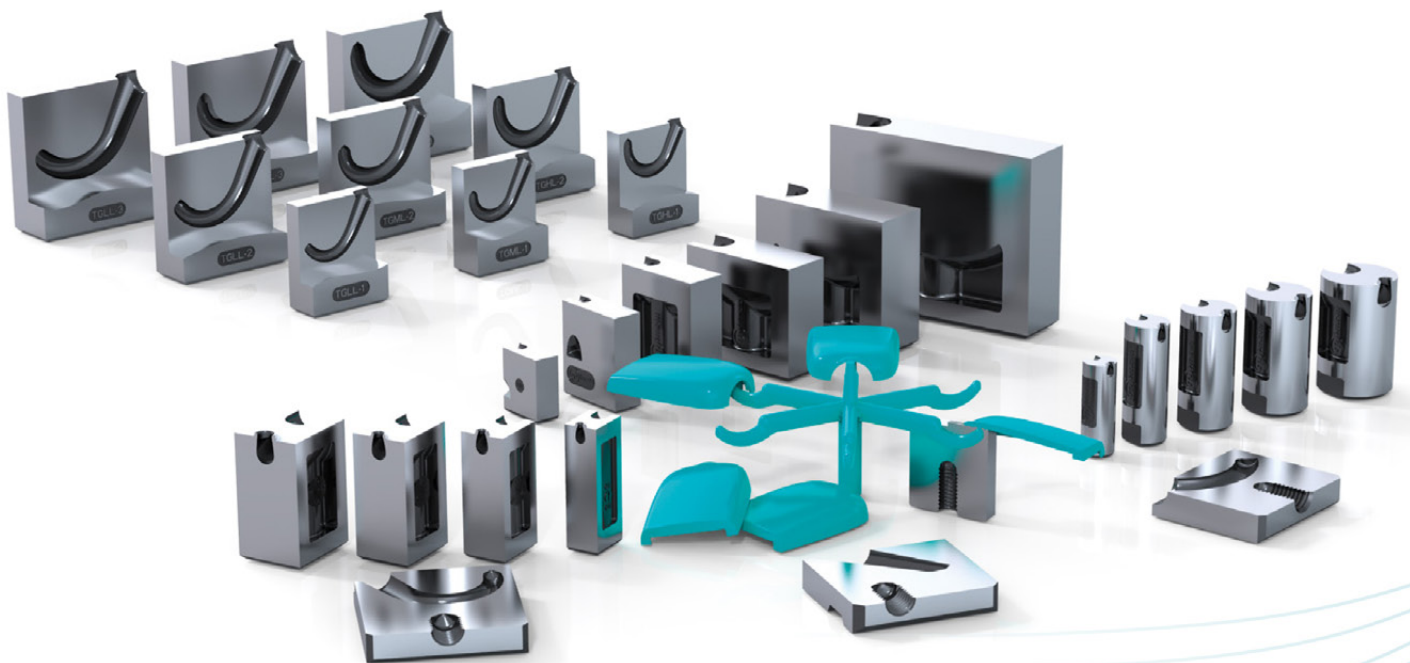
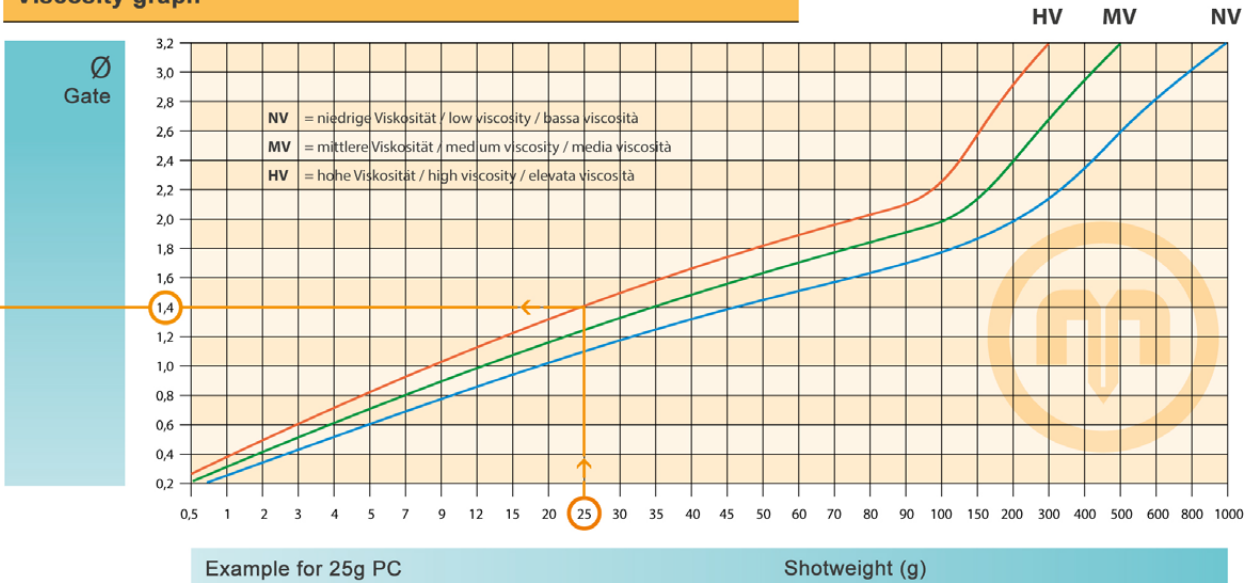


