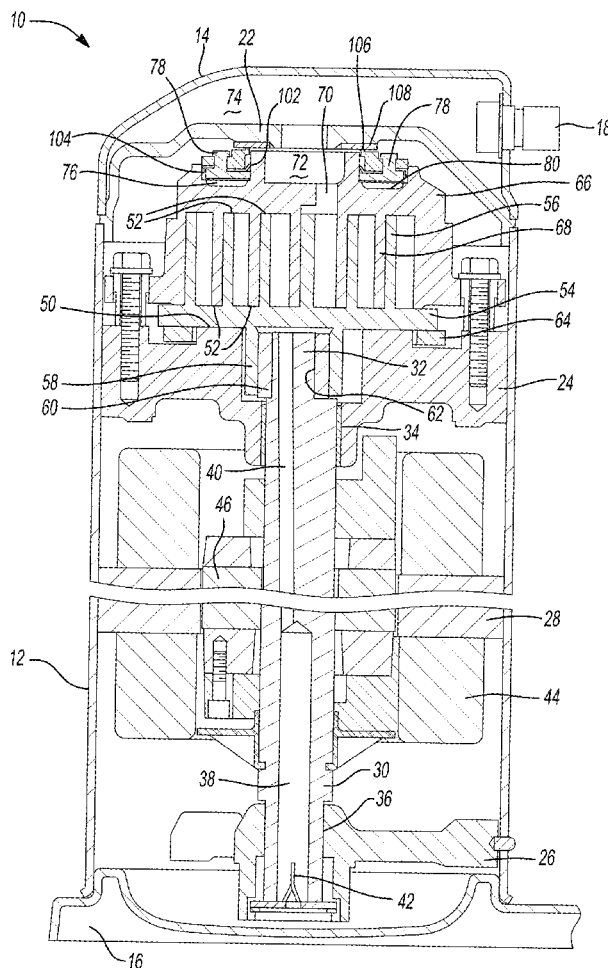


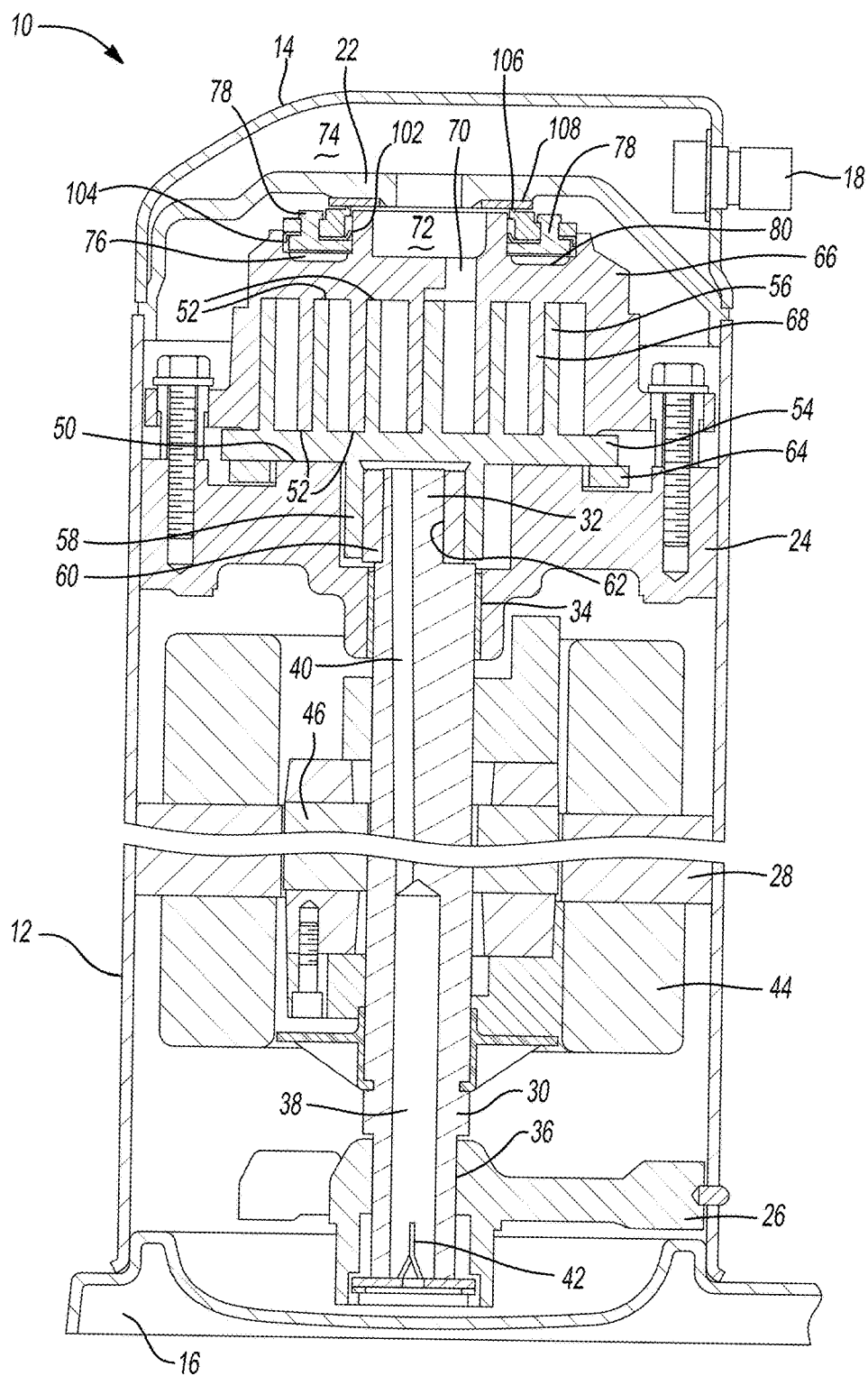


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(19) **United States**(12) **Patent Application Publication** (10) **Pub. No.: US 2019/0178250 A1**  
(43) **Pub. Date: Jun. 13, 2019**(54) **POLYMERIC COMPOSITE INSERT  
COMPONENT FOR A SCROLL  
COMPRESSOR**(52) **U.S. Cl.**  
CPC ..... **F04C 27/005** (2013.01); **F04C 18/0215**  
(2013.01)(71) Applicant: **Emerson Climate Technologies, Inc.**,  
Sidney, OH (US)(57) **ABSTRACT**(72) Inventors: **Jack Morris DeFord**, Casstown, OH  
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Maplewood, OH (US); **Steven Baker**,  
Sidney, OH (US)

A polymeric composite insert component for a scroll compressor comprises a polymer and at least one reinforcing or lubricating particle. The insert component comprises an annular body and an axial projection. The annular body comprises a first annular inner surface defining a first centrally-disposed opening having a central axis. The annular body has a first side configured to engage a partition plate and a second side configured to engage a floating seal assembly. The axial projection extends from the first side of the annular body. The axial projection is configured to engage the partition plate. The insert component is configured to fluidly seal first and second interfaces during operation of the compressor. The first interface is defined between the first contact surface and the partition plate. The second interface defined between the second contact surface and the floating seal assembly.

(21) Appl. No.: **16/210,503**(22) Filed: **Dec. 5, 2018****Related U.S. Application Data**(60) Provisional application No. 62/598,217, filed on Dec.  
13, 2017.**Publication Classification**(51) **Int. Cl.**  
**F04C 27/00** (2006.01)



