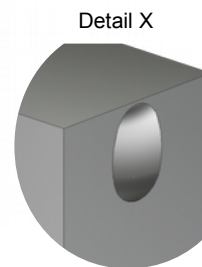
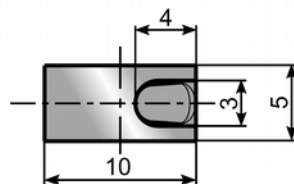
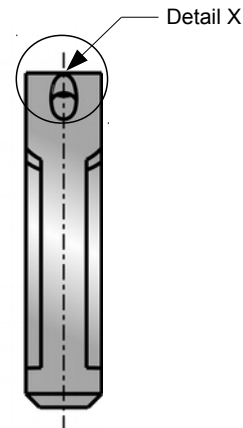
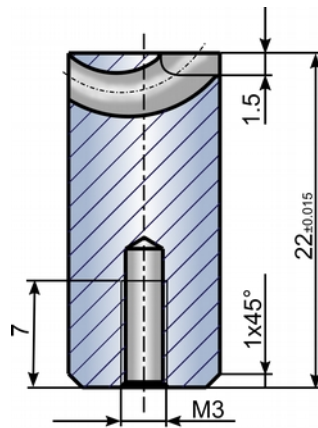
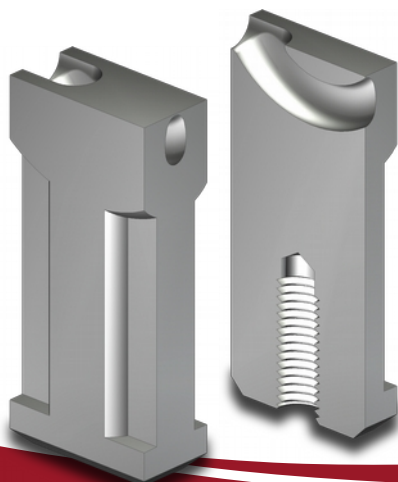


Miniflow® GTM - closed gate diameter



For tunnel gating of small, thin-walled moldings. This gate insert has a closed gate diameter and is therefore suitable for the use of low article weight and for very thin-walled moldings.

- The closed surface enables the creation of individual gate diameter.
- Usable for all thermoplastics including fillers up to 50 % glass fibre.

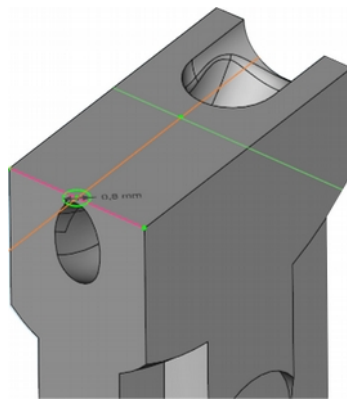


Dimensions: 10x5x22 mm
Material: 1.4028 (420W)
Hardness: 50+5 HRC Rockwell.

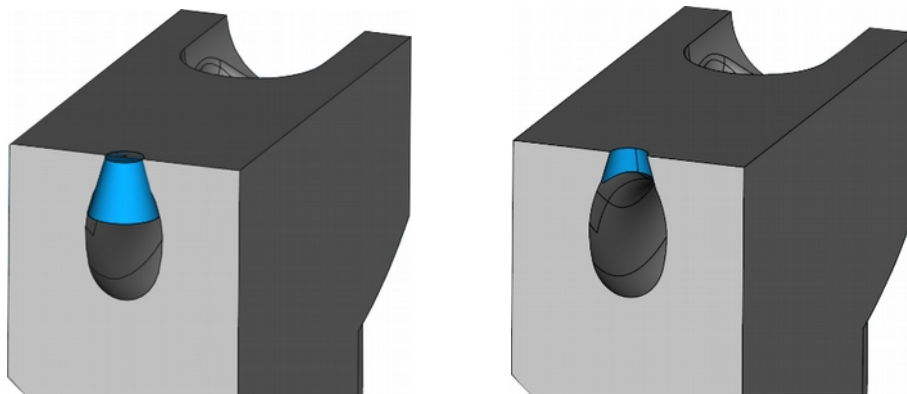
Miniflow® GTM - closed gate diameter

For the Miniflow type GTM without gate, we recommend the following procedure to insert the gate.

1. Create the gate in 3D-CAD. Draw a circle on the end face with the diameter or radius of the gate. The following figure shows a radius R0,8mm in green:



2. Extrude this sketch with max. possible angle of inclination, depending on gate size, or remove the material immediately by cutting the material incl. draft / taper angle:

