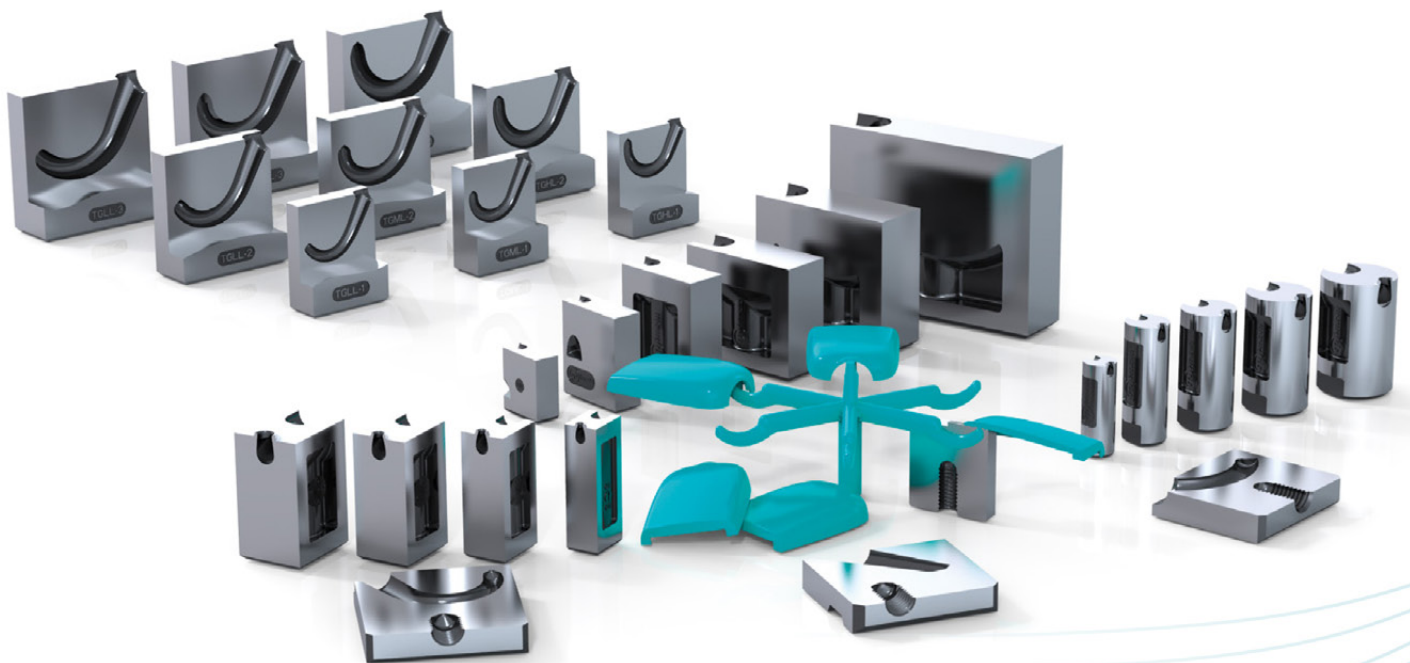
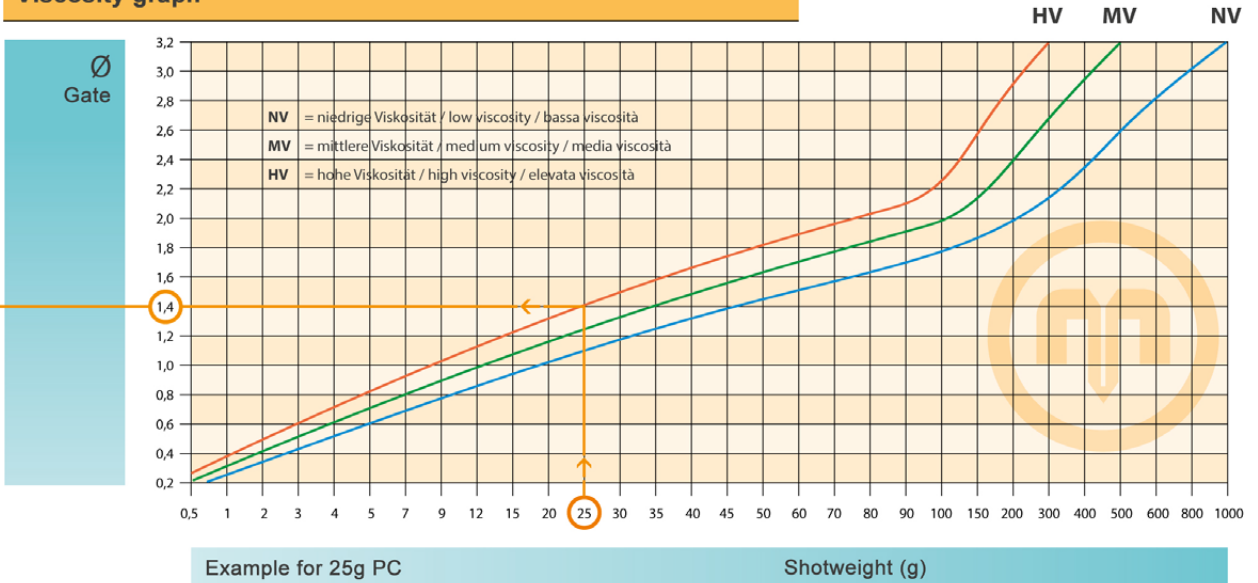


