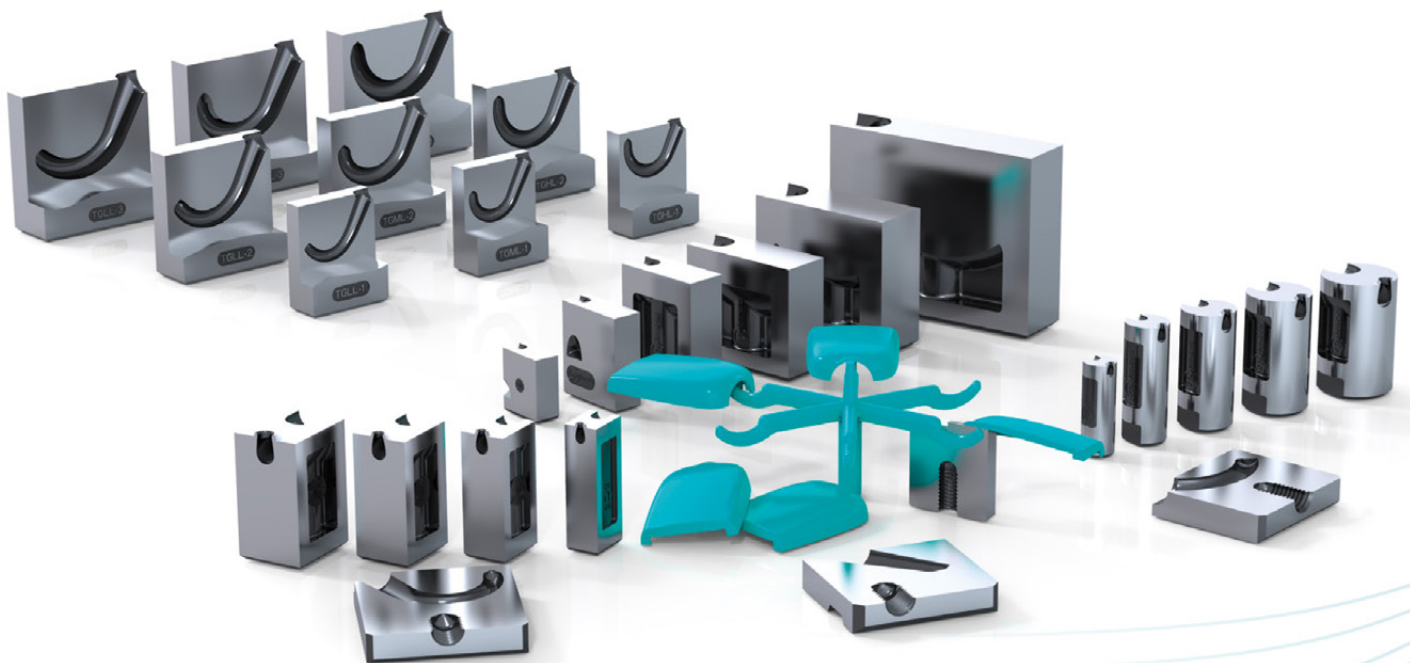
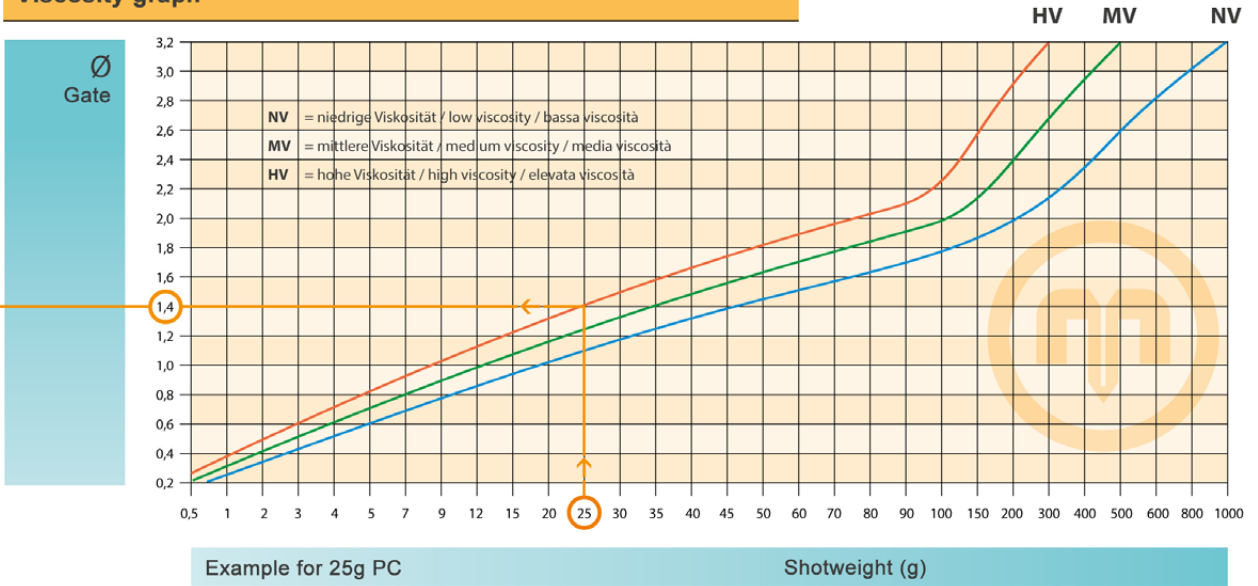