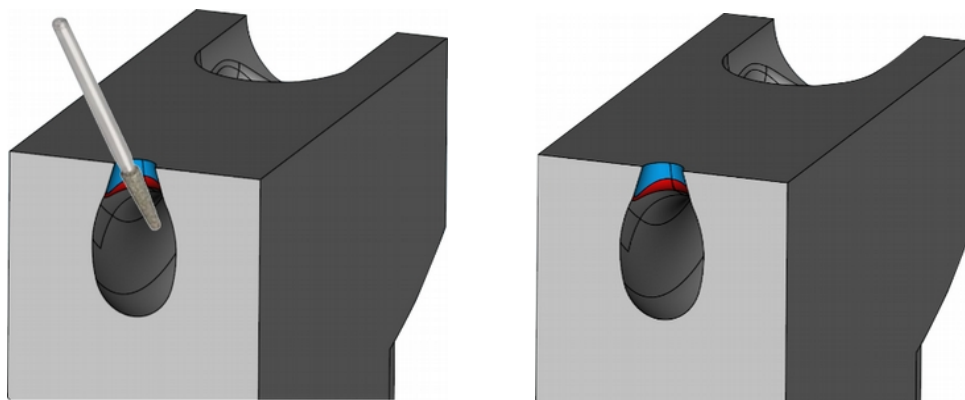


Abmessung: 10x5x22 mm
Werkstoff: 1.4028 (420W)
Härte: 50 + 5 HRC

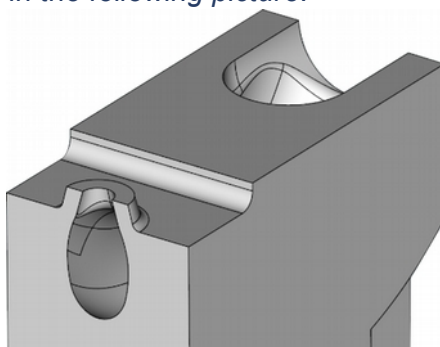
Miniflow® - GTM - closed gate diameter

Für den Miniflow Typ GTM ohne Anschnitt empfehlen wir folgende Vorgehensweise um den Anschnitt einzubringen.

3. *Well round off the sharp edge between the bent tunnel and the gate, e.g. by hand using a diamond mounted point:*



4. *Around the gate you can adjust the GTM Miniflow to the contour and leave a calotte standing, as shown in the following picture:*



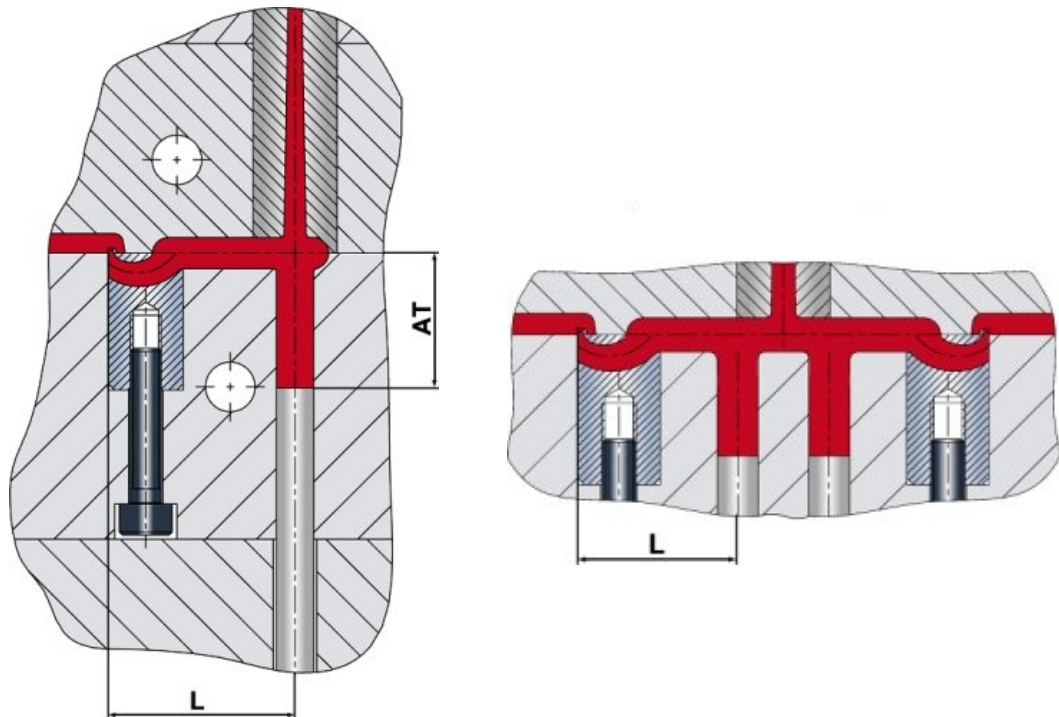
Article No.	Gate Ø in mm	Max. shot weight grams		
		High	Medium	Low
GTM-closed gate diameter	0,5	4	4	3
	0,7	6	5	4
	0,9	12	9	7
	1,1	17	14	9

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Miniflow[®] GTM - closed gate diameter



Plastic Group	Runner Design	L	AT
HD-PE, LD-PE, PET, PP, PA, PC, PVC	round	>15	>11
ABS, M ABS, ASA, PS, PC/ABS, POM, PBT	round	>20	>14
Elastomer TPE, TPU, TPP, TPA	arbitrary	>15	>11
Brittle Plastics	half-round	>25	>18

Resin flow type	Materials
High Viscosity	PA, PE, PC, PP, PET, PVC, PS, SB, TPA, TPE, TPU
Medium Viscosity	ABS, ASA, PS, PC/ABS, PBT, SAN
Low Viscosity	PC, PPS, PSU, POM-H, PES, PPO, PEI, PC-ABS, PC-PBT, PMMA, PVC

» wir haben den Bogen raus...