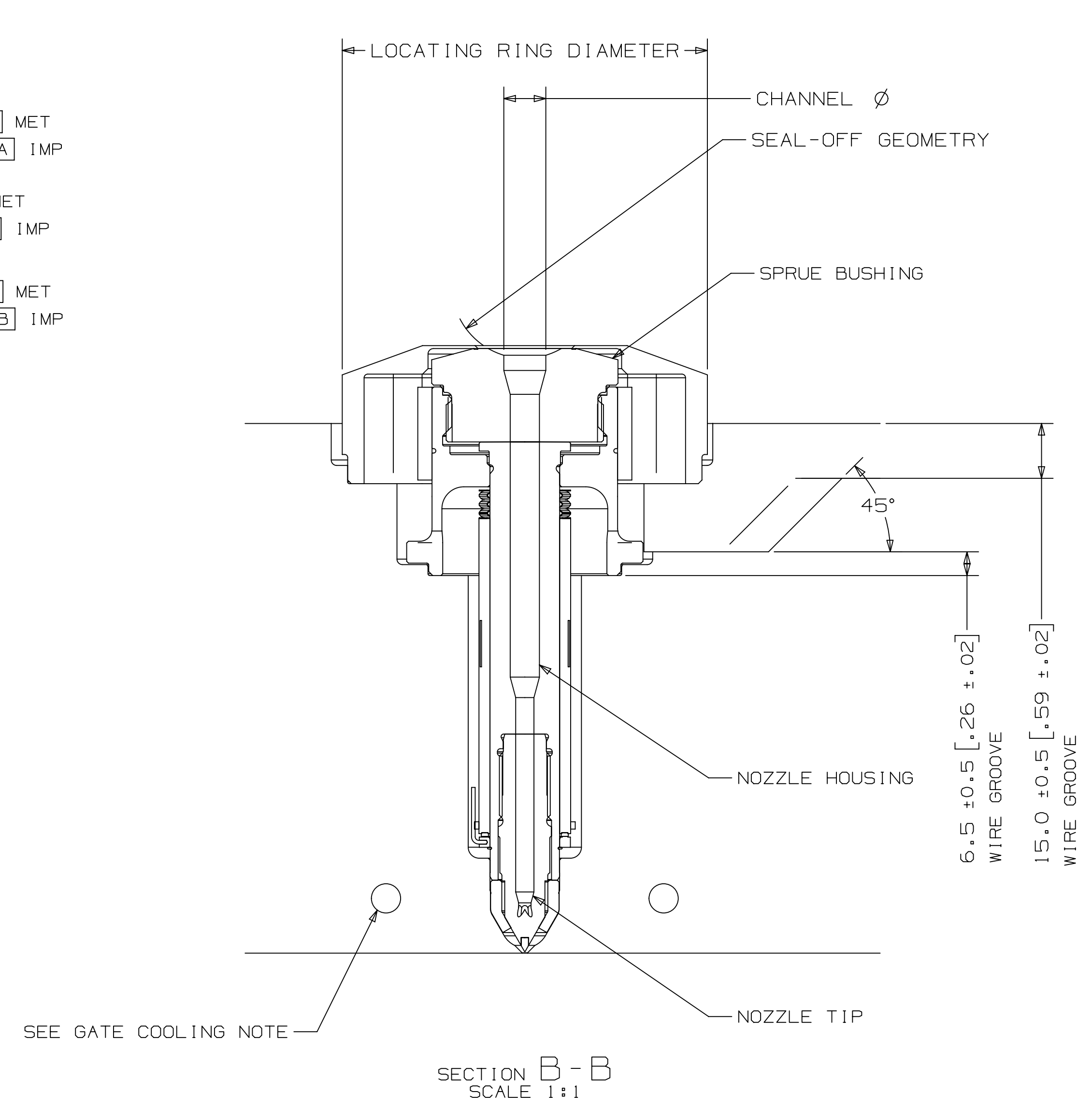
