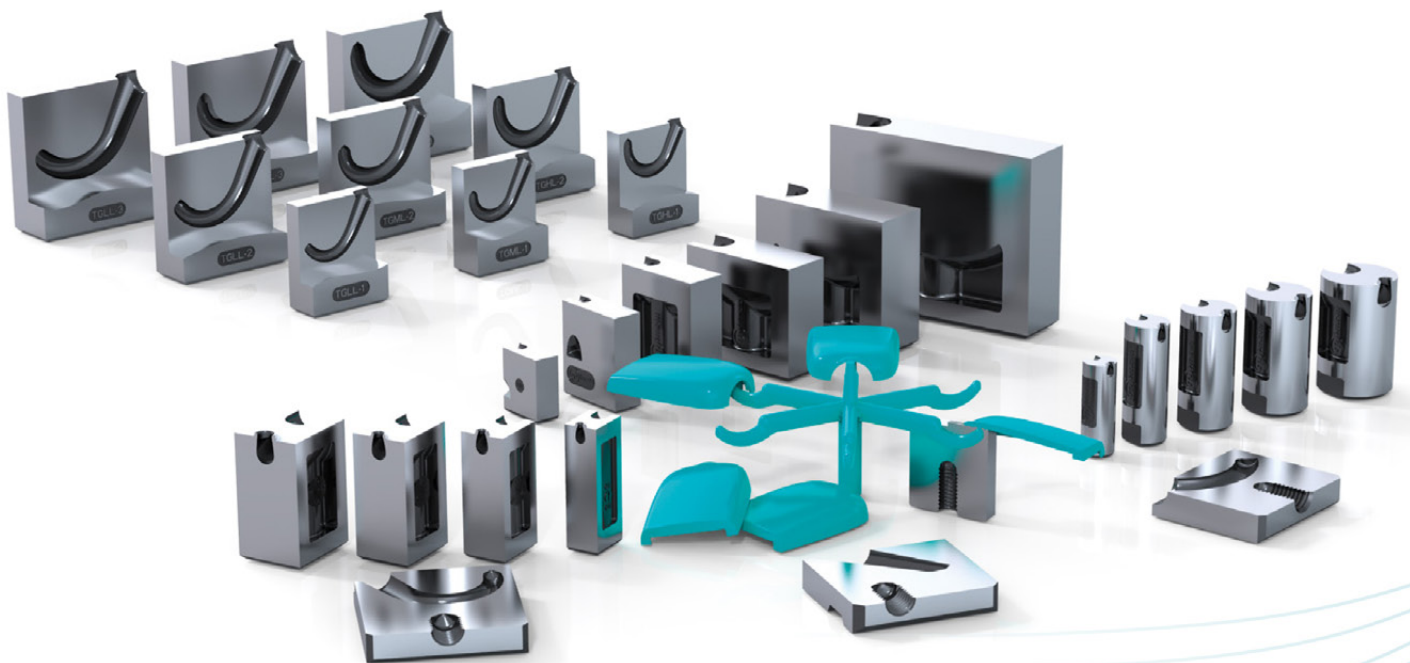
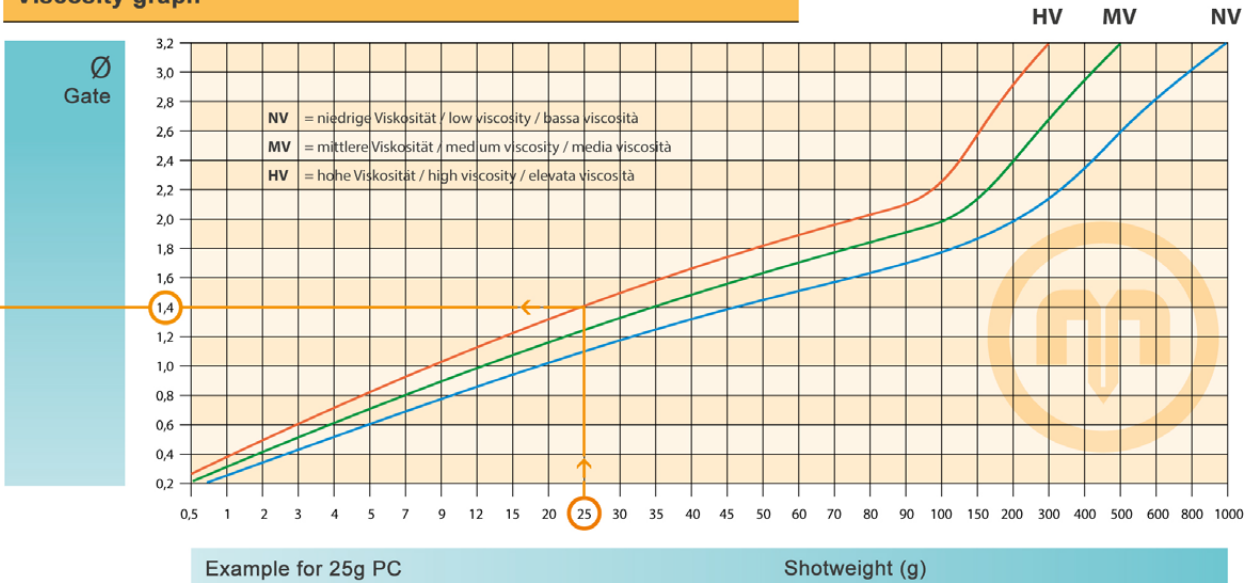


