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WHITE PAPER

How To Properly Mate Compression Limiters and Threaded Inserts in Plastic Assemblies

by Christie L. Jones, Market Development Manager
SPIROL International Corporation, U.S.A.

In applications where the mating component is also plastic, a Compression Limiter is necessary to avoid the creep or stress relaxation in the mating component from reducing the frictional load in the threaded joint.

Similar to Threaded Inserts, Compression Limiters are used to ensure bolted joint integrity in plastic assemblies. As the bolt is tightened to achieve the required friction between threads, the plastic is compressed. The Compression Limiter absorbs the force generated during tightening of the bolt, and isolates the plastic from excessive compressive loads. Without the Compression Limiter, plastic will creep resulting in the loosening and eventual failure of the joint. The Compression Limiter ensures that the joint remains intact throughout the life of the product.

In order for the Compression Limiter to work properly, it should abut the Insert so that the Insert, and not the plastic, carries the load. The ID of the Compression Limiter in the mating component must be larger than the outside diameter of the assembly screw, but smaller than the pilot or face diameter of the Insert to avoid “jack-out”.

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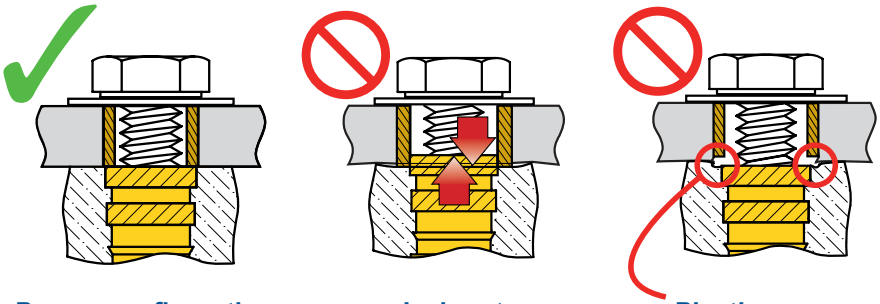

Proper configuration **Jack-out** **Plastic creep**

SPIROL offers three different styles of standard Compression Limiters enabling the most cost effective component to be chosen for each particular assembly depending on performance requirements and installation method.

Series CL220, CL200 and CL350

Series CL400 and CL460

Series CL500

Series CL600 and CL601

Series CL800 and CL801

SPIROL® Series 20, 30 and 51 Inserts
for Plastic Assemblies

SPIROL® Series 14, 19, 63 and 65 Inserts
for Plastic Assemblies

Headed Inserts – **SPIROL** Series 20, 30 and 51 are designed to increase the contact surface for the Compression Limiters. In addition, **SPIROL** Series 14, 19, 63 and 65 generally have adequate surface area. In any event, at the design stage proper contact needs to be evaluated.

If the pilot diameter of the Insert being used is too small for the inside diameter of the Compression Limiter, then a special Compression Limiter with reduced clearance between the assembly screw may resolve the problem. This of course also reduces permissible misalignment.

If the surface area of the Insert is inadequate for proper contact with the Compression Limiter, then the only solution is using a plastic in the mating component that has good anti-creep characteristics and using a Compression Limiter with maximum wall thickness for better distribution of the load. Jack-out in these situations will be a concern and needs to be addressed with avoiding over-torquing the assembly screw.

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Technical Centers

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

SPIROL Mexico
Avenida Avante #250
Parque Industrial Avante Apodaca
Apodaca, N.L. 66607 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

Europe

SPIROL United Kingdom
17 Princewood Road
Corby, Northants
NN17 4ET United Kingdom
Tel: +44 (0) 1536 444800
Fax: +44 (0) 1536 203415

SPIROL France
Cité de l'Automobile ZAC Croix Blandin
18 Rue Léna Bernstein
51100 Reims, France
Tel: +33 (0) 3 26 36 31 42
Fax: +33 (0) 3 26 09 19 76

SPIROL Germany
Ottostr. 4
80333 Munich, Germany
Tel: +49 (0) 89 4 111 905 71
Fax: +49 (0) 89 4 111 905 72

SPIROL Spain
Plantes 3 i 4
Gran Via de Carles III, 84
08028, Barcelona, Spain
Tel/Fax: +34 932 71 64 28

SPIROL Czech Republic
Pražská 1847
274 01 Slaný
Czech Republic
Tel/Fax: +420 313 562 283

SPIROL Poland
ul. Solec 38 lok. 10
00-394, Warszaw, Poland
Tel. +48 510 039 345

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 (0) 21 5046-1451
Fax: +86 (0) 21 5046-1540

SPIROL Korea
16th Floor, 396 Seocho-daero,
Seocho-gu, Seoul, 06619, South Korea
Tel: +82 (0) 10 9429 1451

e-mail: **info@spirol.com**

SPIROL.com