## TUNNEL GATE INSERTS



# 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 <sup>2</sup>	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	0,8	
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	1,2	1,0	1,2	1,4	
1,2	1,13	2,0	1,6	1,2	1,4	1,6	
1,4	1,54	2,4	2,0	1,6	1,8	2,1	
1,6	2,01	2,8	2,4	2,0	2,4	2,8	
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:** TGR / TGS / TGC / TGLL / TGML / TGHL | SGC | TPS

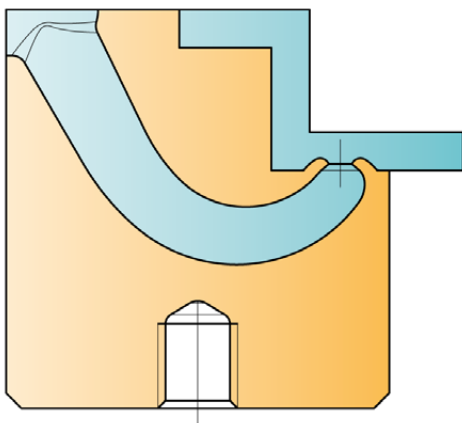
# TGLL

Contourable

Perfect for rigid and enforced plastics




- EN > Space-saving, contourable Tunnel Gate insert for gating below the parting line
- > Highly wear resistant hot working steel M2 (1.3343) 54+2 HRC



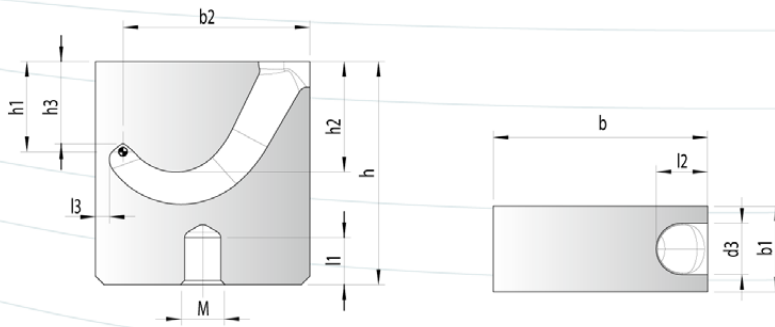
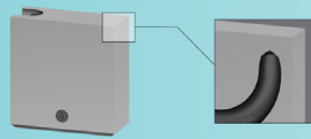
TGLL



	TGLL-1	TGLL-2	TGLL-3
max. contour depth	8,5	10,5	12,5
 Gate point	0,6 - 1,2	0,8 - 1,8	0,5x4,5 - 1,5x5,5
Ø Runner	4	6	8
max. shotweight (g)			
<b>NV</b>	35	120	1000
<b>MV</b>	25	75	500
<b>HV</b>	15	50	300