**Fig-1**

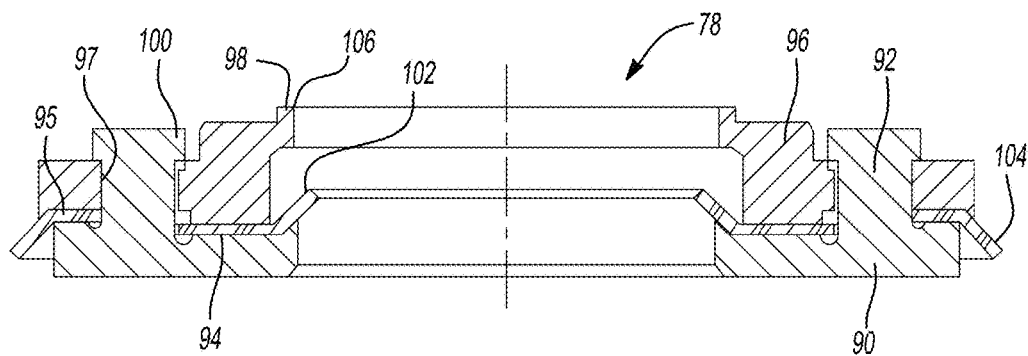


Fig-2

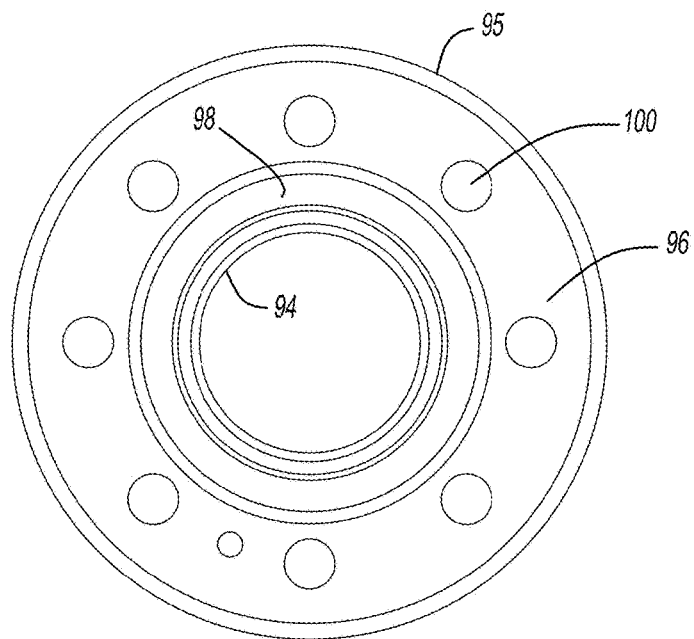


Fig-3

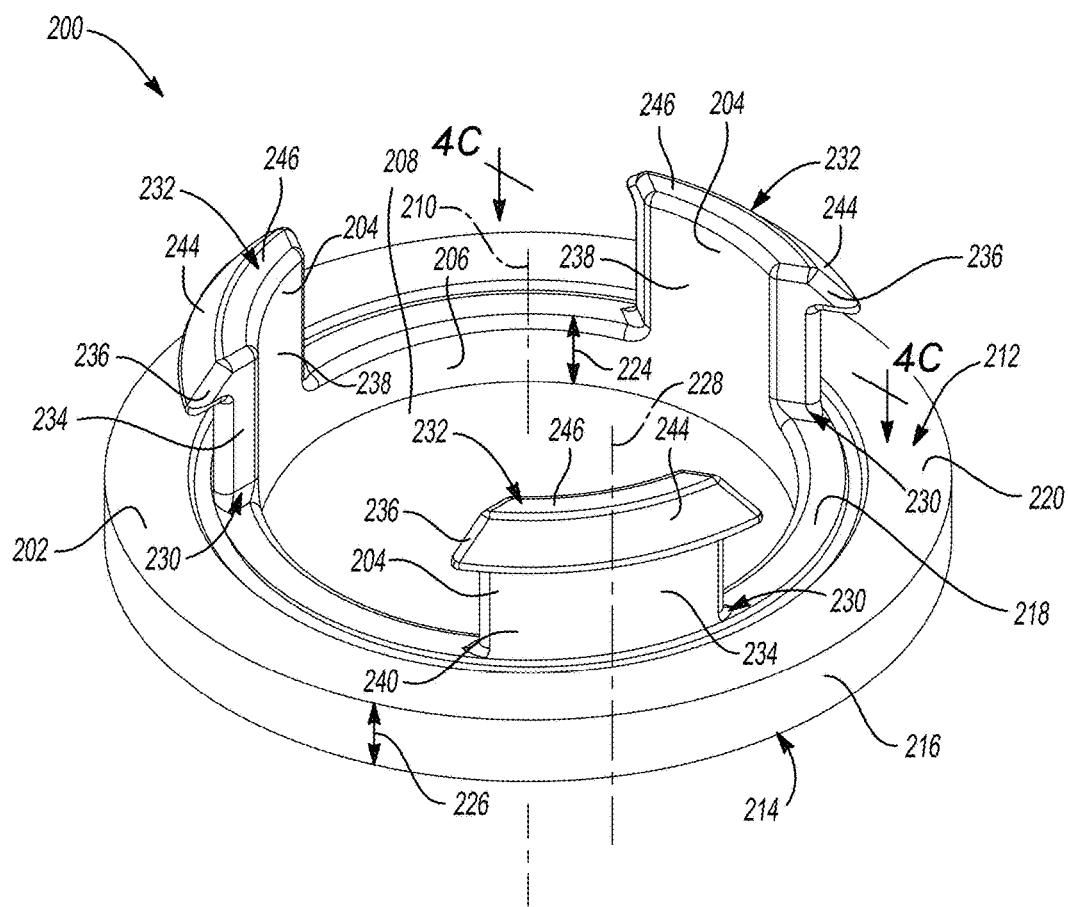
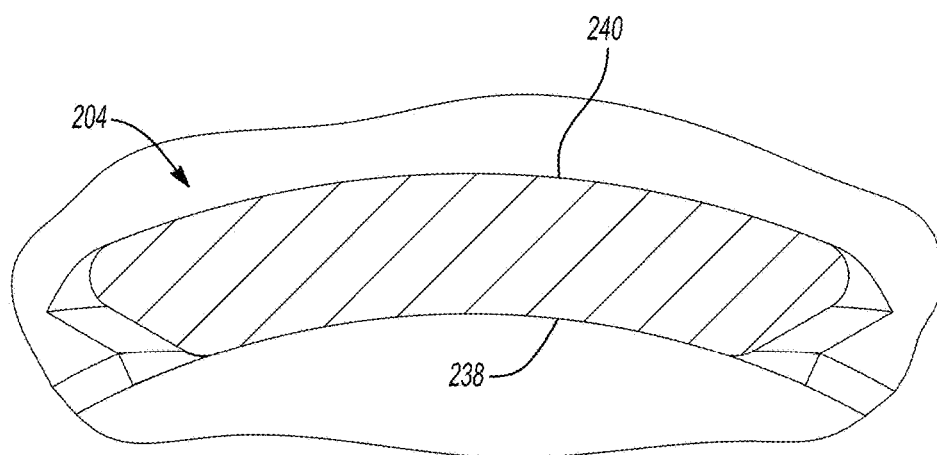
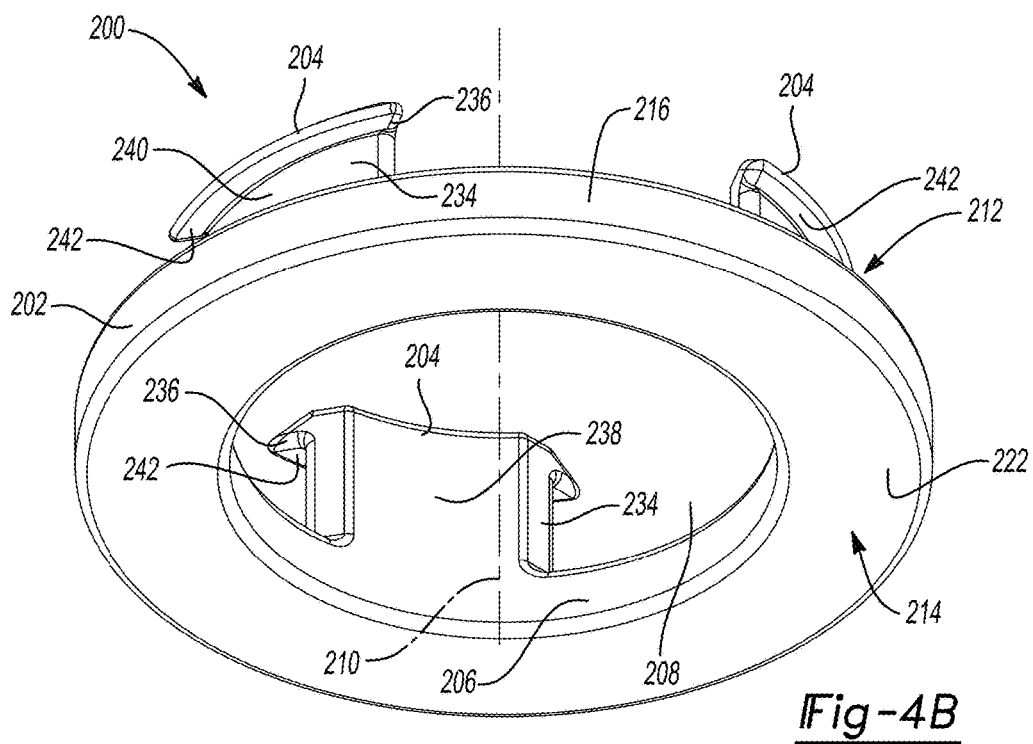


Fig-4A



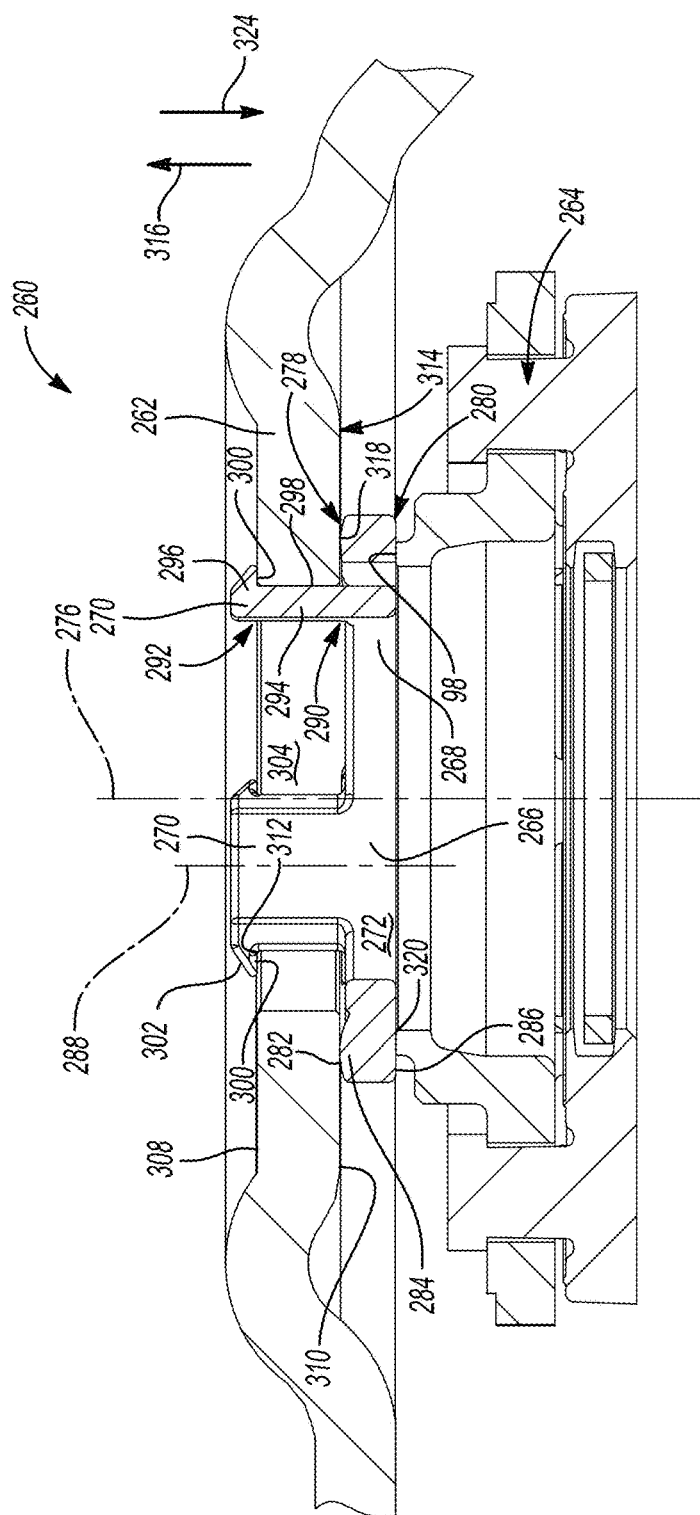
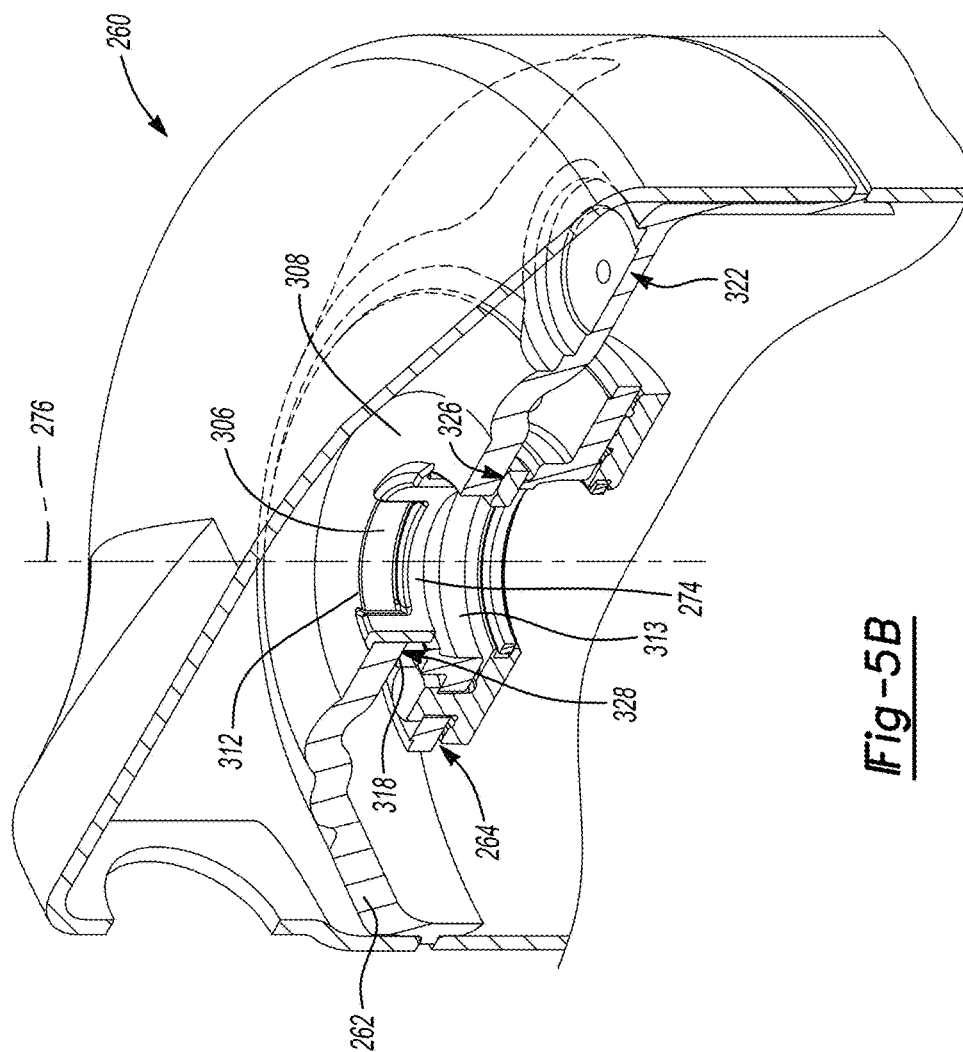