TUNNEL GATE INSERTS



Technical information

Viscosity graph



EN

Caution: When using filled plastics (glass fibres, carbon fibres etc.) you should increase the computed gate diameter by 20%.

The recommended shotweights and gate diameters are guide values only! Please also take into account such individual parameters as part geometry, mold design, type of plastic and fillers.

Gate Diameter

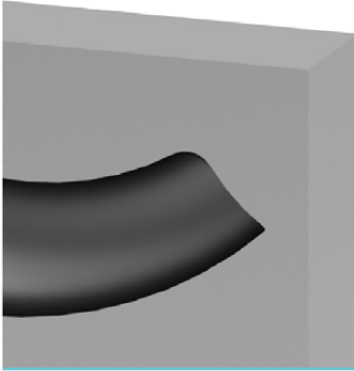
Ø	Cross-sectional area mm ²	Gate Types					
		TGS/TGR	TGC-XS SGC-XS	TGC-S SGC-S TPS-S	TGC-1 SGC-1 TPS-1 TGLL-1 TGML-1 TGHL-1	TGC-2 SGC-2 TPS-2 TGLL-2 TGML-2 TGHL-2	TGC-3 / -4 SGC-3 / -4 TPS-3 TGLL-3 TGML-3 TGHL-3
0,4	0,13	0,6	0,4	0,4	0,6	0,6	
0,6	0,28	0,8	0,6	0,6	0,8	0,8	
0,8	0,50	1,2	0,8	0,8	1,0	1,0	
1,0	0,78	1,6	1,0	1,0	1,2	1,2	
1,2	1,13	2,0	1,2	1,2	1,4	1,4	
1,4	1,54	2,4	1,4	1,4	1,6	1,6	
1,6	2,01	2,8	1,6	1,6	1,8	1,8	
1,8	2,54						0,5 x (4,5)
2,0	3,14						0,6 x (4,6)
2,2	3,8						0,7 x (4,7)
2,4	4,52						0,8 x (4,8)
2,6	5,31						0,9 x (4,9)
2,8	6,15						1,0 x (5,0)
3,0	7,07						1,1 x (5,1)
3,2	8,04						1,2 x (5,2)
:	:						1,3 x (5,3)
4,5	18,8						1,4 x (5,4)
							1,5 x (5,5)
							4,5

Legend for Gate Types:
 TGR / TGS / TGC / TGLL / TGML / TGHL | SGC | TPS

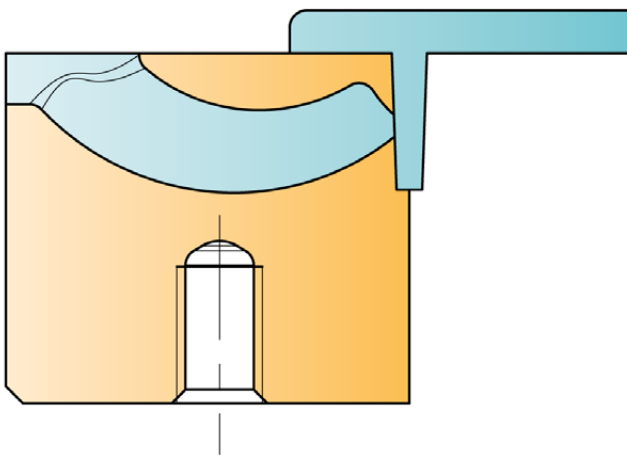
SGC

Side gating

Suitable for all plastics



- EN** > Curved tunnel gating deep inside the part
 > Integrated dead-end recess reduces loss of pressure and shear stress.
 > Highly wear-resistant hot working steel M2 (1.3343) - 54.2 HRC