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

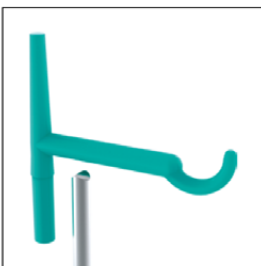
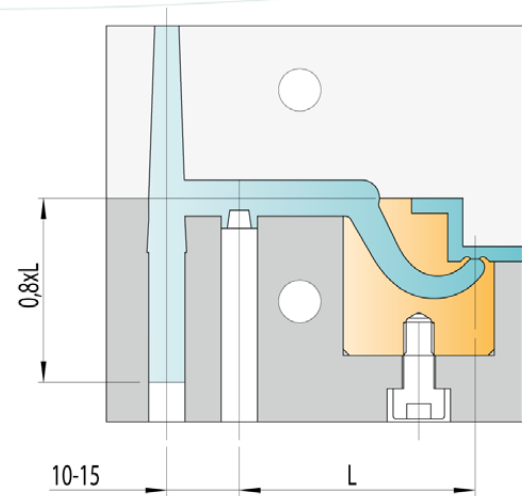
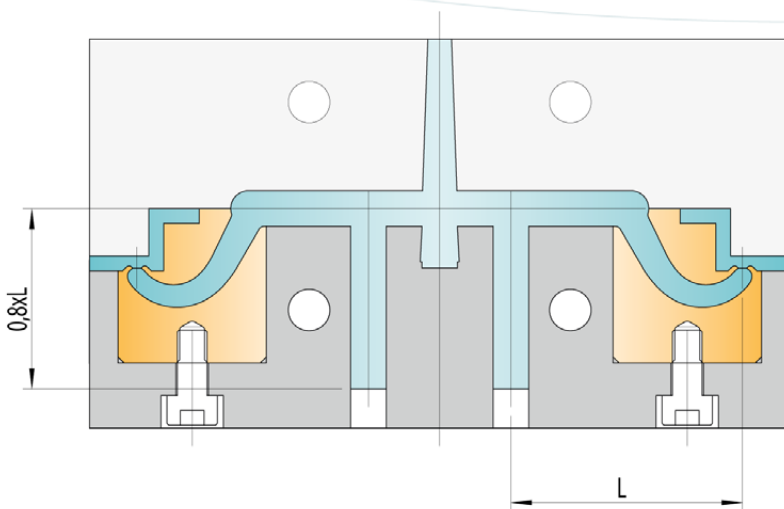
# TGLL Contourable



Typ LL	b	b1	b2	d3	h	h1	h2	h3	l1	l2	l3	M	HRC
TGLL-1	18	8	15,7	4	22	8,5	9,9	7,8	5,5	4,5	1,2	5	54+2
TGLL-2	25	10	21,8	6	26	10,5	12,9	9,6	5,5	6	1,6	5	
TGLL-3	30	12	26	8	30	12,5	14,8	11,6	6,5	7	2,2	6	

Example for 2 cavities

Example for single cavity



Exampel for supplementary ejector

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.
TG-1(HL,ML,LL)	21-27	27-34	34-40	X
TG-2 (HL,ML,LL)	28-34	33-40	39-45	X
TG-3 (HL,ML,LL)	33-40	40-49	46-55	X

X = Restrictedly suitable for rigid and reinforced plastics

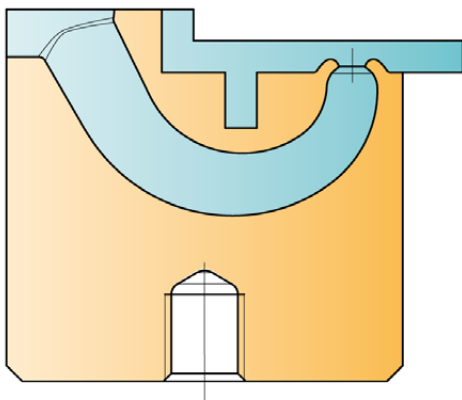
# TGML

Contourable

Restrictedly suitable for rigid and reinforced plastics



- EN > Space saving, contourable Tunnel Gate insert for gating above the parting line
- > Highly wear resistant hot working steel M2 (1.3343) 54+2 HRC