Fig-5A



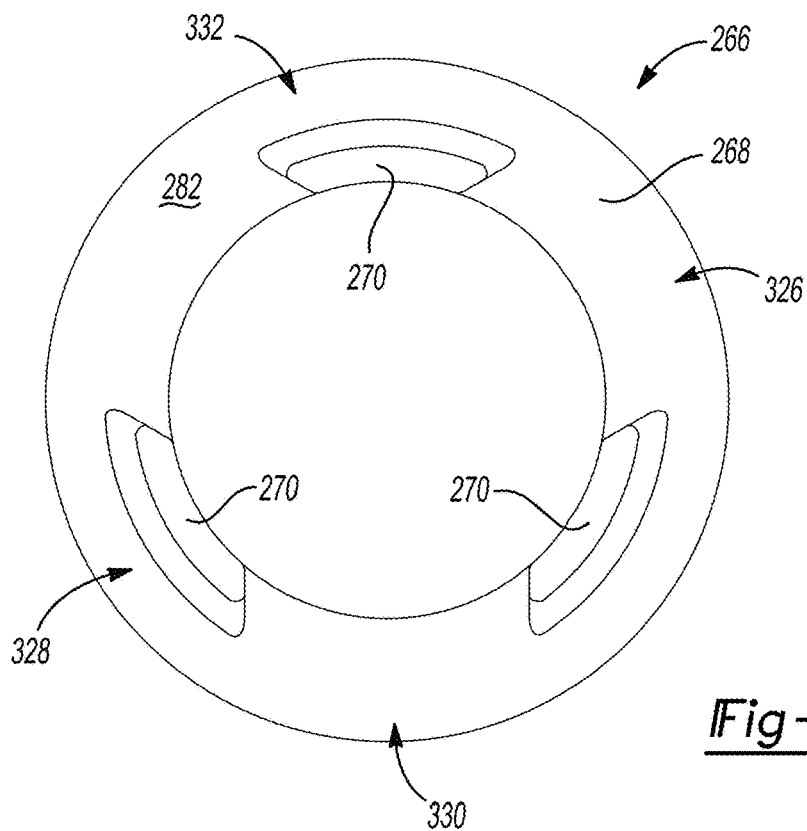


Fig-6A

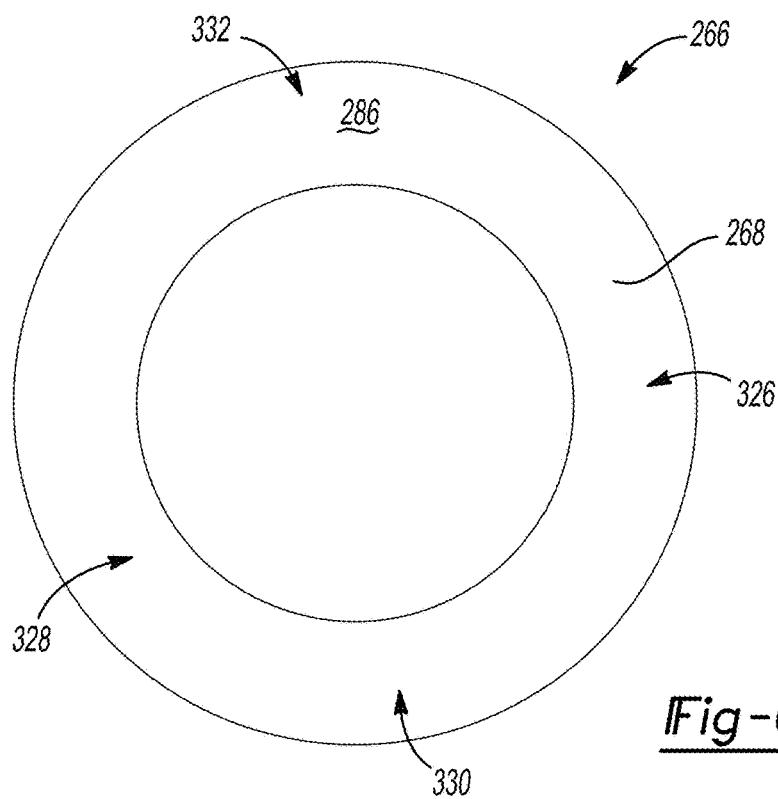


Fig-6B



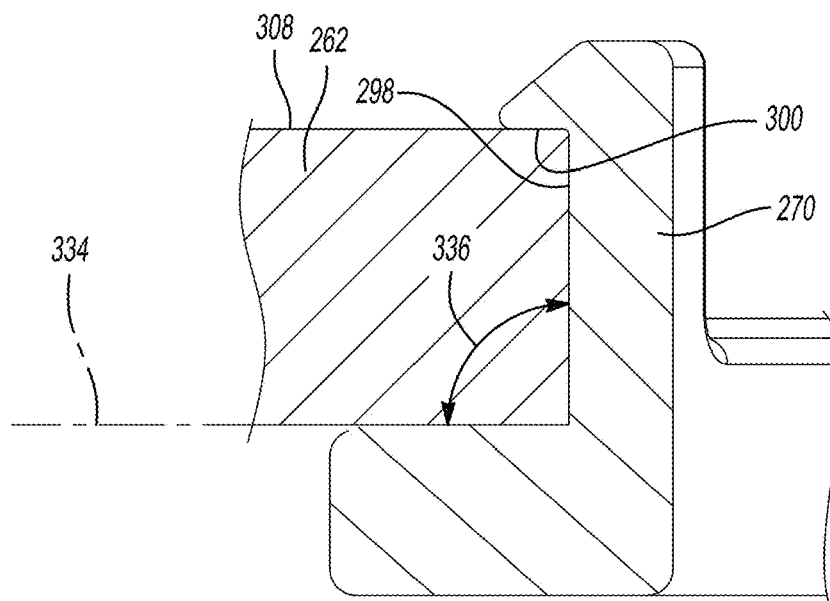


Fig-7

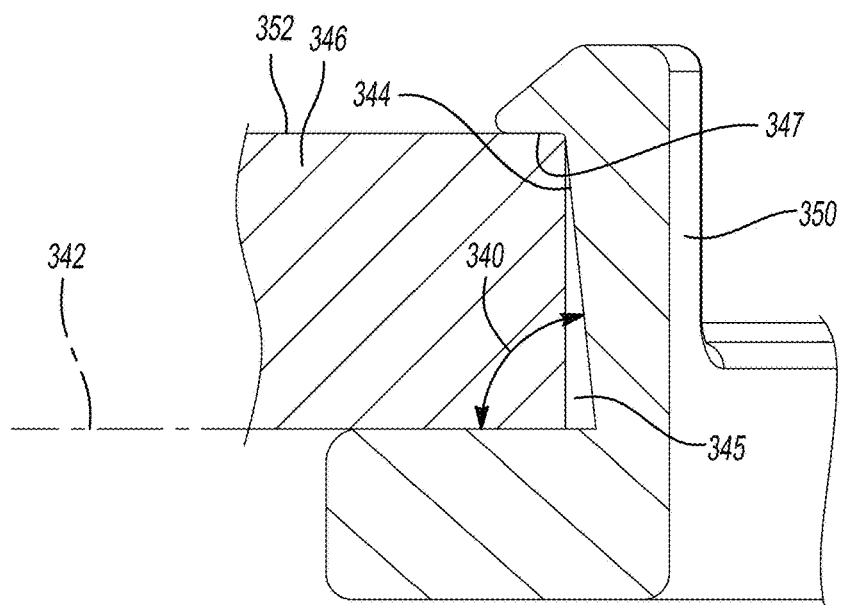
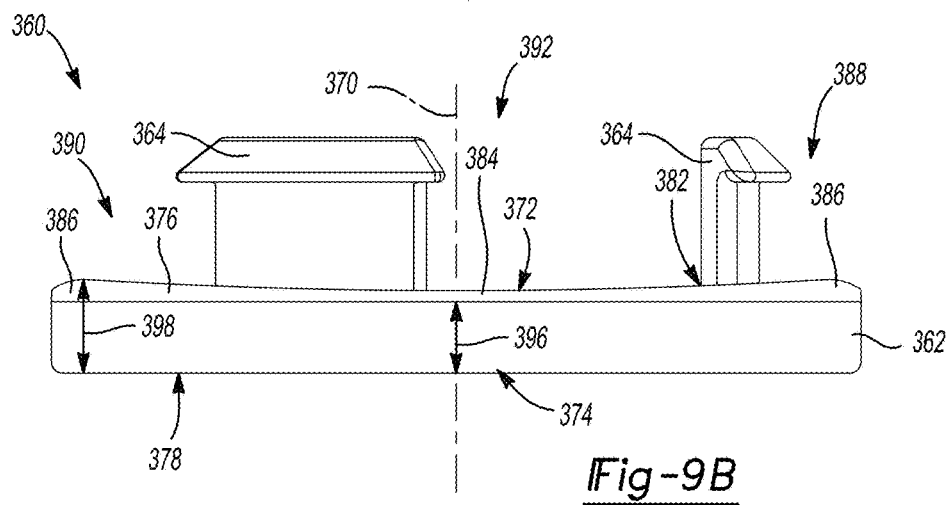
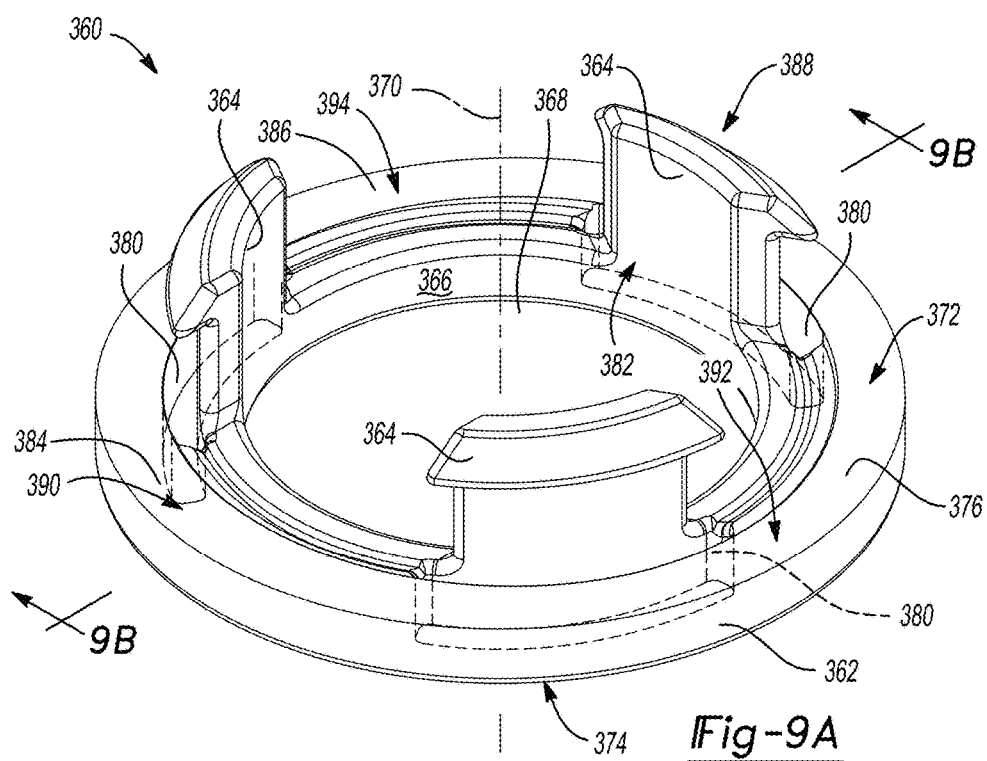
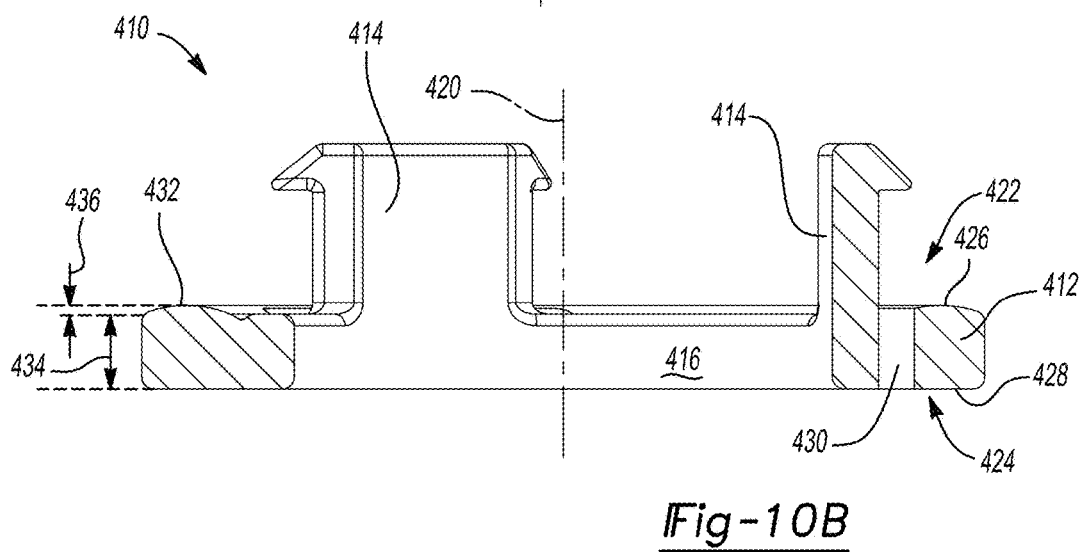
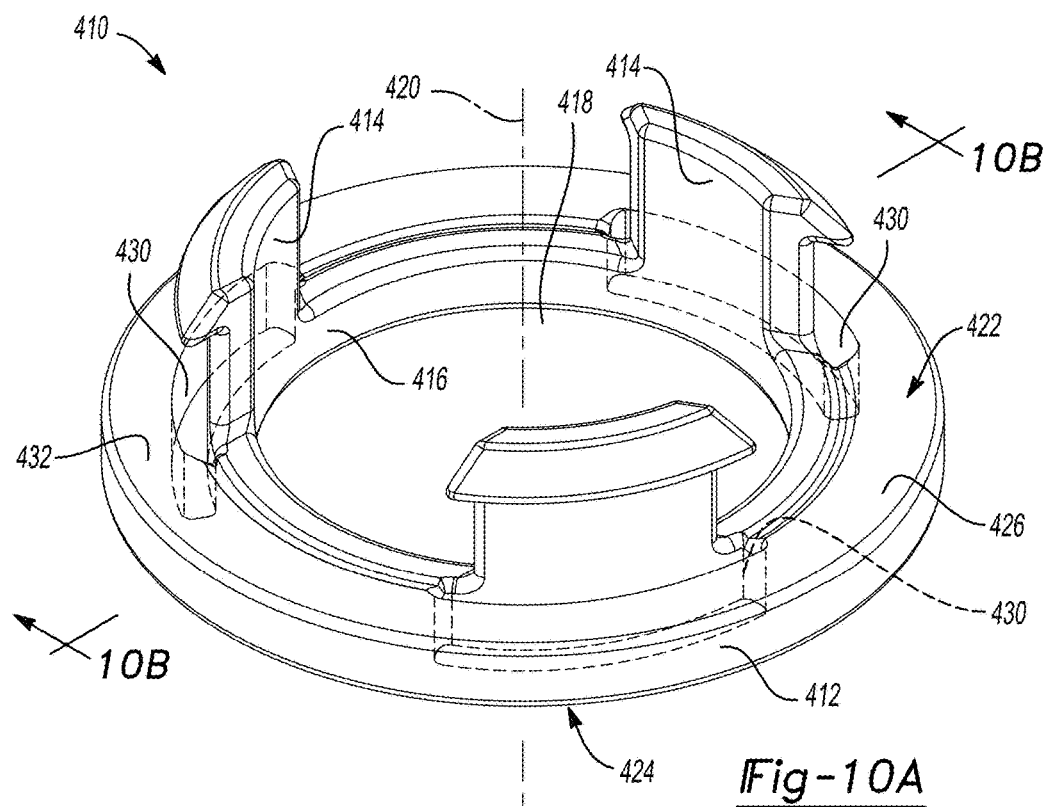