TUNNEL GATE INSERTS



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

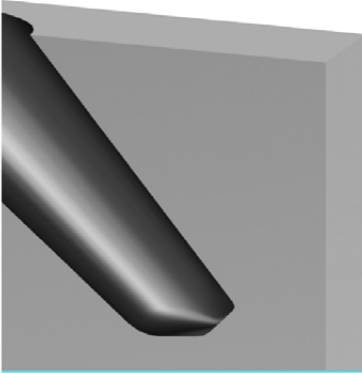
Ø	Cross-sectional area mm ²	Gate Types					
		TGS/TGR	TGC-XS SGC-XS	TGC-S SGC-S TPS-S	TGC-1 SGC-1 TPS-1 TGLL-1 TGML-1 TGHL-1	TGC-2 SGC-2 TPS-2 TGLL-2 TGML-2 TGHL-2	TGC-3 / -4 SGC-3 / -4 TPS-3 TGLL-3 TGML-3 TGHL-3
0,4	0,13	0,6	0,4	0,4	0,6	0,8	
0,6	0,28	0,8	0,6	0,6	0,8	1,0	
0,8	0,50	1,2	0,8	0,8	1,0	1,2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

TGR / TGS / TGC / TGLL / TGML / TGHL
SGC
TPS

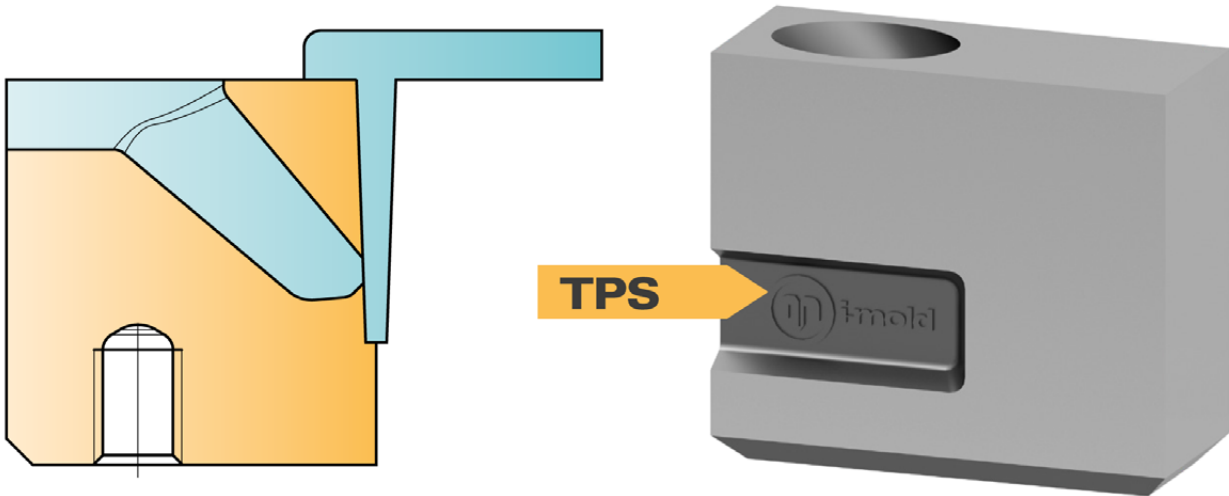
TPS

Side gating


Suitable for all plastics



- EN** > Straight standard sub-gate for side-gating
 > Integrated dead-end recess loss of pressure and shear stress.
 > Highly wear-resistant hot working steel M2 (1.3343) - 54+2 HRC



