

**Threaded Inserts for Plastics** allow designers to replace machined and cast metal components with plastic to achieve significant cost and weight savings while maintaining bolted joint strength – provided that:

1. the proper Insert is selected for the application requirements,
2. the Insert is properly installed into the hole, and
3. the hole in which the Insert is used is designed correctly given the plastic composition, the selected Insert and installation method.

Inserts also provide reusable threads and secure tight threaded joints. Given that Threaded Inserts are generally twice the diameter of screws, the load carrying ability of a joint that uses Inserts is increased by approximately four times the amount as when screws alone are used. Pull-out resistance can be further increased by increasing the length of the Inserts.

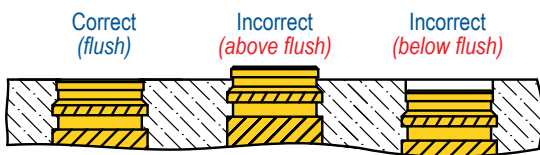
Retention within the hole is provided by the plastic conforming to the external features of the Insert. A sufficient volume of plastic must be displaced to entirely fill these external features so that the Insert achieves maximum performance when the plastic solidifies.

This White Paper focuses on the design guidelines for the holes in plastic assemblies that use Threaded Inserts installed by heat or ultrasonic equipment to ensure maximum performance is achieved.

### Optimum Design Guidelines:

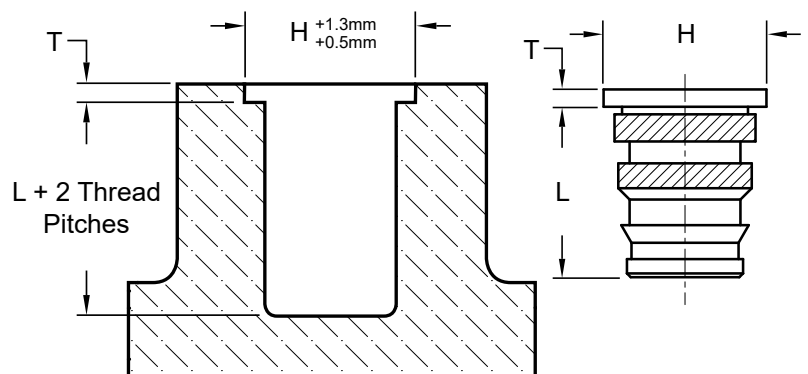
**Holes** for Inserts installed by heat or ultrasonics should always be deeper than the length of the Insert. The assembly screw should never bottom out in the hole as jack-out would result. The recommended minimum hole depth is the Insert length plus two (2) thread pitches.

The top of the installed Insert should be flush with the surface of the plastic part with maximum protrusion from the host of 0.13mm (.005”).



Top of the Insert should be installed as close to flush as possible with the surface of the plastic.

**Counterbores** are only recommended for Headed Inserts so that the top of the Insert will be flush with the surface of the plastic after installation. The diameter of the counterbore should be 0.5mm (.02”) to 1.3mm (.05”) larger than the head diameter of the Insert. The minimum counterbore depth should be specified as the thickness of the head.



**Correct hole size** is critical. Larger holes decrease performance, while smaller holes induce undesirable stresses and potential cracks in the plastic. Undersized holes may also result in flash at the hole edge and make the Insert difficult to install.

SPIROL provides the recommended hole sizes for each Insert style in the Inserts for Plastics Design Guide. The recommended holes need to be reviewed if glass / mineral fillers are used. If the filler content is equal to or greater than 15%, it is suggested to increase the hole 0.08mm (.003”), and if the content is equal to or greater than 35%, the suggested hole increase is 0.15mm (.006”). For intermediate contents interpolation is suggested.

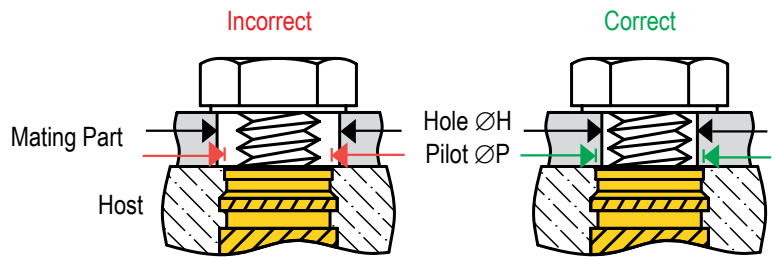
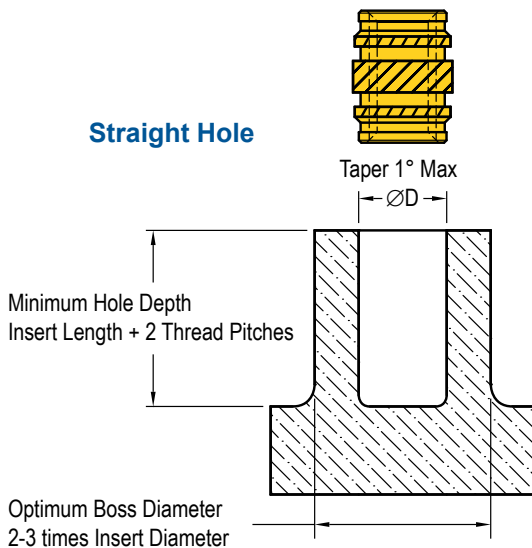
For straight holes, the taper should not exceed 1° included angle. Tapered holes should have an 8° included angle. Only straight Inserts should be used in straight holes, and only tapered Inserts should be used in tapered holes.

