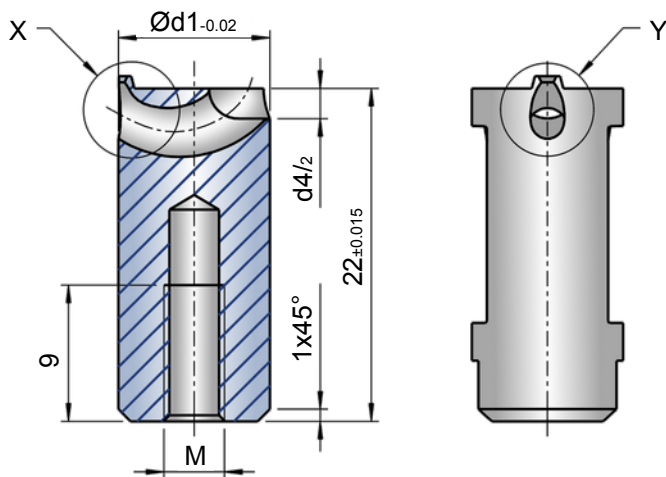
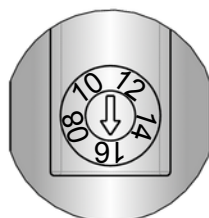
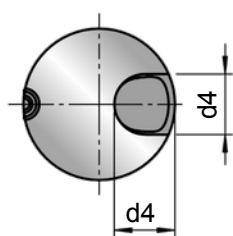


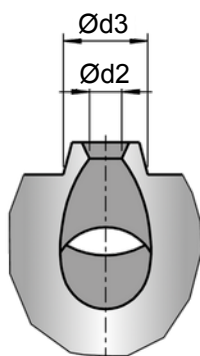
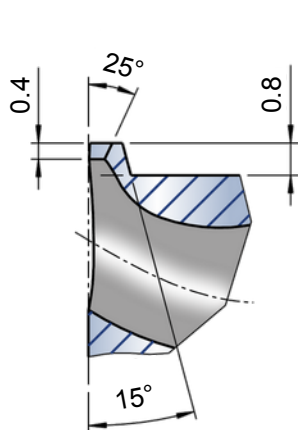
# Standardflow GTR



Größenstempel (Ø d2)



Size stamp (Ø d2)



| Größentabelle GTR 10                       |    |     |     |    |   |                                                         |                                              |                                           |  |
|--------------------------------------------|----|-----|-----|----|---|---------------------------------------------------------|----------------------------------------------|-------------------------------------------|--|
| Size Table GTR 10                          |    |     |     |    |   |                                                         |                                              |                                           |  |
| Artikel Nr.<br>Article No.                 | d1 | d2  | d3  | d4 | M | Viskosität (Fließeigenschaften)<br>Viscosity (Rheology) |                                              |                                           |  |
|                                            |    |     |     |    |   | Leicht<br>fließend<br>high<br>flowability               | normal<br>fließend<br>regular<br>flowability | schwer<br>fließend<br>poor<br>flowability |  |
| GTR 10-08                                  |    | 0,8 | 2,1 |    |   | 8                                                       | 7                                            | 5                                         |  |
| GTR 10-10                                  |    | 1   | 2,3 |    |   | 14                                                      | 12                                           | 9                                         |  |
| GTR 10-12                                  | 10 | 1,2 | 2,5 | 4  | 4 | 20                                                      | 16                                           | 10                                        |  |
| GTR 10-14                                  |    | 1,4 | 2,7 |    |   | 30                                                      | 23                                           | 15                                        |  |
| GTR 10-16                                  |    | 1,6 | 2,9 |    |   | 40                                                      | 30                                           | 20                                        |  |
| Artikelgewicht in Gramm<br>Weight in grams |    |     |     |    |   |                                                         |                                              |                                           |  |

