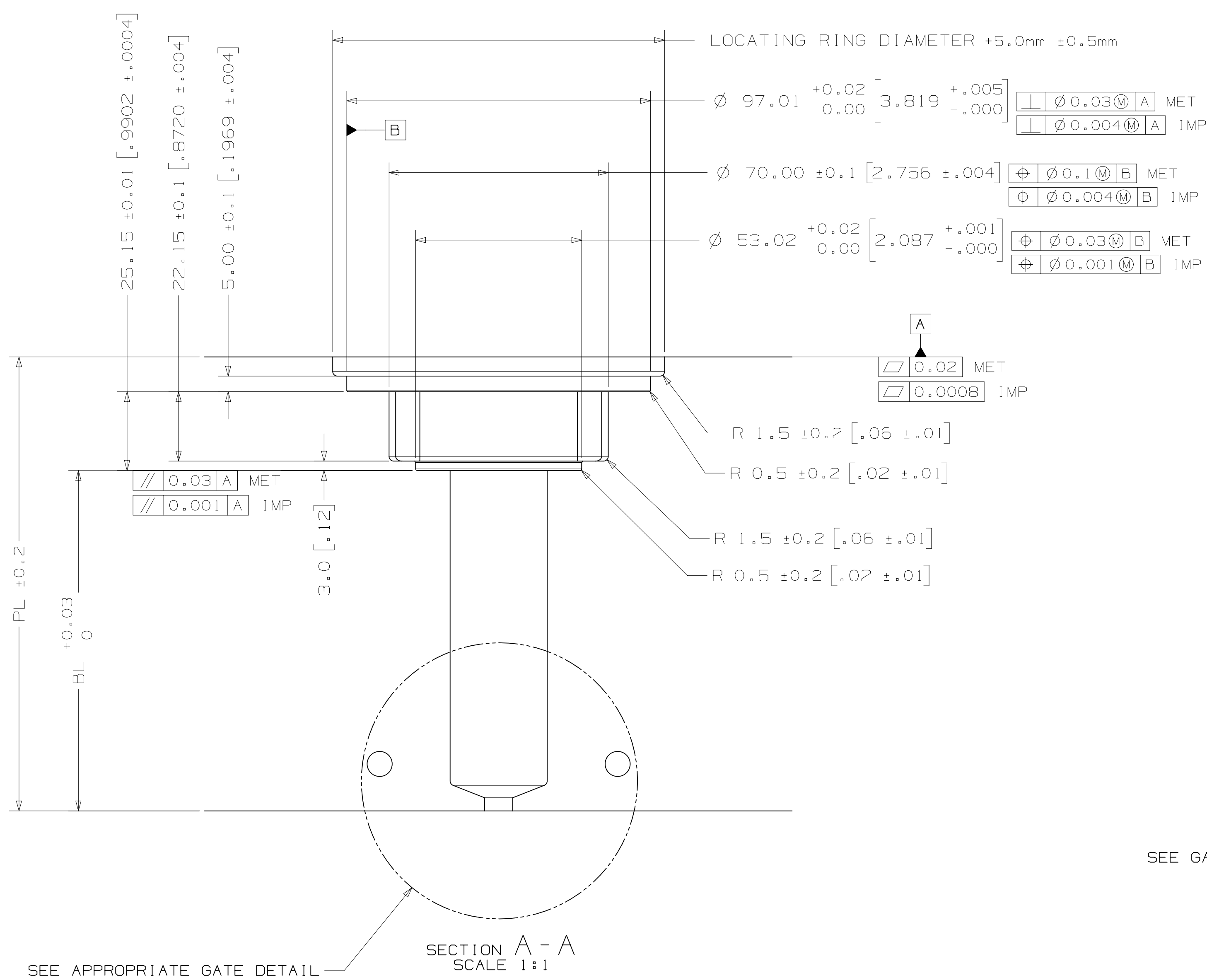
