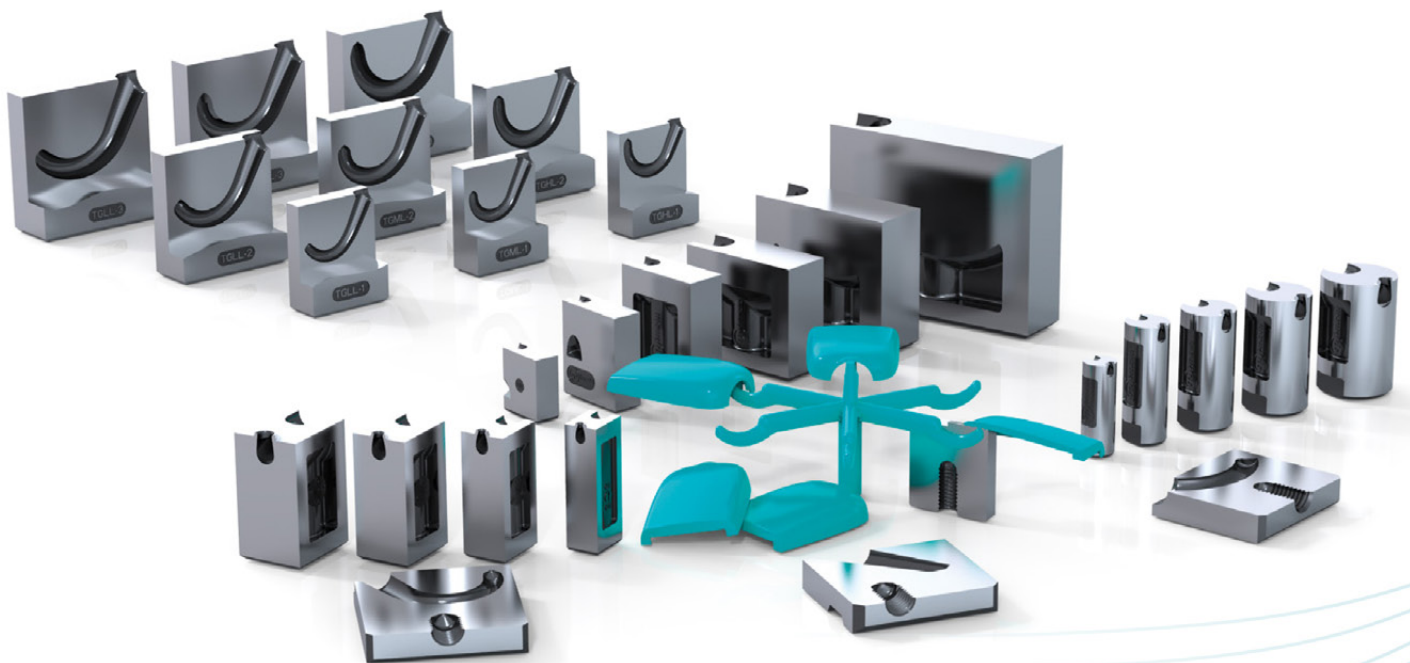
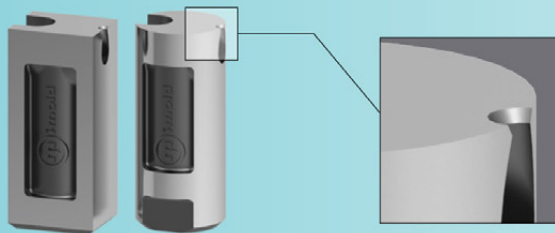