Fig-8







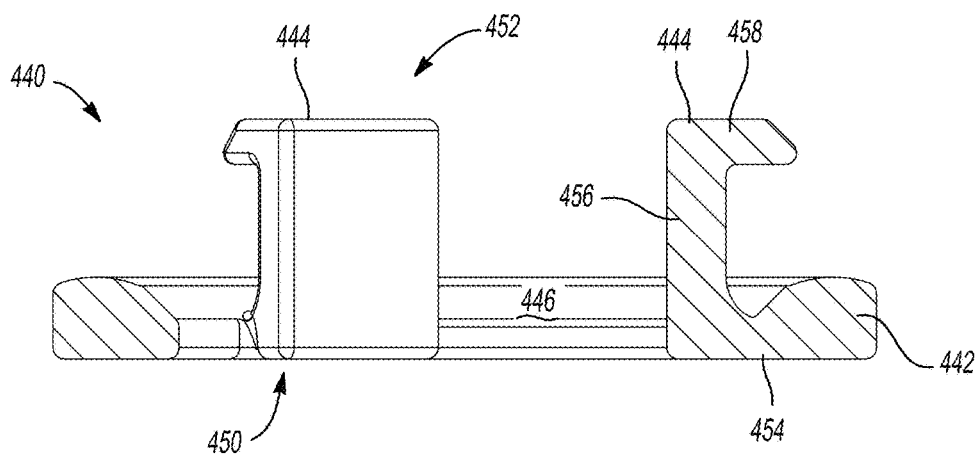


Fig-11B

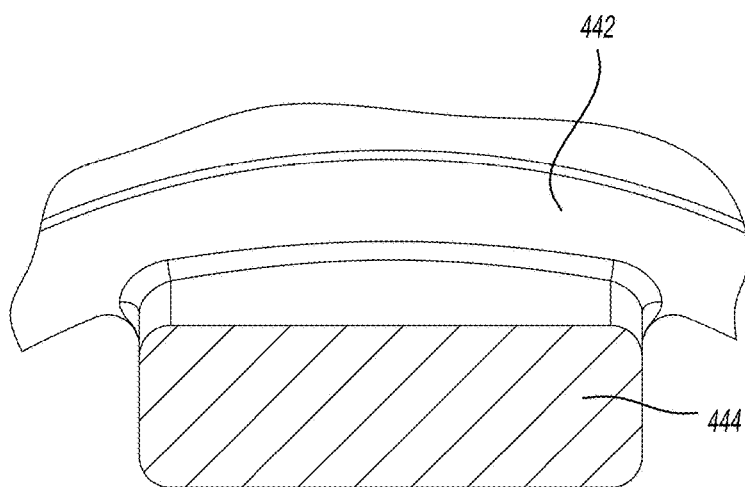


Fig-11C

## POLYMERIC COMPOSITE INSERT COMPONENT FOR A SCROLL COMPRESSOR

### CROSS-REFERENCE TO RELATED APPLICATIONS

[0001] This application claims the benefit of U.S. Provisional Application No. 62/598,217, filed on Dec. 13, 2017. The entire disclosure of the above application is incorporated herein by reference.

### FIELD

[0002] The present disclosure relates to polymeric composite insert components for compressors and more specifically, to polymeric composite insert component designs for providing a fluidic seal between a partition and a floating seal assembly in a scroll compressor, and methods of assembling the polymeric composite insert component to a scroll compressor.

### BACKGROUND

[0003] This section provides background information related to the present disclosure which is not necessarily prior art.

[0004] Scroll machines in general, and particularly scroll compressors, are often disposed in a hermetic shell that defines a chamber within which a working fluid is disposed. A partition within the shell often divides the chamber into a discharge pressure zone and a suction pressure zone. In a low-side arrangement, a scroll assembly is located within the suction pressure zone for compressing the working fluid. Generally, these scroll assemblies incorporate a pair of intermeshed spiral involute portions, one or both of which orbit relative to the other, so as to define one or more moving chambers which progressively decrease in size as they travel from an outer suction port towards a central discharge port. An electric motor is normally provided which operates to cause this relative orbital movement.

[0005] The partition within the shell allows compressed fluid exiting the central discharge port of the scroll assembly to enter the discharge pressure zone within the shell, while simultaneously maintaining the integrity between the discharge pressure zone and the suction pressure zone. The partition normally includes a seal, such as a floating seal assembly. The seal interacts with the partition and with the scroll member defining the central discharge port, so as to maintain a pressure differential within the compressor. Conventional air conditioning scroll compressors typically rely upon the floating seal package's ability to form a metal-to-metal face seal with a portion of the partition, such as a partition plate (e.g., muffler plate) or the shell, during compressor operation. This sealing interface provides separation of the high pressure side and low pressure side of the compressor. It is important to maintain a fluid seal between the floating seal assembly and the partition plate during operation of the compressor. However, the components at the sealing interface may have potential issues with maintaining sealing conditions under all compressor operating conditions and further many suffer from excessive wear that may cause loss of sealing capabilities. The present teachings provide a polymeric composite insert component having improved sealing capability.

### SUMMARY

[0006] This section provides a general summary of the disclosure, and is not a comprehensive disclosure of its full scope or all of its features.

[0007] In various aspects, the present disclosure provides a polymeric composite insert component for a scroll compressor. The polymeric composite insert component comprises a polymer and at least one reinforcing or lubricating particle. The polymeric composite insert component comprises an annular body and an axial projection. The annular body comprises a first annular inner surface. The first annular inner surface defines a first centrally-disposed opening. The first centrally-disposed opening has a central axis extending therethrough. The annular body has a first side and a second side opposite the first side. The first side comprises a first contact surface configured to engage a partition plate. The second side comprises a second contact surface configured to engage a floating seal assembly. The axial projection extends from the first side of the annular body. The axial projection is configured to engage the partition plate. The polymeric composite insert component is configured to fluidly seal both a first interface and a second interface during operation of the scroll compressor. The first interface is defined between the first contact surface and the partition plate. The second interface is defined between the second contact surface and the floating seal assembly.

[0008] In various aspects, the present disclosure provides a scroll compressor comprising a polymeric composite insert component, a partition plate, and a floating seal assembly. The polymeric composite insert component comprises a polymer and at least one reinforcing or lubricating particle. The polymeric composite insert component comprises an annular body and an axial projection. The annular body has a first annular inner surface defining a first centrally-disposed opening. The first centrally-disposed opening has a central axis extending therethrough. The axial projection extends from the annular body. The partition plate comprises a second centrally-disposed opening. The second centrally-disposed opening is aligned with the first centrally-disposed opening with respect to the central axis. The floating seal assembly has a third centrally-disposed opening. The third centrally-disposed opening is aligned with the first centrally-disposed opening and the second centrally-disposed opening with respect to the central axis. The polymeric composite insert component is disposed between the partition plate and the floating seal assembly. The polymeric composite insert component is configured to fluidly seal both a first interface and a second interface during operation of the scroll compressor. The first interface is defined between the polymeric composite insert component and the partition plate. The second interface defined between the polymeric composite insert component and the floating seal assembly.

[0009] In various aspects, the present disclosure provides a method of assembling a scroll compressor. The method includes aligning a first centrally-disposed opening of a polymeric composite insert component with a second centrally-disposed opening of a partition plate along a central axis. The polymeric composite insert component comprises a polymer and at least one reinforcing or lubricating particle. The polymeric composite insert component defines an annular body comprising the first centrally-disposed opening having the central axis extending therethrough. The method further includes orienting a plurality of circumferentially-

disposed tabs on the polymeric composite insert component toward the partition plate. Each respective circumferentially-disposed tab of the plurality projects axially from a side of the annular body. Each respective circumferentially-disposed tab of the plurality comprises a fixed end connected to the annular body, a free end opposite the fixed end, an arm extending between the fixed end and the free end, and a radially-outwardly extending lip disposed at the free end. The method further includes contacting a sloped surface of the free end of the lip of each respective circumferentially-disposed tab with the partition plate. The method further includes translating the polymeric composite insert component toward the partition plate and causing the lips of the respective circumferentially-disposed tabs of the plurality to deflect radially inwardly until the lips snap radially outwardly and engage the partition plate to retain the polymeric composite insert component on the partition plate. A surface defined by the side of the annular body engages the partition plate. The polymeric composite insert component is configured to fluidly seal an interface defined between the surface and the partition plate during operation of the scroll compressor.

[0010] Further areas of applicability will become apparent from the description provided herein. The description and specific examples in this summary are intended for purposes of illustration only and are not intended to limit the scope of the present disclosure.

#### DRAWINGS

[0011] The drawings described herein are for illustrative purposes only of selected embodiments and not all possible implementations, and are not intended to limit the scope of the present disclosure.

[0012] FIG. 1 is a sectional view through a center of a scroll compressor having a conventional design;

[0013] FIG. 2 is a partial sectional view showing a floating seal assembly as in FIG. 1;

[0014] FIG. 3 is a plan view showing an upper seal plate forming a portion of the floating seal assembly as in FIG. 1;

[0015] FIGS. 4A-4C show a polymeric composite insert component according to certain aspects of the present disclosure. FIG. 4A shows a top isometric view of the polymeric composite insert component; FIG. 4B shows a bottom isometric view of the polymeric composite insert component; FIG. 4C shows a partial sectional view taken at line 4C-4C of FIG. 4A;

[0016] FIGS. 5A-5B show a scroll compressor having a polymeric composite insert component according to certain aspects of the present disclosure. FIG. 5A is a partial sectional view of the scroll compressor; FIG. 5B is an isometric section view of the polymeric composite insert component;

[0017] FIGS. 6A-6B show the polymeric composite insert component of FIGS. 5A-5B. FIG. 6A is a top view of the polymeric composite insert component; FIG. 6B is a bottom view of the polymeric composite insert component;

[0018] FIG. 7 is a partial sectional view of the polymeric composite insert component and partition plate of FIGS. 5A-5B;

[0019] FIG. 8 is a partial sectional view of another polymeric composite insert component according to certain aspects of the present disclosure, the polymeric composite insert component being fixed to a partition plate;

[0020] FIGS. 9A-9B show another polymeric composite insert component according to certain aspects of the present disclosure. FIG. 9A is a top isometric view of the polymeric composite insert component; FIG. 9B is a side view of the polymeric composite insert component taken at line 9B-9B of FIG. 9A;

[0021] FIGS. 10A-10B show yet another polymeric composite insert component according to certain aspects of the present disclosure. FIG. 10A is a top isometric view; FIG. 10B is a sectional view taken at line 10B-10B of FIG. 10A; and

[0022] FIGS. 11A-11C show yet another polymeric composite insert component according to certain aspects of the present disclosure. FIG. 11A is a top isometric view; FIG. 11B is a sectional view taken at line 11B-11B of FIG. 11A; and FIG. 11C is a sectional view taken at line 11C-11C of FIG. 11A.

[0023] Corresponding reference numerals indicate corresponding parts throughout the several views of the drawings.

#### DETAILED DESCRIPTION

[0024] Example embodiments will now be described more fully with reference to the accompanying drawings.

[0025] Example embodiments are provided so that this disclosure will be thorough, and will fully convey the scope to those who are skilled in the art. Numerous specific details are set forth such as examples of specific components, devices, and methods, to provide a thorough understanding of embodiments of the present disclosure. It will be apparent to those skilled in the art that specific details need not be employed, that example embodiments may be embodied in many different forms and that neither should be construed to limit the scope of the disclosure. In some example embodiments, well-known processes, well-known device structures, and well-known technologies are not described in detail.

[0026] The terminology used herein is for the purpose of describing particular example embodiments only and is not intended to be limiting. As used herein, the singular forms “a,” “an,” and “the” may be intended to include the plural forms as well, unless the context clearly indicates otherwise. The terms “comprises,” “comprising,” “including,” and “having,” are inclusive and therefore specify the presence of stated features, integers, steps, operations, elements, and/or components, but do not preclude the presence or addition of one or more other features, integers, steps, operations, elements, components, and/or groups thereof. The method steps, processes, and operations described herein are not to be construed as necessarily requiring their performance in the particular order discussed or illustrated, unless specifically identified as an order of performance. It is also to be understood that additional or alternative steps may be employed.

[0027] When an element or layer is referred to as being “on,” “engaged to,” “connected to,” or “coupled to” another element or layer, it may be directly on, engaged, connected or coupled to the other element or layer, or intervening elements or layers may be present. In contrast, when an element is referred to as being “directly on,” “directly engaged to,” “directly connected to,” or “directly coupled to” another element or layer, there may be no intervening elements or layers present. Other words used to describe the relationship between elements should be interpreted in a like fashion (e.g., “between” versus “directly between,” “adja-

cent” versus “directly adjacent,” etc.). As used herein, the term “and/or” includes any and all combinations of one or more of the associated listed items.

