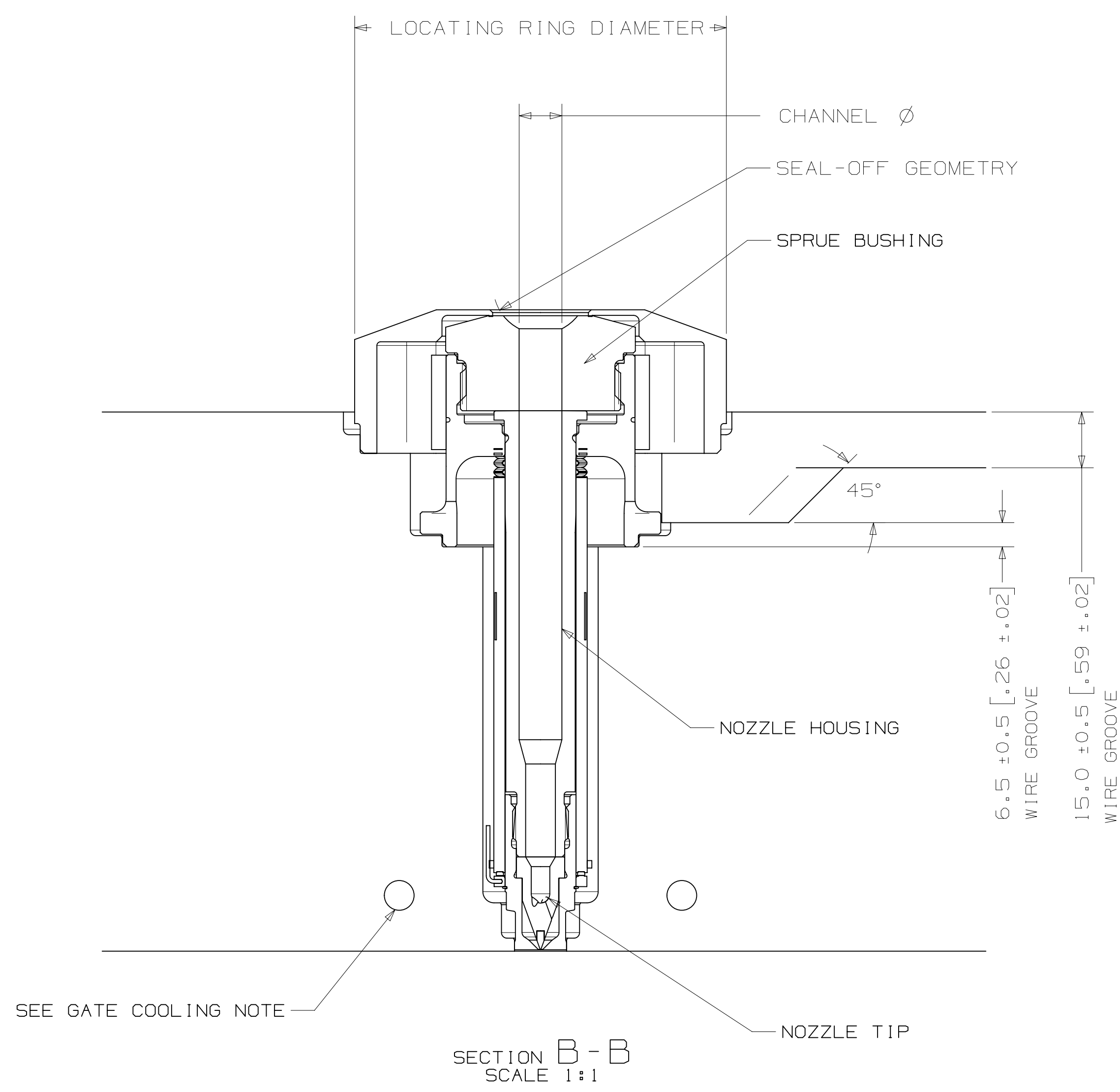