TUNNEL GATE INSERTS



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

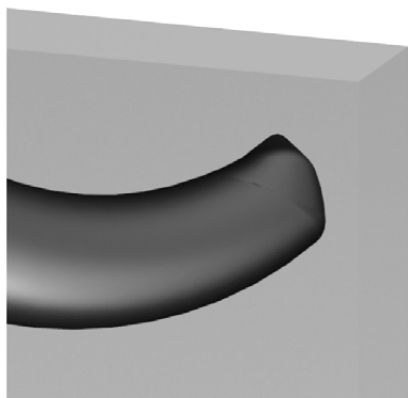
Ø	Cross-sectional area mm ²	Gate Diameter Selection					
		TGS/TGR	TGC-XS SGC-XS	TGC-S SGC-S TPS-S	TGC-1 SGC-1 TPS-1 TGLL-1 TGML-1 TGHL-1	TGC-2 SGC-2 TPS-2 TGLL-2 TGML-2 TGHL-2	TGC-3 / -4 SGC-3 / -4 TPS-3 TGLL-3 TGML-3 TGHL-3
0,4	0,13	0,6	0,4	0,4	0,6	0,8	
0,6	0,28	0,8	0,6	0,6	0,8	1,0	
0,8	0,50	1,2	0,8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

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

TGC

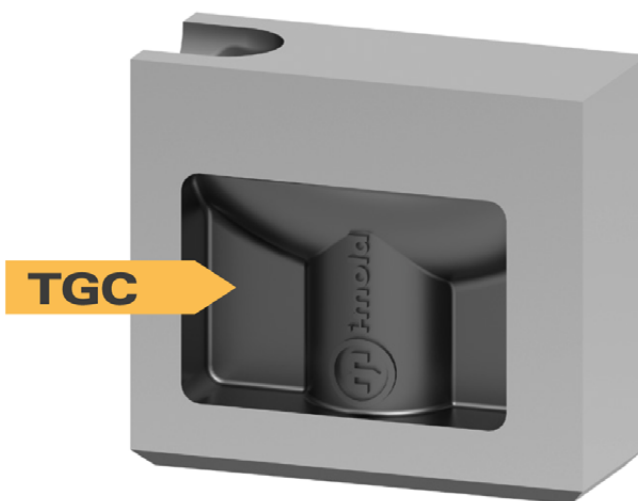
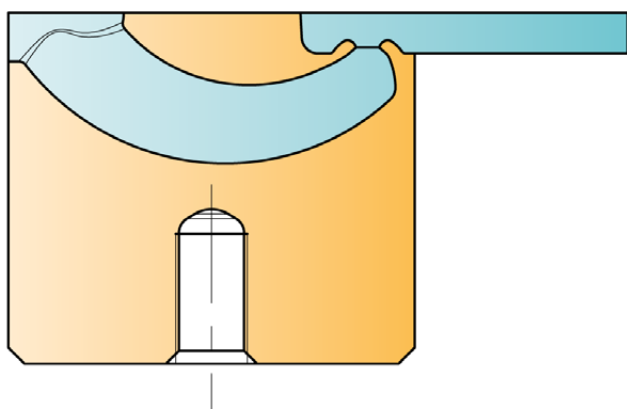
Contourable

Perfect for rigid and enforced plastics



- EN > for contouring up to 10mm
- > individually adjustable
- > available in 2 degrees of hardness (60 HRC / 40 HRC)

