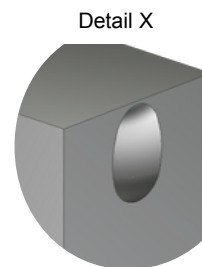
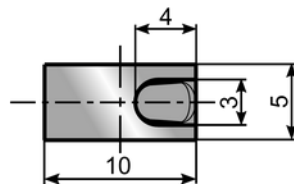
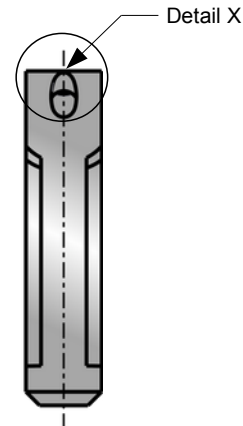
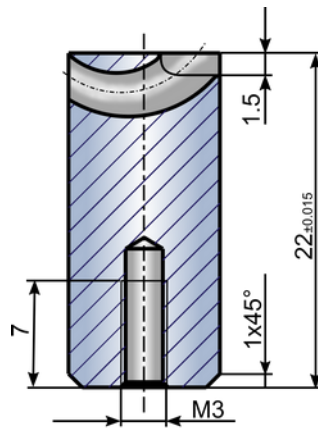


Miniflow® GTM - closed gate diameter



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.

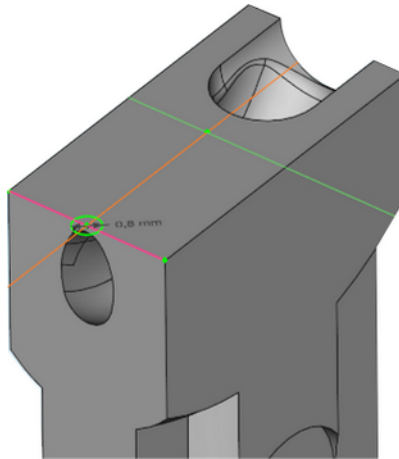


Dimensions: 10x5x22 mm
Material: 1.4028 (420W)
Hardness: 50+5 HRC Rockwell.

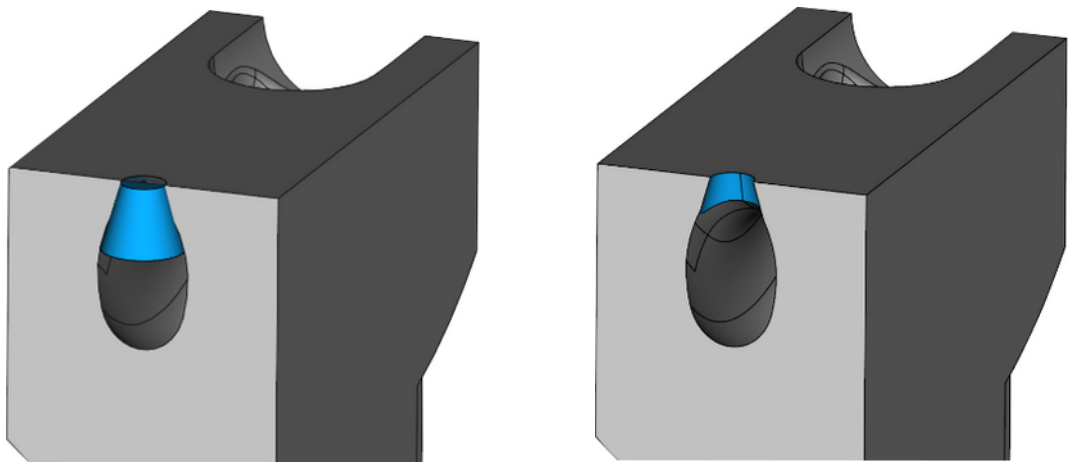
Miniflow® GTM - closed gate diameter

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:

