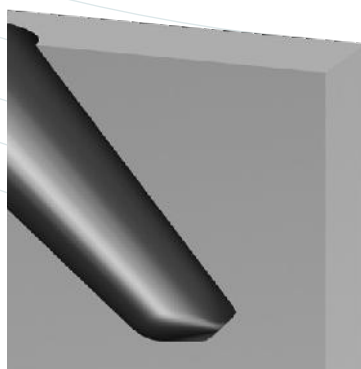


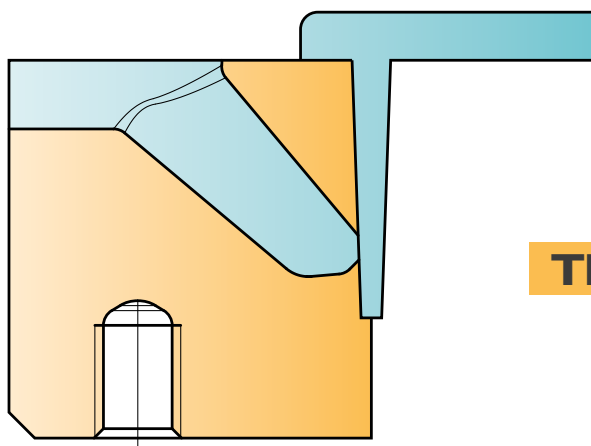
TPS

seitliche Anspritzung
side gating
iniezione laterale

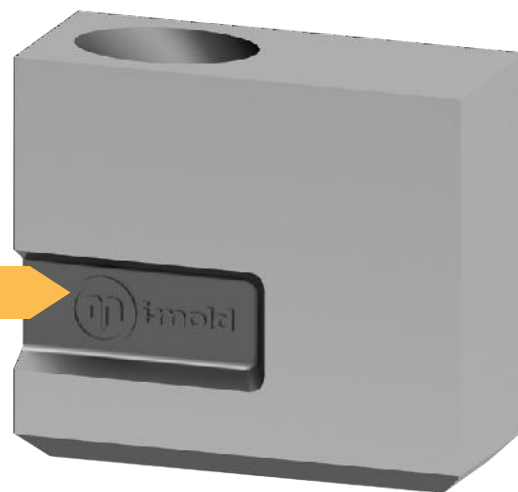
Geeignet für alle Kunststoffe · Suitable for all plastics · Adatto per ogni tipo di plastica



- DE** > **standardisierter Spitztunnel zur seitlichen Anspritzung**
 > **integrierter Stauboden reduziert Druckverlust und Scherung**
 > **hoch verschleißfester Warmarbeitsstahl M2 (1.3343) – 54+2 HRC**
- EN** > straight standard sub-gate for side-gating
 > integrated dead-end recess reduces loss of pressure and shear stress.
 > highly wear-resistant hot working steel M2 (1.3343) – 54+2 HRC
- IT** > tunnel di iniezione standard per iniezione laterale
 > 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