**[0028]** Although the terms first, second, third, etc. may be used herein to describe various elements, components, regions, layers and/or sections, these elements, components, regions, layers and/or sections should not be limited by these terms. These terms may be only used to distinguish one element, component, region, layer or section from another region, layer or section. Terms such as “first,” “second,” and other numerical terms when used herein do not imply a sequence or order unless clearly indicated by the context. Thus, a first element, component, region, layer or section discussed below could be termed a second element, component, region, layer or section without departing from the teachings of the example embodiments.

**[0029]** Spatially relative terms, such as “inner,” “outer,” “beneath,” “below,” “lower,” “above,” “upper,” and the like, may be used herein for ease of description to describe one element or feature’s relationship to another element(s) or feature(s) as illustrated in the figures. Spatially relative terms may be intended to encompass different orientations of the device in use or operation in addition to the orientation depicted in the figures. For example, if the device in the figures is turned over, elements described as “below” or “beneath” other elements or features would then be oriented “above” the other elements or features. Thus, the example term “below” can encompass both an orientation of above and below. The device may be otherwise oriented (rotated 90 degrees or at other orientations) and the spatially relative descriptors used herein interpreted accordingly.

**[0030]** Throughout this disclosure, the numerical values represent approximate measures or limits to ranges to encompass minor deviations from the given values and embodiments having about the value mentioned as well as those having exactly the value mentioned. Other than in the working examples provided at the end of the detailed description, all numerical values of parameters (e.g., of quantities or conditions) in this specification, including the appended claims, are to be understood as being modified in all instances by the term “about” whether or not “about” actually appears before the numerical value. “About” indicates that the stated numerical value allows some slight imprecision (with some approach to exactness in the value; approximately or reasonably close to the value; nearly). If the imprecision provided by “about” is not otherwise understood in the art with this ordinary meaning, then “about” as used herein indicates at least variations that may arise from ordinary methods of measuring and using such parameters. In addition, disclosure of ranges includes disclosure of all values and further divided ranges within the entire range, including endpoints given for the ranges.

**[0031]** In various aspects, the present teachings provide a polymeric composite insert component for sealing an interface between a floating seal assembly and a partition (e.g., a partition plate, a muffler plate, or a shell) in a compressor, such as a scroll compressor. In certain variations, this disclosure provides a polymeric insert component that can be coupled to the partition or the floating seal assembly. In certain aspects, the polymeric insert component comprises a polymer, such as a thermoplastic polymer. In certain aspects, the polymeric insert component comprises a composite material including a polymer and at least one reinforcement material distributed within the polymer. Such a thermoplas-

tic composite provides greater ability to conform to the partition and the floating seal assembly to enhance sealability and seal performance. For example, a thermoplastic composite in the polymeric composite insert component can provide high strength, while enhancing flexibility and elasticity at the interface. More particularly, the polymeric composite insert component conforms to the partition and the floating seal assembly during operation of the compressor, including during deformation of the partition at high loads. Thus, the polymeric composite insert component may increase overall compressor efficiency.

**[0032]** By way of background, a conventional hermetic refrigerant scroll compressor **10** is described in the context of FIG. 1. The scroll compressor **10** comprises a generally cylindrical hermetic shell **12** having welded at the upper end thereof a cap **14** and at the lower end thereof a base **16**. The cap **14** is provided with a refrigerant discharge fitting **18** which may have the usual discharge valve componentry therein (not shown). Other major elements affixed to the shell **12** include a transversely extending partition, which is shown here as a partition plate **22**, which is connected about its periphery along the same joint that cap **14** is attached to shell **12**. A stationary main bearing housing or body **24** is suitably secured to shell **12**, and a lower bearing housing **26** also having a plurality of radially-outwardly extending legs, each of which is also suitably secured to shell **12**. A motor stator **28** is disposed within shell **12**. Flats between the rounded corners on the motor stator **28** provide passageways between the stator **28** and shell **12**, which facilitate the flow of lubricant from the top of the shell **12** to the bottom.

**[0033]** A drive shaft or crankshaft **30** having an eccentric crank pin **32** at the upper end thereof is rotatably journaled in a bearing **34** in the main bearing housing **24** and a second bearing **36** in the lower bearing housing **26**. Crankshaft **30** has at the lower end a relatively large diameter concentric bore **38** which communicates with a radially-outwardly-inclined smaller diameter bore **40** extending upwardly therefrom to the top of the crankshaft. Disposed within bore **38** is a stirrer **42**. The lower portion of the interior shell **12** is filled with lubricating oil, and the bore **38** serves to pump lubricating fluid up the crankshaft **30** and into the bore **40**, and ultimately to all of the various portions of the compressor which require lubrication. The crankshaft **30** is rotatively driven by an electric motor including stator **28**, windings **44** passing therethrough, and a rotor **46** press-fitted on the crankshaft **30**.

**[0034]** An upper surface of main bearing housing **24** is provided with a flat thrust bearing surface **50** on which is disposed an orbiting scroll member **54** defining the usual spiral vane or involute portion **56**. Projecting downwardly from the lower surface of orbiting scroll member **54** is a cylindrical hub **58** having a journal bearing therein and in which is rotatively disposed a drive bushing **60** having an inner bore **62** in which crank pin **32** is drivingly disposed. The crank pin **32** has a flat on one surface which drivingly engages a flat surface (not shown) formed in a portion of bore **62** to provide a radially-compliant driving arrangement. An Oldham coupling **64** is positioned between and keyed to orbiting scroll member **54** and a non-orbiting scroll member **66** to prevent rotational movement of orbiting scroll member **54**.

**[0035]** The non-orbiting scroll member **66** is also provided having a non-orbiting involute portion **68** positioned in meshing engagement with orbiting involute portion **56** of



orbiting scroll member 54. The non-orbiting scroll member 66 has a centrally-disposed discharge passage 70 communicating with an upwardly-open recess 72 which is in fluid communication with a discharge muffler chamber 74 defined by the cap 14 and the partition plate 22 through an opening defined by the partition plate 22. It should be noted that while the exemplary design only shows the partition plate 22, which can serve as a muffler plate, a variety of conventional known designs can alternatively be attached to the shell 12 or partition, including an assembly of plates or components or an external shell/housing.

[0036] Thus, the orbiting involute portion 56 and non-orbiting involute portion 68 (of the two scroll members 54, 66) are arranged together with the scroll involute portions 56, 68 being rotationally displaced 180° from one another. The scroll compressor 10 operates by orbiting the involute portion 56 of orbiting scroll member 54 with respect to the other involute portion 68 of stationary non-orbiting scroll member 66, thus making moving line contacts between the flanks of the respective involute portions 56, 68, thus defining moving isolated crescent-shaped pockets of fluid. The moving fluid pockets carry the fluid to be handled from a first zone in the scroll machine where a fluid inlet is provided, to a second zone in the machine where a fluid outlet is provided. The volume of a sealed pocket changes as it moves from the first zone to the second zone. At any one instant in time there will be at least one pair of sealed pockets; and where there are several pairs of sealed pockets at one time, each pair will have different volumes. In the compressor 10, the second zone is at a higher pressure than the first zone and is physically located centrally in the compressor 10, the first zone being located at the outer periphery of the compressor 10.

[0037] Two types of contacts define the fluid pockets formed between the scroll members 54, 66: (1) axially extending tangential line contacts between the spiral faces or flanks of the involute portions 56, 68 caused by radial forces ("flank sealing"), and (2) area contacts caused by axial forces between the plane edge surfaces defined by terminal edges or tips 52 of each involute portion 56, 68 and the opposite end plate ("tip sealing"). For high efficiency, optimizing sealing for both types of contacts is important.

[0038] One of the difficult areas of design in a scroll-type machine concerns the technique used to achieve tip sealing under all operating conditions, and also at all speeds in a variable speed machine. Conventionally, this has been accomplished by (1) using extremely accurate and very expensive machining techniques, (2) providing the involute portion tips 52 with spiral tip seals, which are difficult to assemble and often unreliable, or (3) applying an axially restoring force by axial biasing the orbiting scroll member 54 or the non-orbiting scroll member 66 towards the opposing scroll using compressed working fluid.

[0039] The utilization of an axial restoring force typically entails one of the two scroll members 54, 66 being mounted for axial movement with respect to the other scroll member. This can be accomplished by securing the non-orbiting scroll member 66 to a main bearing housing 24. Second, a biasing load applied to the axially movable non-orbiting scroll member 66 urges the non-orbiting scroll member 66 into engagement with the orbiting scroll member 54. This can be accomplished by forming a chamber 76 on the side of the non-orbiting scroll member 66 opposite to the orbiting scroll member 54, placing a floating seal assembly 78 in the

chamber 76 and then supplying a pressurized fluid to this chamber 76. The source of the pressurized fluid can be the scroll compressor itself. Thus, an annular recess 80 can be formed in non-orbiting scroll member 66, within which is disposed the floating seal assembly 78. The recesses 72 and 80 and floating seal assembly 78 cooperate to define axial pressure biasing chambers which receive pressurized fluid being compressed by involute portions 56 and 68, so as to exert an axial biasing force on non-orbiting scroll member 66 to thereby urge the tips 52 of respective involute portions 56, 68 into sealing engagement with the opposed end plate surfaces.

[0040] With reference to FIGS. 1-3, a conventional floating seal assembly 78 is shown which has a coaxial sandwiched construction that comprises an annular base plate or lower seal plate 90 conventionally formed out of a metal, such as cast iron or aluminum. Such floating seal assemblies 78 generally function as a valve to enable or prevent flow of high-pressure refrigerant gas from a high-pressure discharge area to the low-pressure suction/inlet area in the compressor 10. At normal operating conditions for the compressor 10, the valve is closed and a face seal minimizes bypass of gas from a discharge side to an inlet/suction side. The valve will, however, open in response to a high discharge-to-suction pressure ratio in the compressor 10 to prevent system failure.

[0041] Thus, in the design shown in FIGS. 1-3, the annular base plate 90 has a plurality of equally-spaced upstanding integral projections or posts 92. Disposed on base plate 90 is an annular inner gasket or seal 94 and an annular outer gasket or seal 95. On top of seals 94, 95 is disposed an annular upper seal plate 96 having a plurality of equally-spaced holes 97 receiving projections 92. Upper annular seal plate 96, which is conventionally formed of a metal, such as grey cast iron, has disposed about the periphery thereof an upwardly projecting planar seal lip that defines a sealing lip or face seal 98. The floating seal assembly 78 is secured together by swaging the ends of each projection 92 as indicated at 100.

[0042] The overall seal assembly 78 therefore provides three distinct seals, namely, an inside diameter seal at 102, an outside diameter seal at 104 and a top or face seal at 106. Seal 102 isolates fluid under intermediate pressure in the bottom of recess 80 from fluid under discharge pressure in recess 72. Seal 104 isolates fluid under intermediate pressure in the bottom of recess 80 from fluid at suction pressure within shell 12. Seal 106 isolates fluid at suction pressure within shell 12 from fluid at discharge pressure in recess 72 across the top of floating seal assembly 78. FIG. 1 illustrates a wear ring 108 attached to partition plate 22 (that in alternative embodiments which are not shown, could be attached to a separate partition plate attached to shell 12 or partition), which provides seal 106 between face seal 98 (of plate 96) and wear ring 108. In lieu of wear ring 108, the lower surface of partition plate 22 can be locally hardened by nitriding, carbo-nitriding or other hardening processes known in the art to form the partition plate 22 against which the face seal 98 can interface.

[0043] The diameter of seal 106 is chosen so that there is a positive upward sealing force on floating seal assembly 78 under normal operating conditions, at normal pressure ratios. Therefore, when excessive pressure ratios are encountered, the floating seal assembly 78 will be forced downwardly by discharge pressure, thereby permitting a leak of high side discharge pressure gas directly across the

top of floating seal assembly **78** to a zone of low side suction gas. If this leakage is great enough, the resultant loss of flow of motor cooling suction gas (aggravated by the excessive temperature of the leaking discharge gas) will cause a motor protector (not shown) to trip, thereby de-energizing the motor. The width of seal **106** is chosen so that the unit pressure on the seal itself (e.g., between face seal **98** and wear ring **108**) is greater than normally encountered discharge pressure, to promote consistent sealing. The discharge pressure of compressor **10** urges the inner lip seal portion of seal **94** into engagement with non-orbiting scroll member **66** to form the inside diameter seal at **102**.

**[0044]** Thus, conventional floating seals, like floating seal assembly **78**, can be an assembly of two metal plates and one or more polymer sealing rings. The lower seal plate **90** is often formed of as-cast aluminum (or other metals) including the vertical posts **92** that fit through holes or openings **100** in the upper seal plate **96**. Upper seal plate **96** is often formed of cast iron (or other metals). The upper seal plate **96** has the face seal **98** feature incorporated into its top surface that interacts with a partition plate **22** (e.g., muffler plate) to form seal **106** whenever the two components are in contact. The polymer seals **94, 95** are located by and held between the two seal plates **90, 96**. The assembly process for conventional seal assemblies involves stacking the pieces together and then plastically deforming the aluminum posts **92** such that the top ends locally spread out over the lower seal plate **90** to form a rigid and secure attachment.

