

Medium Gate-Mate®

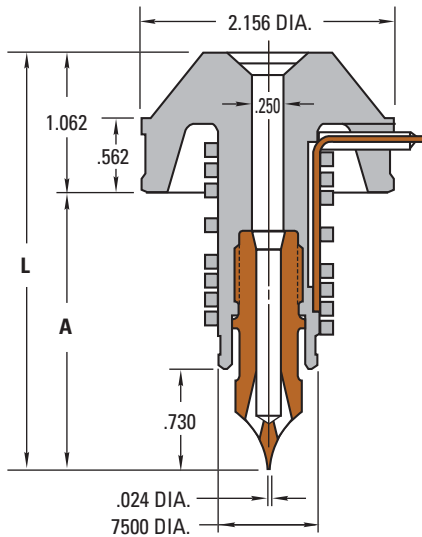
The Medium Gate-Mate Bushing is designed for direct part gating in single cavity molds, eliminating the conventional cold sprue. The unique design of the bushing provides minimal gate vestige, without the objectionable witness lines so commonly found on direct gated parts.

The bushing transfers molten plastics from the machine nozzle to the mold cavity via a direct channel in the body. The bushing, in conjunction with the recommended tip and gate configuration, controls gate vestige height.

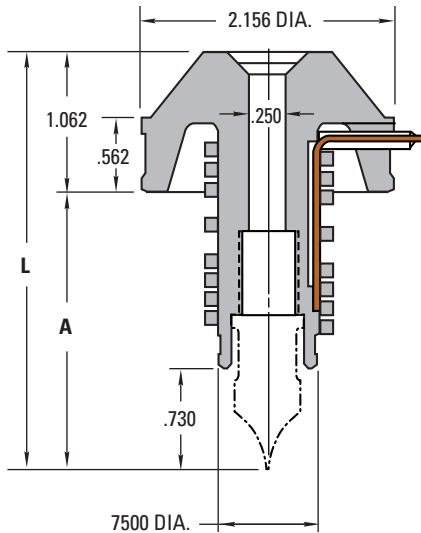
The Medium Gate-Mate Bushing utilizes an advanced design square coil heater and an independent thermocouple, strategically located for precise temperature control.



Bushing Assembly



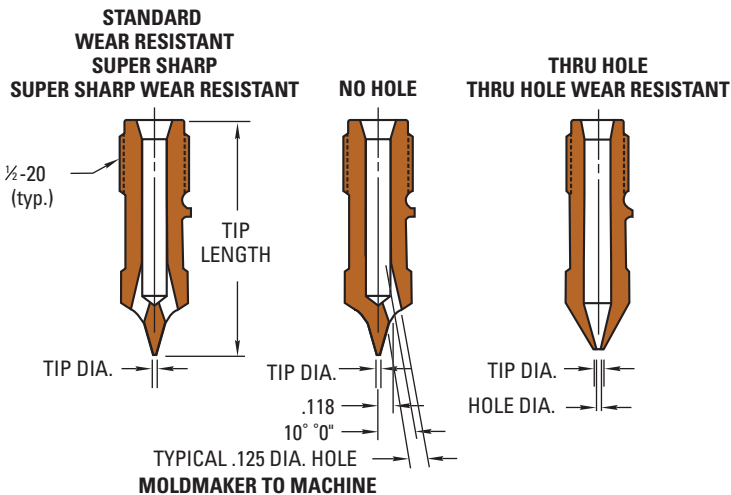
Bushing Sub-Assembly



BUSHING ASSEMBLY (INCLUDES GMT2 TIP)			
ITEM NUMBER	A	L	DUAL SPH. RAD.
GMB5232	2.375	3.437	1/2 & 3/4
GMB5332	3.375	4.437	

BUSHING SUB-ASSEMBLY (ORDER TIP SEPARATELY)			
ITEM NUMBER	A	L	DUAL SPH. RAD.
GMB0020	2.375	3.437	1/2 & 3/4
GMB0030	3.375	4.437	

Gate-Mate® 4 Tips



TIP STYLE	TIP ITEM NUMBER	O DIA.	TIP LENGTH	TIP DIA.	HOLE DIA.
STANDARD	GMT2	.044 MIN.	1.730	.024	N/A
WEAR RESISTANT	GMT0400	.055 MIN.			
SUPER SHARP	GMT0301	.030 MIN.			
SUPER SHARP WEAR RESISTANT	GMT0401	.055 MIN.	1.690	.010	.050
THRU HOLE	GMT0302*	.030 MIN. .050 MAX			
THRU HOLE WEAR RESISTANT	GMT0402*	.055 MIN.	1.730	.024	N/A
NO HOLE	GMT0303	.044 MIN.			