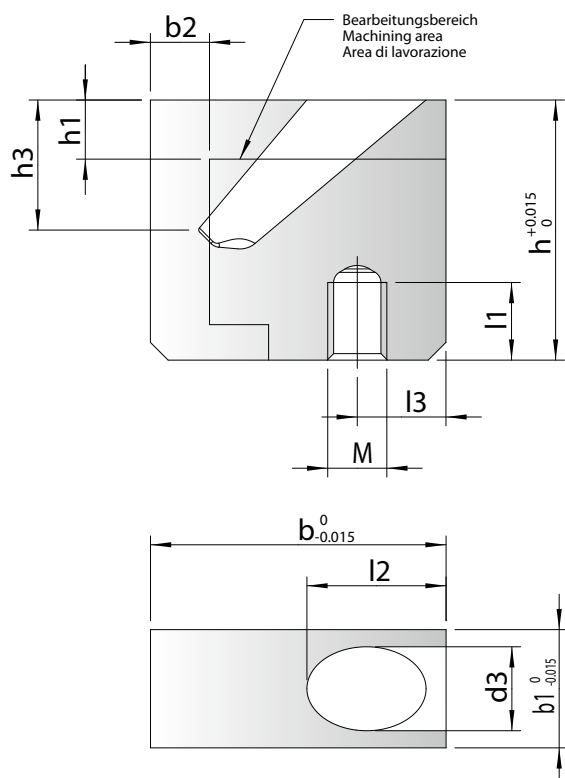
TPS



TPS

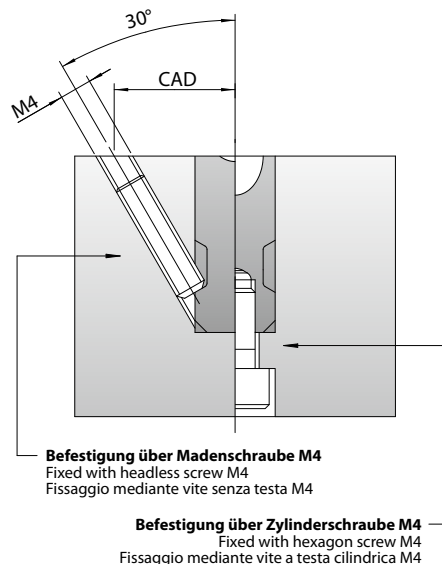
	TPS-S	TPS-1	TPS-2	TPS-3
 Anschnitt / gate point / punto d'iniezione	0,4 - 0,8	0,8 - 1,8	0,8 - 2,8	1,1 - 4,5
max. Schussgewichte (g) · max. shotweight (g) · pesi d'iniezione max. (g)				
NV	30	120	600	1800
MV	20	75	350	1000
HV	12	50	175	600

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



TPS

Befestigungsmöglichkeiten Mounting possibilities Possibilità di fissaggio

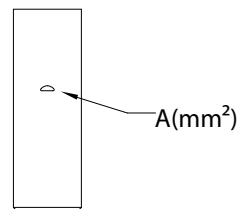
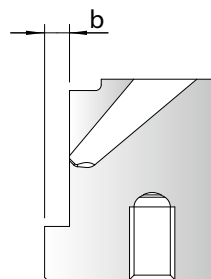


Typ	b	b1	b2 max.	d3	h	h1 max.	h3	l1	l2	l3	M
TPS-S	15	6	2.4	4	18	4	~7	6	7.1	5.5	4
TPS-1	18	8	2.6	6	22	5	~9	6	8.4	6	4
TPS-2	25	10	5	8	22	6	~11	6	11.8	7.5	5
TPS-3	30	12	6.5	10	27	7	~13	6	14.1	8	5

➔ Beispiel Bestellbezeichnung · Example of order specification · Esempio codice di ordinazione: **TPS-1**

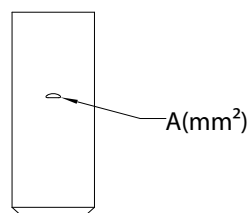
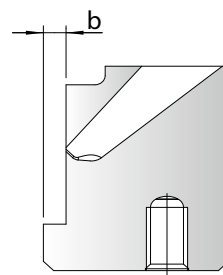
TPS-S

