

# TGR TGS S2

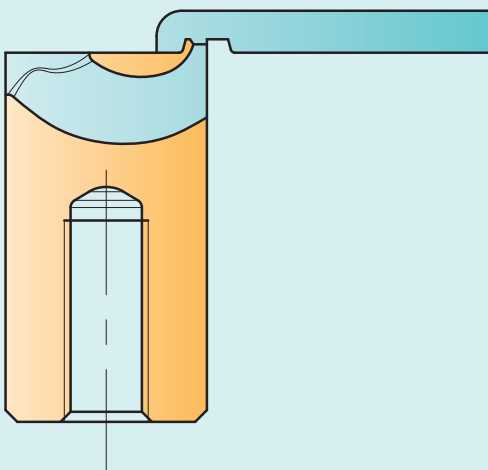
mit Kalotte  
with vestige  
con calotta



- DE**
- für flache Trennungen, inkl. Kalotte mit integrierter Abrisskante
  - direkt einsetzbar! Keine Anpassungen erforderlich
  - in 2 Härteklassen (60 HRC / 40 HRC) erhältlich
  - erhältlich in runder (TGR) und eckiger (TGS) Ausführung

- EN**
- for flat parting surfaces, including vestige with integrated cutting edge
  - ready to use! No adjustments necessary
  - available in 2 degrees of hardness (60 HRC / 40 HRC)
  - available in round (TGR) and square (TGS) versions

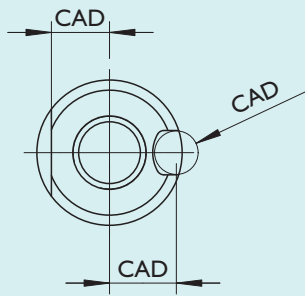
- IT**
- per separazioni piatte, inclusa calotta con bordo di distacco integrato
  - impiego diretto! Non sono necessari adattamenti
  - disponibile in 2 differenti durezza (60 HRC / 40 HRC)
  - disponibile in versione tonda (TGR) e squadrata (TGS)



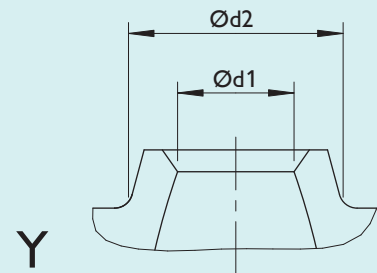
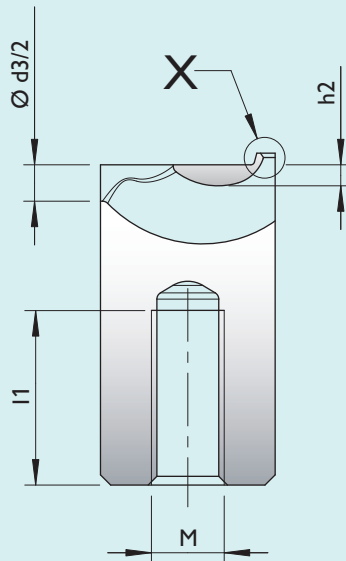
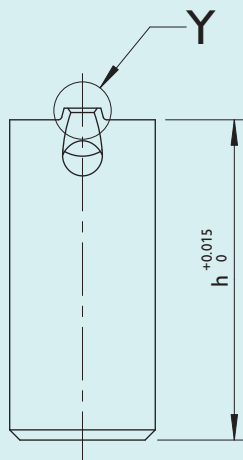
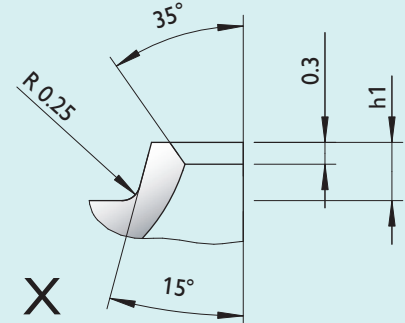
	TGR 6	TGR/TGS 8	TGR/TGS 10	TGR/TGS 12	TGR/TGS 14
Anschnitt / gate point / punto d'iniezione	0.6	0,6 / 0,8	0,8 / 1,2 / 1,6	1,2 / 1,6 / 2,0	1,6 / 2,0 / 2,4 / 2,8
Ø Kanal / runner / canale	2.5	3	4	5	6

	max. Schussgewichte (g) · max. shotweight (g) · pesi d'iniezione max. (g)				
<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 = niedrige Viskosität / low viscosity / bassa viscosità  
 MV = mittlere Viskosität / medium viscosity / media viscosità  
 HV = hohe Viskosität / high viscosity / elevata viscosità