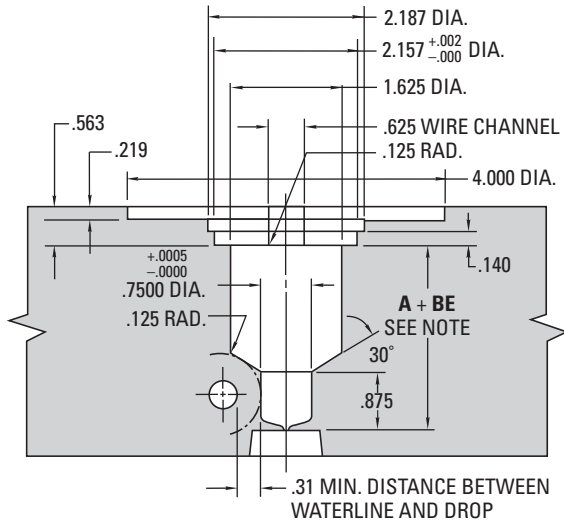
NOTES:

1. Thru-hole tip is designed .040 shorter in length to be a direct replacement for the standard tip; use a .030 to .060 diameter gate
2. A .030 minimum diameter gate is recommended when using the super sharp tip
3. Contact DME for tip recommendations and assistance with your application

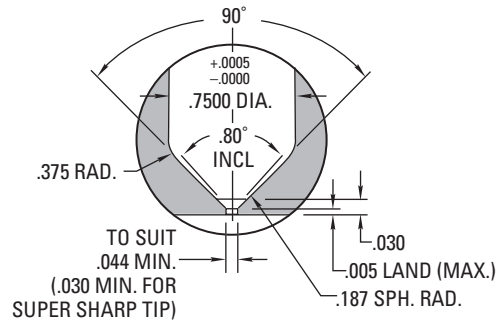
*Contact DME for details to modify thru-hole tips for larger "O" diameters.

Medium Gate-Mate® Machining Dimensions

Machining Dimensions for Bushings



Improved tip insulation, elimination of material degradation in threaded area of tip, and faster color changes can be achieved through use of a Gate Shell Insulator.



NOTE:

The expansion factor must be taken into consideration prior to machining for, and installing bushing. This factor (BE) must then be added to the nominal A dimension. Formula for determining this expansion is as follows: BE = "A" dimension x 0.00000633 x nozzle set point - 68°F (assuming the mold is at 68°F during operation). If mold temperature is different, substitute 68°F with actual mold temperature.

EXAMPLE:

Given a 2.375 inch A dimension, with a Bushing Set Point temp. of 500°F:
 $BE = 2.375 \times 0.000063 \times (500 - 68) = .006$ thus A + BE will be 2.381.

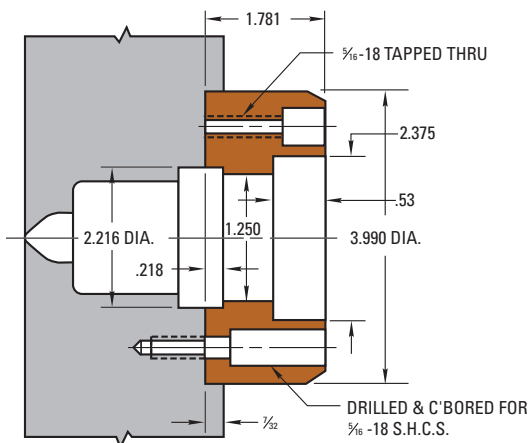
Please note that the above information is given as an example. Variations may occur based on mold configurations and cooling factor. In some instances, it may be necessary to obtain an empirical factor.

ITEM NUMBER REFERENCE		A
BUSHING ASSEMBLY	BUSHING SUB-ASSEMBLY	
GMB5232	GMB0020	2.375
GMB5332	GMB0030	3.375

Replacement Parts

ITEM NUMBER REFERENCE		SQUARE COIL HEATERS (240 VAC)			THERMOCOUPLE (TYPE J, 36" LEADS)	
BUSHING ASSEMBLY	BUSHING SUB-ASSEMBLY	ITEM NUMBER	WATTS	LENGTH	ITEM NUMBER	LENGTH
GMB5232	GMB0020	SCH3142	315	1.70	TC9600	1.35
GMB5332	GMB0030	SCH3242	315	2.70	TC9700	2.35

Medium Gate-Mate Locating Ring



ITEM NUMBER
6545

NOTES:

- Two (2) 5/16 - 18 S.H.C.S. are included with Locating Ring
- Two (2) Drilled and C'bored holes for 5/16 - 18 S.H.C.S. are on a 1.656 circle radius in Locating Ring
- C'bore depth in Top Clamp Plate and C'bore depth in Locating Ring can be altered to suit application