



Cashew Gate Inserts

S2 Series

- 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

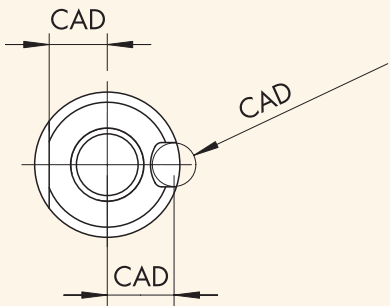


TGR



TGS

Anti-rotation locking possibility



| | 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 |
| MAXIMUM SHOT WEIGHT | | | | | |
| NV | 3 | 5 | 30 | 50 | 200 |
| MV | 2 | 4 | 20 | 35 | 120 |
| HV | 1 | 3 | 12 | 25 | 75 |

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



TGR12

• Actual Size •



TGS12

| TGR | Cat. No. | d | d1 | d2 | d3 | h | h1 | h2 | I1 | I2 | M | Series | HRC |
|-----|--------------|-----|-----|-----|------|------|-----|-----|----|------|----|--------|--|
| | TGR6 | 6 | 0,6 | 1,9 | 2,5 | 17,0 | 0,6 | 0,8 | 10 | 2,5 | 4 | S2 | Version U = 40 HRC* *(available while quantity lasts) Version H = 60 HRC |
| | TGR8 | 8 | 0,6 | 1,9 | 3 | 22,0 | 0,6 | 1,1 | 13 | 3,25 | 4 | S2 | |
| | TGR10 | 8 | 0,8 | 2,1 | 3 | 22,0 | 0,6 | 1,1 | 13 | 3,25 | 4 | S2 | |
| | | 10 | 0,8 | 2,2 | 4 | 22,0 | 0,8 | 1,2 | 12 | 4 | 5 | S2 | |
| | | 10 | 1,2 | 2,6 | 4 | 22,0 | 0,8 | 1,2 | 12 | 4 | 5 | S2 | |
| | | 10 | 1,6 | 3,0 | 4 | 22,0 | 0,8 | 1,2 | 12 | 4 | 5 | S2 | |
| | TGR12 | 12 | 1,2 | 2,6 | 5 | 22,0 | 0,8 | 1,4 | 11 | 5 | 5 | S2 | |
| | | 12 | 1,6 | 3,0 | 5 | 22,0 | 0,8 | 1,4 | 11 | 5 | 5 | S2 | |
| | | 12 | 2,0 | 3,4 | 5 | 22,0 | 0,8 | 1,4 | 11 | 5 | 5 | S2 | |
| | TGR14 | 14 | 1,6 | 3,0 | 6 | 22,0 | 0,8 | 1,6 | 10 | 6 | 6 | S2 | |
| | | 14 | 2,0 | 3,4 | 6 | 22,0 | 0,8 | 1,6 | 10 | 6 | 6 | S2 | |
| | | 14 | 2,4 | 3,8 | 6 | 22,0 | 0,8 | 1,6 | 10 | 6 | 6 | S2 | |
| | 14 | 2,8 | 4,2 | 6 | 22,0 | 0,8 | 1,6 | 10 | 6 | 6 | S2 | | |

| TGS | Cat. No. | b | b1 | d1 | d2 | d3 | h | h1 | h2 | I1 | I2 | M | Series | HRC |
|-----|--------------|----|----|-----|-----|----|------|-----|-----|----|------|---|--------|--|
| | TGS8 | 8 | 6 | 0,6 | 1,9 | 3 | 22,0 | 0,6 | 1,1 | 13 | 3,25 | 4 | S2 | Version U = 40 HRC* *(available while quantity lasts) Version H = 60 HRC |
| | | 8 | 6 | 0,8 | 2,1 | 3 | 22,0 | 0,6 | 1,1 | 13 | 3,25 | 4 | S2 | |
| | TGS10 | 10 | 8 | 0,8 | 2,2 | 4 | 22,0 | 0,8 | 1,2 | 12 | 4 | 5 | S2 | |
| | | 10 | 8 | 1,2 | 2,6 | 4 | 22,0 | 0,8 | 1,2 | 12 | 4 | 5 | S2 | |
| | | 10 | 8 | 1,6 | 3,0 | 4 | 22,0 | 0,8 | 1,2 | 12 | 4 | 5 | S2 | |
| | TGS12 | 12 | 10 | 1,2 | 2,6 | 5 | 22,0 | 0,8 | 1,4 | 11 | 5 | 5 | S2 | |
| | | 12 | 10 | 1,6 | 3,0 | 5 | 22,0 | 0,8 | 1,4 | 11 | 5 | 5 | S2 | |
| | | 12 | 10 | 2,0 | 3,4 | 5 | 22,0 | 0,8 | 1,4 | 11 | 5 | 5 | S2 | |
| | TGS14 | 14 | 12 | 1,6 | 3,0 | 6 | 22,0 | 0,8 | 1,6 | 10 | 6 | 6 | S2 | |
| | | 14 | 12 | 2,0 | 3,4 | 6 | 22,0 | 0,8 | 1,6 | 10 | 6 | 6 | S2 | |
| | | 14 | 12 | 2,4 | 3,8 | 6 | 22,0 | 0,8 | 1,6 | 10 | 6 | 6 | S2 | |
| | | 14 | 12 | 2,8 | 4,2 | 6 | 22,0 | 0,8 | 1,6 | 10 | 6 | 6 | S2 | |