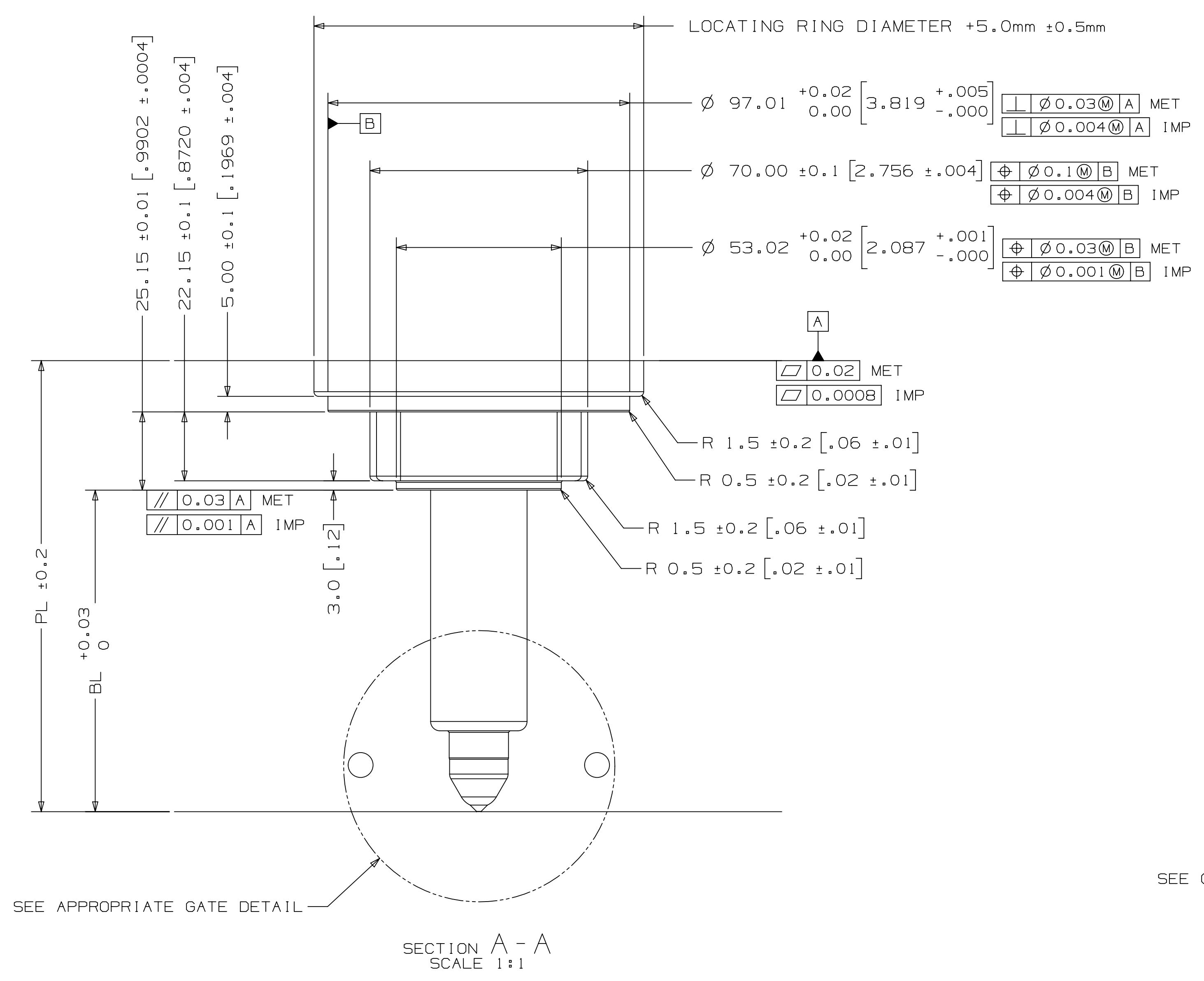