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



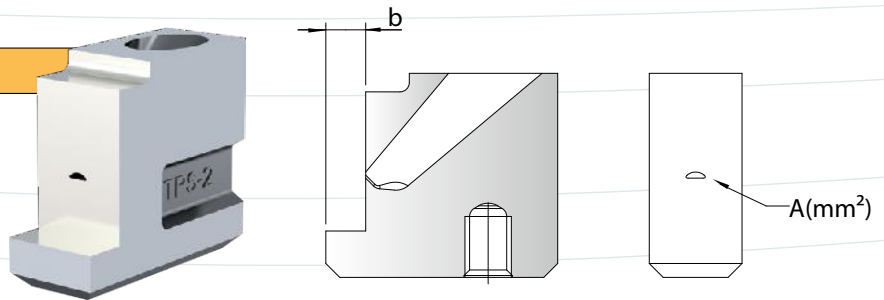
TPS-1

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



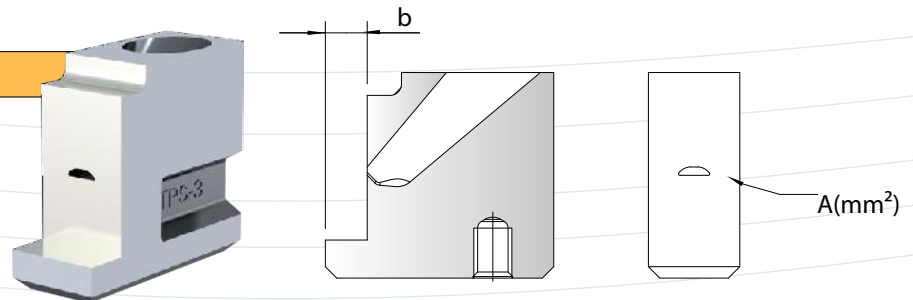
TPS-2

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

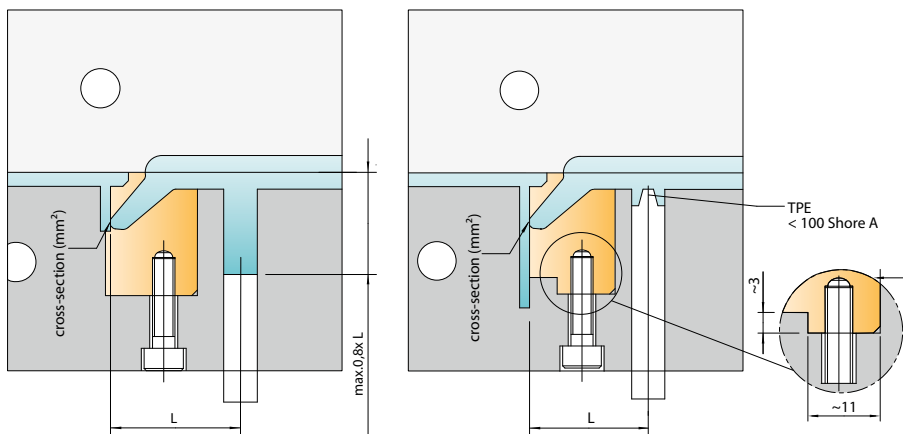


Standardeinbau für flache und mittlere Konturtiefen

Standard installation for shallow and medium contour depths
montaggio standard per pareti di bassa e media profondità

Sondereinbau für große Konturtiefen

Special installation for deep contours
montaggio standard per pareti di alta profondità



DE Thermoplastische Elastomere (TPE)

- > Niedrige 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)

- > Basso durezza Shore = distanza L più ridotta
- > Utilizzare un perno di guida
- > Durezza: max. 100 Shore A

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

Materialart · Material type · Tipo di materiale		
flexible Materialien flexible materials · materiali flessibili		steife Materialien rigid materials · materiali rigidi
TPS-S	~ 18	~ 23
TPS-1	~ 22	~ 30
TPS-2	~ 28	~ 38
TPS-3	~ 33	~ 47

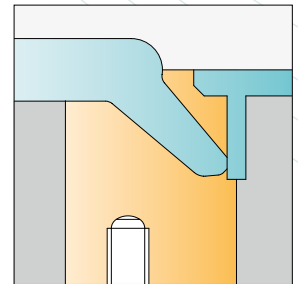
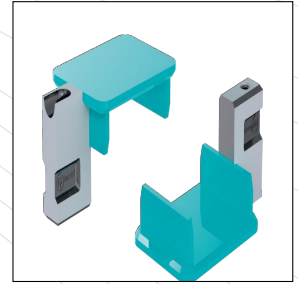
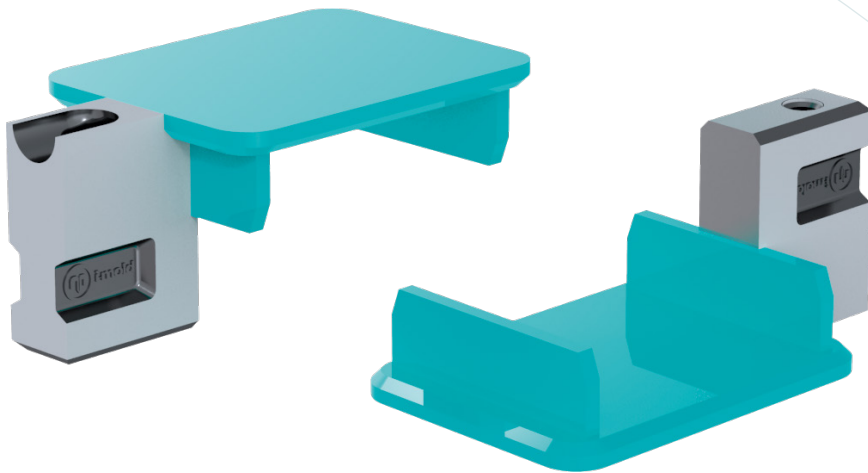
Einbaubeispiele