**[0045]** When assembled, the one or more polymer seals **94, 95** are retained by the two seal plates **90, 96** in a first plane and the sealing interface with the non-orbiting scroll member **66** occurs along a surface of the non-orbiting scroll member **66** that is generally perpendicular to the plane of retention by the two plates **90, 96**. Thus, the one or more polymer seals **94, 95** bend through an approximately 90° angle to achieve their sealing.

**[0046]** In various aspects, the present teachings provide a polymeric composite insert component for improved sealing between a partition and a floating seal assembly in a compressor, such as a scroll compressor. The polymeric composite insert component is disposed between the partition and the floating seal assembly. The polymeric composite insert component may be formed of a composite that includes a polymer and a reinforcement or lubricating phase. The polymeric composite insert component may provide a fluid seal at a first interface between the partition and the polymeric composite insert component and at a second interface between the polymeric composite insert component and the floating seal assembly. The polymeric construction enables the insert component to conform to the partition and the floating seal assembly more effectively than the metal-to-metal joint of the compressor described in FIGS. 1-3, particularly during operation of the compressor.

**[0047]** Operation of the compressor, especially at high loads, may cause the partition to deform. Such deformation may act on the component(s) engaging the partition to create respective areas of high pressure and low pressure on the component. In the example described in FIGS. 1-3, the deformed partition **22** acts on the floating seal assembly **78** to create respective high and low pressure areas on a top surface of the partition **22**. The metal interface surfaces of the partition **22** and the floating seal assembly **78** may be too inflexible to provide a continuous interface and fluidic seal

when the partition deforms. The resulting imperfect seal may create leak paths and lead to a lower overall compressor efficiency.

**[0048]** In various aspects, the polymeric composite insert component according to the teachings of the present disclosure may be relatively elastic. Thus, it can form a more compliant interface and an improved seal compared to a metal-to-metal interface. In certain embodiments, a first contact surface of the polymeric composite insert component that engages the partition may be provided with a waveform shape that compliments the deformation of the partition to create a relatively uniform contact pressure and further improve sealing at the first and the second interfaces. In certain other embodiments, the first contact surface of the polymeric composite insert component may be provided with a circumferential protrusion, such as a circumferential barrel, to increase pressure at the first and the second interfaces.

**[0049]** The polymer resin of the polymeric composite insert component may be further provided with a reinforcement or lubricating phase (e.g., reinforcing or lubricating filler particles or fibers) that forms a polymeric composite, which is particularly advantageous for use as a part of a seal component in a scroll member, such as the polymeric composite insert component. A “composite” can refer to a material which includes a polymer resin or matrix having a plurality of reinforcing or lubricating particles distributed throughout as a reinforcement phase. Composite polymer matrices provide additional strength and structural integrity, while providing superior wear resistance for use as a seal material.

**[0050]** In various aspects, suitable polymers include a thermoplastic resin, which provides a heat-resistant matrix for at least one or more distinct reinforcing or lubricating particles to form the composite that forms the insert component. Suitable thermoplastic polymers can be selected from the polyaryletherketone (PAEK) family. In certain variations, the polyaryletherketone (PAEK) thermoplastic polymer can be selected from the group consisting of: polyetherketone (PEK), polyetheretherketone (PEEK), polyetheretheretherketone (PEEEK), polyetherketoneketone (PEKK), polyetheretherketoneketone (PEEKK), polyetheretheretherketone (PEKEEK), and polyetheretherketoneetherketone (PEEKEK) and combinations thereof. In other variations, the thermoplastic matrix material may comprise polyamide imide (PAI), polyphenylene sulfide (PPS), polyimide (PI), polyphthalamide (PPA), or polyether imide (PEI) alone or as combined with any of the other suitable thermoplastic polymers discussed just above. In certain variations, the thermoplastic polymer is selected from the group consisting of: a polyaryl ether ketone (PAEK) or other ultra-performing polymer including, but not limited to poly(phenylene sulphide) (PPS), poly(sulphone) (PS), polyamide imide (PAI), or polyimide (PI). In certain variations, a particularly desirable carrier material or thermoplastic polymer is an ultra-performance, high temperature thermoplastic resin, such as a member of the polyaryl ether ketone (PAEK) family like polyetheretherketone (PEEK). In various aspects, the polymer includes a thermoset resin. Suitable thermoset resins include epoxy, polyester, phenolic, and imides, such as polyamide imide (PAI) and polyimide (PI) (which may be formulated as thermoplastic or thermoset).

**[0051]** Reinforcing or lubricating particles for the composite material of the insert component may include inorganic materials, metals, or high performance polymeric materials (particles or fibers). The reinforcing particles or fillers can be any number of anti-friction/anti-wear compounds including, but not limited to inorganic fillers, organic fillers, and polymeric particles used as fillers. Thus a solid material in particulate form (e.g., a plurality of solid particles) that contributes to a low coefficient of friction or provides additional tribological or synergistic properties to the overall anti-wear material composition, while reinforcing the resin in the composite, is particularly desirable. In various aspects, the composite material of the insert component includes at least one reinforcing or lubricating particle. In certain variations, a suitable composite for the insert component comprises a first reinforcing or lubricating particle and a second reinforcing or lubricating particle distinct from the first reinforcing or lubricating particle. In yet other variations, the composite for the insert component may comprise three or more distinct reinforcing and/or lubricating particles.

**[0052]** In certain variations, the composite of the insert component comprises a plurality of reinforcing particles that are distinct from one another. In certain variations, the insert component comprises at least one reinforcing or lubricating particle selected from the group consisting of: polytetrafluoroethylene (PTFE), molybdenum disulfide ( $\text{MoS}_2$ ), tungsten disulfide ( $\text{WS}_2$ ), antimony trioxide, hexagonal boron nitride, carbon fiber, graphite, graphene, lanthanum fluoride, carbon nanotubes, polyimide particles (or powderized polyimide polymer), polybenzimidazole (PBI) particles, and combinations thereof. In certain embodiments, a first reinforcing particle and a second reinforcing particle distinct from the first reinforcing particle can be independently selected from the group consisting of: polytetrafluoroethylene (PTFE) particles (or powderized PTFE), molybdenum disulfide ( $\text{MoS}_2$ ) particles, tungsten disulfide ( $\text{WS}_2$ ), antimony trioxide, hexagonal boron nitride particles, carbon fibers, graphite particles, graphene particles, lanthanum fluoride, carbon nanotubes, polyimide particles (or powderized polyimide polymer), polybenzimidazole (PBI) particles (e.g., fibers), and combinations thereof. In certain preferred variations, three distinct reinforcing or lubricating particles are independently selected from the group consisting of: poly(tetrafluoroethylene) (PTFE), graphite, carbon fiber, antimony trioxide, carbon nanotubes, polyimide, and combinations thereof. In certain variations, a first reinforcing or lubricating particle comprises poly(tetrafluoroethylene) (PTFE) particles, while a second reinforcing or lubricating particle comprises graphite, and a third reinforcing or lubricating particle comprises carbon fiber.

**[0053]** Referring to FIGS. 4A-4C, one embodiment of a polymeric composite insert component 200 according to certain aspects of the present disclosure is shown. A polymeric composite insert component 200 includes an annular body 202 and an axial projection. The axial projection comprises a plurality of circumferentially-disposed tabs 204. The circumferentially-disposed tabs 204 project from the annular body 202. The annular body 202 has an annular inner surface 206 that defines a centrally-disposed opening 208. A central axis 210 extends longitudinally through the centrally-disposed opening 208. The annular body 202 includes a first side 212 and a second side 214 opposite the first side 212.

**[0054]** The annular body 202 includes an annular outer surface 216. The first side 212 of the annular body 202 includes a tab surface 218 and a first contact surface 220. The first contact surface 220 is disposed in a radially outward position from the tab surface 218. The first contact surface 220 may be substantially planar. The second side 214 includes a second contact surface 222. The second contact surface 222 may be substantially planar. The second contact surface 222 may be disposed substantially parallel to the first contact surface 220 such that the first and the second contact surfaces 220, 222 are substantially perpendicular to the central axis 210. The tab surface 218 has a first height 224 with respect to the second contact surface 222 in an axial direction parallel to the central axis 210. The first contact surface 220 has a second height 226 with respect to the second contact surface 222 in the axial direction. Although the first height 224 is shown as less than the second height 226 in FIG. 4A, in various other embodiments, the first and the second heights 224, 226 may be equal or the second height 226 may be greater than the first height 224. The annular body 202 should have a minimum thickness to provide a sufficient seal. The minimum thickness may be dependent upon load, contact pressure, and stress.

**[0055]** The tabs 204 are circumferentially-disposed about the central axis 210. Thus, each of the respective tabs 204 may be disposed at an equal distance from the central axis 210 and spaced at a pre-determined distance around the tab surface 218 of annular body 202. The tabs 204 project from the tab surface 218 and extend along a tab axis 228 that is substantially parallel to the central axis 210. Each tab 204 has a fixed end 230 and a free end 232. The fixed end 230 joins the tab 204 to the annular body 202. The free end 232 can be radially-inwardly flexed toward the central axis 210. As will be discussed in greater detail in other embodiments, the tabs 204 may be flexed radially inwardly when the polymeric composite insert component 200 is assembled to a partition of a scroll compressor.

**[0056]** Each tab 204 may include an arm 234 and a lip 236. The arm 234 extends between the fixed end 230 and the free end 232. The lip 236 is disposed at the free end 232 and extends radially outwardly from the arm 234. As best shown in FIG. 4C, the arm 234 has an arc-shaped cross section in a transverse plane perpendicular to the tab axis 228. Thus, a radially-inward arm surface 238 and a radially-outward arm surface 240 are each curved. The radially-inward arm surface 238 may be continuous with the annular inner surface 206.

**[0057]** The lip 236 may include a third contact surface 242 that extends radially outwardly from the radially-outward arm surface 240. The third contact surface 242 may be substantially perpendicular to the radially-outward arm surface 240. A sloped surface 244 extends from the third contact surface 242, radially inwardly toward the free end 232 of the arm 234. An upper lip surface 246 extends between the sloped surface 244 and the radially-inward arm surface 238.

**[0058]** The polymeric composite insert component 200 as shown includes three tabs 204. However, in other variations, the quantity of tabs 204 may be less than three or greater than three. For example, the quantity of tabs 204 may be two, four, or five (not shown). In certain embodiments, the tabs 204 may occupy greater than or equal to about 20% and less than or equal to about 85% of a total circumference of

the centrally-disposed opening **208**, optionally greater than or equal to about 20% and less than or equal to about 80%, optionally greater than or equal to about 20% and less than or equal to about 75%, optionally greater than or equal to about 20% and less than or equal to about 70%, optionally greater than or equal to about 20% and less than or equal to about 65%, optionally greater than or equal to about 20% and less than or equal to about 60%, optionally greater than or equal to about 20% and less than or equal to about 55%, optionally greater than or equal to about 20% and less than or equal to about 50%, optionally greater than or equal to about 25% and less than or equal to about 45%, optionally greater than or equal to about 30% and less than or equal to about 40%, optionally greater than or equal to about 32% and less than or equal to about 38%, optionally greater than or equal to about 34% and less than or equal to about 36%, and optionally about 35%. Each of the tabs **204** may be equally spaced about the central axis **210**. Thus, the tab axes **228** may be disposed about 120° from one another. However, in other embodiments, the tabs **204** may be unevenly spaced about the central axis **210** (not shown).

[0059] With reference to FIGS. 5A-7, a portion of a scroll compressor **260** is shown. The scroll compressor **260** includes a partition plate **262** and a floating seal assembly **264** that may be similar to the partition plate **22** and floating seal assembly **78** of the compressor **10** of FIG. 1. The scroll compressor **260** further includes a polymeric composite insert component **266** that is coupled to the partition plate **262** and engages the floating seal assembly **264**. Although the polymeric composite insert component **266** is shown as being disposed between the partition plate **262** and the floating seal assembly **264**, in other embodiments, the polymeric composite insert component **266** may be disposed between the partition plate **262** and a non-orbiting scroll (see e.g., non-orbiting scroll **66** of FIG. 1). Various components of the floating seal assembly **264** are the same as those shown in FIGS. 1-3. For brevity, floating seal assembly components previously discussed in the context of FIGS. 1-3 will not be reintroduced in subsequent discussion of the figures, unless pertinent to the features discussed herein.

[0060] The polymeric composite insert component **266** includes an annular body **268** and circumferentially-disposed tabs **270** similar to the annular body **202** and circumferentially-disposed tabs **204** of FIGS. 4A-4C. The annular body **268** includes a first annular inner surface **272**, a first centrally-disposed opening **274** (FIG. 5B), and a central axis **276** similar to the annular inner surface **206**, centrally-disposed opening **208**, and central axis **210** of FIGS. 4A-4C. The annular body **268** further includes a first side **278** disposed toward the partition plate **262** and a second side **280** disposed toward the floating seal assembly **264**. A first contact surface **282** of the first side **278** is defined by a circumferential barrel **284** and engages the partition plate **262**. A second contact surface **286** is substantially planar and engages the face seal **98** of the floating seal assembly **264**.

