

October 13, 2010

The proper method for setting the correct edge is as follows:

Determine the correct edge distance (of the insert) using the formula $D - M/2 - (E + SB) = \text{Edge}$

Determine the difference between the insert you have and the edge distance (ED) that is needed.

Determine the body width (M)

Using a caliper set & lock the backstop to the distance of M (body width) + ED (edge difference). See figure 1

While placing the component into the tool slide the component against the backstop, place the hold down over the component and you are ready to form the leads. See figure 2.

Using a caliper set this gap to M + ED

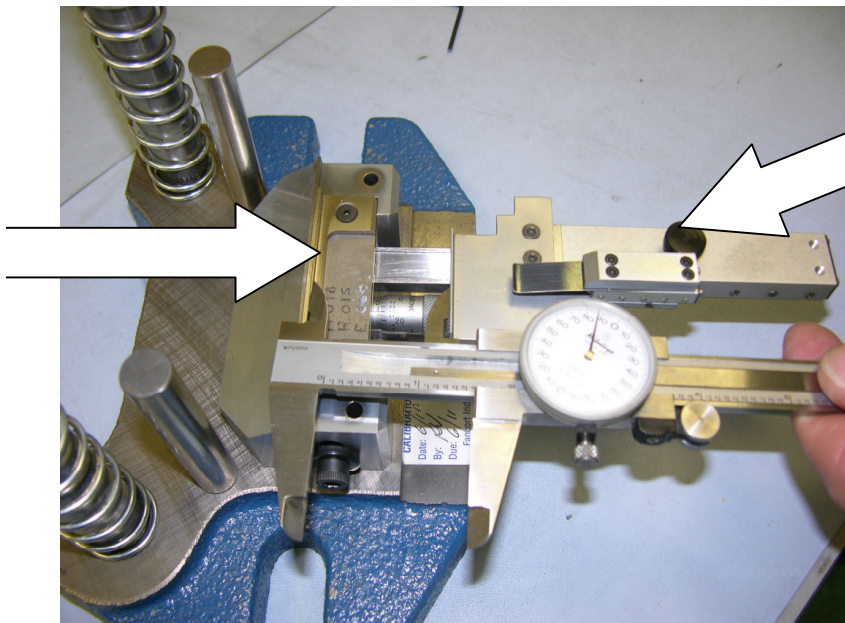


Figure 1

Gap is set and component is ready to form

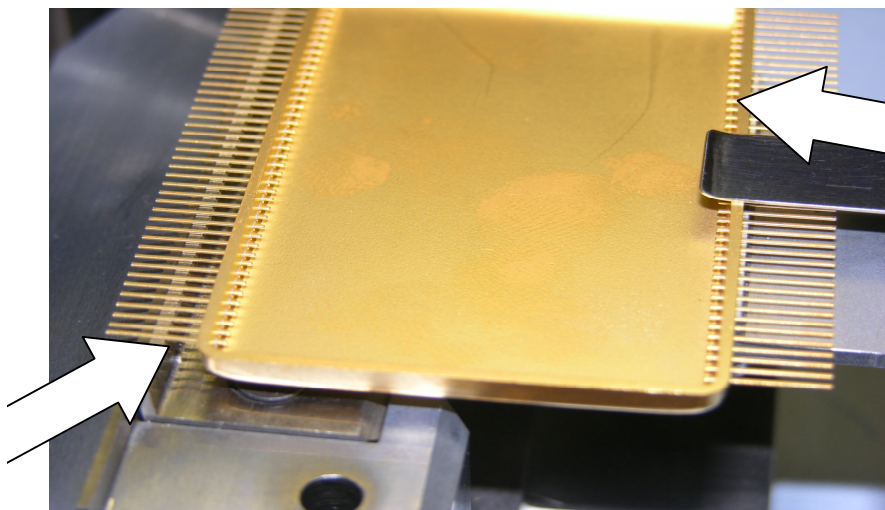


Figure 2