| Größentabelle GTR 12                       |    |     |     |    |   |                                                         |                                              |                                           |  |
|--------------------------------------------|----|-----|-----|----|---|---------------------------------------------------------|----------------------------------------------|-------------------------------------------|--|
| Size Table GTR 12                          |    |     |     |    |   |                                                         |                                              |                                           |  |
| Artikel Nr.<br>Article No.                 | d1 | d2  | d3  | d4 | M | Viskosität (Fließeigenschaften)<br>Viscosity (Rheology) |                                              |                                           |  |
|                                            |    |     |     |    |   | Leicht<br>fließend<br>high<br>flowability               | normal<br>fließend<br>regular<br>flowability | schwer<br>fließend<br>poor<br>flowability |  |
| GTR 12-08                                  |    | 0,8 | 2,1 |    |   | 8                                                       | 7                                            | 5                                         |  |
| GTR 12-10                                  |    | 1   | 2,3 |    |   | 14                                                      | 12                                           | 9                                         |  |
| GTR 12-12                                  |    | 1,2 | 2,5 |    |   | 20                                                      | 16                                           | 10                                        |  |
| GTR 12-14                                  | 12 | 1,4 | 2,7 | 5  | 5 | 30                                                      | 23                                           | 15                                        |  |
| GTR 12-16                                  |    | 1,6 | 2,9 |    |   | 40                                                      | 30                                           | 20                                        |  |
| GTR 12-18                                  |    | 1,8 | 3,1 |    |   | 54                                                      | 40                                           | 27                                        |  |
| GTR 12-20                                  |    | 2   | 3,3 |    |   | 68                                                      | 52                                           | 34                                        |  |
| Artikelgewicht in Gramm<br>Weight in grams |    |     |     |    |   |                                                         |                                              |                                           |  |

| Größentabelle GTR 14                       |    |     |     |    |   |                                                         |                                              |                                           |  |
|--------------------------------------------|----|-----|-----|----|---|---------------------------------------------------------|----------------------------------------------|-------------------------------------------|--|
| Size Table GTR 14                          |    |     |     |    |   |                                                         |                                              |                                           |  |
| Artikel Nr.<br>Article No.                 | d1 | d2  | d3  | d4 | M | Viskosität (Fließeigenschaften)<br>Viscosity (Rheology) |                                              |                                           |  |
|                                            |    |     |     |    |   | Leicht<br>fließend<br>high<br>flowability               | normal<br>fließend<br>regular<br>flowability | schwer<br>fließend<br>poor<br>flowability |  |
| GTR 14-12                                  |    | 1,2 | 2,5 |    |   | 20                                                      | 16                                           | 10                                        |  |
| GTR 14-14                                  |    | 1,4 | 2,7 |    |   | 30                                                      | 23                                           | 15                                        |  |
| GTR 14-16                                  |    | 1,6 | 2,9 |    |   | 40                                                      | 30                                           | 20                                        |  |
| GTR 14-18                                  | 14 | 1,8 | 3,1 | 6  | 6 | 54                                                      | 40                                           | 27                                        |  |
| GTR 14-20                                  |    | 2   | 3,3 |    |   | 68                                                      | 52                                           | 34                                        |  |
| GTR 14-22                                  |    | 2,2 | 3,5 |    |   | 85                                                      | 65                                           | 43                                        |  |
| GTR 14-24                                  |    | 2,4 | 3,7 |    |   | 100                                                     | 80                                           | 50                                        |  |
| Artikelgewicht in Gramm<br>Weight in grams |    |     |     |    |   |                                                         |                                              |                                           |  |

## Technische Information

Für die unterflurige Anspritzung kleiner und mittelgroßer Bauteile mit flacher Trennung. Das erhabene Köpfchen garantiert einen verdeckten Abriss des Angießpunktes.

- Erhältlich mit den Anspritzdurchmessern von 0,8 bis 2,4 mm.
- Verwendbar für sämtliche Thermoplaste inkl. Füllstoffe bis 50 % Glasfaser.

