



Flex System General Limitations

The Flex is the most accurate and adjustable tool Fancort manufactures but it does have limitations:

- ▶ Standard adjustable cut length depending on the part/package size for the standard FLEX is 0.450 inches to 3.0 inches max.
- ▶ Maximum lead thickness is 0.012 inches.
- ▶ Large round leads cannot be handled.
- ▶ One sided parts cannot be handled.
- ▶ Package thickness maximum 0.150 inches above and below the forming line.
Standard clearance for side exit parts/packages up to 0.300 inches. (Special versions for thick parts are available. Contact your Fancort Industries representative for further information).
- ▶ External centering nests are required to handle bottom brazed parts.
- ▶ 0.500 inches minimum cut setting in most cases.
- ▶ Total lead length from body of part to trimmed leads has a maximum limit of 0.120 inches. This includes the sum of the shoulder plus foot length.
- ▶ Minimum shoulder needs to be 0.035 inches and a minimum STD JEDEC foot of 0.025 inches.
- ▶ Contact your Fancort representative when the foot is greater than 0.050 inches (see figure below)
- ▶ Due to lead thickness and spring-back; "sticking" is sometimes an issue with a Flex system. This happens mainly because of gold, or solder, build-up on the tool members. When forming devices of this type frequent cleaning or use of dedicated tools is recommended.

Note: The bars or tie bar corners need to be removed prior to using the tool. You can use Fancort P/N F-3A found under cutters in our catalog or a high quality scissors, although scissors are not recommended since it can introduce skew.

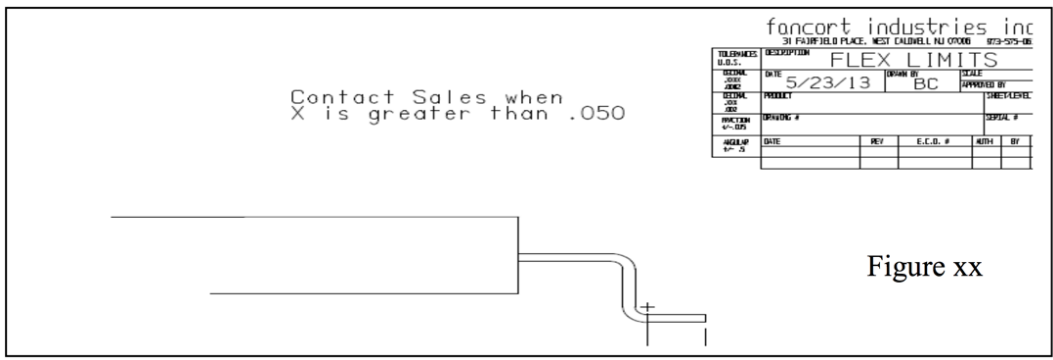


Figure xx

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