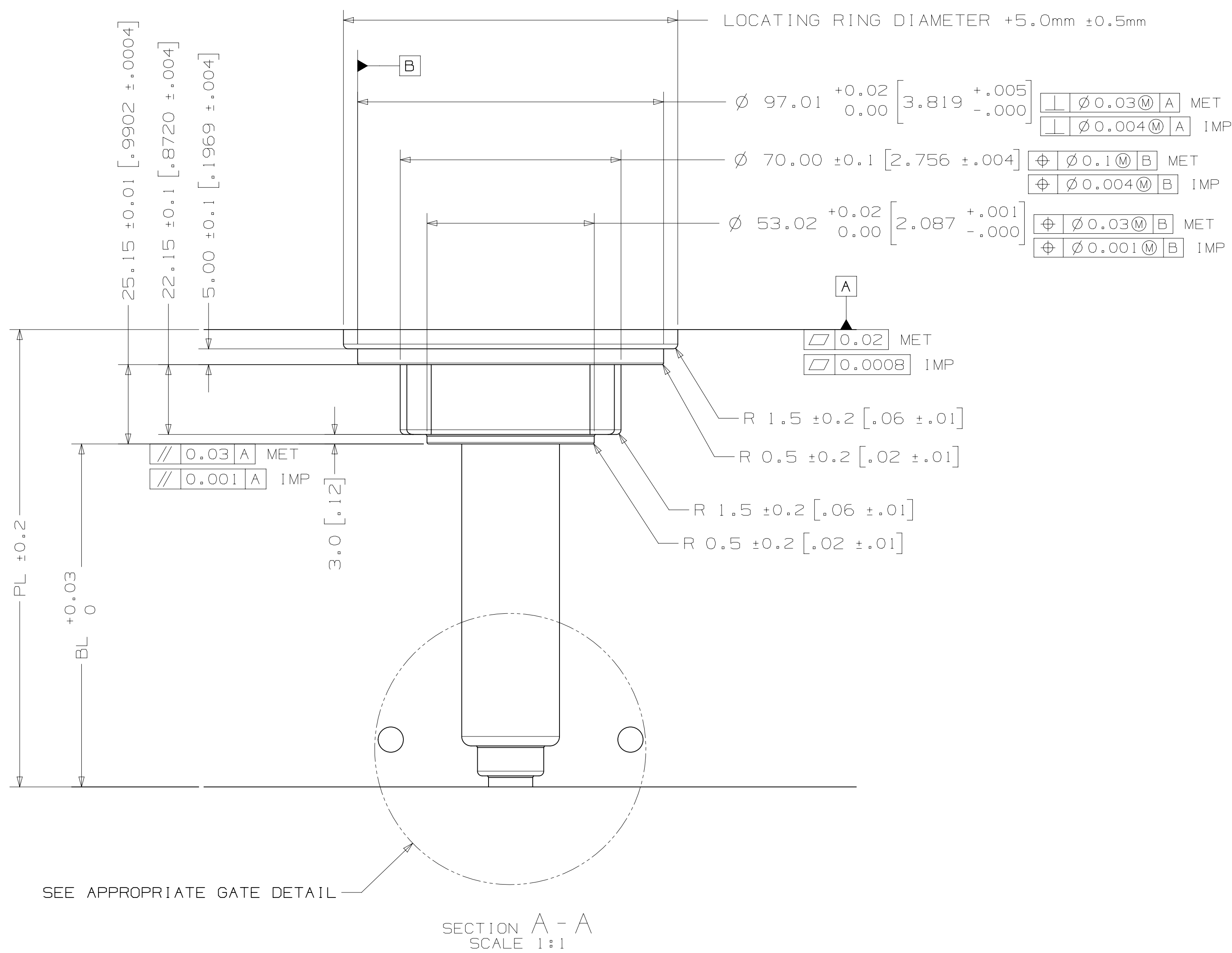