## Technical information

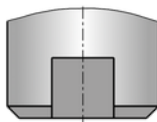
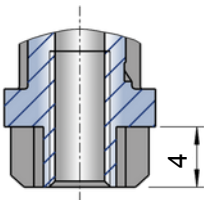
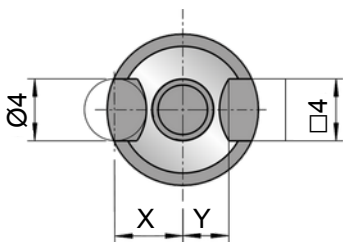
For tunnel gating of small to medium-sized moldings along a flat separating plane. The projecting calotte ensures concealed degating.

- Available gate diameters from 0,8 to 2,4 mm.
- Usable for all thermoplastics including fillers up to 50 % glass fibre.

# Standardflow GTR

## Verdrehsicherung *Anti-rotation locking system*

| Abstandstabelle Verdrehsicherung<br><i>Anti-rotation locking system dimensions</i> |                                |                       |
|------------------------------------------------------------------------------------|--------------------------------|-----------------------|
| Artikel Nr.                                                                        | Abstand Zyl.Stift X            | Abstand Passfeder Y   |
| <i>Article No.</i>                                                                 | <i>Parallel pin distance X</i> | <i>Key distance Y</i> |
| GTR 10                                                                             | 4,5 mm                         | 3,0 mm                |
| GTR 12                                                                             | 5,2 mm                         | 3,8 mm                |
| GTR 14                                                                             | 6,0 mm                         | 4,5 mm                |



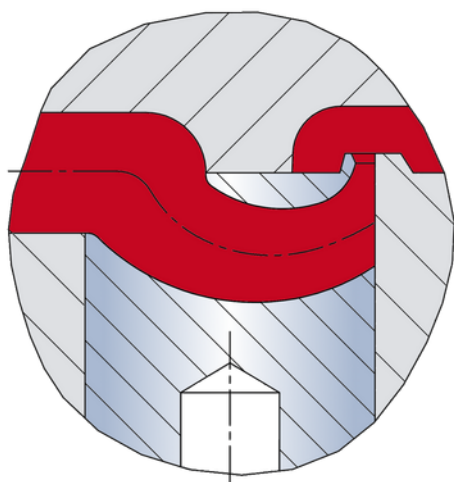
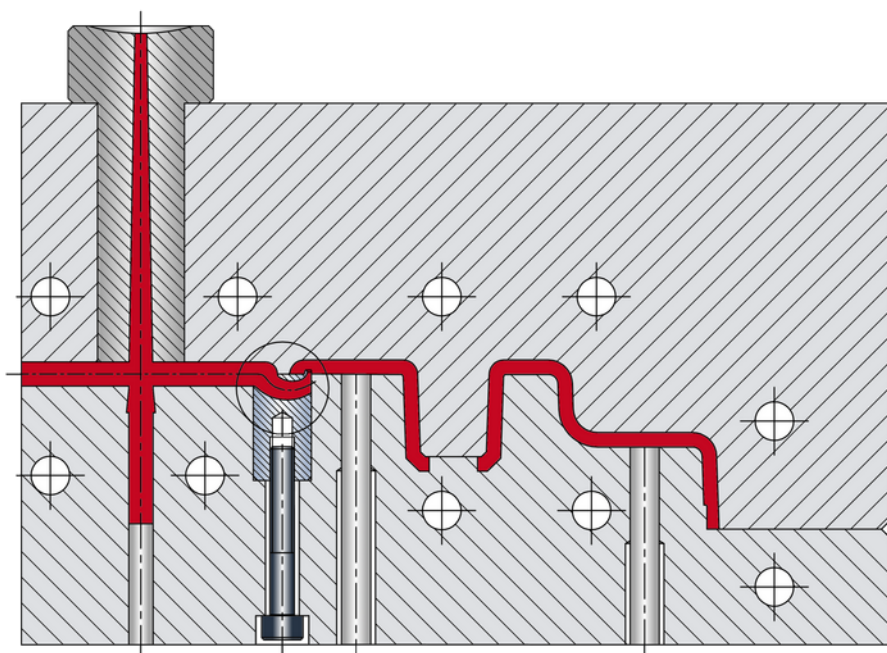
### Einbauhinweis – Verdrehsicherung

Durch Verwendung eines Passstiftes bzw. einer Passfeder kann der Einsatz gegen Verdrehen gesichert werden. Die Verschraubung des Einsatzes ist meist ausreichend.

