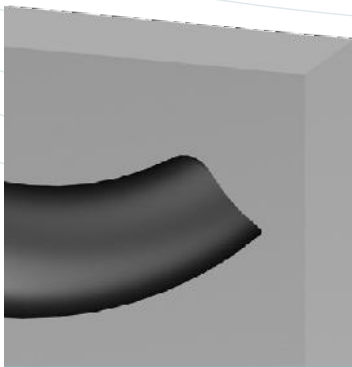


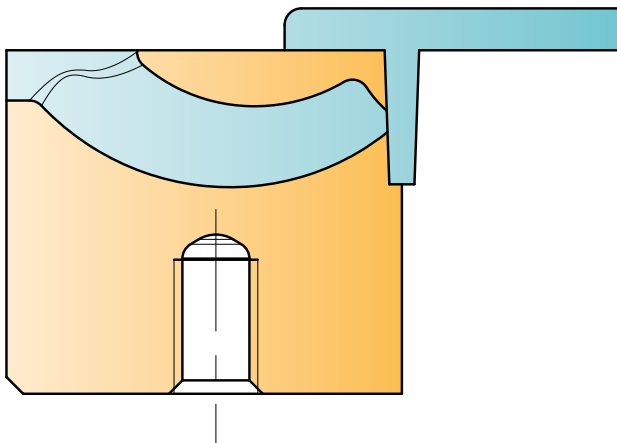
SGC


seitliche Anspritzung
side gating
iniezione laterale

Geeignet für alle Kunststoffe · Suitable for all plastics · Adatto per ogni tipo di plastica



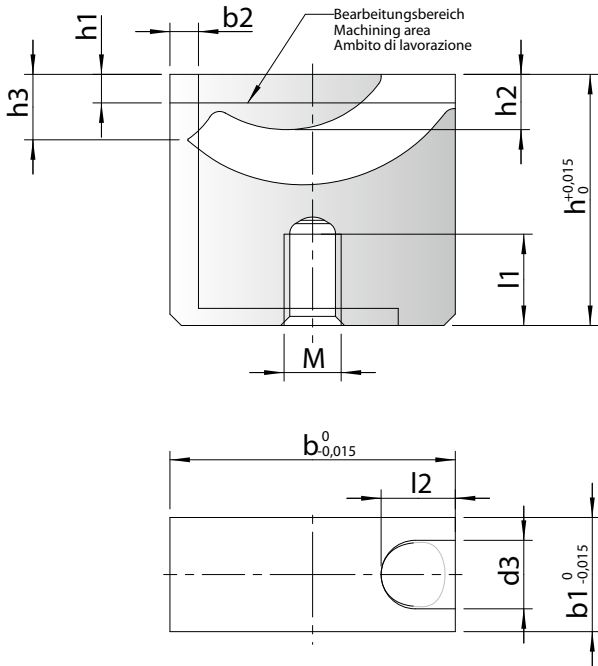
- DE** > gebogener Kanal ermöglicht die Anspritzung in Bereichen, die tief im Bauteil liegen
 - > integrierter Stauboden reduziert Druckverlust und Scherung
 - > hoch verschleißfester Warmarbeitsstahl M2 (1.3343) – 54+2 HRC
- EN** > curved tunnel permits gating deep inside the part
 - > integrated dead-end recess reduces loss of pressure and shear stress.
 - > highly wear-resistant hot working steel M2 (1.3343) – 54+2 HRC
- IT** > il canale curvato consente l'iniezione in zone profonde del componente
 - > il fondo di ritenzione integrato riduce la perdita di pressione e l'attrito
 - > acciaio per lavorazioni a caldo particolarmente resistente all'usura M2 (1.3343) – 54+2 HRC



| | SGC-XS | SGC-S | SGC-1 | SGC-2 | SGC-3 |
|--------------------------------------------------------------------------------------------------------------------------------|-----------|-----------|-----------|-----------|---------------|
|  Anschnitt / gate point / punto d'iniezione | 0,4 - 0,8 | 0,4 - 1,0 | 0,6 - 1,4 | 0,8 - 2,1 | ~ Ø 1,1 - 3,3 |
| Ø Kanal / runner / canale | 2.5 | 2.5 | 4 | 6 | 8 |