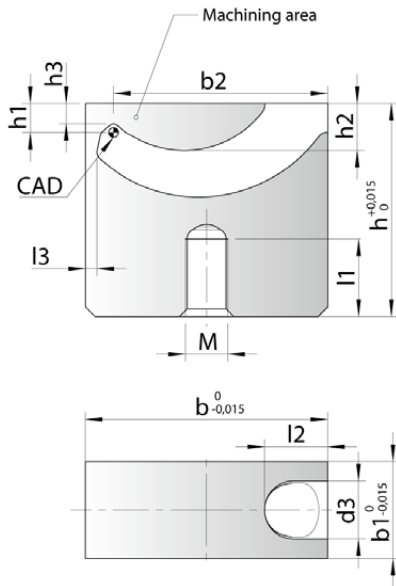
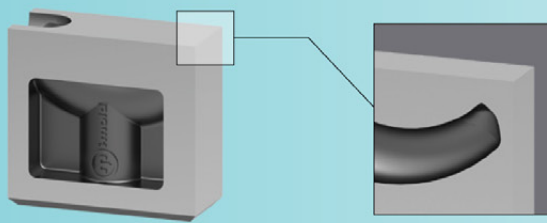
TGC



	TGC-XS	TGC-S	TGC-1	TGC-2	TGC-3	TGC-4
max. contour depth	1	2	2	3	5	10
Gate point	0,4 - 0,6	0,4 - 0,8	0,6 - 1,2	0,8 - 1,8	0,5x4,5 - 1,5x5,5	0,5x4,5 - 1,5x5,5
Ø Runner	2.5	2.5	4	6	8	8
max. shotweight (g)						
NV	5	12	35	120	1000	1000
MV	4	7	25	75	500	500
HV	3	5	15	50	300	300

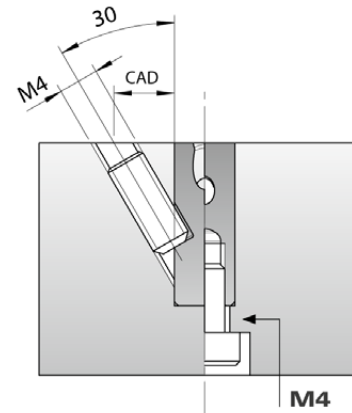
NV = low viscosity
 MV = medium viscosity
 HV = high viscosity

TGC Contourable



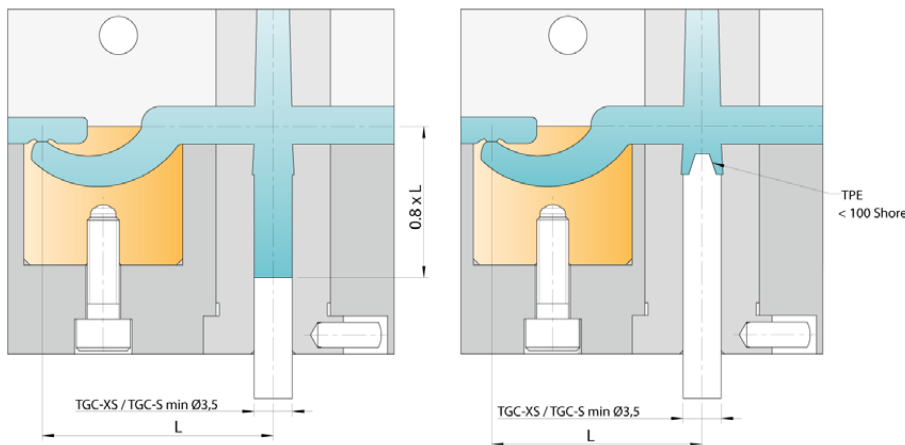
TGC-XS / TGC-S

Mounting possibilities



Typ	b	b1	b2	d3	h	h1	h2	h3	l1	l2	l3	M	HRC
TGC-XS	10	5	8.5	2.5	12	1	1.9	0.6	5	3.2	0.7	4	Version U = 40 HRC Version H = 60 HRC
TGC-S	15	6	13.3	2.5	18	2	3.5	1.5	8	4	0.9	4	
TGC-1	18	8	16	4	22	2	3.5	1.3	9	5.2	0.9	5	
TGC-2	25	10	22.1	6	22	3	4.8	2.1	8	6.5	1.2	5	
TGC-3	30	12	26.9	8	27	5	7.5	4.1	9	7	1.2	6	
TGC-4	45	12	41.2	8	36	10	16.7	9.1	8	9.6	1.8	6	