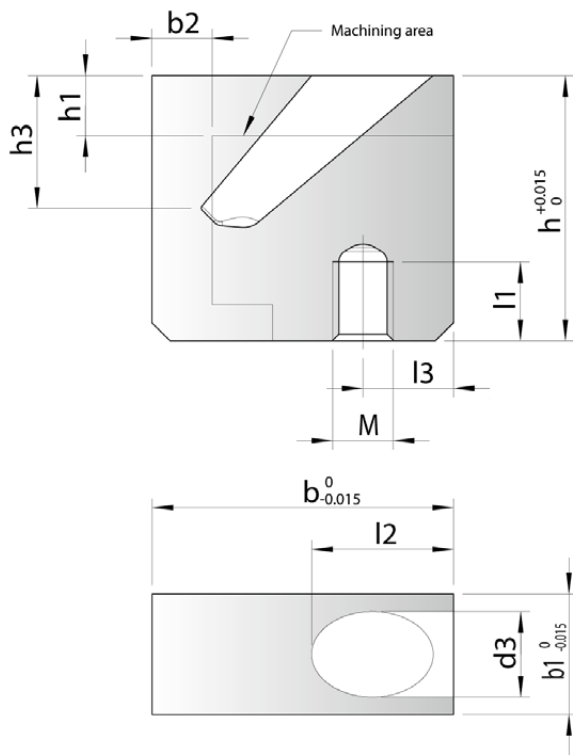
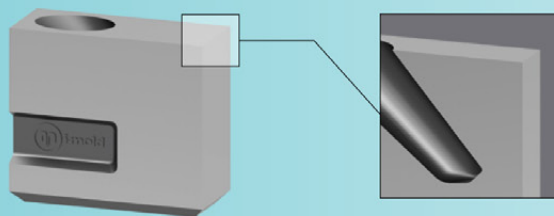
TPS

	TPS-S	TPS-1	TPS-2	TPS-3
 Gate point	0,4 - 0,8	0,8 - 1,8	0,8 - 2,8	1,1 - 4,5
max. shotweight (g)				
NV	30	120	600	1800
MV	20	75	350	1000
HV	12	50	175	600

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

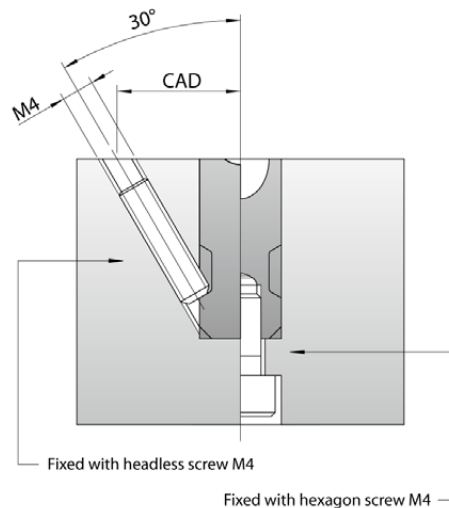
TPS

Side gating



TPS

Mounting possibilities

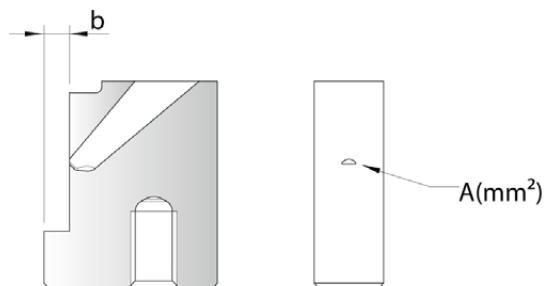


Typ	b	b1	b2 max.	d3	h	h1 max.	h3	l1	l2	l3	M
TPS-S	15	6	2.4	4	18	4	~7	6	7.1	5.5	4
TPS-1	18	8	2.6	6	22	5	~9	6	8.4	6	4
TPS-2	25	10	5	8	22	6	~11	6	11.8	7.5	5
TPS-3	30	12	6.5	10	27	7	~13	6	14.1	8	5