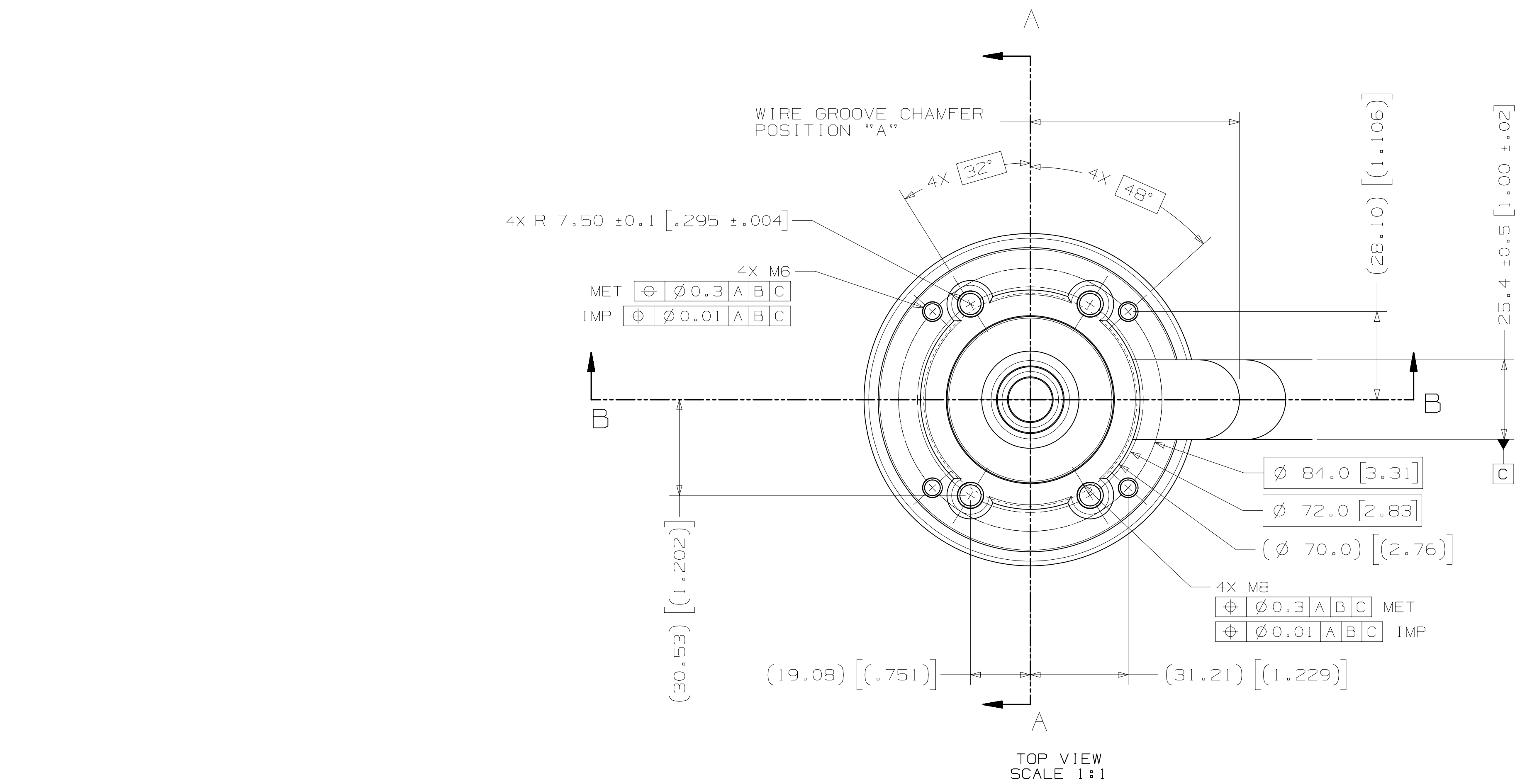