➔ Example of order specification: **TGC-XS-U**



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

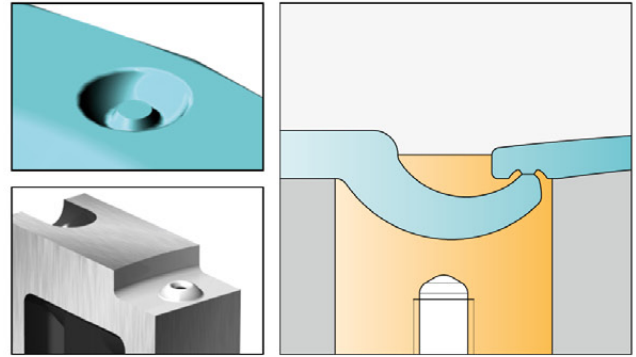
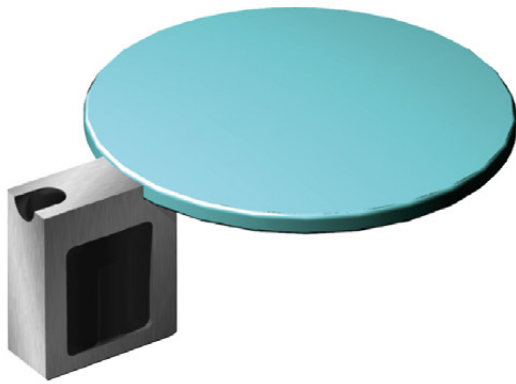
Table for distance L

	Material type			
	TPE, TPU etc.	PE, PP, PET etc.	PC/ABS ABS, PA, POM, HI-PC etc.	PA+GF, PC, SAN, PMMA etc.
TGC-XS	12-16	13-20	16-23	22-29
TGC-S	16-21	18-25	21-28	27-34
TGC-1	21-26	26-34	31-39	36-45
TGC-2	28-33	31-39	36-44	41-50
TGC-3	33-38	38-48	43-53	48-58
TGC-4	48-53	53-63	58-68	X

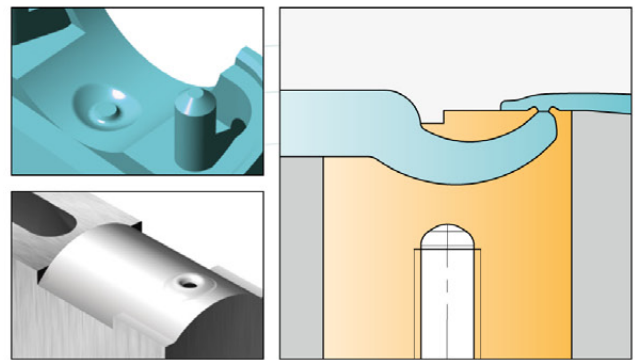
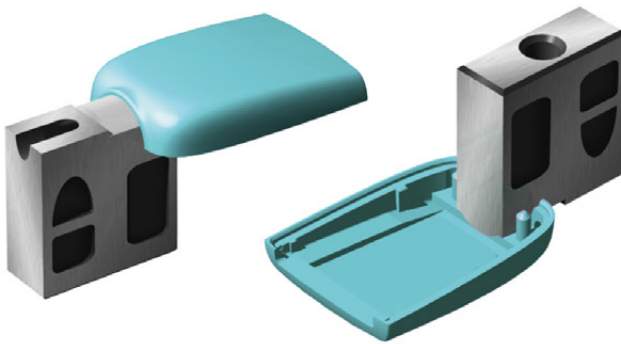
X = Restrictedly suitable for rigid and reinforced plastics

Examples of installation

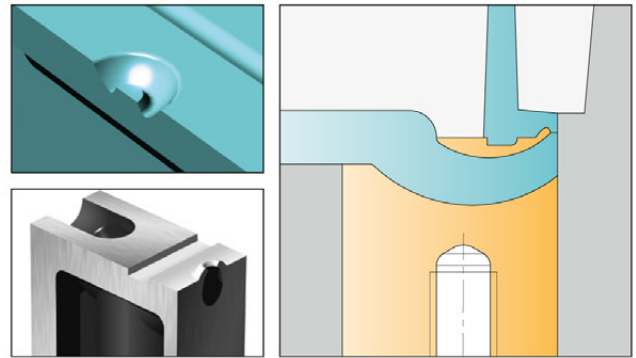
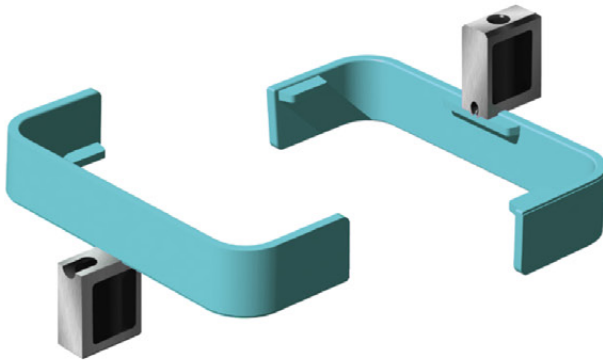
Under surface



Under rounded surface



Half gate point



Angled gating