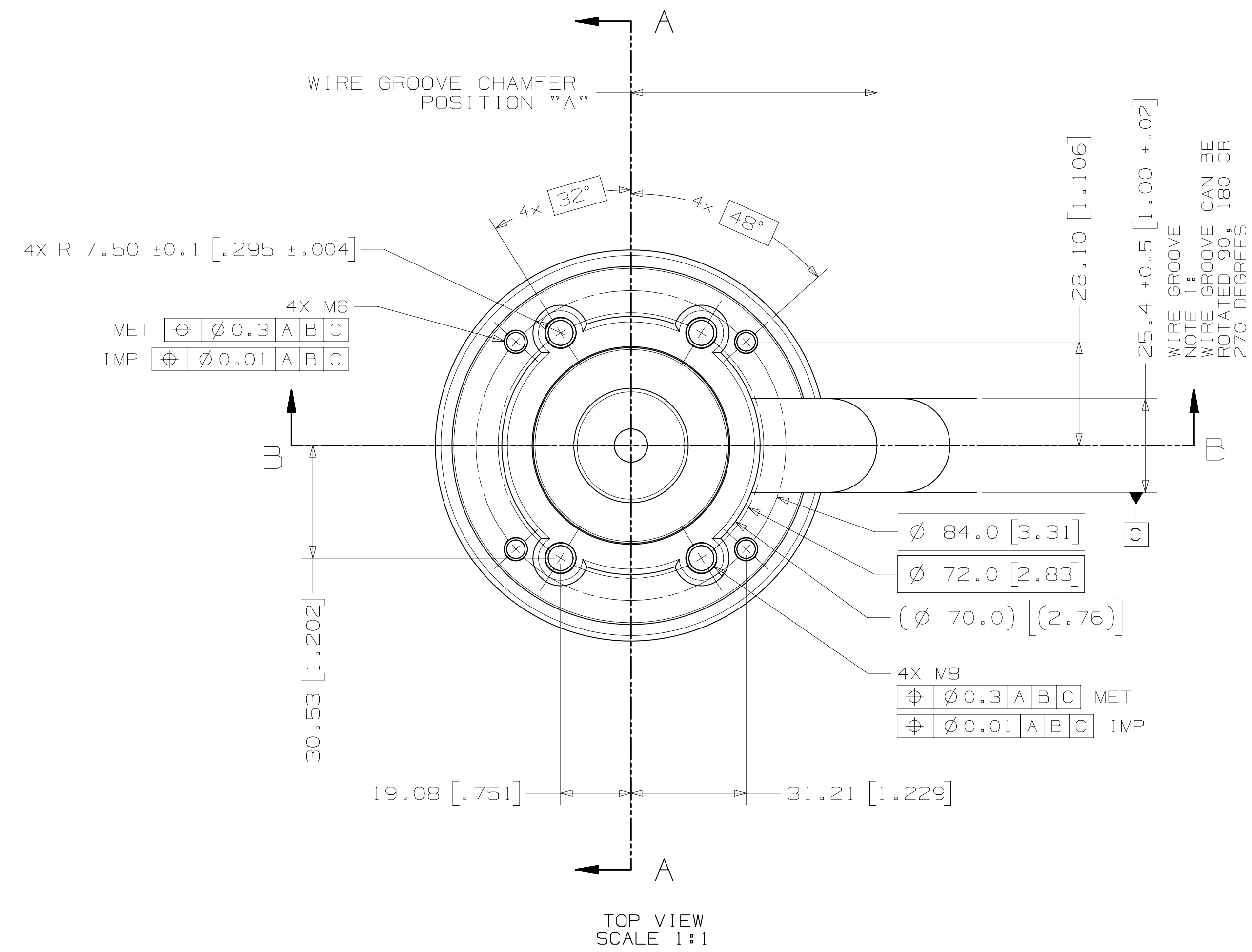