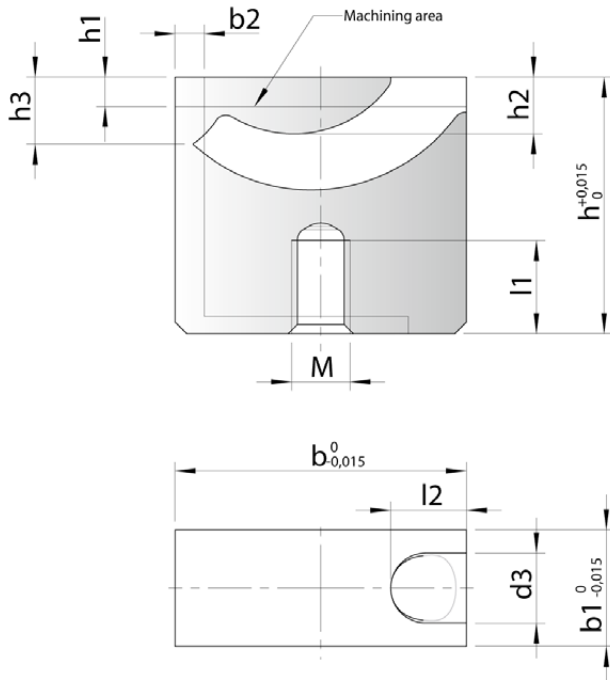
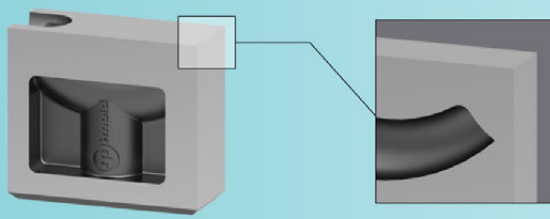
	SGC-XS	SGC-S	SGC-1	SGC-2	SGC-3
Gate point	0,4 - 0,8	0,4 - 1,0	0,6 - 1,4	0,8 - 2,1	~Ø 1,1 - 3,3
Ø Runner	2.5	2.5	4	6	8
max. shotweight (g)					
NV	12	20	35	250	1000
MV	7	12	25	120	500
HV	5	8	15	90	300

NV = low viscosity
 MV = medium viscosity
 HV = high viscosity

SGC

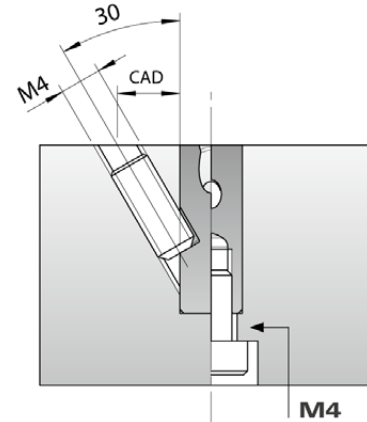
SGC

Side gating



SGC-XS / SGC-S

Mounting possibilities

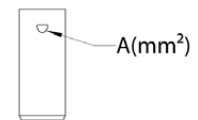
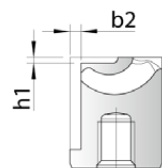


Typ	b	b1	b2 max.	d3	h	h1 max.	h2	h3	l1	l2	M
SGC-XS	10	5	1.1	2.5	12	0.6	1.9	2.0	5	3.2	4
SGC-S	15	6	2.0	2.5	18	2	3.5	4.0	8	4	4
SGC-1	18	8	1.8	4	22	2	3.5	4.1	9	5.2	5
SGC-2	25	10	2.5	6	22	2.5	4.8	5.7	8	6.5	5
SGC-3	30	12	2.8	8	27	4.5	7.5	8.4	9	7	6

