

PLASTIC ASSEMBLY SYSTEMS

SPIN WELDING JOINT DESIGN

T = Wall Thickness

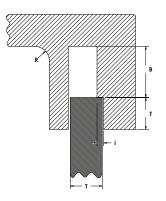
 $B = \sim 1.5 \times T$

C = Clearance ~ 0.005"

R = Radius ~ 0.050"

L = Lead-in (0.020 to 0.040")

i = Interference (0.010 to 0.020")



FLANGED SHEAR JOINT DESIGN

T = Wall Thickness

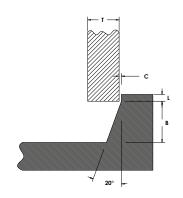
B = ~1.5 x T

C = Clearance ~ 0.005"

R = Radius ~ 0.050"

L = Lead-in (0.020 to 0.040")

i = Interference (0.010 to 0.020")



SHEAR JOINT DESIGN FOR NYLON

T = Wall Thickness

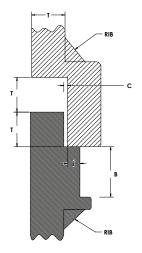
 $B = \sim 1.5 \times T$

C = Clearance ~ 0.005"

R = Radius ~ 0.050"

L = Lead-in (0.020 to 0.040")

i = Interference (0.010 to 0.020")



SHEAR JOINT DESIGN

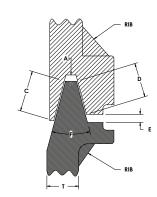
T = Wall Thickness

F = 30° minimum

A = Depth of weld $\sim 0.5 \times T$ to $0.8 \times T$

D = Weld surface $\sim 2.5 \times T$

E = A + 0.010"



TONGUE & GROOVE JOINT

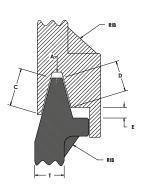
T = Wall Thickness

F = 30° minimum

A = Depth of weld $\sim 0.5 \times T$ to $0.8 \times T$

D = Weld surface $\sim 2.5 \times T$

E = A + 0.010"



TONGUE & GROOVE JOINT WITH EXTERNAL SKIRT

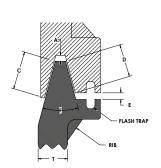
T = Wall Thickness

F = 30 ° minimum

A = Depth of weld $\sim 0.5 \times T$ to $0.8 \times T$

D = Weld surface $\sim 2.5 \times T$

E = A + 0.010"



TONGUE & GROOVE JOINT WITH FLASH TRAP