## TUNNEL GATE INSERTS

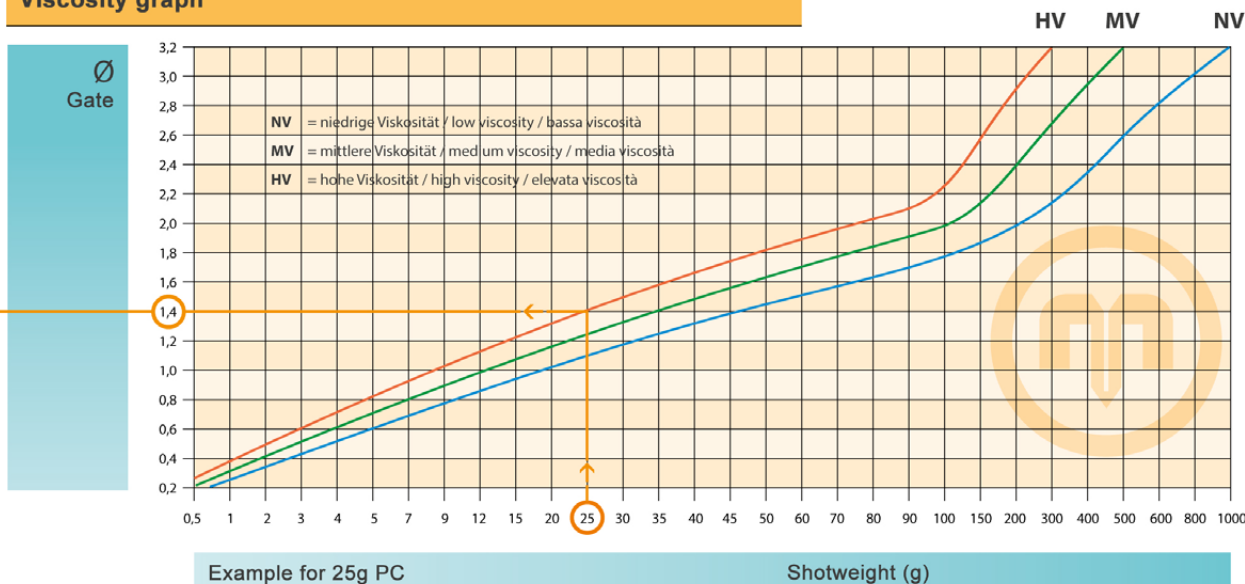


# Standard Version S1



## 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

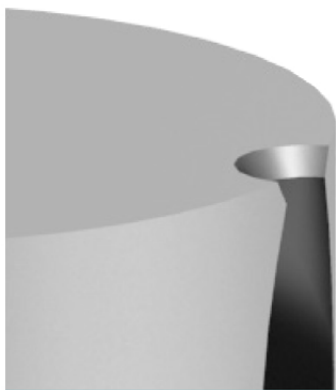
Ø	Cross-sectional area mm <sup>2</sup>	Gate Types					
		TGS/TGR	TGC-XS SGC-XS	TGC-S SGC-S TPS-S	TGCL-1 TGML-1 TGHL-1	TGCL-2 TGML-2 TGHL-2	TGC-3 / -4 SGC-3 / -4 TPS-3 TGCL-3 TGML-3 TGHL-3
0,4	0,13	0,6	0,4	0,4	0,6	0,8	
0,6	0,28	0,8	0,6	0,6	0,8	1,0	
0,8	0,50	1,2	0,8	0,8	1,0	1,2	
1,0	0,78	1,6	1,0	1,0	1,2	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:** TGR / TGS / TGC / TGCL / TGML / TGHL | SGC | TPS

# TGR TGS S1

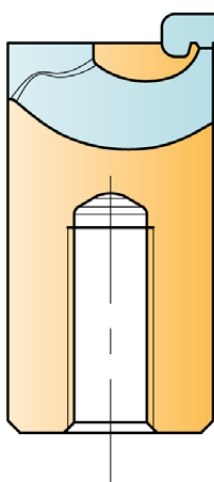
with machining allowance


Suitable for all plastics



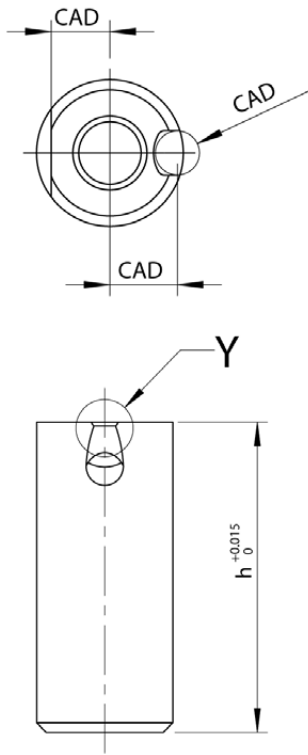
- EN**
- > with machining allowance on upper surface
  - > slight contourings possible
  - > same properties as version S2
  - > available in round (TGR) and square (TGS) versions

TGR / TGS S1

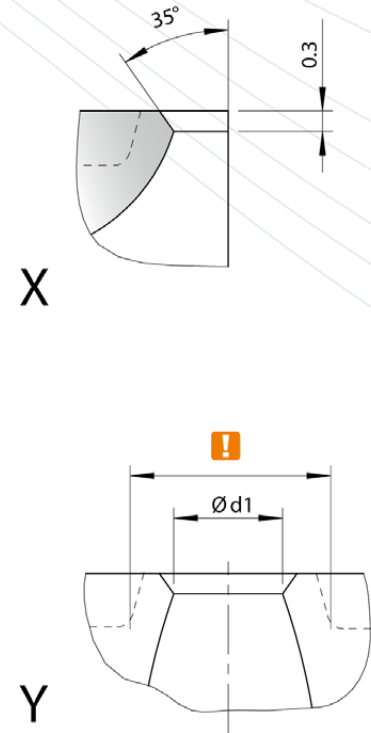
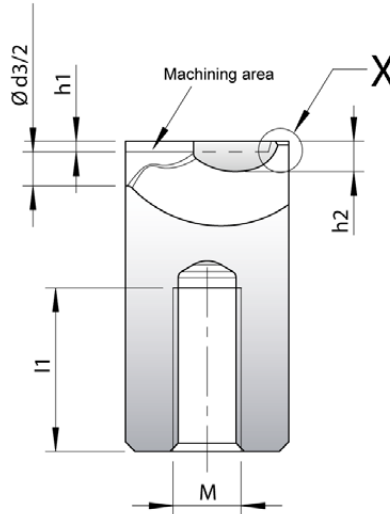