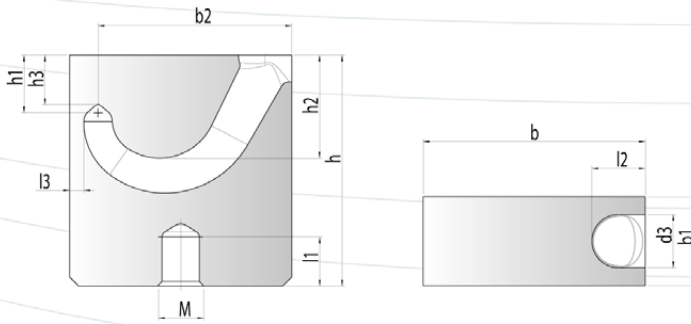
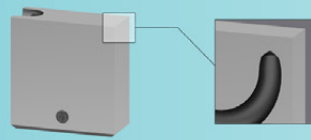
TGML



	TGML-1	TGML-2	TGML-3
max. contour depth	5,5	6,5	7,5
⚙ Gate point	0,6 - 1,2	0,8 - 1,8	0,5x4,5 - 1,5x5,5
∅ Runner	4	6	8
<b>max. shotweight (g)</b>			
<b>NV</b>	35	120	1000
<b>MV</b>	25	75	500
<b>HV</b>	15	50	300

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

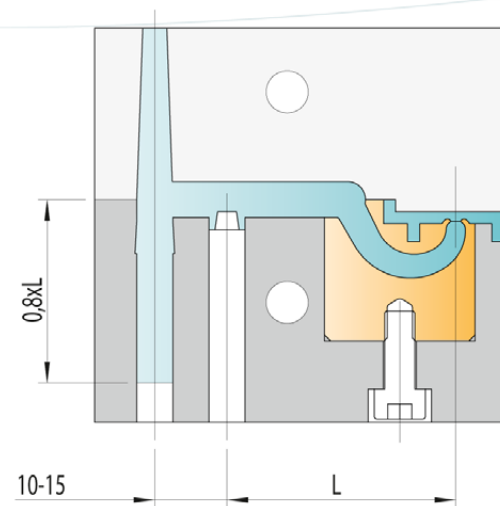
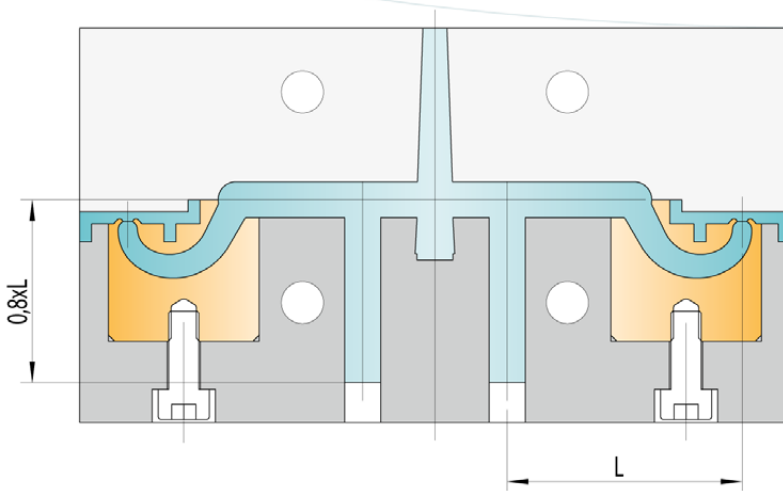
# TGML Contourable



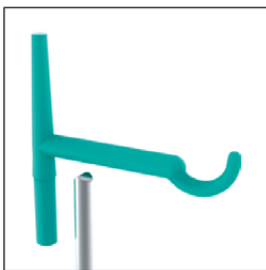
Typ ML	b	b1	b2	d3	h	h1	h2	h3	l1	l2	l3	M	HRC
TGML-1	18	8	15,7	4	22	5,5	9,5	4,86	5,5	4,5	1,2	5	54+2
TGML-2	25	10	21,8	6	26	6,5	11,6	5,6	5,5	6	1,6	5	
TGML-3	30	12	26	8	30	7,5	14,5	6,6	6,5	7	2,0	6	