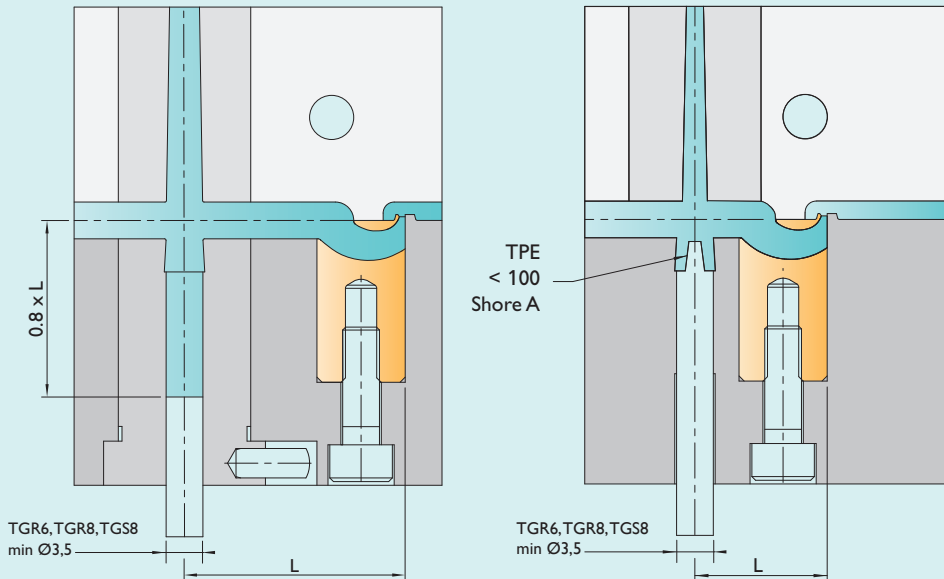


**Mögliche Verdrehsicherung**  
Anti-rotation locking possibility  
Possibilità di protezione antitorzione



TGS	Typ	b	b1	d1	d2	d3	h	h1	h2	l1	l2	M	Version	HRC
	TGS8	8	6	0.6	1.9	3	22.0	0.6	1.1	13	3.25	4	S2	Version U = 40 HRC Version H = 60 HRC
				0.8	2.1									
	TGS10	10	8	0.8	2.2	4	22.0	0.8	1.2	12	4	5	S2	
				1.2	2.6									
				1.6	3.0									
	TGS12	12	10	1.2	2.6	5	22.0	0.8	1.40	11	5	5	S2	
				1.6	3.0									
				2.0	3.4									
	TGS14	14	12	1.6	3.0	6	22.0	0.8	1.6	10	6	6	S2	
				2.0	3.4									
				2.4	3.8									
				2.8	4.2									

TGR	Typ	d	d1	d2	d3	h	h1	h2	l1	l2	M	Version	HRC	
	TGR6	6	0.6	1.9	2.5	17.0	0.6	0.8	10	2.5	4	S2	Version U = 40 HRC Version H = 60 HRC	
	TGR8	8	0.6	1.9	3	22.0	0.6	1.1	13	3.25	4	S2		
				0.8	2.1									
	TGR10	10	0.8	2.2	4	22.0	0.8	1.2	12	4	5	S2		
				1.2	2.6									
				1.6	3.0									
	TGR12	12	1.2	2.6	5	22.0	0.8	1.4	11	5	5	S2		
				1.6	3.0									
				2.0	3.4									
	TGR14	14	1.6	3.0	6	22.0	0.8	1.6	10	6	6	S2		
				2.0	3.4									
				2.4	3.8									
			2.8	4.2										



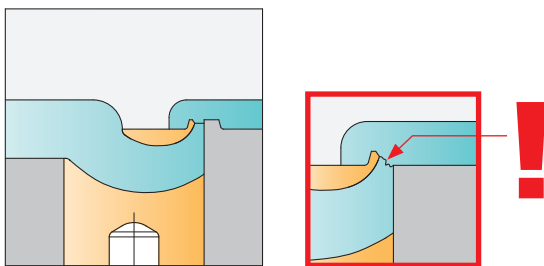
- DE Thermoplastische Elastomere (TPE)**
  - Kleine Shorehärte = geringeres Abstandsmaß L
  - Zentrierzapfen verwenden
  - Shorehärte max. 100 Shore A
- EN Thermoplastic elastomers (TPE)**
  - Low Shore hardness = shorter distance L
  - Use centring pin
  - Max. hardness 100 Shore A
- IT Elastomeri termoplastici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

**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.
<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

**Empfehlungen · Recommendations · Consigli**

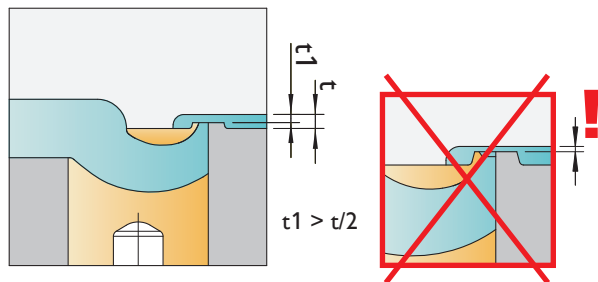
**Gegenkalotte · Companion vestige / Controcalotta**      **Flache Teile · Flat parts / Pezzi piatti**



**DE\_** Um ein optimales Abreißen des Anschnittes zu Gewährleisten (insbesondere bei flachen Teilen) empfehlen wir im Bereich der Kalotte mit Abrisskante eine Gegenkalotte vorzusehen. Diese gewährleistet ein Abreißen parallel zur Trennebene. Besonders bei Materialien zu empfehlen die zu Fadenzug neigen

**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.

**IT\_** Per garantire un ottimale distacco del punto d'iniezione (soprattutto con pezzi piatti) è consigliabile l'impiego di una controcalotta nella zona della calotta con bordo di distacco. In questo modo si garantisce un distacco parallelo alla linea di giunzione. Questo metodo è consigliabile soprattutto per i materiali che tendono a sfilacciarsi.



**DE\_** Bei sehr dünnen Teilen muss die Kalotte abgeschliffen werden. ( $t_1 > t_2$ )

**EN\_** If the molded part is very thin, the calotte must be ground down. ( $t_1 > t_2$ )

**IT\_** Per la realizzazione di pezzi molto sottili è necessario rettificare la calotta. ( $t_1 > t_2$ )