		TGR 6	TGR/TGS 8	TGR/TGS 10	TGR/TGS 12	TGR/TGS 14
	gate point	0.6	0,6 / 0,8	0,8 / 1,2 / 1,6	1,2 / 1,6 / 2,0	1,6 / 2,0 / 2,4 / 2,8
∅	runner	2.5	3	4	5	6
<b>max. shotweight (g)</b>						
	<b>NV</b>	3	5	30	50	200
	<b>MV</b>	2	4	20	35	120
	<b>HV</b>	1	3	12	25	75

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



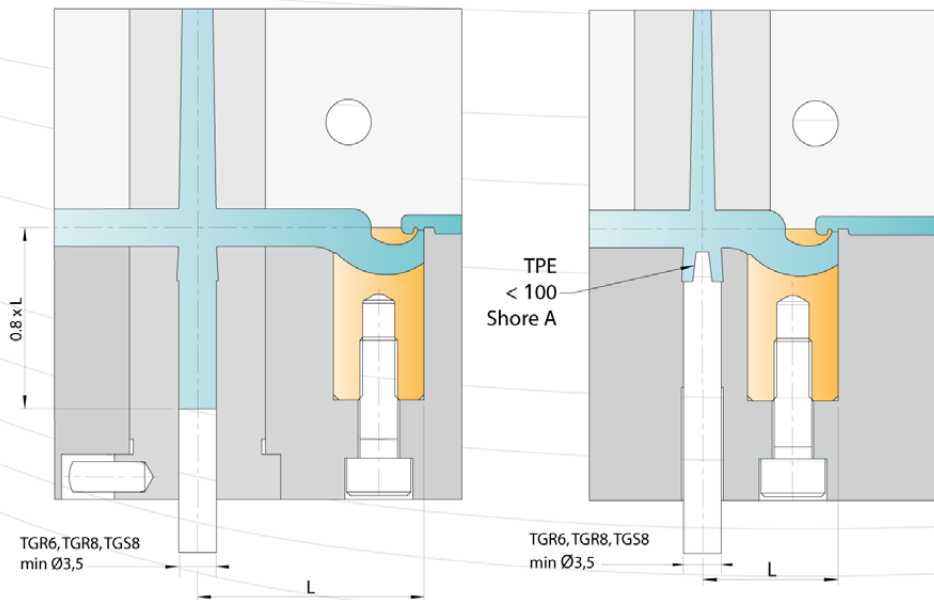
Anti-rotation locking possibility



**!** Minimum size of vestige same as version S2

TGS	Typ	b	b1	d1	d3	h	h1	h2	l1	l2	M	Version
	TGS8	8	6	0.6	3	22.6	0.6	1.7	13	3.25	4	S1
				0.8								
	TGS10	10	8	0.8	4	22.8	0.8	2.0	12	4	5	S1
				1.2								
				1.6								
	TGS12	12	10	1.2	5	22.8	0.8	2.2	11	5	5	S1
				1.6								
				2.0								
	TGS14	14	12	1.6	6	22.8	0.8	2.4	10	6	6	S1
				2.0								
				2.4								
				2.8								

TGR	Typ	d	d1	d3	h	h1	h2	l1	l2	M	Version	
	TGR6	6	0.6	2.5	17.6	0.6	1.4	10	2.5	4	S1	
	TGR8	8	0.6	3	22.6	0.6	1.7	13	3.25	4	S1	
				0.8								
	TGR10	10	0.8	4	22.8	0.8	2.0	12	4	5	S1	
				1.2								
			1.6									
	TGR12	12	1.2	5	22.8	0.8	2.2	11	5	5	S1	
			1.6									
			2.0									
	TGR14	14	1.6	6	22.8	0.8	2.4	10	6	6	S1	
			2.0									
			2.4									
			2.8									



