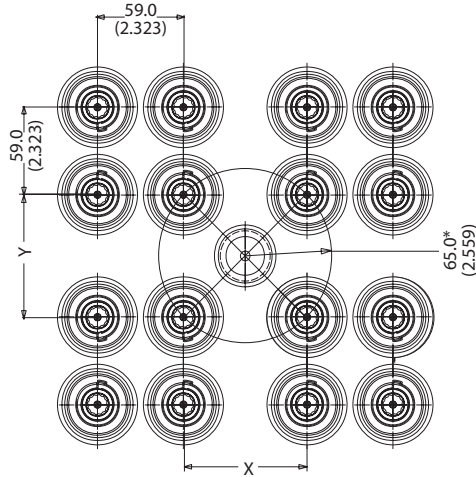


Ultra 750 Nozzles

Pitch spacing



Valve gate large piston (EX)

Valve gate large piston (EX)

Note: The sprue minimum radius 65.0 mm (2.559") and the X and Y minimum distances must all be satisfied.

X and Y must be greater than 92.0 mm (3.622")

Note: Minimum distance between outermost nozzle drop center to outer edge of the manifold plate is 125 mm (4.921"). If reduced distance is required contact Husky.

* Plunger style sprue bushing require additional spacing.
Review required.

Husky Injection Molding Systems
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Ultra 750 Nozzles

Ideal for medium to large parts with throughputs up to 350 grams/sec., hot tip and valve gate options accommodate most engineering and commodity resins.

Features:

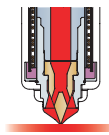
- Hot tip and valve gate options
- 31.0 mm diameter (1.220") nozzle bore
- 14.01 mm diameter (0.552") nozzle sealoff
- Maximum pressure is 1793 bar (35,000 psi for UP)
- Minimum pitch spacing of 44.5 mm (1.60")
- Three year leakproof guarantee with UltraSeal®

Applications

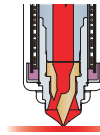
The Ultra 750 nozzle provides exciting opportunities for molders and mold makers in the closure, packaging, medical, technical, automotive and housewares markets because it offers medium to high throughput capability with a wide variety of hot tip and valve gated options. The Ultra 750 nozzle is designed to provide a versatile alternative for multi-cavity production of medium sized parts. In addition to a wide range of valve gated tip styles, the Ultra 750 valve gate nozzle offers flexible cylinder sizes for most applications. The Ultra 750 hot tip nozzle offers a wide range of tip options for a variety of resin and gating requirements. For color change applications, UltraFlow tips are available in both hot tip and valve gated styles. The Ultra 750 features a wide operating window and an optimized thermal profile for easy start-ups. All Husky hot runners feature UltraSeal technology and come with a three year leakproof guarantee.

Gating options

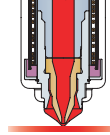
Hot tip



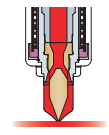
HT-D



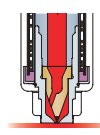
HT-U



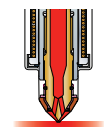
HT-T



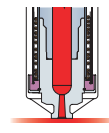
HT-DX



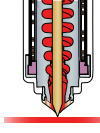
HT-DC



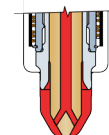
HT-S6



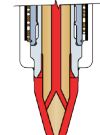
TS



HT-UF

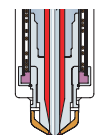


HT-D

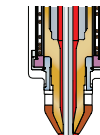


HT-DX

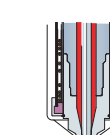
Valve gate



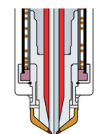
VG



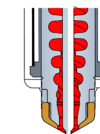
VG-R



VX



VG-HP



VG-VF

HUSKY®

Keeping our customers in the lead

Ultra 750 Nozzles

Ultra 750 Hot Tip - Application Guidelines

Throughput (grams/second)

Viscosity	HT-D	HT-S6	HT-UF	HT-U	HT-DX	HT-T	HT-DC	TS
Low	175	175	175	175	175	175	175	350
Medium	80	80	80	80	80	80	80	250
High	40	40	40	40	40	40	40	60

