

## XI. COMMON LEAD FORMING PROCESS QUESTIONS:

*Q: How close can the first bend be to the component body?*

A: Depending on the lead material thickness and pitch, from .035" - .050" minimum edge distance. There is a positive relationship between increased clamping area and tip-to-tip dimension and consistency in coplanarity and lead alignment.

*Q: How close of a tolerance in the tip-to-tip dimension can one reasonably expect from Fancort equipment?*

A: Typically +/- .005". As low as +/- .002".

Variable factors affecting this tolerance include:

1. Lead exit position
2. Lead thickness variation
3. Total available clamping area

Note: The impact of springback is always greater on top brazed components because of the leg length; therefore, tip-to-tip tolerances may need to be higher.

*Q: How do you control the standoff height (component height above the PCB)?*

A: 1. Manual adjustment via micrometer-driven wedge on standard form and trim equipment requires pre-measurement of components.

2. Automatic height adjustment via microprocessor-controlled stepper motor on "Floating Anvil" equipment; no pre-measurement required.

*Q: How are components located in the equipment nest when body dimensions vary?*

A: Lead-frame registration on quadpack tools; centering mechanism or interchangeable nests for flatpacks.