➔ Example of order specification: **TPS-1**

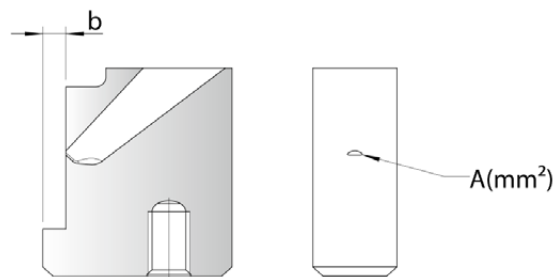
TPS-S

A [mm ²]	~ Ø [mm]	b2 [mm]
0.12	0.4	2.1
0.40	0.7	2.2
0.75	1.0	2.3
1.13	1.2	2.4



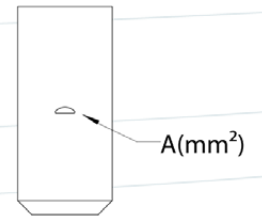
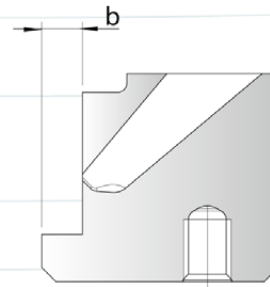
TPS-1

A [mm ²]	~ Ø [mm]	b2 [mm]
0.49	0.8	2.2
0.92	1.1	2.3
1.42	1.4	2.4
1.97	1.6	2.5
2.56	1.8	2.6



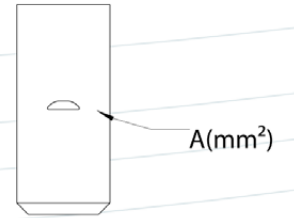
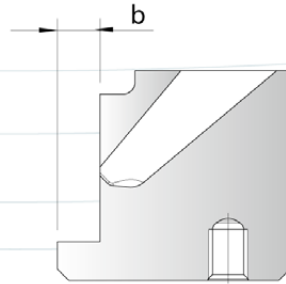
TPS-2

A [mm ²]	~ Ø [mm]	b2 [mm]
0.54	0.8	4.2
1.05	1.2	4.3
1.64	1.5	4.4
2.3	1.7	4.5
3.0	1.9	4.6
3.76	2.2	4.7
4.55	2.4	4.8
5.37	2.6	4.9
6.23	2.8	5.0



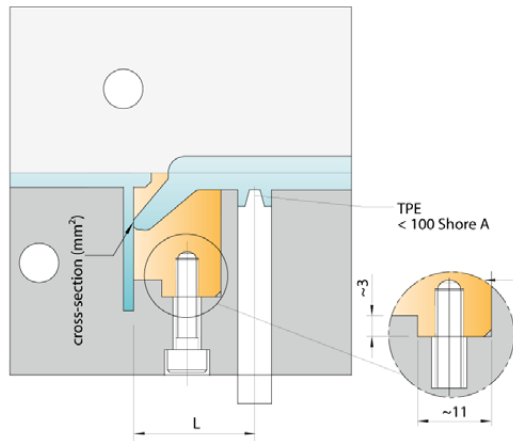
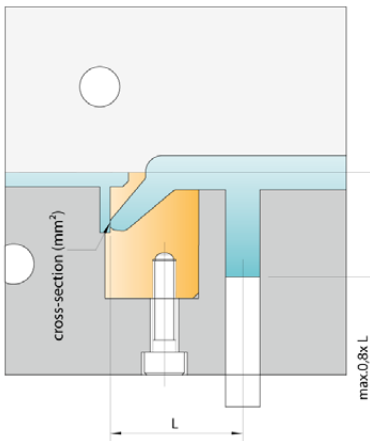
TPS-3

A [mm ²]	~ Ø [mm]	b2 [mm]
1.0	1.1	5.2
1.81	1.5	5.3
2.7	1.9	5.4
3.67	2.2	5.5
4.7	2.4	5.6
5.78	2.7	5.7
6.92	3.0	5.8
8.09	3.2	5.9
9.3	3.4	6.0
max. 15.8	4.5	6.5



