



PRE TINNED PARTS AND HOW THEY AFFECT THE TOOLS AND THE LEAD FORMING PROCESS

1. Do not use pre-tinned parts if possible, Tinning will cause your parts to stick to the forming members on the bottom of the tool and require much additional cleaning. If you choose to use pre tinned parts; dedicated tools are a better choice than adjustable tools because they have and can have lifter built in to overcome the parts sticking ... the flex because of all of it moving part is very subject to sticking and tinning adds to this problem
2. High pin count quads, also, can be subject to sticking because of all of the forming and cutting forces required. The Gold is not as bad as the solder but it, too, will adhere to the forming members and build up over time.... again dedicated tools can deal with this better.
3. When using the tool with pre tinned parts clean frequently both the top and bottom of the tool.
4. If you can Increase the radius both on the foot and sometimes the shoulder this could help.
5. Different plating can, also, be tried, but this is a trial and error thing that would take much time.
6. Sometimes increasing the clamping width of the anvils could help; this would require a new wider shoulder and maybe an increase in the tip to tip.
7. You can also add to the clearance in the tool, but this will allow the parts leg to spring back more than the normal 4-7 degrees.
8. For high running parts and no sticking we can provide dedicated tools with mechanical lifters.

Please contact me if you have any questions....

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