CAD files available at:

To order — Cat. No.-d1-Series-HRC. Example: TGR6-06-S2-U





Cashew Gate Inserts

S2 Series

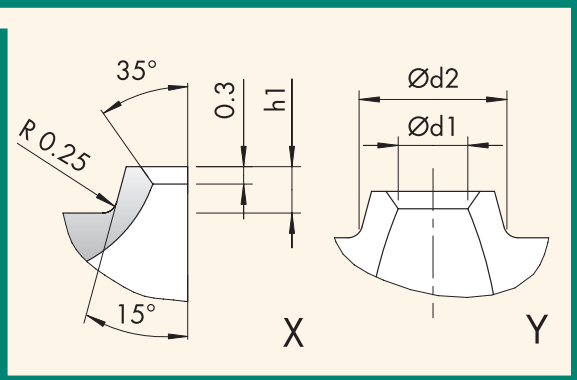
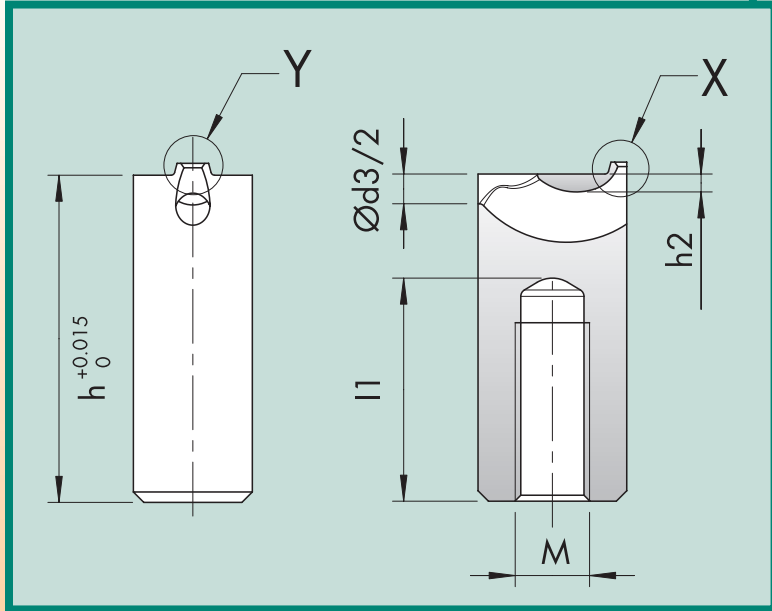


Table for distance L

| Part No. | Material Type | | | |
|------------|----------------|------------------|------------------------------|----------------------------|
| | TPE, TPU, etc. | PE, PP, PET etc. | PC/ABS, PA, POM, HI-PC, etc. | PA+GF, PC, SAN, PMMA, etc. |
| TGR 6 | 9-12 | 12-18 | 15-22 | 18-25 |
| TGR/TGS 8 | 11-14 | 15-22 | 19-27 | 23-30 |
| TGR/TGS 10 | 15-18 | 19-27 | 24-33 | 28-36 |
| TGR/TGS 12 | 18-22 | 22-30 | 27-36 | 32-40 |
| TGR/TGS 14 | 20-25 | 25-33 | 30-37 | 35-43 |

Recommendations

Companion Vestige

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.

Flat Parts

If the molded part is very thin, the calotte must be ground down. ($t1 > t/2$)

Thermoplastic elastomers (TPE)

- Low Shore hardness = shorter distance L
- Use centring pin
- Max. hardness 100 Shore A

TGR6, TGR8, TGS8
min Ø3,5