Material compatibility

Resin	HT-D STD WR	HT-S6	HT-UF STD WR	HT-U STD WR	HT-DX STD WR	HT-T STD WR	HT-DC STD WR	TS	Resin Structure
ABS	✓ ✓	×	✓ ✓	✓ ✓	✓ ✓	✓ ✓	✓ ✓	✓ F	A
CAB	◇ ◇	×	×	×	×	×	◇ ◇	◇ ◇	A
PC	✓ ✓	×	✓ ✓	×	×	×	✓ ✓	✓	A
PEI	◇ ◇	×	×	×	×	×	◇ ◇	◇ ◇	A
PETG	×	×	×	×	×	×	◇ ◇	◇ ◇	A
PMMA	✓ ✓	×	✓ ✓	✓ ✓	✓ ✓	◇ ◇	✓ ✓	✓	A
PPO(PPE+PS/PA)	✓ ✓	×	×	×	×	×	✓ ✓	✓	A/SC
PS	✓ ✓	✓	✓ ✓	✓ ✓	✓ ✓	✓ ✓	✓ ✓	◇ F	A
PSU	◇ ◇	×	×	×	×	×	◇ ◇	◇ ◇	A
TPUR	✓ ✓	×	✓ ✓	×	×	◇ ◇	✓ ✓	×	A
TPE	✓ ✓	×	✓ ✓	✓ ✓	✓ ✓	✓ ✓	✓ ✓	◇	A
Flex. PVC	◇ ◇	×	×	×	×	×	×	◇	A
SAN	✓ ✓	×	✓ ✓	×	×	✓ ✓	✓ ✓	◇ F	A
TPO	✓ ✓	×	✓ ✓	◇ ◇	◇ ◇	✓ ✓	✓ ✓	◇	A
PA	✓ ✓	×	◇ ✓	◇ ◇	×	✓ ✓	✓ ✓	✓	SC
PBT	✓ ◇	×	✓ ✓	×	×	×	✓ ◇	◇	SC
PE	✓ ✓	◇	✓ ✓	✓ ✓	✓ ✓	✓ ✓	✓ ✓	◇	SC
POM	✓ ✓	×	✓ ✓	×	×	✓ ✓	✓ ✓	◇	SC
PP	✓ ✓	✓	✓ ✓	✓ ✓	◇ ◇	✓ ◇	✓ ✓	✓	SC
PPS	◇ ◇	×	×	×	×	×	◇ ◇	◇	SC
PBT/PC	✓ ✓	×	✓ ✓	×	×	◇ ◇	◇ ◇	◇	SC
PC/ABS	✓ ✓	×	✓ ✓	◇ ◇	◇ ◇	✓ ◇	✓ ✓	✓	
Abrasive	×	×	×	×	×	×	×	✓	
Color Change	✓ ✓	✓	✓ ✓	×	×	×	✓ ✓	✓	

- ✓ Recommended
- ◇ Requires Review
- ×
- SC Semi-Crystalline
- B Blend
- A Amorphous
- F Flow Pin

Ultra 750 Valve Gate

Throughput (grams/second)

Viscosity	SCVG	VG	VX	VG-R	VG-UF
Low	250	250	250	250	175
Medium	150	150	150	150	80
High	50	50	50	50	40

Material compatibility

Resin	VG	VX	VG-R	VG-UF	Resin Structure
Abrasive	×	✓	×	×	
ABS	✓	✓	◇	◇	A
CAB	◇	×	×	×	A
Color Change	✓	✓	×	×	
Flex. PVC	◇	×	×	×	A
PA	◇	✓	×	×	SC
PBT	✓	◇	×	×	SC
PBT/PC	◇	◇	×	×	B
PC	✓	✓	◇	×	A
PC/ABS	✓	◇	×	×	B
PE	✓	◇	◇	✓	SC
PEI	◇	×	×	×	A
PET	×	◇	×	×	SC
PETG	◇	◇	◇	×	A
PMMA	✓	×	×	×	A
POM	◇	◇	×	×	SC
PP	✓	◇	✓	◇	SC
PPO(PPE+PS/PA)	◇	◇	×	×	A/SC
PPS	◇	◇	×	×	SC
PS	✓	×	✓	◇	A
PSU	◇	◇	×	×	A
SAN	✓	✓	×	×	A
TPE	◇	◇	◇	◇	A
TPO	◇	◇	◇	◇	A
TPUR	◇	◇	×	×	A

- ✓ Recommended
- ◇ Requires Review
- ×
- SC Semi-Crystalline
- B Blend
- A Amorphous
- F Flow Pin

Ultra 750 Nozzles

Ultra SideGate-Application Guidelines

Max Throughput per gate (g/sec.)