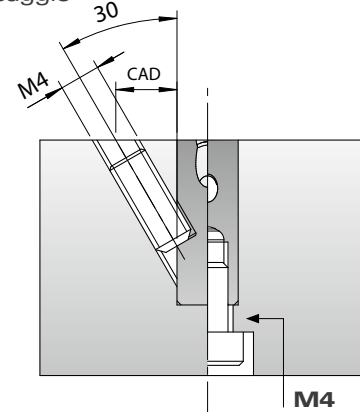
| | max. Schussgewichte (g) · max. shotweight (g) · pesi d'iniezione max. (g) | | | | |
|-----------|---------------------------------------------------------------------------|----|----|-----|------|
| NV | 12 | 20 | 35 | 250 | 1000 |
| MV | 7 | 12 | 25 | 120 | 500 |
| HV | 5 | 8 | 15 | 90 | 300 |

NV = niedrige Viskosität / low viscosity / bassa viscosità
 MV = mittlere Viskosität / medium viscosity / media viscosità
 HV = hohe Viskosität / high viscosity / elevata viscosità



SGC-XS / SGC-S

Befestigungsmöglichkeiten
Mounting possibilities
Possibilità di fissaggio

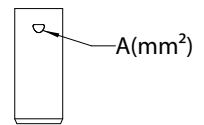
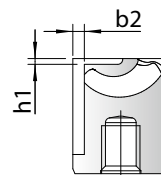


| Typ | b | b1 | b2 max. | d3 | h | h1 max. | h2 | h3 | l1 | l2 | M |
|--------|----|----|---------|-----|----|---------|-----|-----|----|-----|---|
| SGC-XS | 10 | 5 | 1.1 | 2.5 | 12 | 0.6 | 1.9 | 2.0 | 5 | 3.2 | 4 |
| SGC-S | 15 | 6 | 2.0 | 2.5 | 18 | 2 | 3.5 | 4.0 | 8 | 4 | 4 |
| SGC-1 | 18 | 8 | 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 |

➔ Beispiel Bestellbezeichnung · Example of order specification · Esempio codice di ordinazione: **SGC-XS**

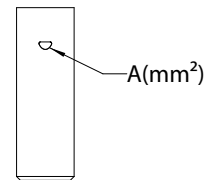
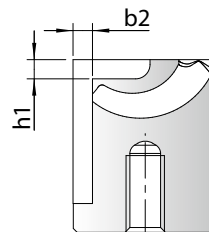
SGC-XS

| 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 |



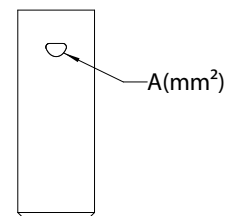
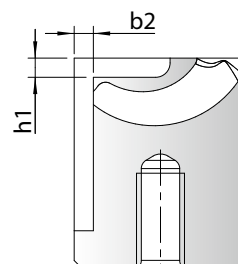
SGC-S

| 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 |



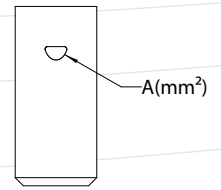
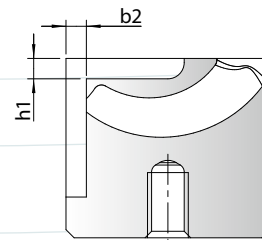
SGC-1

| 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 |



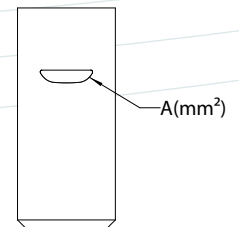
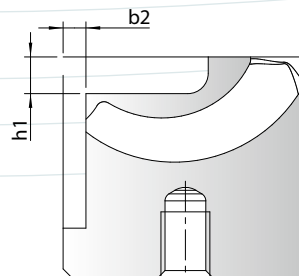
SGC-2