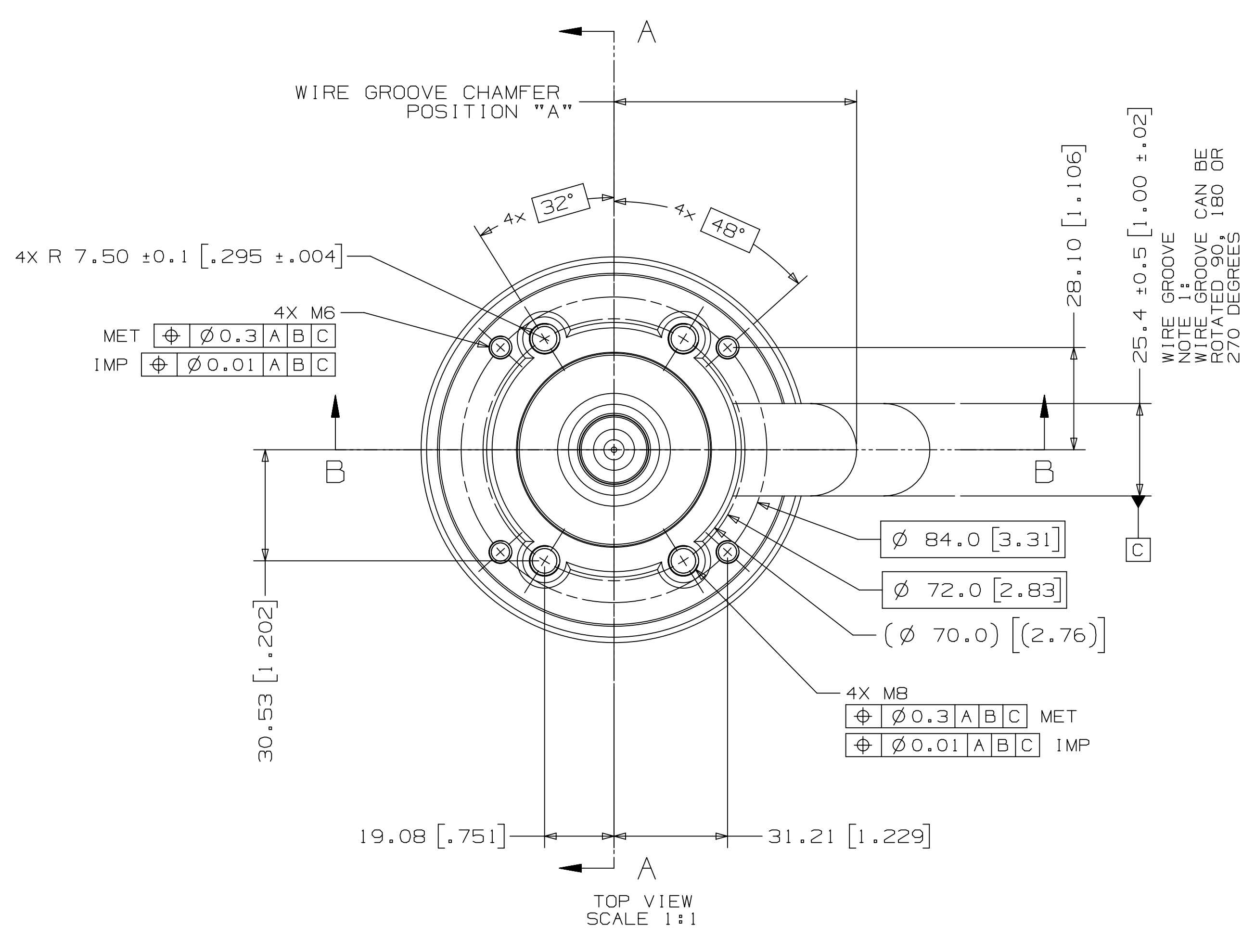