Standard installation for shallow and medium contour depths

Special installation for deep contours



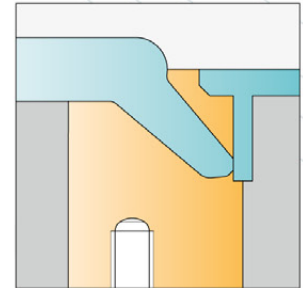
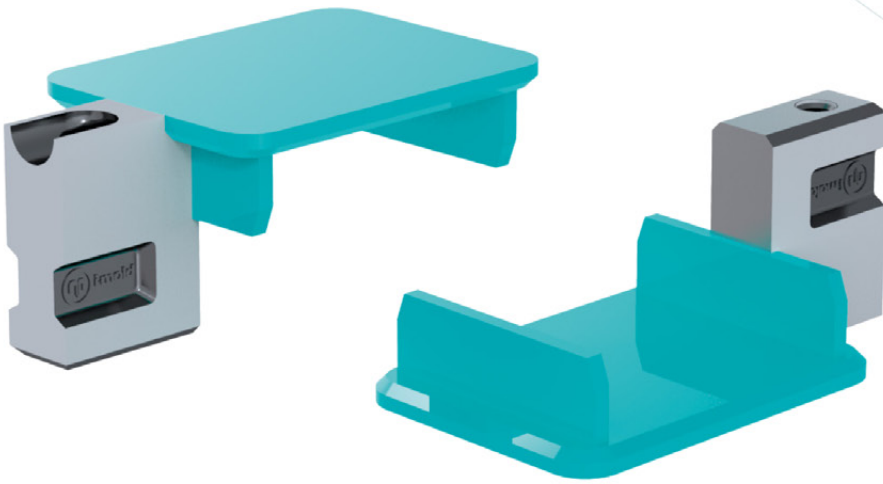
- EN Thermoplastic elastomers (TPE)**
- > Low Shore hardness = shorter distance L
 - > Use centring pin
 - > Max. hardness 100 Shore A

Table for distance L

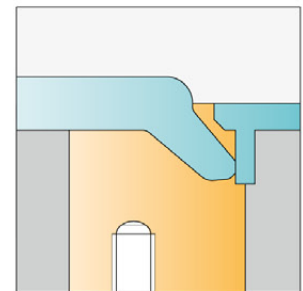
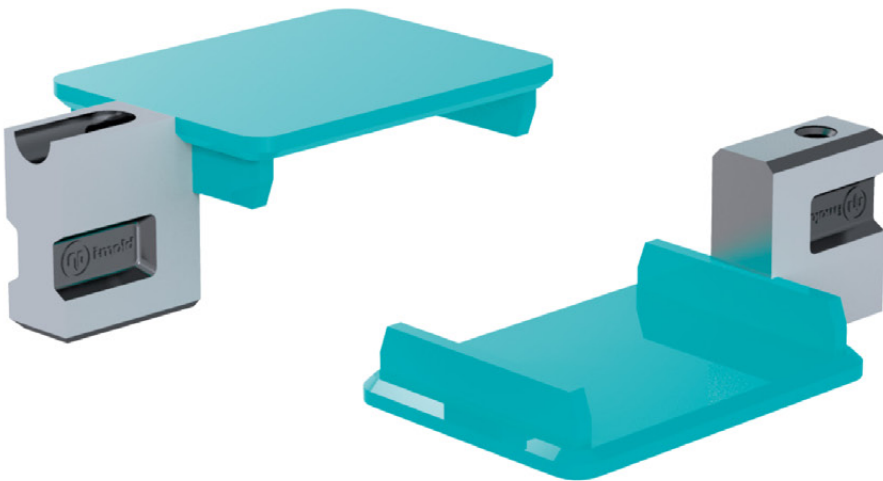
	Material type	
	Flexible materials	Rigid materials
TPS-5	~ 18	~ 23
TPS-1	~ 22	~ 30
TPS-2	~ 28	~ 38
TPS-3	~ 33	~ 47

Examples of installation

Side Gating - Standard Installation



Side Gating - For Flat Contours



Side Gating - For Deep Contours

