

To achieve optimal alignment when using Coiled Pins, two primary design elements must be adhered to:

- 1) The hole diameters in the host and mating component must be correctly sized to achieve the desired interference and accuracy of alignment.
- 2) The engagement length of the Coiled Pin in the component providing primary retention must be no less than 60% of the pin's overall length. The remaining protruding length will align with the mating component. Increasing the initial length of engagement is recommended in thru-hole applications; however, the Coiled Pin still has to protrude in order to align the mating component. (Figure 1)

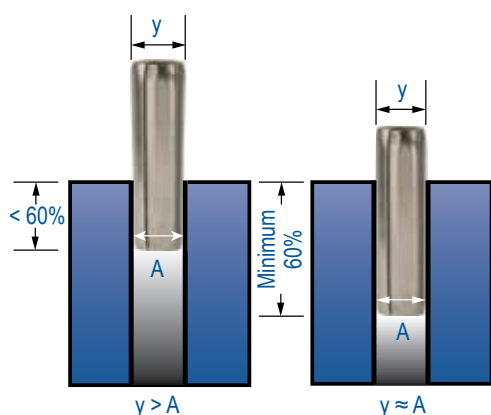


Figure 1: This diagram demonstrates proper installation depth. When a Coiled Pin is installed less than 60% of its overall length two conditions may occur:

- (y) or the free end diameter will not be properly controlled creating inconsistent 'fit' when parts are mated downstream in the production process.
- The pin may not maintain position in the component in which it is intended to be retained during future disassembly. This is of greatest importance when multiple alignment pins are utilized between components.

### Interference fit for maximum alignment accuracy:

Coiled Pins are functional springs that conform to the holes into which they are installed. The assembly force to achieve maximum accuracy in alignment should not exceed a 'light' press to seat mating components. Depending upon the Coiled Pin's duty, quantity of alignment pins, and host material, this may be as little as a tap with the palm of a hand or a mallet. An interference fit must not be confused with that of a traditional Solid Dowel which typically requires seating with pneumatic or hydraulic presses. This is a primary benefit of the Coiled Pin.

To ensure a light press fit, ideally, the hole size in both the host and mating components should be precision matched within the recommended tolerance range. This may not be practical if holes are not drilled together as an assembly.

In situations where holes cannot be precision matched or where the cost of honing/reaming is prohibitive, a significant benefit of the Coiled Pin is its ability to compensate for larger hole tolerances. The recommended tolerance range may be divided between components as demonstrated in Figure 2. (Note: Utilizing less of the allowable manufacturing tolerance will further improve the fit and alignment of the assembly.)

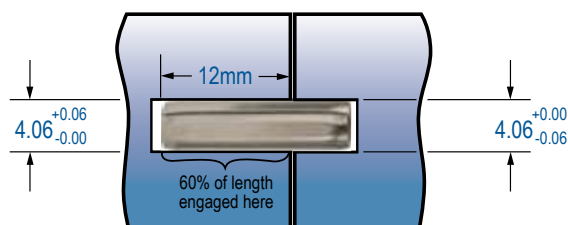


Figure 2: Recommended hole size and pin depth for interference fit of CLDP 4 x 20 LBK

Assigning the larger tolerance to the 60% retention location ensures interference between the free end of the pin and the opposing hole that is prepared at the lower half of the tolerance. Where there is interference there is no clearance, thus ensuring proper projection of the primary hole's position.

## Clearance fit for course alignment and ease of assembly:

If a clearance fit over the pin is desired for ease of assembly, it will be necessary to compensate for spring recovery at the pin's free end. To determine the maximum diameter of the free end of the pin, install the pin to 60% of the pin's length into the maximum hole size of the primary retention host and measure the exposed diameter. A 0.025mm (.001") to 0.05mm (.002") clearance factor should be added to the free end of the pin depending upon desired alignment accuracy. (Figure 3)

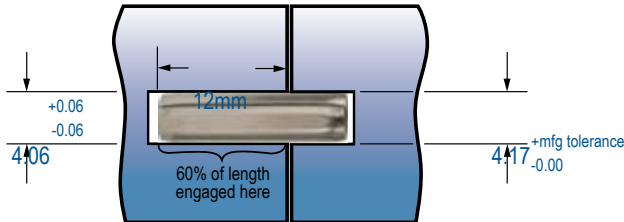


Figure 3: Recommended hole size for clearance fit with CLDP 4 x 20 LBK

When used as a free fit alignment dowel, assembly force is not a consideration; although it is important to note that consideration should be given to using the Coiled Pin as an interference fit solution. As outlined above, Coiled Pins provide the benefit of a zero clearance fit without the added complexity of high insertion force.