### Installation instruction - Anti-rotation locking system

The insert can be secured against inadvertent rotation by a parallel pin and key system. In most cases the gate insert is adequately secured by the bolt.

## Einbaubeispiel: Standard *Installation example: Standard*



### Technische Information

Die Vorderseite des Angießeinsatzes wird durch den Formeinsatz verschlossen.

- um Druckverlust zu verringern.
- um Freistrahlbildung zu vermeiden.

### Technical information

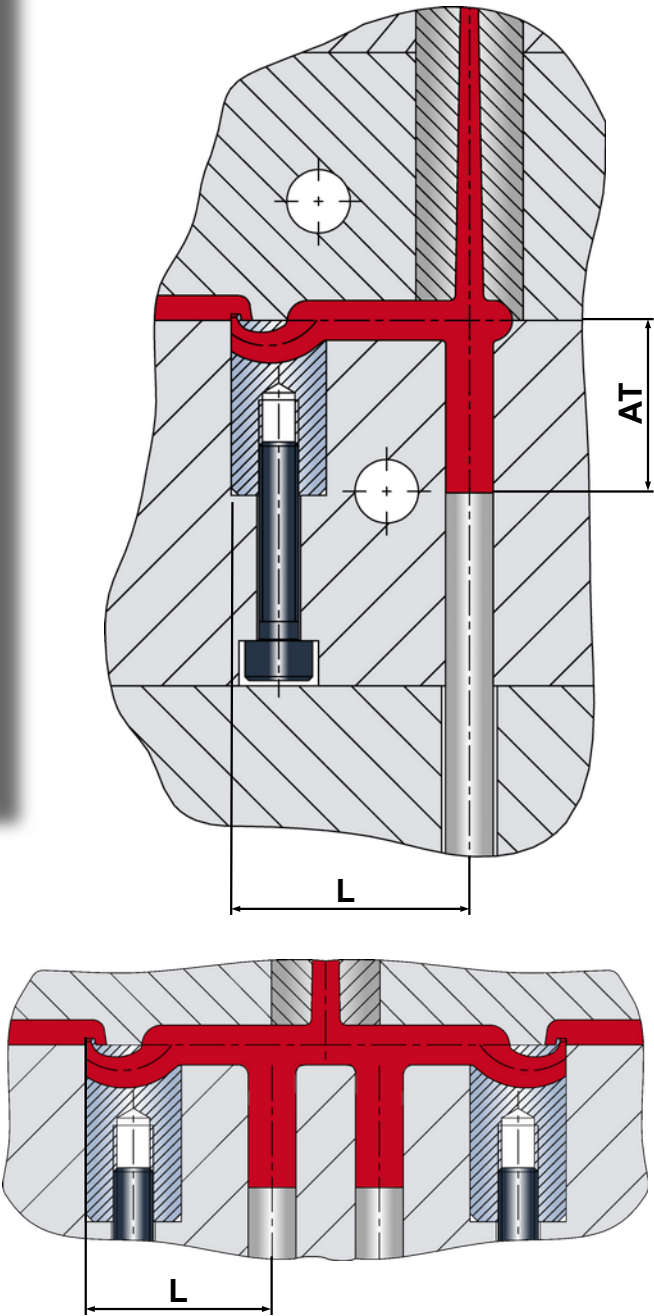
*The front of the gate insert is sealed Off by the mould cavity.*