Example for 2 cavities

Example for single cavity



TGML



Example for supplementary ejector

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.
TG-1(HL,ML,LL)	21-27	27-34	34-40	X
TG-2 (HL,ML,LL)	28-34	33-40	39-45	X
TG-3 (HL,ML,LL)	33-40	40-49	46-55	X

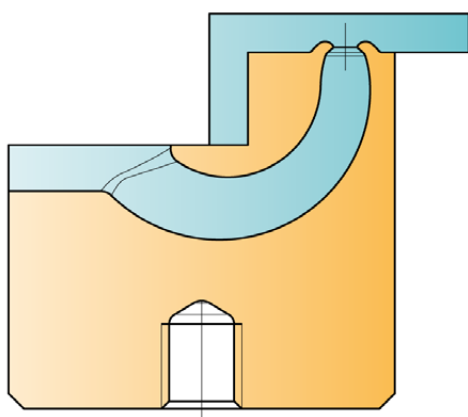
X = Restrictedly suitable for rigid and reinforced plastics

# TGHL Contourable

**Not suitable for rigid and reinforced plastics**




- EN** > Space-saving, contourable Tunnel Gate insert for gating above the parting line
- > Highly wear resistant hot working steel M2 (1.3343) 54+2 HRC



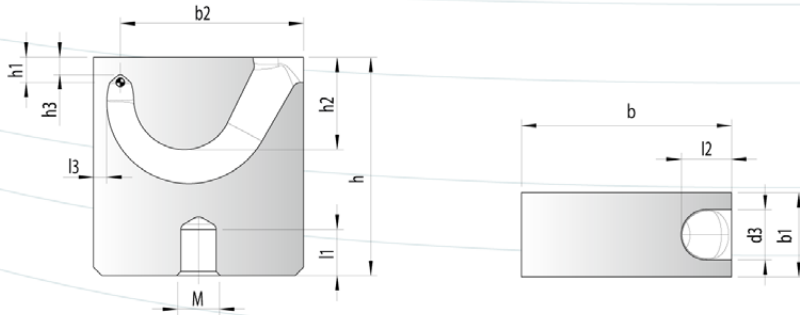
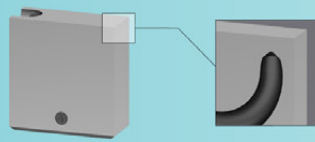
**TGHL** →



	TGHL-1	TGHL-2	TGHL-3
max. contour depth	2	3	3
 Gate point	0,6 - 1,2	0,8 - 1,8	0,5x4,5 - 1,5x5,5
Ø Runner	4	6	8
max. shotweight (g)			
<b>NV</b>	35	120	1000
<b>MV</b>	25	75	500
<b>HV</b>	15	50	300