Coiled Pins are often used for alignment. They are available in heavy, standard, and light duty to suit different host materials and application requirements.

## Selecting the Appropriate Duty for Alignment:

The Coiled Pin is available in three "duties" to enable the designer to choose the optimum combination of strength, flexibility and diameter to suit different host materials and application requirements. Light duty pins are recommended for soft (aluminum, plastic), brittle (ceramic) or thin materials and where holes are close to an edge. In most alignment applications, the pins are not typically subjected to significant loads. In these instances, light duty pins are often used since installation is easy as a result of lower insertion forces. Standard duty pins were designed for use in nonferrous and mild steel components. Heavy duty pins should only be used in hardened materials where space or design limitations rule out a larger diameter standard duty pin.

Although this article offers general design guidelines, it is recommended that Application Engineers who specialize in fastening and joining be consulted to ensure the components are properly designed and the proper Coiled Pin is selected for each specific assembly.

e-mail: [info-uk@spirol.com](mailto:info-uk@spirol.com)

## Technical Centres

### Europe

**SPIROL United Kingdom**  
17 Princeswood Road  
Corby, Northants  
NN17 4ET United Kingdom  
Tel. +44 1536 444800  
Fax. +44 1536 203415

**SPIROL France**  
Cité de l'Automobile ZAC Croix Blandin  
18 Rue Léna Bernstein  
51100 Reims, France  
Tel. +33 3 26 36 31 42  
Fax. +33 3 26 09 19 76

**SPIROL Germany**  
Ottostr. 4  
80333 Munich, Germany  
Tel. +49 89 4 111 905 71  
Fax. +49 89 4 111 905 72

**SPIROL Spain**  
08940 Cornellà de Llobregat  
Barcelona, Spain  
Tel. +34 93 193 05 32  
Fax. +34 93 193 25 43

**SPIROL Czech Republic**  
Sokola Tůmy 743/16  
Ostrava-Mariánské Hory 70900  
Czech Republic  
Tel/Fax. +420 417 537 979

**SPIROL Poland**  
ul. M. Skłodowskiej-Curie 7E / 2  
56-400, Oleśnica, Poland  
Tel. +48 71 399 44 55

### Americas

**SPIROL International Corporation**  
30 Rock Avenue  
Danielson, Connecticut 06239 U.S.A.  
Tel. +1 860 774 8571  
Fax. +1 860 774 2048

**SPIROL Shim Division**  
321 Remington Road  
Stow, Ohio 44224 U.S.A.  
Tel. +1 330 920 3655  
Fax. +1 330 920 3659

**SPIROL West**  
1950 Compton Avenue, Suite 112  
Corona, California 92881 U.S.A.  
Tel. +1 951 273 5900  
Fax. +1 951 273 5907

**SPIROL Canada**  
3103 St. Etienne Boulevard  
Windsor, Ontario N8W 5B1 Canada  
Tel. +1 519 974 3334  
Fax. +1 519 974 6550

**SPIROL Mexico**  
Carretera a Laredo KM 16.5 Interior E  
Col. Moisés Saenz  
Apodaca, N.L. 66613 Mexico  
Tel. +52 81 8385 4390  
Fax. +52 81 8385 4391

**SPIROL Brazil**  
Rua Mafalda Barnabé Soliane, 134  
Comercial Vitória Martini, Distrito Industrial  
CEP 13347-610, Indaiatuba, SP, Brazil  
Tel. +55 19 3936 2701  
Fax. +55 19 3936 7121

### Asia Pacific

**SPIROL Asia Headquarters**  
1st Floor, Building 22, Plot D9, District D  
No. 122 HeDan Road  
Wai Gao Qiao Free Trade Zone  
Shanghai, China 200131  
Tel. +86 21 5046 1451  
Fax. +86 21 5046 1540

**SPIROL Korea**  
160-5 Seokchon-Dong  
Songpa-gu, Seoul, 138-844, Korea  
Tel. +86 21 5046-1451  
Fax. +86 21 5046-1540