

Ultra 1000 Nozzles

For throughputs up to 750 grams/sec., the Ultra 1000 nozzle accommodates engineering grade and commodity resins for larger part sizes.

Features:

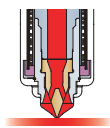
- Hot tip and valve gate options
- 42.0 mm diameter (1.650") nozzle bore
- 18.01 mm diameter (0.709") nozzle sealoff
- Maximum injection pressure is 2068 bar (30 kpsi)
- Minimum pitch spacing of 61.0 mm (2.40")
- Three year leakproof guarantee with UltraSeal®

Applications

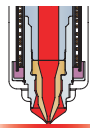
The Ultra 1000 nozzle provides a platform suitable for molders and mold makers in the automotive and general markets because it is the largest Ultra nozzle. The Ultra 1000 nozzle is designed for single or multi cavity production of large, heavy parts, including totes, trash cans and highly filled mechanical parts. This nozzle features a wide operating window, with valve gate and hot tip gating styles. The Ultra 1000 nozzle's large melt channels provides the flow area necessary to fill large, long flow length parts with today's fast injection rates without over shearing or excessive pressure drop. The Ultra 1000 nozzle is available for polyolefin and engineering grade resins. All Husky hot runners come with a three year leakproof guarantee.

Gating options

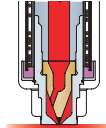
Hot tip



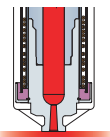
HT-D



HT-T

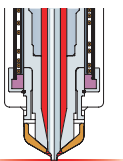


HT-DC

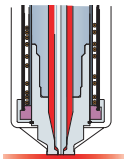


TS

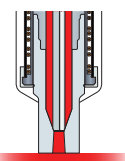
Valve gate



VG



VX



VX-X

Throughput (grams/second)

Viscosity	VG	VX	VX-X	HT-D	HT-T	HT-DC	TS
Low	450	450	450	350	350	350	750
Medium	200	200	200	150	150	150	350
High	80	80	80	50	50	50	90

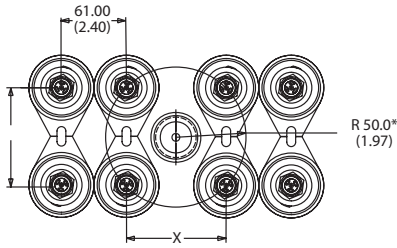
Material compatibility

Resin	VG	VX	VX-X	HT-D	HT-T	HT-DC	TS	Resin Structure
Abrasive	◇	✓	✓	◇	◇	✓	✓	
ABS	✓	✓	✓	✓	×	✓	◇	A
Color Change	✓	✓	✓	×	×	✓	✓	
PA	◇	✓	✓	✓	×	✓	✓	SC
PA(GF)	◇	✓	✓	◇	◇	✓	✓	SC
PBT	✓	✓	✓	◇	◇	◇	✓	SC
PBT/PC	✓	✓	✓	◇	×	✓	✓	B
PC	✓	✓	✓	◇	×	◇	✓	A
PC/ABS	✓	✓	✓	◇	×	✓	✓	B
PE	◇	◇	◇	✓	✓	◇	✓	SC
PETG	◇	×	×	×	◇	◇	×	A
PMMA	✓	✓	✓	◇	×	◇	✓	A
POM	◇	◇	◇	◇	×	◇	◇	SC
PP	✓	✓	✓	✓	◇	✓	✓	SC
PP (TALC)	✓	✓	✓	✓	◇	◇	◇	SC
PPO(PPE+PS/PA)	✓	✓	✓	✓	◇	◇	◇	A/SC
PS	✓	✓	✓	✓	×	✓	✓	A
SAN	✓	✓	✓	✓	×	✓	◇	A
TPE/TPO	✓	◇	◇	◇	◇	◇	×	A

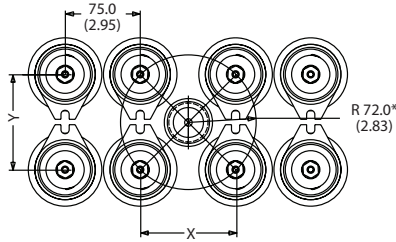
- ✓ Recommended
- ◇ Requires Review
- ×
- SC Semi-Crystalline
- B Blend
- A Amorphous

Ultra 1000 Nozzles

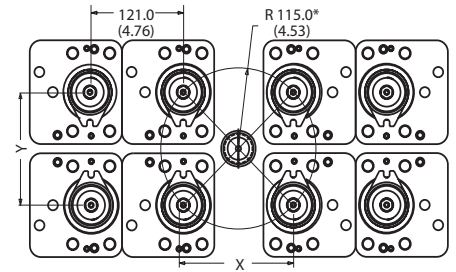
Pitch spacing



Hot tip pitch spacing



Valve gate (no airplate) pitch spacing



Valve gate (airplate) pitch spacing

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 50.0 mm (1.97") and the X and Y minimum distances must all be satisfied.

X and Y must be greater than 70.7 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.

Valve gate (no airplate)

Note: The sprue minimum radius 72.0 mm (2.83") and the X and Y minimum distances must all be satisfied.

X and Y must be greater than 101.8 mm (4.01")

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.

Valve gate (airplate)

Note: The sprue minimum radius 115.0 mm (4.53") and the X and Y minimum distances must all be satisfied.

X and Y must be greater than 162.6 mm (6.40")

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.

Husky Injection Molding Systems
www.husky.ca

Head Office Canada • Tel. (905) 951 5000 • Fax (905) 951 5384
Asia China • Tel. (86) 21 3850 8000 • Fax (86) 21 5048 4900
Europe Luxembourg • Tel. (352) 52 11 51 • Fax (352) 52 60 10

* HUSKY, HUSKY KEEPING OUR CUSTOMERS IN THE LEAD & DESIGN and ULTRASEAL are registered trade-marks of Husky Injection Molding Systems Ltd. in the United States and other countries, and may be used by certain of its affiliated companies under License. Other HUSKY product or service names or logos referenced in these materials are trade-marks of Husky Injection Molding Systems Ltd. and may be used by certain of its affiliated companies under License.
© 2014 Husky Injection Molding Systems Ltd. All rights are reserved.