# INSTALLATION DRAWING

DRAWING NO. 8091885



NOZZLE SERIES	NOZZLE TIP	PL RANGE	Approx. BL *
U750	HT-S	73.28 (2.885) - 230.42 (9.072)	43.5 (1.71) - 183 (7.20)

\* 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
	FLAT	4 - 8
	FLAT	11.5 - 8
	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 (3.99)	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.

**RECOMMENDED GATE MATERIAL**  
NOTE! THESE MATERIALS MAY NOT OFFER THE DESIRED RESISTANCE TO ABRASIVE AND/OR CORROSIVE RESINS, FILLERS AND/OR ADDITIVES.  
AISI H13 (48-51 Rc)  
AISI 420 (48-51 Rc)

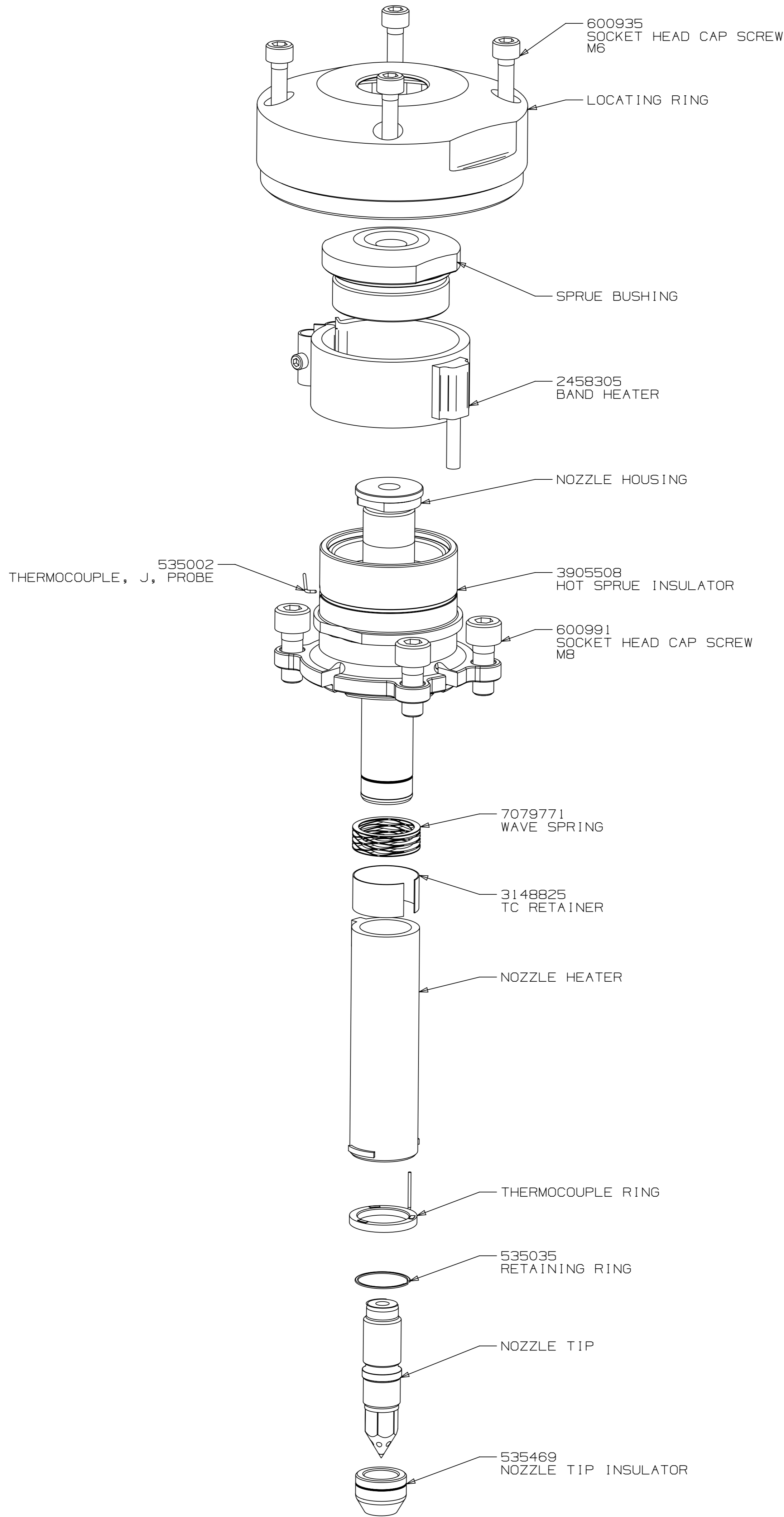
**RECOMMENDED GATE MANUFACTURING GUIDELINES**

- 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. SOFTENS THE AREA AROUND THE WELD AND CAN CAUSE GATE FAILURES.

GAT PER ANE V14.00.1204 AND HSKY ADDENDUM - HSK4 UNLESS OTHERWISE SPECIFIED NO. MODEL IS BASIC NEW TOLERANCES OPERATIONS ARE BASIC GENERAL TOLERANCES: <b>ISO 1101</b> BROKEN EDGE/CHAMFER: 1.0 ± 0.2 X 45° FILLET/RADIUS: R0.8 ± 0.2 SURFACE FINISH: $\sqrt{3.2}$	FOR TORQUE SPECIFICATIONS, REFER TO HS 252 METRIC: <b>ISO 817</b> IMPERIAL: <b>ASME B1.1</b> WEIGHT: - kg SCALE: N/A SIZE: AOR SHEET: 1 OF 2	<b>HUSKY</b> TITLE: HOT SPRUE U750-HT-S SCALE: N/A SIZE: AOR SHEET: 1 OF 2 REV: 1
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# ASSEMBLY DRAWING

DRAWING 8091885 REV 1



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	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	4.8	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 = (-)	