- *to reduce pressure loss.*
- *to avoid jetting.*

Einbaumaße GTM GTR/GTE GTK

Installation dimensions GTM GTR/GTE GTK

| Kunststoffgruppe<br>Plastic group          | GTM                    | GTR/GTE                | GTK                    |
|--------------------------------------------|------------------------|------------------------|------------------------|
| HD-PE, LD-PE, PET, PP, PA, PC, PVC. (L)    | >15                    | >20                    | >25                    |
| Kanalausführung<br>Runner design           | rund<br>round          | rund<br>round          | rund<br>round          |
| Auswerfertiefe (AT)<br>Ejector depth (AT)  | >11                    | >16                    | >20                    |
| ABS, M ABS, ASA, PS, PC/ABS, POM, PBT. (L) | >20                    | >25                    | >30                    |
| Kanalausführung<br>Runner design           | rund<br>round          | rund<br>round          | rund<br>round          |
| Auswerfertiefe (AT)<br>Ejector depth (AT)  | >14                    | >20                    | >24                    |
| Elastomere TPE, TPU, TPP, TPA. (L)         | >15                    | >15                    | >20                    |
| Kanalausführung<br>Runner design           | beliebig<br>arbitrary  | beliebig<br>arbitrary  | beliebig<br>arbitrary  |
| Auswerfertiefe (AT)<br>Ejector depth (AT)  | >11                    | >11                    | >16                    |
| Spröde Kunststoffe (L)<br>Brittle plastics | >25                    | >30                    | >40                    |
| Kanalausführung<br>Runner design           | halbrund<br>half-round | halbrund<br>half-round | halbrund<br>half-round |
| Auswerfertiefe (AT)<br>Ejector depth (AT)  | >18                    | >24                    | >32                    |



Technische Information

Das Abstandsmaß „L“ beschreibt den von uns empfohlenen Abstand vom Anspritzpunkt bis zum Angussauswerfer.

Das Abstandsmaß „AT“ beschreibt die in Relation stehende Auswerfertiefe.

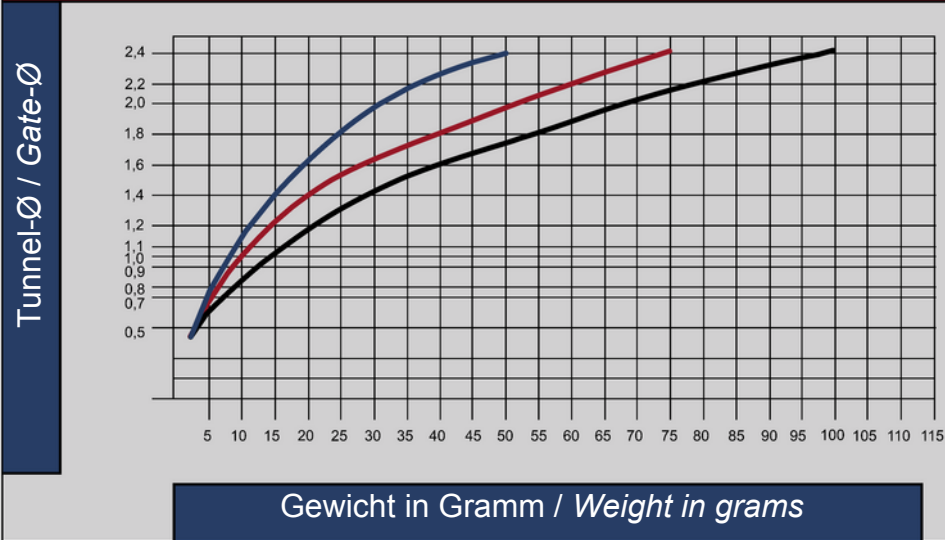
Technical information

Recommended distances "L" from the injection point to the sprue ejector are given above for the various material groups.

The distance "AT" describes the correlated ejector depth.

Viskositätstabelle Standard Einsätze  
Table of viscosity Standard Tunnel Gates

Viskositätstabelle - Table of viscosity



**Niedrige Viskosität**

**Low Viscosity**

(PA, PE, PC, PP, PET, PVC, PS, SB, TPA, TPE, TPU)



**Mittlere Viskosität**

**Medium Viscosity**

(ABS, ASA, PS, PC/ABS, PBT, SAN)



**Hohe Viskosität**

**High Viscosity**

(PC, PPS, PSU, POM-H, PES, PPO, PEI, PC-ABS, PC-PBT, PMMA, PVC)