➔ Example of order specification: **SGC-XS**

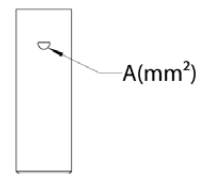
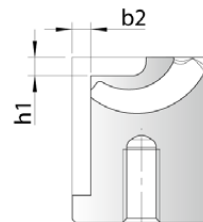
SGC-XS

A [mm ²]	~ Ø [mm]	b2 [mm]
0.13	0.4	0.9
0.3	0.6	1.0
0.53	0.8	1.1



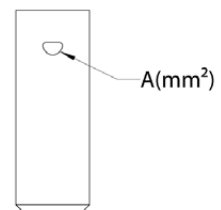
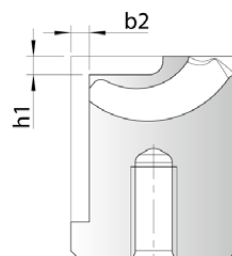
SGC-S

A [mm ²]	~ Ø [mm]	b2 [mm]
0.15	0.4	1.7
0.33	0.6	1.8
0.55	0.8	1.9
0.79	1.0	2.0



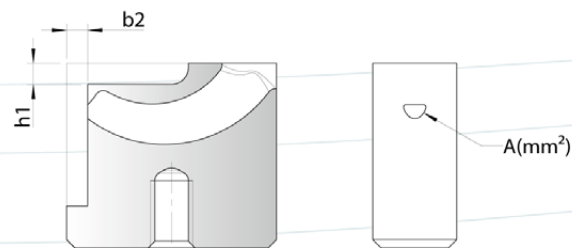
SGC-1

A [mm ²]	~ Ø [mm]	b2 [mm]
0.28	0.6	1.4
0.53	0.8	1.5
0.82	1	1.6
1.15	1.2	1.7
1.52	1.4	1.8



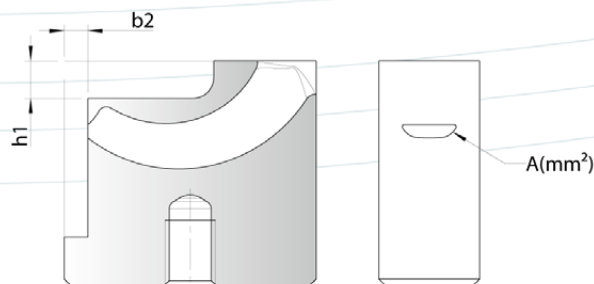
SGC-2

A [mm ²]	~ Ø [mm]	b2 [mm]
0.28	0.6	1.7
0.54	0.8	1.8
0.84	1	1.9
1.2	1.2	2
1.57	1.4	2.1
2	1.6	2.2
2.43	1.75	2.3
2.9	1.9	2.4
3.4	2.1	2.5



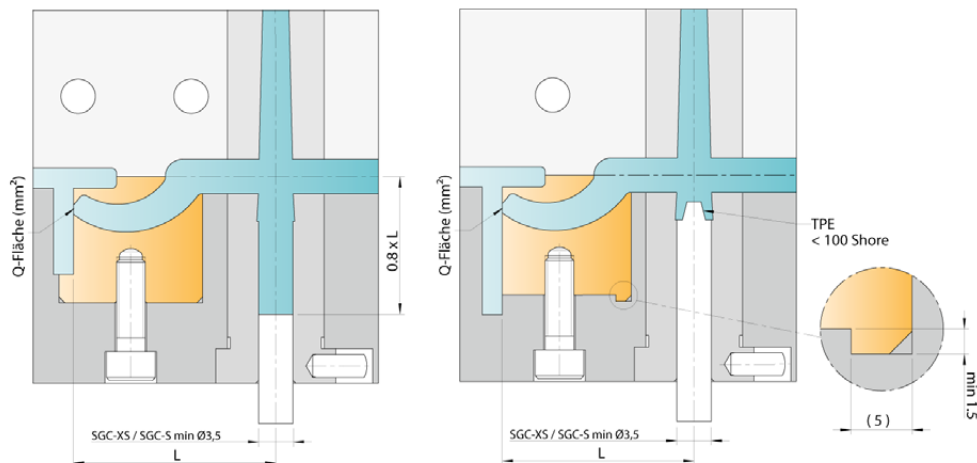
SGC-3

A [mm ²]	~ Ø [mm]	b2 [mm]
1	1.1	2
1.75	1.5	2.1
2.56	1.8	2.2
3.43	2.1	2.3
4.35	2.35	2.4
5.32	2.6	2.5
6.33	2.85	2.6
7.38	3	2.7
8.48	3.3	2.8