Viscosity	SG-1	SG-2	SG-4
Low	10	10	10
Medium	4	4	4
High	1	1	1

Material Compatibility

Resin	HT-S6	TS	Resin Structure
Abrasive	×	×	
ABS	✓	◇	A
COC	✓	◇	A
Color Change	◇	◇	
COP	✓	◇	A
Flex. PVC	◇	◇	A
MABS	✓	◇	A
PA	×	×	SC
PBT	×	×	SC
PBT/PC	×	×	B
PC	✓	◇	A
PC/ABS	◇	◇	B
PCTG, PCTA	✓	◇	A
PE	✓	◇	SC
PEI	×	×	A
PET	×	×	SC
PETG	×	×	A
PMMA	✓	◇	A
POM	×	✓	SC
PP	✓	✓	
PPO	×	×	A/SC
PPS	×	×	SC
PS	✓	◇	A
PSU	×	×	A
SAN	✓	◇	A
SBC (K-Resin)	✓	◇	A
TPE	◇	◇	A
TPO	◇	◇	A
TPUR	◇	◇	A

Ultra 750 UP-Application Guidelines

Max Throughput (g/sec.)

Viscosity	HT-D	HT-DX
Low	300	300
Medium	-	-
High	-	-

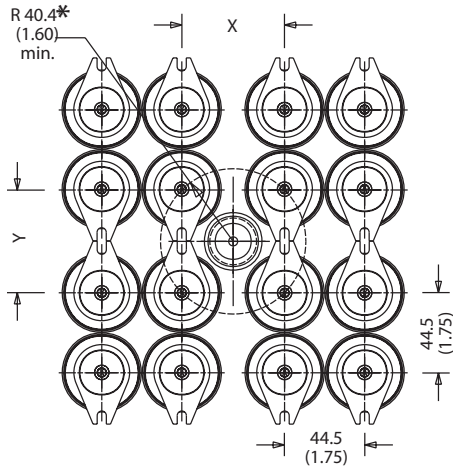
Material compatibility

Resin	HT-D	HT-DX	Resin Structure
PE	×	×	SC
PP	✓	✓	SC
PS	✓	✓	A

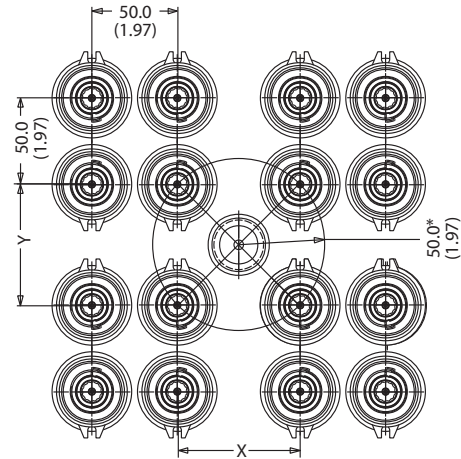
- ✓ Recommended
 - ◇ Requires Review
 - ×
- SC Semi-Crystalline
 - B Blend
 - A Amorphous
 - F Flow Pin

Ultra 750 Nozzles

Pitch spacing



Hot tip



Standard valve gate (LX)

Hot tip

- For applications that exceed 16 drops contact a Husky hot runner specialist
- Tighter pitch layouts may be available, contact Husky for more options

Note: The sprue minimum radius 40.4 mm (1.60") and the X and Y minimum distances must all be satisfied.

For < 8 drops X and Y must be > 57.5 mm (2.26")

For > 8 drops X and Y must be > 76.2 mm (3.00")

Note: Minimum distance between outermost nozzle drop center to outer side edge of the manifold plate is 75mm (2.95"). Minimum distance between the outermost nozzle drop center to the outer top and bottom edge of the manifold plate is 100mm (3.93"). If reduced distance is required contact Husky.

* Plunger style sprue bushing require additional spacing. Review required.

Standard valve gate (LX)

Note: The sprue minimum radius 50.0 mm (1.97") and the X and Y minimum distances must all be satisfied.

X and Y must be greater than 71.0 mm (2.80")

Note: Minimum distance between outermost nozzle drop center to outer side edge of the manifold plate is 75mm (2.95"). Minimum distance between outermost nozzle drop center to outer top and bottom edge of manifold plate is 100mm (3.93"). If reduced distance is required contact Husky.

* Plunger style sprue bushing require additional spacing. Review required.