| 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 |



Standardeinbau für flache und mittlere Konturtiefen

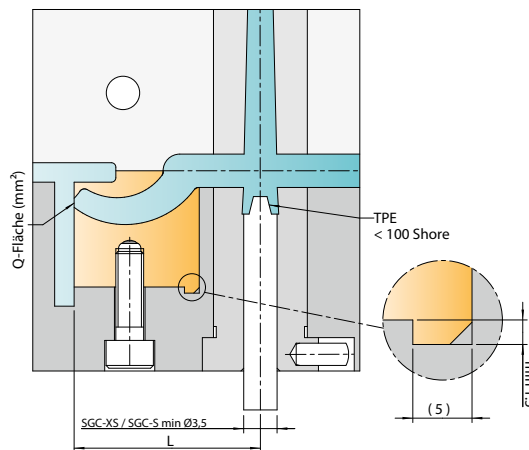
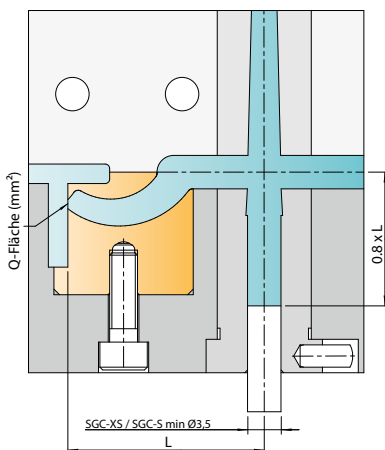
Standard installation for shallow and medium contour depths

Montaggio standard per medie ed elevate profondità di contornatura

Sondereinbau für große Konturtiefen

Special installation for deep contours

Montaggio speciale per grandi profondità di contornatura



- DE Thermoplastische Elastomere (TPE)**
 - > Kleine Shorehärte = geringeres Abstandsmaß L
 - > Zentrierzapfen verwenden
 - > Shorehärte max. 100 Shore A
- EN Thermoplastic elastomers (TPE)**
 - > Low Shore hardness = shorter distance L
 - > Use centring pin
 - > Max. hardness 100 Shore A
- IT Elastomeri termoplastici (TPE)**
 - > Bassa durezza Shore = distanza L più ridotta
 - > Utilizzare un perno di guida
 - > Durezza: max. 100 Shore A

SGC

Diagramm für Abstandsmaß L · Table for distance L · Diagramma per la distanza L

| | Materialart · Material type · Tipo di materiale | | | |
|--------|-------------------------------------------------|------------------|-----------------------------|---------------------------|
| | 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 |

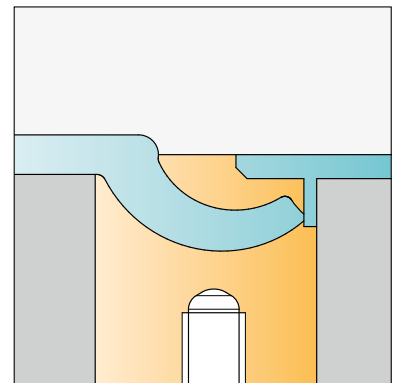
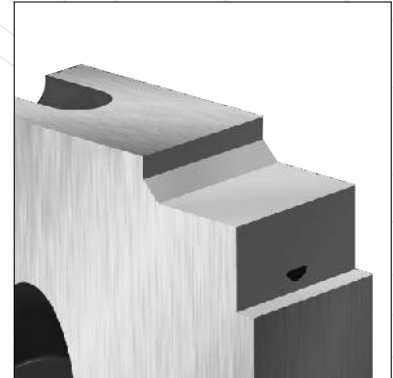
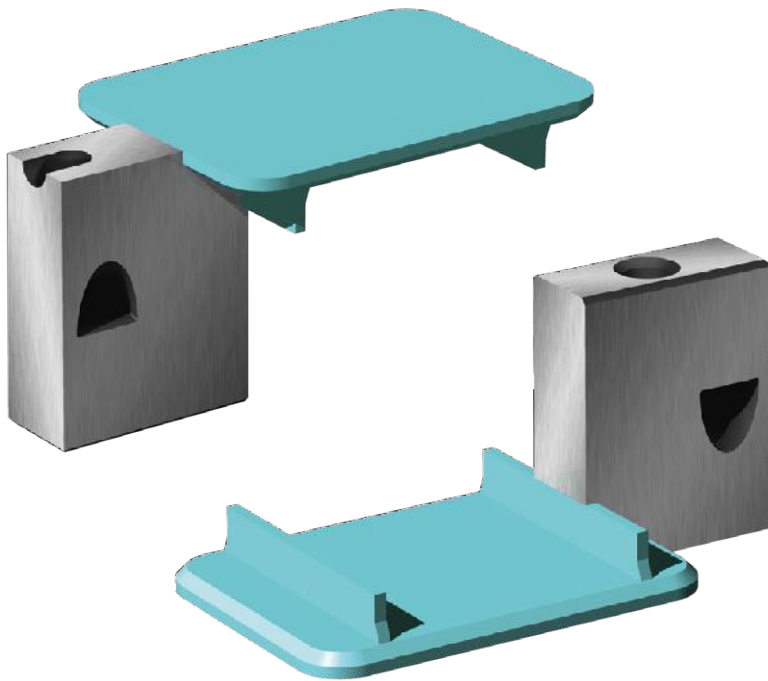
Einbaubeispiele