INSTALLATION DRAWING

REV 0
8042693



NOZZLE SERIES	NOZZLE TIP	PL RANGE	Approx. BL *
U750	HT-TS	68.68(2.704) - 235.84(9.285)	39(1.54) - 189(7.44)

* Approx. BL VALUES IN THE TABLE ARE REFERENCES WHICH CAN DEVIATE BY +/-1mm. FINAL BL VALUE CAN BE FOUND ON GATE DETAIL DRAWING AND 3D AFTER FINISHED DESIGN. BL AVAILABLE IN THE INCREMENT OF 10mm WITHIN RANGE.

SPRUE BUSHING	
SEAL-OFF GEOMETRY	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	

LOCATING RING DIAMETER	WIRE GROOVE CHAMFER POSITION "A" (±2.0)
U750 100mm	66.7
101.3mm (3.99")	66.7
125mm	78.7

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
AISI H13 (48-5) Rc1
AISI 420 (48-5) Rc1

RECOMMENDED GATE MANUFACTURING GUIDELINES

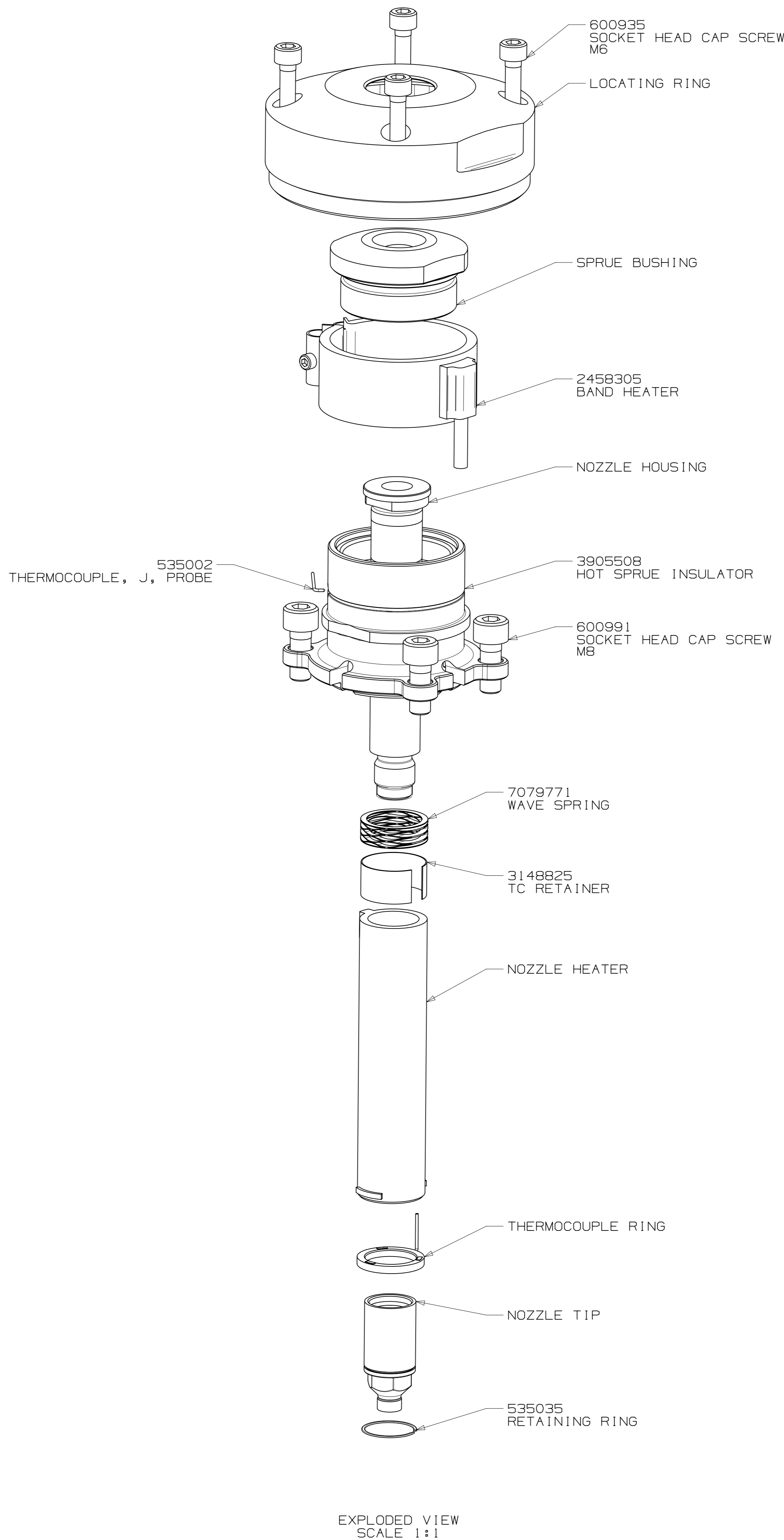
- HARDENED GATE INSERTS (48-5) ARE RECOMMENDED WHEN USING SOFTER CAVITY STEELS. SOFTER CAVITIES MAY BE ACCEPTABLE FOR CERTAIN APPLICATIONS. CONTACT YOUR HUSKY REPRESENTATIVE WITH QUESTIONS.
- EDM'ING THE GATE AREA CAUSES MICRO CRACKS WHICH LEAD TO BRITTLE GATE FAILURES. ALSO - DO NOT EDM THE MOLDING 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	DRWNG	CHKD
5	2020-05-26	TABLE UPDATED PER LATEST CALCULATION	DRWNG DEEBAN N T	CHKD
4	2019-07-09	TEMPLATE VALUES UPDATED AS PER SOL 2.0	DRWNG MURALIDHARAN	CHKD
3	2019-02-05	SINGLE CAVITY NAMEPLATE REMOVED	DRWNG ARJUN	CHKD
2	2018-05-20	DRAWING NAME CHANGED	DRWNG ANJSHAL	CHKD
0	2017-09-07	ORIGINAL ISSUE - DESIGNED BY: DHANANLEYAN	DRWNG DHANANLEYAN	CHKD: PICHLER KLAUS