[0061] Each of the circumferentially-disposed tabs **270** includes a tab axis **288**, a fixed end **290**, a free end **292**, an arm **294**, and a lip **296** similar to the tab axis **228**, fixed end **230**, free end **232**, arm **234**, and lip **236** of the polymeric composite insert component **200** of FIGS. 4A-4C. Each arm **294** includes a radially-outward arm surface **298** similar to the radially-outward arm surface **240** of the polymeric composite insert component **200** of FIGS. 4A-4C. Each lip **296** includes a third contact surface **300** and an upper lip

surface **302** similar to the third contact surface **242** and upper lip surface **246** of the polymeric composite insert component of FIGS. 4A-4C.

[0062] The partition plate **262** includes a second annular inner surface **304** defining a second centrally-disposed opening **306** (FIG. 5B). The first and second centrally-disposed openings **274**, **306** are coaxial such that they are both aligned with the central axis **276**. The partition plate **262** further includes a top surface **308** and a bottom surface **310** opposite the top surface **308**. The top surface **308** is oriented toward a discharge muffler chamber (see, e.g., discharge muffler chamber **74** of FIG. 1) and the bottom surface **310** is oriented toward the polymeric composite insert component **266**.

[0063] The first contact surface **282** of the annular body **268** of the polymeric composite insert component **266** at least partially engages the bottom surface **310** of the partition plate **262**. The circumferentially-disposed tabs **270** project through the second centrally-disposed opening **306** of the partition plate **262**. The radially-outward arm surface **298** at least partially engages the second annular inner surface **304** of the partition plate **262**. The lips **296** of the circumferentially-disposed tabs **270** extend radially outwardly to engage an inner diameter **312** of the top surface **308** of the partition plate **262**. More specifically, the third contact surfaces **300** of the lips **296** engage the top surface **308** of the partition plate **262** to retain the polymeric composite insert component **266** on the partition plate **262**. While the polymeric composite insert component **266** is shown as being fixed to the partition plate **262**, a person of ordinary skill in the art would understand that it could alternatively be fixed to the floating seal assembly **264**. In such an embodiment, the circumferentially-disposed tabs **270** of the polymeric composite insert component **266** would project through a third centrally-disposed opening **313** (FIG. 5B) of the floating seal assembly **264** to couple the polymeric composite insert component **266** to the floating seal assembly **264** in a similar manner as described above with respect to the partition plate **262**.

[0064] In various aspects, the present teachings provide a method of attaching the polymeric composite insert component **266** to the partition plate **262**. The polymeric composite insert component **266** is brought to a bottom side **314** of the partition plate **262** so that the first side **278** of the polymeric composite insert component **266** is orientated toward the bottom surface **310** of the partition plate **262**. The central axis **276** of the polymeric composite insert component **266** is aligned with the second centrally-disposed opening **306** of the partition plate **262**. The polymeric composite insert component **266** is translated toward the partition plate **262** in an upward direction **316** substantially parallel to the central axis **276**. The upper lip surfaces **302** of the tabs **270** engage the partition plate **262** to deflect the tabs **270** radially inwardly toward one another and toward the central axis **270**. The lips **296** slide along the second annular inner surface **304** of the partition plate **262** until they clear the second centrally-disposed opening **306** of the partition plate **262**. The lips **296** then snap radially outwardly so that the radially-outward arm surface **298** engages the second annular inner surface **304** and the third contact surface **300** engages the top surface **308** of the partition plate **262**.

[0065] Although the first contact surface **282** and the third contact surface **300** are both shown as being in contact with the partition plate **262**, in other embodiments, the simulta-

neous contact of both the first contact surface 282 and the third contact surface 300 with the partition plate 262 is unnecessary. In one example, the circumferentially-spaced tabs 204 of polymeric composite insert component 266 may omit the lip 236 altogether. This configuration is possible because of a relatively small clearance between the floating seal assembly 264 and the partition plate 262. In this configuration, the arms 294 may be long enough to cover the relatively small clearance.

[0066] When the compressor 260 is in operation, the partition plate 262 may become deformed, particularly under high loads. Some deformation of the partition plate 262 may also occur when the compressor is not in operation (e.g., due to the cold rolling manufacturing process used to form the partition plate, press fit of the partition plate 262 to the shell 12 or the cap 14, or welding the partition plate 262 to the shell 12). Deflection of the partition plate 262 may cause a non-uniform pressure distribution at a first interface 318 defined between the bottom surface 310 of the partition plate 262 and the first contact surface 282 of the polymeric composite insert component 266. The non-uniform pressure distribution at the first interface 318 leads to a corresponding non-uniform pressure distribution at a second interface 320 defined between the second contact surface 286 of the polymeric composite insert component 266 and the face seal 98 of the floating seal assembly 264. The non-uniform pressure distributions at the first interface 318 and the second interface 320 can result in non-contact areas at the interfaces 318, 320, thereby creating leak paths and reducing overall compressor efficiency.

[0067] In one example, the partition plate 262 may include one or more lower stiffness regions 322. The lower stiffness region 322 may be a relatively flat lobe for mounting a pressure relief valve and a temperature relief valve (not shown), by way of non-limiting example. The lower stiffness region 322 deflects in a downward direction 324 parallel to the central axis 276 and opposite the upward direction 316. Downward deflection of the partition plate 262 creates relatively a high pressure region at the first interface 318 at the circumferential position of the lower stiffness region 322. Another higher pressure region may be present at a circumferential position opposite the lower stiffness region 322 (i.e., about 180° from the lower stiffness region 322 with respect to the central axis 276). The deflection of the partition plate 262 may also create corresponding lower pressure regions that are disposed between the higher pressure regions (e.g., about 90° from each the higher pressure regions, when there are two higher pressure regions). The higher pressure regions and lower pressure regions may be present at both the first interface 318 and the second interface 320.

[0068] In the present example, the deflection of the partition plate 262 may create a relatively high pressure region at a first circumferential location 326 on the polymeric composite insert component 266. The first circumferential location 326 may be axially aligned with the lower stiffness region 322 of the partition plate 262. Another higher pressure region is present at a second circumferential location 328 opposite the first circumferential location 326. Thus, the second circumferential location 328 is disposed about 180° from the first circumferential location 326 with respect to the central axis 276. A third circumferential location 330 may be circumferentially disposed between the first location 326 and the second location 328 and a fourth circumferential

location 332 may be circumferentially disposed between the first location 326 and the second location 328. The third circumferential location 330 may be disposed equidistant or about 90° between the first circumferential location 326 the second circumferential location 328. The fourth circumferential location 332 may be disposed equidistant or about 90° between the first circumferential location 326 and the second circumferential location 328. Thus, the fourth circumferential location 332 may be disposed opposite the third circumferential location 330 or about 180° from the third circumferential location 330. A person skilled in the art would understand that the principles of this disclosure apply equally regardless of the circumferential location of the deflection or the quantity of high and low pressure regions. Thus, the polymeric composite insert component 266 may be capable of providing a fluid seal between the partition plate 262 and the floating seal assembly 264 independent of the design and resulting deflection of the partition plate 262.

[0069] Inward deflection of the partition plate 262 at the second annular inner surface 306 may also cause decreased contact between the top surface 308 of the partition plate 262 and the third contact surface 300 of the lips 296. With reference to FIG. 7, the tab 270 is shown engaging the partition plate 262. A plane 334 is disposed perpendicular to the central axis 276. A tab angle 336 is defined between the plane 334 and the radially-outward arm surface 298. The tab angle 336 may be about 90°.

[0070] Referring now to FIG. 8, in other embodiments, another tab angle 340 may be defined between a plane 342 and a radially-outward arm surface 344, similar to the plane 334 and radially-outward arm surface 298 of FIG. 7. The tab angle 340 may be less than about 90°, optionally greater than or equal to about 75° and less than about 90°, optionally greater than or equal to about 80° and less than about 90°, optionally greater than or equal to about 81° and less than about 90°, optionally greater than or equal to about 82° and less than about 90°, optionally greater than or equal to about 83° and less than about 90°, optionally greater than or equal to about 84° and less than about 90°, optionally greater than or equal to about 85° and less than about 90°, optionally greater than or equal to about 86° and less than about 90°, optionally greater than or equal to about 87° and less than about 90°, and optionally greater than or equal to about 88° and less than about 90°. Thus, the tab angle 340 may provide an undercut that creates a gap 345. The gap 345 may accommodate radially-inward deflection of a partition plate 346. Thus, a third contact surface 347 of a tab 348 of a polymeric composite insert component 350 may remain in contact with a top surface 352 of the partition plate 346 during radially-inward deflection of the partition plate 346.

[0071] Referring now to FIGS. 9A-9B, another polymeric composite insert component 360 is shown. The polymeric composite insert component 360 includes an annular body 362 and an axial projection comprising a plurality of circumferentially-disposed tabs 364 extending therefrom. The annular body 362 has an annular inner surface 366 defining a centrally-disposed opening 368. A central axis 370 extends through the centrally-disposed opening 368. The annular body 362 has a first side 372 and a second side 374 opposite the first side 372. The first side 372 includes a first contact surface 376 and the second side 374 includes a second contact surface 378.

[0072] The circumferentially-disposed tabs 364 may be similar to the circumferentially-disposed tabs 270 of FIGS.

5A-7. The annular body 362 includes a plurality of circumferentially-disposed openings 380. The circumferentially-disposed openings 380 are disposed adjacent to and in a radially outward position from the respective plurality of circumferentially-disposed tabs 364. The openings 380 may decrease a stiffness of the tabs 364 at a fixed end 382 to enable the tabs 364 to more readily flex radially inwardly when the polymeric composite insert component 360 is assembled to a partition or a floating seal assembly.

[0073] The first contact surface 376 defines a circumferential waveform shape defining at least two valleys 384 and at least two peaks 386. The valleys 384 may be defined at a first circumferential location 388 and a second circumferential location 390. The peaks 386 may be defined at a third circumferential location 392 and a fourth circumferential location 394. The valleys 384 and peaks 386 may be defined in an axial direction parallel to the central axis 370 to complement axial deflection of a partition plate. For example, the partition plate may deflect axially downwardly at the first circumferential location 388 and the second circumferential location 390 and axially upwardly at the third circumferential location 392 and the fourth circumferential location 394. Thus, a magnitude of pressure difference between higher pressure areas and lower pressure areas may be minimized. In some embodiments, pressure at the first contact surface 376 may be relatively uniform under normal operating conditions.

[0074] The second contact surface 378 may be relatively planar. The second contact surface 378 may be substantially perpendicular to the central axis 370. The first circumferential location 388 and the second circumferential location 390 may have a first thickness 396 with respect to the second contact surface 378. The third circumferential location 392 and the fourth circumferential location 394 may have a second thickness 398. The second thickness 398 may be greater than the first thickness 396. In some embodiments, a difference between the second thickness 398 and the first thickness 396 may be greater than about 0 mm and less than or equal to about 0.2 mm, optionally greater than or equal to about 0.01 mm and less than or equal to about 0.19 mm, optionally greater than or equal to about 0.02 mm and less than or to about 0.18 mm, optionally greater than or equal to about 0.03 mm and less than or to about 0.17 mm, optionally greater than or equal to about 0.04 mm and less than or to about 0.16 mm, optionally greater than or equal to about 0.05 mm and less than or to about 0.15 mm, optionally greater than or equal to about 0.06 mm and less than or to about 0.14 mm, optionally greater than or equal to about 0.07 mm and less than or to about 0.13 mm, optionally greater than or equal to about 0.08 mm and less than or to about 0.12 mm, optionally greater than or equal to about 0.09 mm and less than or to about 0.11 mm, and optionally about 0.1 mm.

[0075] The first circumferential location 388 may be disposed opposite the second circumferential location 390. Thus, the first circumferential 388 location may be disposed 180° from the second circumferential location 390. The third circumferential location 392 and the fourth circumferential location 394 may be disposed circumferentially between the first circumferential location 388 and the second circumferential location 390. The third circumferential 392 location may be disposed between the first circumferential location 388 and the second circumferential location 390, about 90° from each of the first circumferential location 388 and the

second circumferential location 390. The fourth circumferential 394 location may be disposed between the first circumferential location 388 and the second circumferential location 390, about 90° from each of the first circumferential location 388 and the second circumferential location 390. The third circumferential location 392 is disposed opposite the fourth circumferential location 394. Thus, the third circumferential 394 location is disposed 180° from the fourth circumferential location 394.

[0076] The polymeric composite insert component 360 may further include an anti-rotation feature (not shown). The anti-rotation feature may prevent the polymeric composite insert component from rotating about the central axis 370 with respect to the partition plate. By way of non-limiting example, the anti-rotation feature may include a hole, notch, slot, or other receptacle that engages a protrusion in the partition plate. Alternatively, the protrusion may be present on the polymeric composite insert component 360 and the receptacle may be present on the partition plate.