<b>RECOMMENDED GATE COOLING GUIDELINES</b> ADEQUATE COOLING IS ESSENTIAL FOR THE PROPER FUNCTION OF THIS SYSTEM. REFER TO THE HOT RUNNER PRODUCT GUIDE FOR MORE DETAILED GUIDELINES. <a href="http://www.husky.ca">www.husky.ca</a>	
<b>RECOMMENDED GATE MATERIAL</b> 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)	
<b>RECOMMENDED GATE MANUFACTURING GUIDELINES</b> <ul style="list-style-type: none"> <li>- 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.</li> <li>- 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.</li> <li>- MACHINE THE GATE HOLE AFTER HARDENING TO AVOID EXCESSIVE QUENCH IN THE THIN SECTION DURING HEAT TREAT &amp; RESULTING OVERHARDENING IN THE GATE AREA.</li> <li>- RECESSED GATES ON THE PRODUCT REDUCE THE GATE AREA STRENGTH LEADING TO GATE FAILURES.</li> <li>- WELDING THE GATE AREA INCREASES STRESSES AT THE GATE, SOFTENS THE AREA AROUND THE WELD AND CAN CAUSE GATE FAILURES.</li> </ul>	

FOR TORQUE SPECIFICATIONS, REFER TO HS 252	METRIC	<b>HUSKY</b>	TITLE	HOT SPRUE					
	<small>THIS DRAWING AND INFORMATION CONTAINED WITHIN IS CONFIDENTIAL AND/OR PROPRIETARY TO HUSKY INJECTION MOLDING SYSTEMS LTD. OR ONE OF ITS SUBSIDIARIES. ("HUSKY") AND MAY NOT BE COPIED, DISCLOSED OR USED, IN WHOLE OR IN PART, WITHOUT THE PRIOR WRITTEN CONSENT OF HUSKY.</small>		U750-HT-S						
WEIGHT	- kg	SCALE	NONE	SIZE	AIR	DRAWING	8091885	REV	1
		SHEET 2 OF 2							