COST PER ASM: 114.50-124.00 AND HUSKY ADDRESS: HUSKY BASIC OPERATING SPECIFIED CNO MODEL TO DIMS: NEW TOLERANCES/OPERATIONS ARE SHOWN GENERAL TOLERANCES: METRIC IMPERIAL BROKEN EDGES/CHAMFERS: 1:0.2 X 45° 0.04 (0.01) X 45° FILLET/RADIUS: R0.8 (0.2) R0.03 (0.01) SURFACE FINISH: Ra 3.2	FOR TORQUE SPECIFICATIONS, REFER TO HS 252	METRIC IMPERIAL WEIGHT: - kg SCALE: NONE SIZE: AOR SHEET: 1 OF 2	HUSKY TITLE: HOT SPRUE U750-HT-TS SCALE: NONE SIZE: AOR SHEET: 1 OF 2 REV: 0
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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 www.husky.cc 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.	

EXPLODED VIEW
SCALE 1:1

REV	DATE	DESCRIPTION	NAME
5	2020-05-26	TABLE UPDATED PER LATEST CALCULATION	DRWN: DEEBAN N T CHKD:
4	2019-07-09	TEMPLATE VALUES UPDATED AS PER SCL 2.0	DRWN: MURALIDHARAN CHKD:
3	2019-02-05	SINGLE CAVITY NAMEPLATE REMOVED	DRWN: ARUN CHKD:
2	2018-06-20	DRAWING NAME CHANGED	DRWN: ANUSHLAL CHKD:
0	2017-09-07	ORIGINAL ISSUE - DESIGNED BY: DHANANJEYAN	DRWN: DHANANJEYAN CHKD: PICHLER KLAUS

FOR TORQUE SPECIFICATIONS, REFER TO HS 252			TITLE HOT SPRUE U750-HT-TS	
WEIGHT	- kg		SCALE	NONE
		SIZE	AIR	DRAWING
		SHEET	2 OF 2	8042693
		REV		0