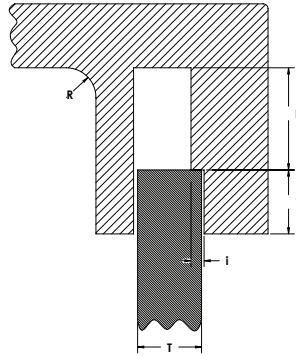


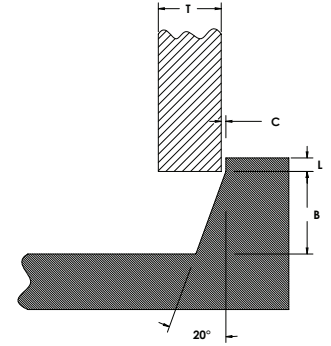
## SPIN WELDING JOINT DESIGN

**T = Wall Thickness**  
**B =  $\sim 1.5 \times T$**   
**C = Clearance  $\sim 0.005''$**   
**R = Radius  $\sim 0.050''$**   
**L = Lead-in (0.020 to 0.040'')**  
**i = Interference (0.010 to 0.020'')**



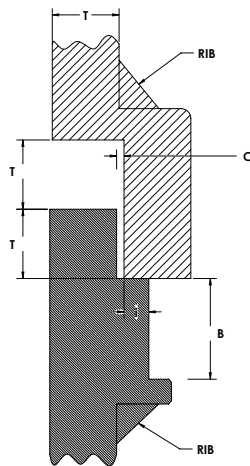
**FLANGED SHEAR JOINT DESIGN**

**T = Wall Thickness**  
**B =  $\sim 1.5 \times T$**   
**C = Clearance  $\sim 0.005''$**   
**R = Radius  $\sim 0.050''$**   
**L = Lead-in (0.020 to 0.040'')**  
**i = Interference (0.010 to 0.020'')**



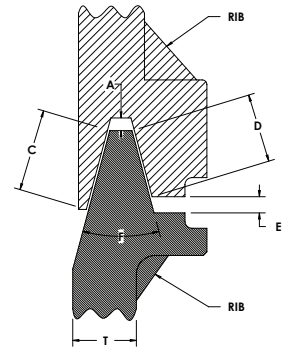
**SHEAR JOINT DESIGN FOR NYLON**

**T = Wall Thickness**  
**B =  $\sim 1.5 \times T$**   
**C = Clearance  $\sim 0.005''$**   
**R = Radius  $\sim 0.050''$**   
**L = Lead-in (0.020 to 0.040'')**  
**i = Interference (0.010 to 0.020'')**



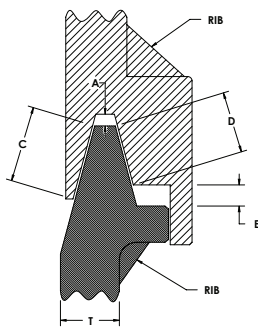
**SHEAR JOINT DESIGN**

**T = Wall Thickness**  
**F =  $30^\circ$  minimum**  
**A = Depth of weld  $\sim 0.5 \times T$  to  $0.8 \times T$**   
**D = Weld surface  $\sim 2.5 \times T$**   
**E =  $A + 0.010''$**



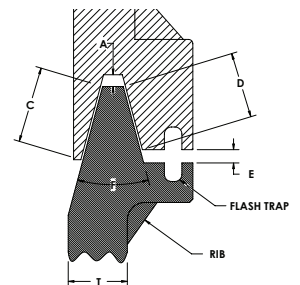
**TONGUE & GROOVE JOINT**

**T = Wall Thickness**  
**F =  $30^\circ$  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 =  $30^\circ$  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**