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

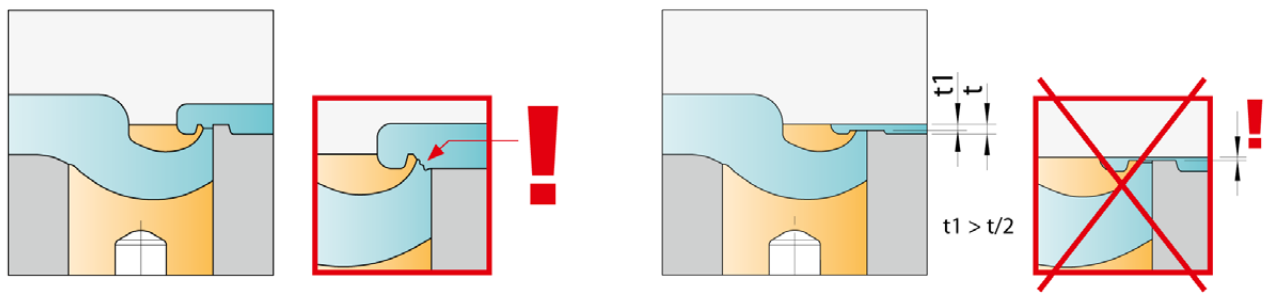
**TGR / TGS S1**

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.
<b>TGR 6</b>	9-12	12-18	15-22	18-25
<b>TGR/TGS 8</b>	11-14	15-22	19-27	23-30
<b>TGR/TGS 10</b>	15-18	19-27	24-33	28-36
<b>TGR/TGS 12</b>	18-22	22-30	27-36	32-40
<b>TGR/TGS 14</b>	20-25	25-33	30-37	35-43

Recomendations

**Companion vestige** **Flat parts**

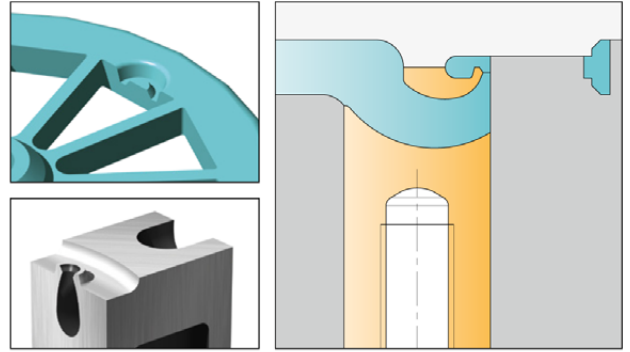


**EN** For optimum degating (especially of flat parts), we recommend the use of a companion vestige supplementing the vestige with cutting edge. This configuration will ensure that the part is separated from the runner flush with the parting line. Users will find this particularly advantageous in cases where materials are susceptible to stringing.

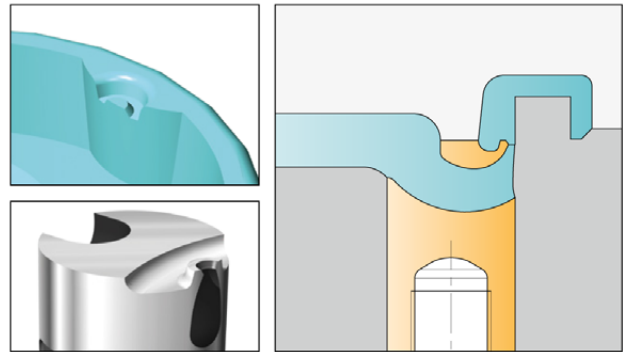
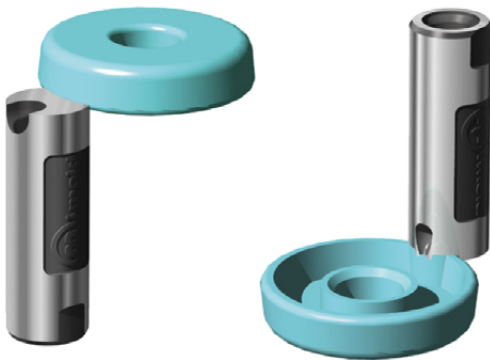
**EN** If the molded part is very thin, the calotte must be ground down. ( $t_1 > t/2$ )

# Exemples of installation

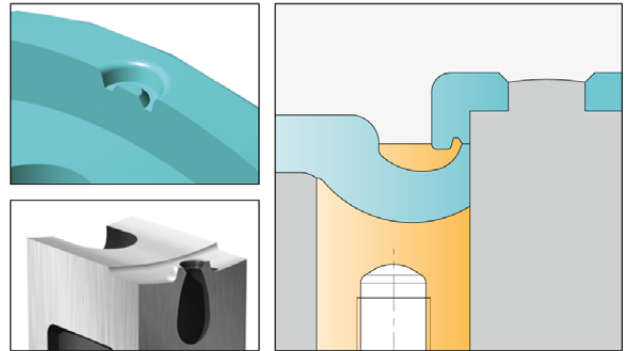
rounded edge



with flow promoter



rounded separation



flat, with companion vestige

