



## FANCORT FLEX SYSTEM - GENERAL LIMITATIONS – PM FSFA5000L 19\_FEBRUARY\_2014

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.