Examples of installation · Esempi di montaggio

Seitliche Anspritzung – Standard Einbau

Side gating – standard installation

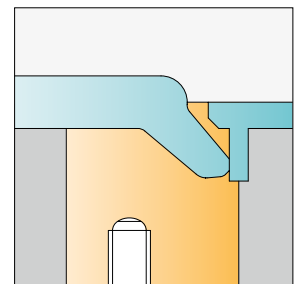
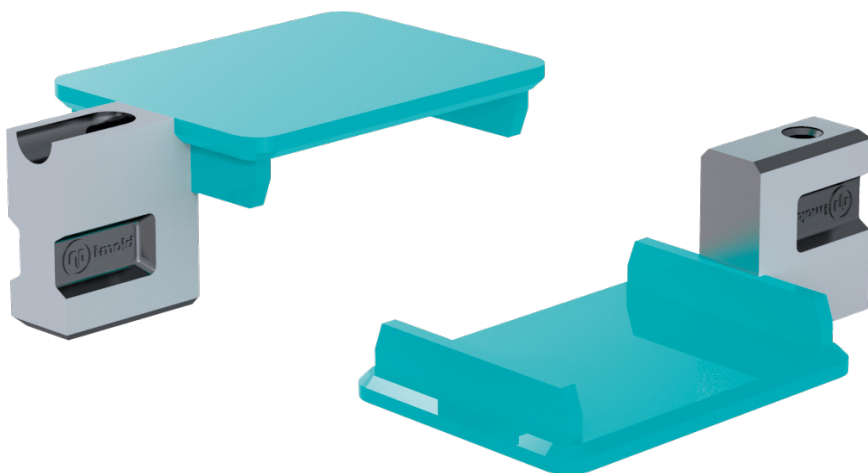
Iniezione laterale – montaggio standard



Seitliche Anspritzung – für flache Konturtiefen

Side gating – for flat contours

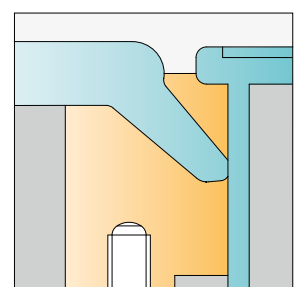
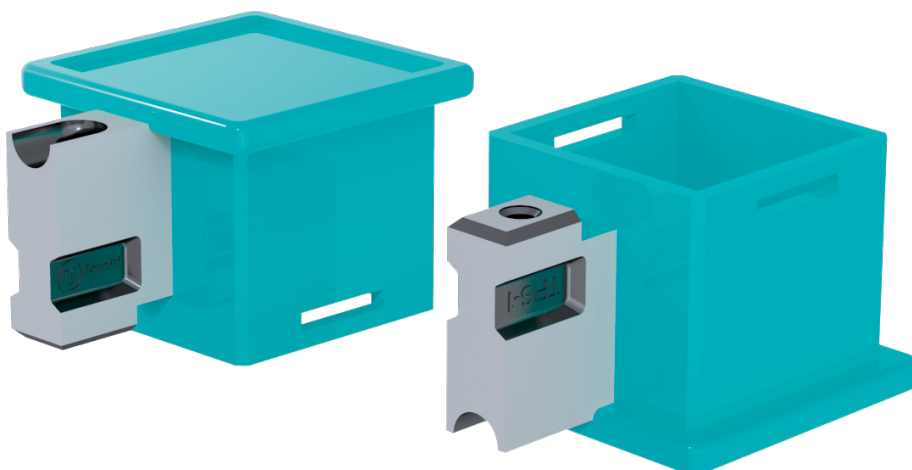
Iniezione per pareti laterali poco profonde