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

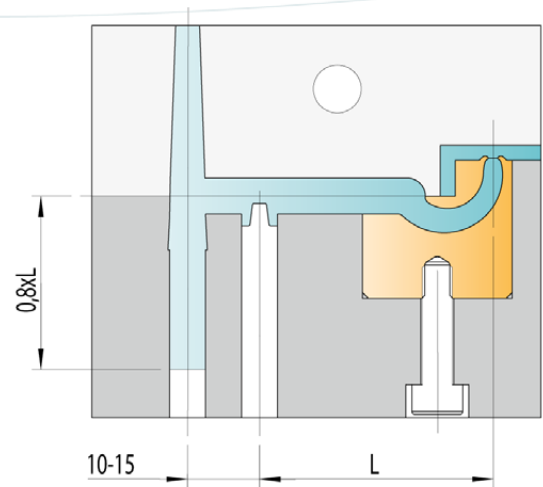
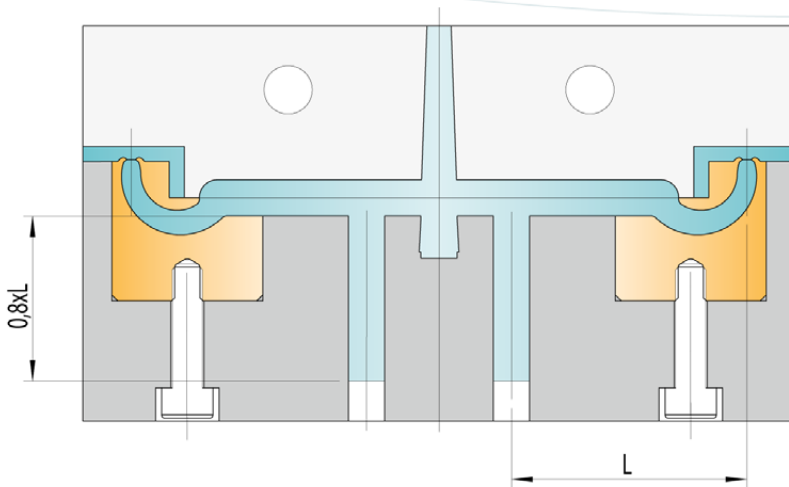
# TGHL Contourable



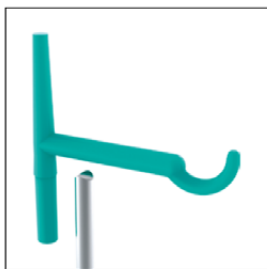
Typ HL	b	b1	b2	d3	h	h1	h2	h3	l1	l2	l3	M	HRC
TGHL-1	18	8	15,7	4	22	2	7,6	1,3	5,5	4,5	1,2	5	54+2
TGHL-2	25	10	21,8	6	26	3	11	2,1	5,5	6	1,6	5	
TGHL-3	30	12	26	8	30	3	12,2	2,1	6,5	7	2,0	6	

Example for 2 cavities

Example for single cavity



TGHL



Exampel for supplementary ejector

Table for distance L

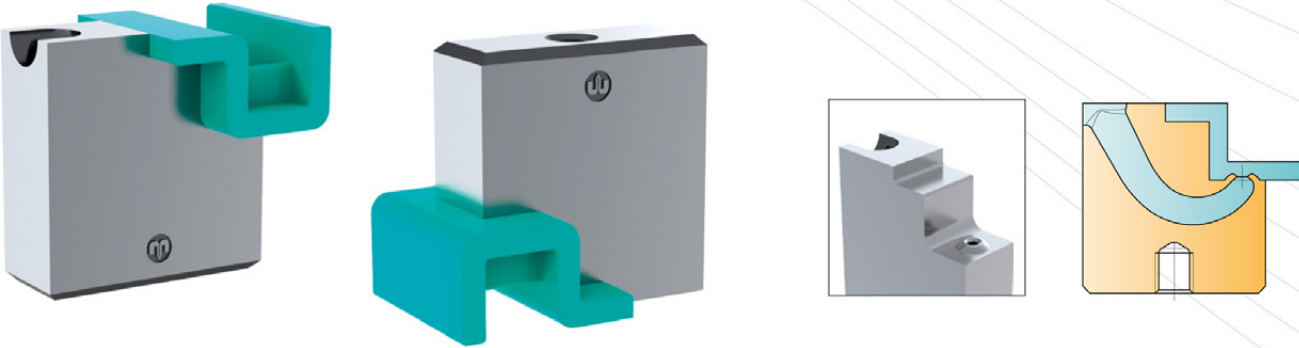
	Material type			
	TPE, TPU etc.	PE, PP, PET etc.	PC/ABS, PA, POM, HI-PC etc.	PA+GF, PC, SAN, PMMA etc.
TG-1(HL,ML,LL)	21-27	27-34	34-40	X
TG-2 (HL,ML,LL)	28-34	33-40	39-45	X
TG-3 (HL,ML,LL)	33-40	40-49	46-55	X

X = Not suitable for rigid and reinforced plastics



# Examples of installation

TGLL low contour step



TGML with peripheral rib



TGHL high contour step



TGHL with peripheral rib