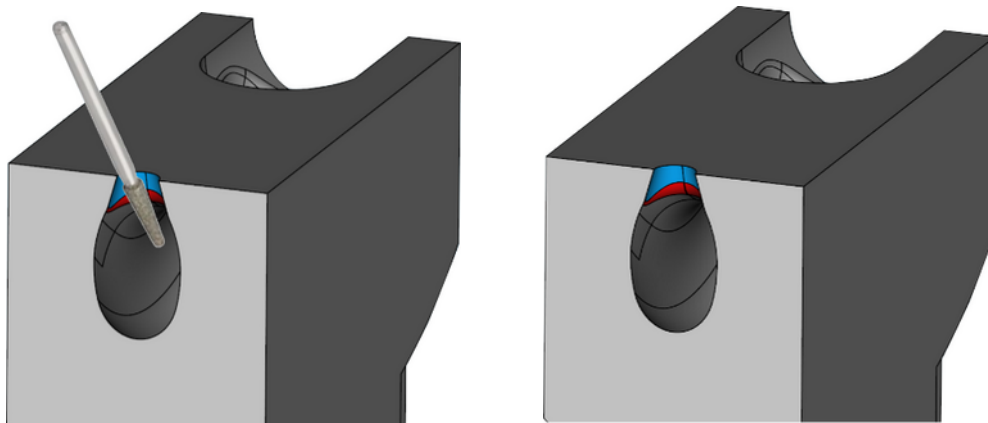


Abmessung: 10x5x22 mm
Werkstoff: 1.4028 (420W)
Härte: 50 + 5 HRC

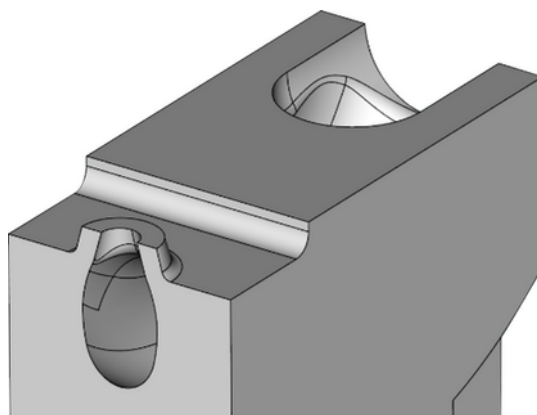
Miniflow® - GTM - closed gate diameter

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

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:



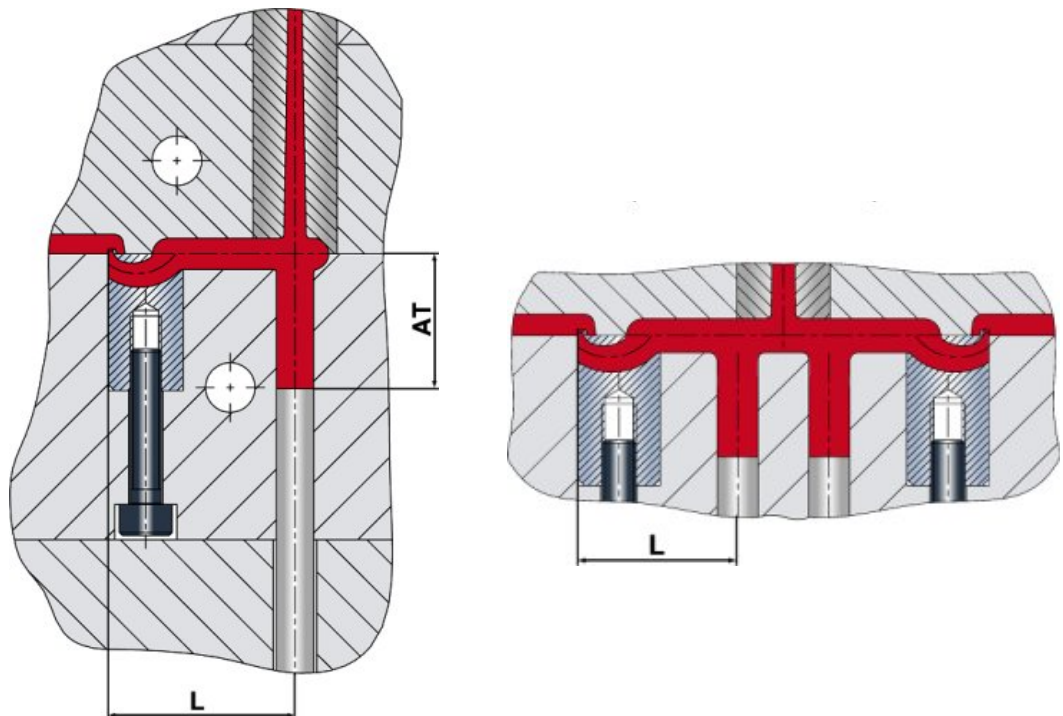
Article No.	Gate Ø in mm	Max. shot weight grams		
		High-Flowability	Medium-Flowability	Low-Flowability
GTM-closed gate diameter	0,3	3	3	2
	0,5	4	4	3
	0,7	6	5	4
	0,9	12	9	7
	1,1	17	14	9
	1,4	25	20	15

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 64823 Groß-Umstadt

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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...