[0077] In other embodiments, the first side 422 may include different geometry to complement and conform to expected deflection of the partition plate. In one example, the first side 422 may have other quantities of alternating peaks and valleys, such as three peaks and three valleys, four peaks and four valleys, or ten peaks and ten valleys. In another example, the first side 422 may be a sloped surface having a single high point (i.e., a single peak). In yet another example, the first side 422 may have a single discrete hump or protrusion that does not extend circumferentially around the entire first side 422.

[0078] In still other embodiments, the second side 424 may be non-planar. For example, the second side 424 may have geometry to complement and conform to expected deflection of the floating seal assembly. In one example, the second side 424 may include a circumferential waveform shape having alternating peaks and valleys, similar to the peaks 386 and valleys 384 of the first side 422 shown in FIGS. 9A-9B. In another example, the second side 424 may have a discrete high point or low point.

[0079] Referring to FIGS. 10A-10B, yet another polymeric composite insert component 410 is shown. The polymeric composite insert component 410 includes an annular body 412 and a plurality of circumferentially-disposed tabs 414 extending therefrom. The annular body 412 has an annular inner surface 416 defining a centrally-disposed opening 418. A central axis 420 extends through the centrally-disposed opening 418. The annular body 412 has a first side 422 and a second side 424 opposite the first side 422. The first side 422 includes a first contact surface 426 and the second side 424 includes a second contact surface 428. The circumferentially-disposed tabs 414 may be similar to the circumferentially-disposed tabs 270 of FIGS. 5A-7. The annular body 412 includes a plurality of circumferentially-disposed openings 430 similar to the circumferentially-disposed openings 380 of FIGS. 9A-9B.

[0080] The first contact surface 426 may define a circumferential protrusion 432. The circumferential protrusion 432 may be disposed in a radially outward position from the circumferentially-disposed tabs 414. The circumferential protrusion 432 may be hump or barrel-shaped. The circumferential protrusion 432 may increase average pressure between the polymeric composite insert component 410 and

a partition plate by decreasing average contact area. The increased pressure reduces leak paths to provide a better fluid seal.

[0081] In some embodiments, the first contact surface **426** may include more than one circumferential protrusions **432**. For example, the first contact surface **426** may include a first circumferential protrusion and a second circumferential protrusion disposed in a radially outward position from the first circumferential protrusion. Thus, a circumferential void space may be disposed between the first circumferential protrusion and the second circumferential protrusion. The inclusion of multiple circumferential protrusions may further improve the fluid seal.

[0082] With reference to FIGS. 11A-11C, yet another polymeric composite insert component **440** is shown. The polymeric composite insert component **440** includes an annular body **442** and an axial projection including a plurality of circumferentially-disposed tabs **444**. The annular body **442** may be similar to the annular body **268** of FIGS. 5A-7. Thus, the annular body **442** may include an annular inner surface **446** defining a centrally-disposed opening **448**. [0083] Each of the circumferentially-disposed tabs **444** includes a fixed end **450** and a free end **452**. The circumferentially-disposed tab **444** includes a circumferential connector **454** disposed at the fixed end **450**, an arm **456** extending between the fixed end **450** and the free end **452**, and a circumferentially extending lip **458** disposed at the free end **452**. The tab **444** is connected to the annular inner surface **446** of the annular body **442** by the circumferential connector **454**.

[0084] The free ends **452** of the tabs **444** can flex radially inwardly when the polymeric composite insert component **440** is assembled to a partition plate or a floating seal assembly. The tabs **444** have a rectangular cross section at a transverse plane perpendicular to a central axis **460** of the annular body **442**. The tabs **444** having a rectangular cross section have a lower stiffness than the tabs **204** of FIGS. 4A-4C, which have arc-shaped cross sections. Thus, the tabs **444** having a rectangular cross section exhibit less resistance to flexing radially inwardly during assembly to the partition plate or the floating seal assembly. Furthermore, a flex axis for the tabs **444** fixed to the annular inner surface **446** is lower compared to the tabs **204** fixed to the tab surface **218** of FIGS. 4A-4C. Thus, the tabs **444** have a longer lever arm than the tabs **204** and can therefore be radially-inwardly flexed with less effort.

[0085] The foregoing description of the embodiments has been provided for purposes of illustration and description. It is not intended to be exhaustive or to limit the disclosure. Individual elements or features of a particular embodiment are generally not limited to that particular embodiment, but, where applicable, are interchangeable and can be used in a selected embodiment, even if not specifically shown or described. The same may also be varied in many ways. Such variations are not to be regarded as a departure from the disclosure, and all such modifications are intended to be included within the scope of the disclosure.

What is claimed is:

1. A polymeric composite insert component for a scroll compressor comprising a polymer and at least one reinforcing or lubricating particle, the polymeric composite insert component comprising:

an annular body comprising a first annular inner surface defining a first centrally-disposed opening that has a

central axis extending therethrough, the annular body having a first side and a second side opposite the first side, the first side comprising a first contact surface configured to engage a partition plate and the second side comprising a second contact surface configured to engage a floating seal assembly; and

an axial projection extending from the first side of the annular body, the axial projection being configured to engage the partition plate, wherein the polymeric composite insert component is configured to fluidly seal both a first interface defined between the first contact surface and the partition plate, and a second interface defined between the second contact surface and the floating seal assembly during operation of the scroll compressor.

2. The polymeric composite insert component of claim 1, wherein the axial projection comprises a plurality of circumferentially-disposed tabs configured to engage the partition plate to couple the polymeric composite insert component to the partition plate, each respective circumferentially-disposed tab projecting axially from the first side of the annular body.

3. The polymeric composite insert component of claim 2, wherein each respective circumferentially-disposed tab of the plurality further comprises a fixed end and a free end, the fixed end being connected to the annular body and the free end being configured to flex in a radially inward direction toward the central axis.

4. The polymeric composite insert component of claim 3, wherein each respective circumferentially-disposed tab of the plurality comprises an arm extending between the fixed end and the free end, and a radially-outwardly extending lip disposed at the free end, the arm being configured to extend through a second centrally-disposed opening in the partition plate, and the lip having a third contact surface configured to engage the partition plate.

5. The polymeric composite insert component of claim 4, wherein each arm comprises a radially-outward arm surface configured to engage a second annular inner surface of the partition plate, and a tab angle is defined between the radially-outward arm surface and a transverse plane substantially perpendicular to the central axis, the tab angle being less than or equal to about 90°.

6. The polymeric composite insert component of claim 2, wherein each respective circumferentially-disposed tab has a rectangular cross section in a transverse plane substantially perpendicular to the central axis.

7. The polymeric composite insert component of claim 1, wherein the first contact surface defines a circumferential waveform shape defining at least two valleys in a first circumferential location and a second circumferential location and at least two peaks in a third circumferential location and a fourth circumferential location, the first circumferential location being disposed opposite the third circumferential location and the second circumferential location being disposed opposite the fourth circumferential location.

8. The polymeric composite insert component of claim 7, wherein:

the second contact surface is substantially planar;

the annular body has a first thickness at the first and the second circumferential locations; and

the annular body has a second thickness at the third circumferential location and the fourth circumferential location, the second thickness being greater than the first thickness.

9. The polymeric composite insert component of claim 1, wherein the first contact surface of the annular body includes a circumferential protrusion.

10. The polymeric composite insert component of claim 1, wherein:

the polymer is a thermoplastic polymer selected from the group consisting of: polyaryletherketone (PAEK), polyetherketone (PEK), polyetheretherketone (PEEK), polyetheretheretherketone (PEEEK), polyetherketoneketone (PEKK), polyetheretherketoneketone (PEEKK) polyetherketoneetheretherketone (PE-KEEK), polyetheretherketonetherketone (PEEKEK), poly(phenylene sulphide) (PPS), poly(sulphone) (PS), polyamide imide (PAI), polyimide (PI), polyphthalimide (PPA), polyetherimide (PEI), and combinations thereof; and

the at least one reinforcing or lubricating particle is selected from the group consisting of: polytetrafluoroethylene (PTFE), molybdenum disulfide ( $\text{MoS}_2$ ), tungsten disulfide ( $\text{WS}_2$ ), antimony trioxide, hexagonal boron nitride, carbon fiber, graphite, graphene, lanthanum fluoride, carbon nanotubes, polyimide, polybenzimidazole (PBI), and combinations there.

11. The polymeric composite insert component of claim 1, wherein the polymer is a thermoset polymer selected from the group consisting of: epoxy, polyester, phenolic, and imides, such as polyamide imide (PAI) and polyimide (PI).

12. A scroll compressor comprising:

a polymeric composite insert component comprising a polymer and at least one reinforcing or lubricating particle, wherein the polymeric composite insert component further comprises:

an annular body having a first annular inner surface defining a first centrally-disposed opening having a central axis extending therethrough; and

an axial projection extending from the annular body;

a partition plate comprising a second centrally-disposed opening, wherein the second centrally-disposed opening is aligned with the first centrally-disposed opening with respect to the central axis; and

a floating seal assembly having a third centrally-disposed opening, wherein the third centrally-disposed opening is aligned with the first centrally-disposed opening and the second centrally-disposed opening with respect to the central axis, the polymeric composite insert component is disposed between the partition plate and the floating seal assembly, and the polymeric composite insert component is configured to fluidly seal a first interface defined between the polymeric composite insert component and the partition plate, and a second interface defined between the polymeric composite insert component and the floating seal assembly during operation of the scroll compressor.

13. The scroll compressor of claim 12, wherein the axial projection comprises a plurality of circumferentially-disposed tabs projecting axially from the annular body, and the circumferentially-disposed tabs extend through the second centrally-disposed opening to engage the partition plate to couple the polymeric composite insert component to the floating seal assembly.

14. The scroll compressor of claim 13, wherein each respective circumferentially-disposed tab of the plurality comprises a fixed end connected to the annular body, a free end configured to flex in a radially-inward direction toward the central axis, an arm extending between the fixed end and the free end, and a radially-outwardly extending lip disposed at the free end, the lip engaging the partition plate to couple the polymeric composite insert component to the partition plate.

15. The scroll compressor of claim 14, wherein each arm comprises a radially-outward arm surface configured to engage a second annular inner surface of the partition plate, and an angle is defined between the radially-outward arm surface and a transverse plane substantially perpendicular to the central axis, the angle being less than about  $90^\circ$ .

16. The scroll compressor of claim 14, wherein each respective circumferentially-disposed tab has a rectangular cross section in a transverse plane perpendicular to the central axis.

17. The scroll compressor of claim 13, wherein the polymeric composite insert component comprises a first contact surface at the first interface, the first contact surface including a circumferential protrusion disposed in a radially outward position from the plurality of circumferentially-disposed tabs.

18. The scroll compressor of claim 12, wherein the polymeric composite insert component comprises a first contact surface at the first interface, the first contact surface defining a circumferential waveform shape defining at least two valleys in a first circumferential location and a second circumferential location and at least two peaks a third circumferential location and a fourth circumferential location, the first circumferential location being disposed opposite the third circumferential location and the second circumferential location being disposed opposite the fourth circumferential location with respect to the central axis.

19. The scroll compressor of claim 12, wherein:

the polymer is a thermoplastic polymer selected from the group consisting of: polyaryletherketone (PAEK), polyetherketone (PEK), polyetheretherketone (PEEK), polyetheretheretherketone (PEEEK), polyetherketoneketone (PEKK), polyetheretherketoneketone (PEEKK) polyetherketoneetheretherketone (PE-KEEK), polyetheretherketonetherketone (PEEKEK), poly(phenylene sulphide) (PPS), poly(sulphone) (PS), polyamide imide (PAI), polyimide (PI), polyphthalimide (PPA), polyetherimide (PEI), and combinations thereof; and

the at least one reinforcing or lubricating particle is selected from the group consisting of: polytetrafluoroethylene (PTFE), molybdenum disulfide ( $\text{MoS}_2$ ), tungsten disulfide ( $\text{WS}_2$ ), antimony trioxide, hexagonal boron nitride, carbon fiber, graphite, graphene, lanthanum fluoride, carbon nanotubes, polyimide, polybenzimidazole (PBI), and combinations thereof.

20. A method of assembling a scroll compressor comprising:

aligning a first centrally-disposed opening of a polymeric composite insert component with a second centrally-disposed opening of a partition plate along a central axis, wherein the polymeric composite insert component comprises a polymer and at least one reinforcing or lubricating particle and defines an annular body



comprising the first centrally-disposed opening having the central axis extending therethrough;

orienting a plurality of circumferentially-disposed tabs on the polymeric composite insert component toward the partition plate, each respective circumferentially-disposed tab of the plurality projecting axially from a side of the annular body and comprising a fixed end connected to the annular body, a free end opposite the fixed end, an arm extending between the fixed end and the free end, and a radially-outwardly extending lip disposed at the free end;

contacting a sloped surface of the free end of the lip of each respective circumferentially-disposed tab with the partition plate; and

translating the polymeric composite insert component toward the partition plate and causing the lips of the respective circumferentially-disposed tabs of the plurality to deflect radially inwardly until the lips snap radially outwardly and engage the partition plate to retain the polymeric composite insert component on the partition plate, and a surface defined by the side of the annular body engages the partition plate, wherein the polymeric composite insert component is configured to fluidly seal an interface defined between the surface and the partition plate during operation of the scroll compressor.

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