**Moulded holes** are preferred over drilled holes. The strong, denser surface of the moulded hole increases performance. Core pins should be large enough to allow for shrinkage.

Insert performance is affected by the plastic boss and/or wall thickness surrounding the Insert. Generally, the **optimum wall thickness** or **boss diameter of the plastic** is two (2) to three (3) times the Insert diameter with the relative multiplier decreasing as the Insert diameter increases. The wall thickness has to be enough to avoid bulging during installation, and strong enough to withstand the recommended installation torque of the screw. Poor knit lines will cause failures and reduced Insert performance. Ribs can be added to the boss for added strength.

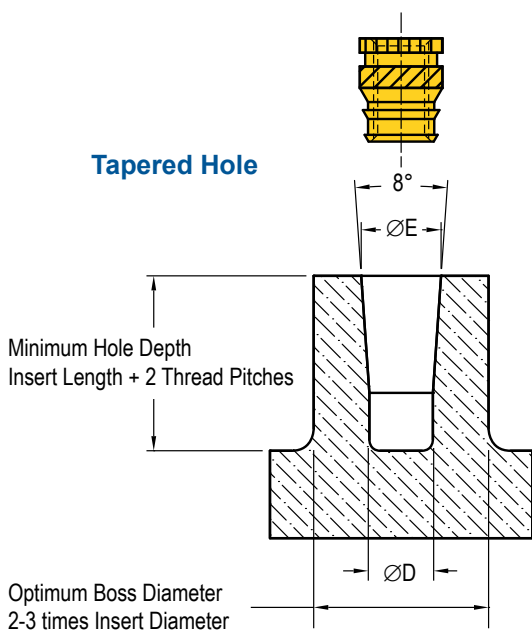
**The diameter of the clearance hole in the mating component is very important.** The Insert, and not the plastic, must carry the load. The hole in the mating component must be larger than the outside diameter of the assembly screw, but smaller than the pilot or face diameter of the Insert. This prevents jack-out. If a larger hole in the mating component is required for alignment purposes, a Headed Insert should be considered.

### Straight Hole



Hole in mating part must be smaller than Insert pilot diameter in host to prevent the Insert from pulling through the assembly – known as “jack-out”.

### Tapered Hole



*Given the variety of different plastics and fillers and combinations thereof, consultation with SPIROL Engineering is strongly recommended for each application.*

**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**  
Cit  de l'Automobile ZAC Croix Blandin  
18 Rue L na 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**  
Pra sk  1847  
274 01 Slan y  
Czech Republic  
Tel/Fax: +420 313 562 283

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

**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 Barnab  Soliane, 134  
Comercial Vit ria 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 (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-uk@spirol.com](mailto:info-uk@spirol.com)

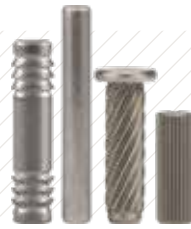
**SPIROL.co.uk**



Coiled Spring Pins



Slotted Spring Pins



Solid Pins



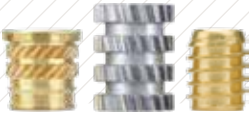
Alignment Dowels /  
Bushings



Spacers & Rolled  
Tubular Components



Compression  
Limiters



Threaded Inserts  
for Plastics



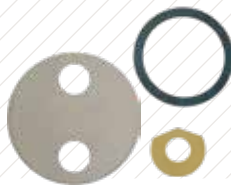
Railroad Nuts



Disc Springs



Precision Shims &  
Thin Metal Stampings



Precision Washers



Parts Feeding  
Technology



Pin Installation  
Technology



Insert Installation  
Technology



Compression Limiter  
Installation Technology

Please refer to [www.SPIROL.co.uk](http://www.SPIROL.co.uk) for current specifications and standard product offerings.

SPIROL offers complimentary Application Engineering support! We will assist on new designs as well as help resolve issues, and recommend cost savings on existing designs. Let us help by visiting **Application Engineering Services** on [SPIROL.co.uk](http://SPIROL.co.uk).