Examples of installation · Esempi di montaggio

Seitliche Anspritzung – Standard Einbau

Side gating – standard installation

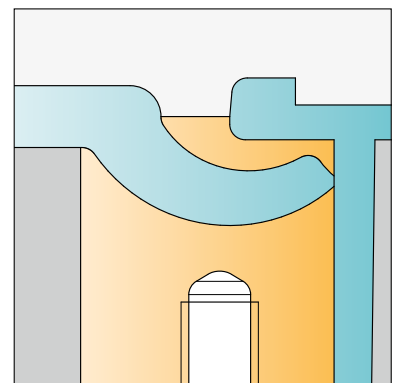
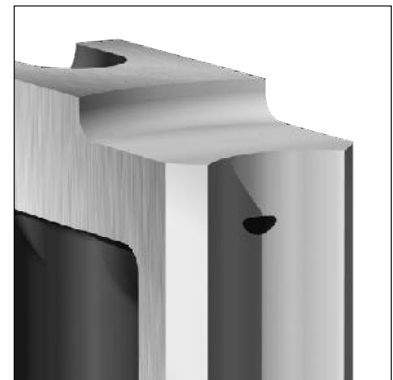
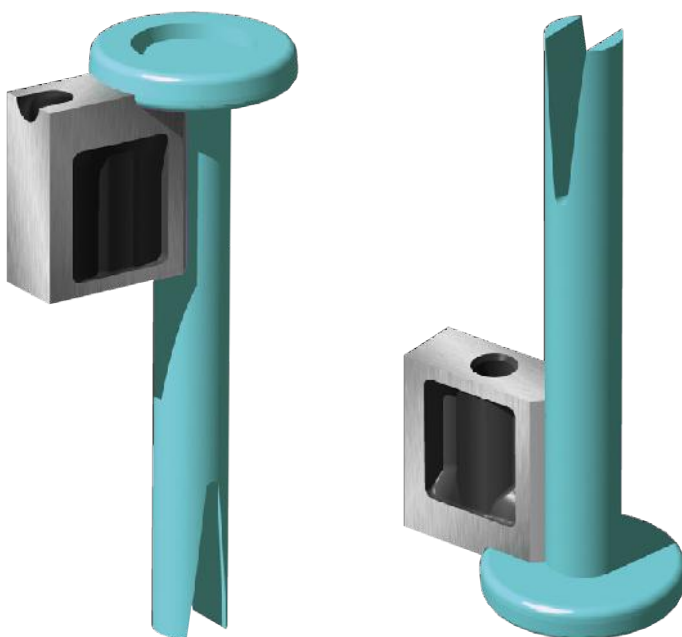
Iniezione laterale – montaggio standard