Seitliche Anspritzung – für große Konturtiefen

Side gating – for deep contours

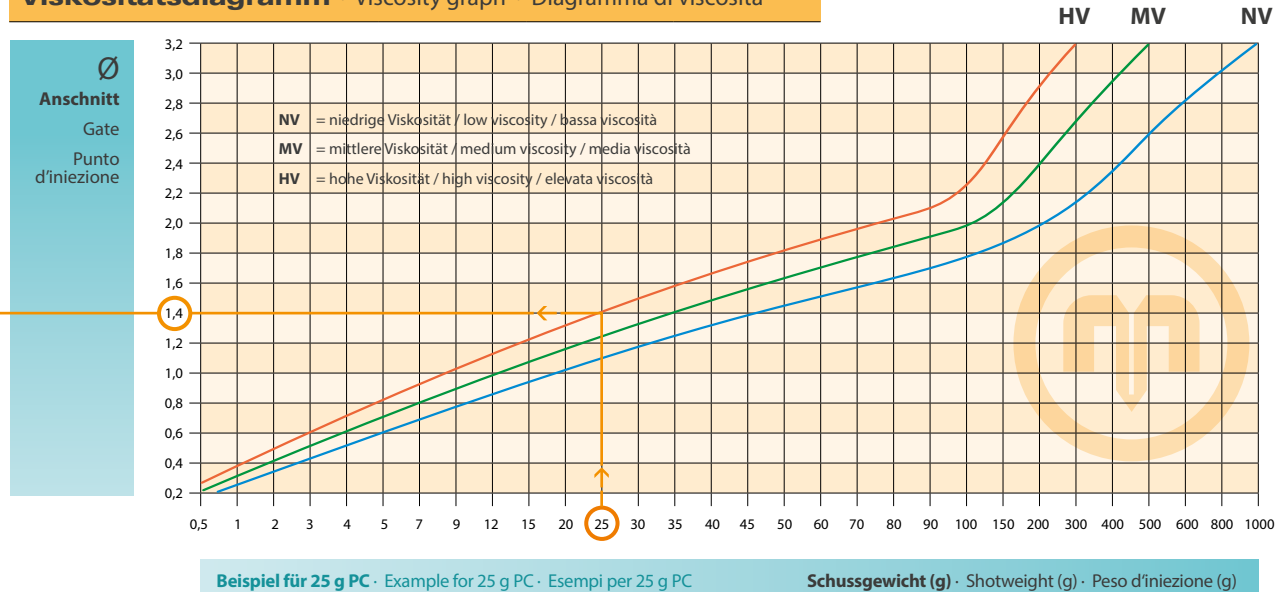
iniezione per pareti laterali molto profonde



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	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	0,5 x (4,5)
0,6	0,28	0,8	0,6	0,6	0,8	1,0	0,6 x (4,6)
0,8	0,50	1,2	0,8	0,8	1,0	1,2	0,7 x (4,7)
1,0	0,78	1,6		1,0	1,2	1,4	0,8 x (4,8)
1,2	1,13	2,0		1,2	1,4	1,6	0,9 x (4,9)
1,4	1,54	2,4			1,8	2,1	1,0 x (5,0)
1,6	2,01	2,8				2,8	1,1 x (5,1)
1,8	2,54						1,2 x (5,2)
2,0	3,14						1,3 x (5,3)
2,2	3,8						1,4 x (5,4)
2,4	4,52						1,5 x (5,5)
2,6	5,31						
2,8	6,15						
3,0	7,07						
3,2	8,04						
:	:						
4,5	18,8						

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

4,5