

Nozzle Selection

Nozzle Options

All specifications are subject to change without notification.

The charts below are used to aid you in determining the best nozzle size for your specific application:

	Large Parts	Medium Parts	Small Parts	Engineering/ Glass Filled Resins	Shot Size	Valve Gate
Micron			X	X	< Than 50 Grams	
Accugate Series	X	X		X	50 -3500 Grams	X
Sprue Bushings (Single Cavity / Direct Feed)	X	X		X	50-3500 Grams	

THROUGHPUT

Nozzle Type	Micron	Accugate	Accugate Series			Sprue Bushing		
	156	197	250	375	625	.750"	1.00"	1.50"
Single Application	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes
Manifold Application	Yes	Yes	Yes	Yes	Yes	No	No	No
SPRUE GATE	Micron	Accugate	Accugate Series			Sprue Bushing		
	156	197	250	375	625	.750"	1.00"	1.50"
Pp,Ps	100	250	500	2000	4000	250	500	2000
LdPe, PVC-p, SAN	75	200	400	1500	3000	200	400	1500
ABS, HDPe, Pa	50	150	300	1000	2000	150	300	1000
PET, POM	30	75	150	750	1500	75	150	750
PBT, Pc, PMMA, PPO	15	30	100	500	1000	50	100	500
Pinpoint Gate	Micron	Accugate	Accugate Series					
	156	197	250	375	625			
Pp,Ps	100	250	500	2000	4000			
LdPe, PVC-p, SAN	75	200	400	1500	3000			
ABS, HDPe, Pa	50	150	300	1000	2000			
PET, POM	30	75	150	750	1500			
PBT, Pc, PMMA, PPO	15	30	100	500	1000			
Multi-Tip			Accugate Series					
			250	375	625			
Pp,Ps			500	2000	4000			
LdPe, PVC-p, SAN			400	1500	3000			
ABS, HDPe, Pa			300	1000	2000			
PET, POM			150	750	1500			
PBT, Pc, PMMA, PPO			100	500	1000			

*Please confirm all dimensions and nozzle suitability by referring to www.heaterwerks.com or contacting fast heat directly.

DIRECT FEED APPLICATIONS



Tip Selection

Please use the charts below to determine the appropriate tips for your nozzles.

Gate Styles:

Sprue Extra Stock Sprue Pinpoint Nylon Sprue	A=Amorphous C= Crystalline S= Semi- Crystalline	Micropoint 3= Excellent 2= Good 1= Application Dependent		
		Sprue Nylon	Sprue	Pinpoint
ABS	A	3	2	3
ABS – FR	A	2	3	1
ABS / Pa6	C	0	3	1
Acetal –C	C	0	3	3
Acetal – H	C	0	3	1
Acrylic	A	3	2	3
CAB	A	1	3	1
CAP	A	1	3	1
EVA	A	3	2	3
LCP	C	0	2	0
Pa6	C	0	3	3
Pa66	C	0	3	2
Pa11 & 12	C	0	3	2
PBA	C	2	2	2
PBT	C	0	3	2
Pc	A	2	2	2
Pc / ABS	A	2	2	2
Pc / PBT	C	0	3	1
PEEK	C	0	2	0
PEI	A	0	2	0
PES	A	0	2	0
PET	C	0	3	2
Pe- LD	S	3	3	3
Pe- HD	S	3	3	3
Pp	S	3	3	3
Ps	A	3	2	3
PPE	A	2	3	2
PPE / Nylon	C	0	2	0
PPS	C	0	2	0
PSU	A	1	2	0
PVC-p	A	3	3	3
PVC- U	A	0	0	0
SAN	A	3	2	3
SB	A	3	2	3
TPEElastomer	C	2	2	2
TPR Rubber	A	2	2	2
TPU Urethane	A	2	2	2

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Tip Selection

Please use the charts below to determine the appropriate tips for your nozzles.

Gate Styles:

Sprue Extra Stock Sprue Pinpoint Nylon Sprue Multi-Point (custom)	A=Amorphous C= Crystalline S= Semi- Crystalline	Precision II 3= Excellent 2= Good 1= Application Dependent		
		Sprue Nylon	Sprue	Pinpoint
ABS	A	3	2	3
ABS – FR	A	3	3	1
ABS / Pa6	C	0	3	2
Acetal –C	C	0	3	3
Acetal – H	C	0	3	2
Acrylic	A	3	2	3
CAB	A	1	3	2
CAP	A	1	3	2
EVA	A	3	2	3
LCP	C	0	2	1
Pa6	C	0	3	3
Pa66	C	0	3	2
Pa11 & 12	C	0	3	2
PBA	C	3	3	3
PBT	C	0	3	3
Pc	A	3	2	3
Pc / ABS	A	3	3	3
Pc / PBT	C	0	3	2
PEEK	C	0	2	0
PEI	A	0	2	2
PES	A	0	2	1
PET	C	0	3	2
Pe- LD	S	3	3	3
Pe- HD	S	3	3	3
Pp	S	3	3	3
Ps	A	3	2	3
PPE	A	2	3	3
PPE / Nylon	C	0	2	0
PPS	C	0	2	1
PSU	A	1	2	1
PVC-p	A	3	3	3
PVC- U	A	2	2	1
SAN	A	3	2	3
SB	A	3	2	3
TPEElastomer	C	3	3	3
TPR Rubber	A	3	3	3
TPU Urethane	A	3	3	3

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Tip Selection

Please use the charts below to determine the appropriate tips for your nozzles.

Gate Styles:

Sprue Extra Stock Sprue Pinpoint Valv Gate Nylon Sprue Multi-Point (custom)	A=Amorphous C= Crystalline S= Semi- Crystalline	Precision II 3= Excellent 2= Good 1= Application Dependent			
		Sprue	Extra Stock Sprue	Valve Gate	Pinpoint
ABS	A	3	3	3	3
ABS – FR	A	3	3	1	1
ABS / Pa6	C	3	3	2	2
Acetal –C	C	3	3	2	2
Acetal – H	C	3	3	2	1
Acrylic	A	3	3	3	3
CAB	A	3	3	2	2
CAP	A	3	3	2	2
EVA	A	3	3	3	3
LCP	C	3	3	1	1
Pa6	C	3	3	2	2
Pa66	C	2	2	1	1
Pa11 & 12	C	2	2	2	1
PBA	C	3	3	3	3
PBT	C	3	3	2	2
Pc	A	3	3	2	2
Pc / ABS	A	3	3	2	2
Pc / PBT	C	2	3	1	1
PEEK	C	1	2	0	0
PEI	A	2	3	0	0
PES	A	2	3	1	1
PET	C	3	3	3	3
Pe- LD	S	3	3	3	3
Pe- HD	S	3	3	3	3
Pp	S	3	3	3	3
Ps	A	3	3	3	3
PPE	A	3	3	3	3
PPE / Nylon	C	2	3	0	0
PPS	C	2	3	0	0
PSU	A	3	3	1	1
PVC-p	A	3	3	3	3
PVC- U	A	2	3	1	1
SAN	A	3	3	3	3
SB	A	3	3	3	3
TPEElastomer	C	3	3	2	2
TPR Rubber	A	3	3	3	3
TPU Urethane	A	3	3	3	3

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