Seitliche Anspritzung – angepasst an Teil

Side gating – adapted to part

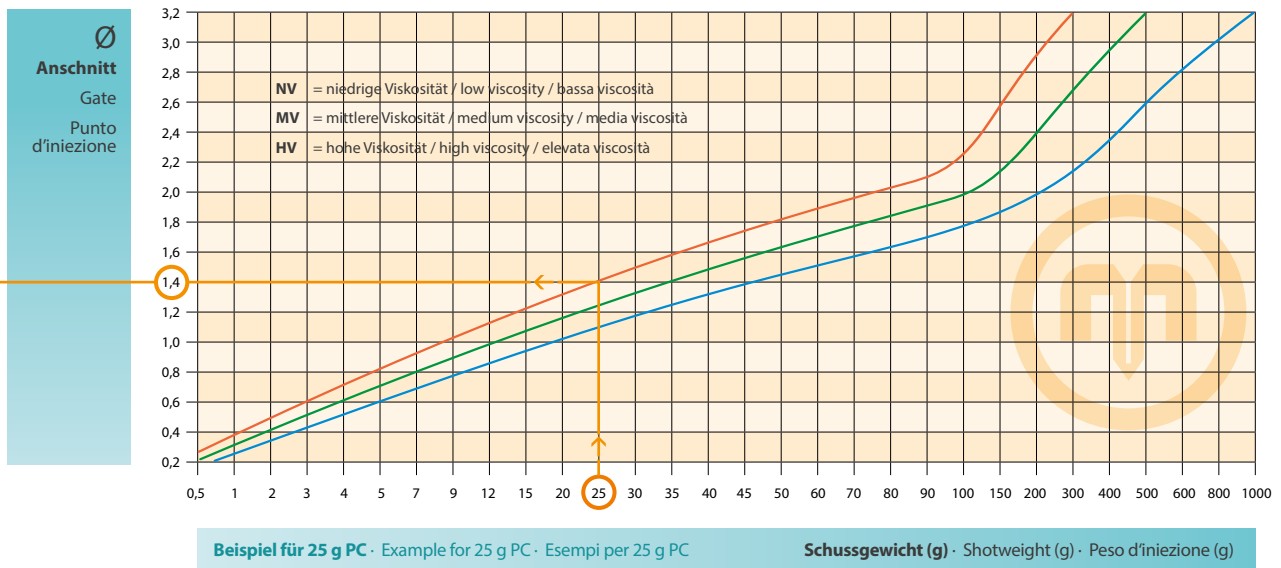
Iniezione laterale – adattata al pezzo



Technische Information

Technical information · Informazioni tecniche

Viskositätsdiagramm · Viscosity graph · Diagramma di viscosità



DE

Achtung: Bei Verwendung von gefüllten Kunststoffen (Glasfaser, Kohlefaser, etc.), den mit der Tabelle ermittelten Anschnittdurchmesser um 20 % vergrößern!

Die empfohlenen Schussgewichte und Anschnittdurchmesser sind nur Richtwerte. Geometrie des Teiles, Werkzeugkonzept, Kunststofftyp und Füllstoffe müssen individuell berücksichtigt werden.

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.

IT

Attenzione: In caso di impiego di plastica caricata (fibre di vetro, di carbonio ecc.) è necessario aumentare del 20% il diametro d'iniezione calcolato in base alla tabella!

I pesi ed i diametri d'iniezione consigliati sono soltanto valori indicativi. La geometria del pezzo, il sistema di stampo, il tipo di plastica ed i riempitivi devono essere considerati individualmente.

Anschnittdurchmesser · Gate Diameter · Diametro del punto d'iniezione

| Ø | Querschnittsfläche in mm ² Cross-sectional area mm ² Superficie trasversale mm ² | Material Groups | | | | | |
|-----|-------------------------------------------------------------------------------------------------------------------------|-----------------|------------------|-------------------------|-------------------------------------------------------|-------------------------------------------------------|-----------------------------------------------------------------|
| | | 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 | | | | | | 0,8 x (4,8) |
| 3,0 | 7,07 | | | | | | 0,9 x (4,9) |
| 3,2 | 8,04 | | | | | | 0,9 x (4,9) |
| : | : | | | | | | 1,0 x (5,0) |
| 4,5 | 18,8 | | | | | | 1,1 x (5,1) |
| | | | | | | | 1,2 x (5,2) |
| | | | | | | | 1,3 x (5,3) |
| | | | | | | | 1,4 x (5,4) |
| | | | | | | | 1,5 x (5,5) |
| | | | | | | | 4,5 |

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