INSTALLATION DRAWING



NOZZLE SERIES	NOZZLE TIP	PL RANGE	Approx. BL *
U750	HT-CAP	68.69 [2.704] - 235.86 [9.286]	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.

U750	SPRUE BUSHING	
	SEAL-OFF GEOMETRY	CHANNEL Ø
	SPHERICAL RADIUS	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	

U750	LOCATING RING DIAMETER	WIRE GROOVE CHAMFER POSITION "A" (±2.0)
	100	66.7
	101.3 [3.991]	66.7
	125	78.7

DIMENSIONS SHOWN AS: millimeters (inches)

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.ca

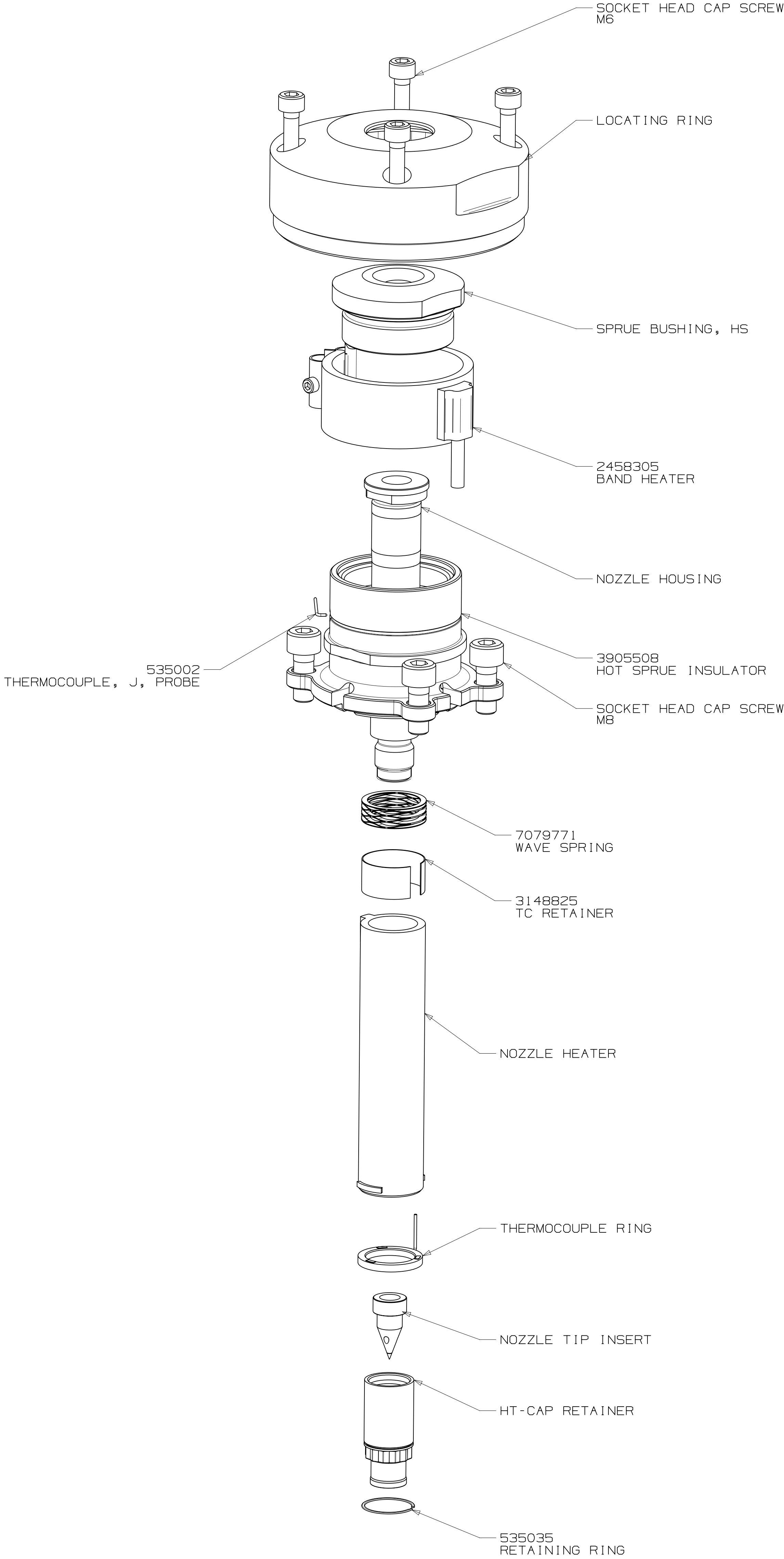
RECOMMENDED GATE MATERIAL
NOTE: THESE MATERIALS MAY NOT OFFER THE DESIRED RESISTANCE TO ABRASIVE AND/OR CORROSIVE RESINS, FILLERS AND/OR ADDITIVES FOR CERTAIN APPLICATIONS. CONTACT YOUR HUSKY REPRESENTATIVE WITH QUESTIONS.
AISI H13 (48-51 Rc)
AISI 420 (48-51 Rc)

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. SOFTENING THE AREA AROUND THE WELD AND CAN CAUSE GATE FAILURES.

FOR TORQUE SPECIFICATIONS, REFER TO HS 252		METRIC		TITLE	
HOT RUNNER Y14.50-1504 AND HUSKY ADDENDUM - H254		THIS DRAWING AND INFORMATION IS THE PROPERTY OF HUSKY. IT IS TO BE USED FOR THE DESIGN AND MANUFACTURE OF THE HOT RUNNER SYSTEM ONLY. IT IS NOT TO BE REPRODUCED OR USED IN ANY OTHER MANNER WITHOUT THE WRITTEN PERMISSION OF HUSKY.		HOT SPRUE	
BROKEN EDGE/CHAMFER: 1:0.2 X 45°		0.04 ±0.01 X 45°		U750-HT-CAP	
FILLET/ROUND: R0.8±0.2		R0.03±0.01		DRAWING NO. 8088142	
SURFACE FINISH: Ra 3.2		Ra 0.8		SHEET 1 OF 2	
WEIGHT: - kg		SCALE: NONE		REV: 3	

ASSEMBLY DRAWING



REV 3
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	26
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.ca FOR MORE DETAILED GUIDELINES.	
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FOR TORQUE SPECIFICATIONS, REFER TO HS 252		METRIC 			
WEIGHT		NO INTELLECTUAL PROPERTY RIGHTS ARE GRANTED INCLUDING ANY LICENSE IMPLIED OR OTHERWISE. ALL RIGHTS RESERVED. COPYRIGHT 2020 HUSKY.		TITLE	
- kg		SCALE NONE		HOT SPRUE	
		SHEET 2 OF 2		U750-HT-CAP	
		SIZE AIR		DRAWING 8088142	
				REV 3	