Standard installation for shallow and medium contour depths

Special installation for deep contours



- EN Thermoplastic elastomers (TPE)**
- > Low Shore hardness = shorter distance L
 - > Use centring pin
 - > Max. hardness 100 Shore A

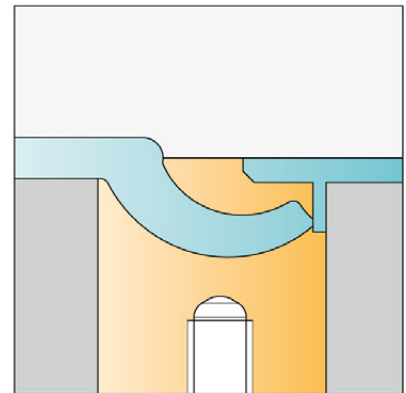
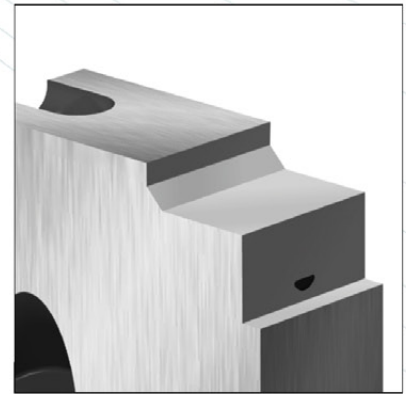
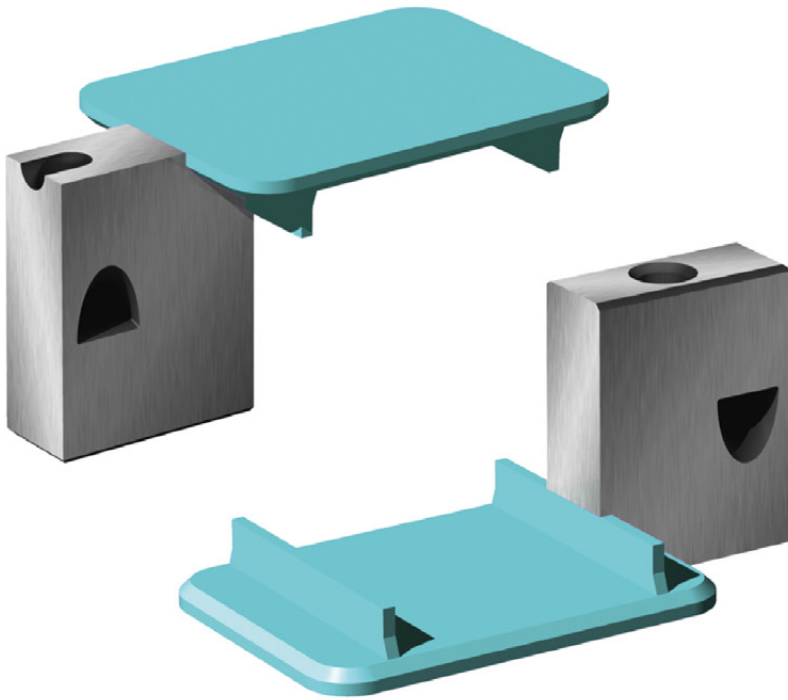
SGC

Table for distance L

	Material type			
	TPE, TPU etc.	PE, PP, PET etc.	PC/ABS, PA, POM, HI-PC etc.	PA+GF, PC, SAN, PMMA etc.
SGC-XS	12-16	13-20	16-23	22-29
SGC--S	16-21	18-25	21-28	27-34
SGC--1	21-26	26-34	31-39	36-45
SGC--2	28-33	31-39	36-44	41-50
SGC--3	33-38	38-48	43-53	48-58

Examples of installation

Side gating - Standard installation



Side gating - adapted to part

