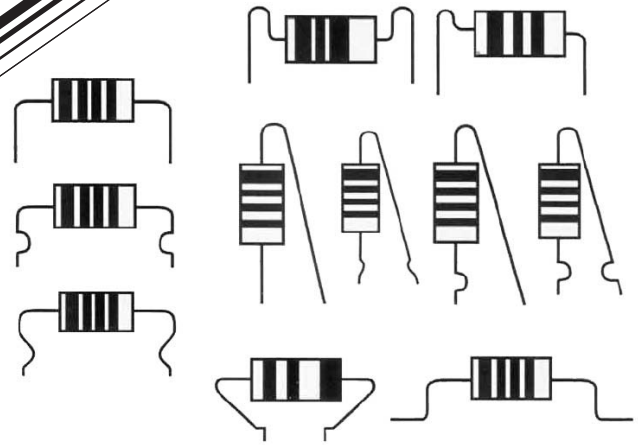


GPD Global

611 Hollingsworth Street
Grand Junction, CO 81505

Tel: (970) 245-0408 Fax: (970) 245-9674
Web: www.gpd-global.com



CF-8 Component Forming Dies

CF-8 Component Forming Dies are precisely manufactured to form Axial Components accurately into horizontally and vertically mounted configurations.

DIES CAN BE SELECTED AND ORDERED BY ACCESSING THE BRIEF INDEX LOCATED AT THE FRONT OF THE CATALOG. THE INDEX IS A NUMERICAL LISTING OF DIE NUMBERS AND A BRIEF EXPLANATION OF EACH. THESE SAME DIES ARE LISTED AGAIN IN THE MAIN BODY OF THE CATALOG AND ILLUSTRATE DIE FUNCTION AND LIMITATION IN A DETAILED FORMAT.

WHEN ORDERING SPECIAL * DIES OR CONFIGURATIONS NOT SHOWN IN THE CATALOG ADDITIONAL INFORMATION IS REQUIRED IN THE FORM OF COMPONENT SAMPLES, P.C. BOARD SAMPLES, AND DESIRED COMPONENT SHAPE INFORMATION.

* SPECIAL DIES MAY BE SUBJECT TO A PRE-DETERMINED ENGINEERING CHARGE. IN SOME CASES WE MAY NOT BE ABLE TO ACCOMPLISH THE REQUESTED FORM DUE TO MACHINE AND DIE LIMITATIONS.

WE WOULD LIKE TO HELP YOU IN ANY WAY WITH YOUR FORMING NEEDS. PLEASE CALL 970-245-0408

STANDARD DELIVERY TIMES FOR DIES:

STANDARD DIES	STOCK TO 4 WEEKS
MODIFICATIONS OR SPECIAL DIES	6-8 WEEKS

CF-8 Die Catalog for Component Forming Dies

TABLE OF CONTENTS

TYPE & P/N	DESCRIPTION	PAGES
HORIZONTAL	(for sizes other than standard, add \$100.00)	1 & 2
800A-0030	.030 Std Horizontal Die Set	
800A-0040	.040 Std Horizontal Die Set	
800A-0060	.060 Std Horizontal Die Set	
800A-0080	.080 Std Horizontal Die Set	
800A-0100	.100 Std Horizontal Die Set	
MODIFIED HORIZONTAL		3 & 4
800B-0030	.030 Modified Horizontal Die Set	
800B-0040	.040 Modified Horizontal Die Set	
800B-0060	.060 Modified Horizontal Die Set	
800B-0080	.080 Modified Horizontal Die Set	
800B-0100	.100 Modified Horizontal Die Set	
SINGLE PIN		5 & 6
800D-6030	.030 Station #6	
800D-7030	.030 Station #7	
800D-6040	.040 Station #6	
800D-7040	.040 Station #7	
800D-6060	.060 Station #6	
800D-7060	.060 Station #7	
800D-6080	.080 Station #6	
800D-7080	.080 Station #7	
800D-6100	.100 Station #6	
800D-7100	.100 Station #7	
VERTICAL PARALLEL DIE KITS		7 & 8
800H-1100	.015/ .062 (7 piece)	
800H-1000	.015/ .030 (3 piece)	
800H-3000	.030/ .045 (3 piece)	
800H-4000	.045/ .062 (3 piece)	
TYPE #2A STRESS RELIEF KIT .015/ .040		9 & 10
800L-002A	Type #2A Stress Relief Kit .015/ .040	

= requires purchase of secondary exit chute package

* = available on machines after 9/1/89 or CF8s upgraded with extended stroke capability in Stations 4&5

TYPE & P/N	DESCRIPTION	PAGES
CF-8 NOTCHED PLATE KIT		35
800L-0NPK	CF-8 Notched Plate Kit	
CENTER-TO-CENTER DIE SET		11 & 12
800C-0200	1/8 Watt 200 CTC Die Set	
800C-1000	1000 CTC Die Set	
UNDERFORMING DIE SET (6 PIECE) (previously 800I-0000)		13 & 14
800I-0040	Under forming Die Set with .040 Pin Die	
800I-0060	Under forming Die Set with .060 Pin Die	
800I-0080	Under forming Die Set with .080 Pin Die	
REFLOW DIES		15 & 16
800J-0030	Reflow Die (30)	
800J-0035	Reflow Die (35)	
800J-0040	Reflow Die (40)	
800J-0045	Reflow Die (45)	
800J-0050	Reflow Die (50)	
800J-0055	Reflow Die (55)	
800J-0060	Reflow Die (60)	
800J-0065	Reflow Die (65)	
800J-0070	Reflow Die (70)	
800J-0080	Reflow Die (80)	
800J-0090	Reflow Die (90)	
800J-0100	Reflow Die (100)	
800J-0110	Reflow Die (110)	
800J-0120	Reflow Die (120)	
800J-0130	Reflow Die (130)	
LOCK-IN KIT (14 PIECE DIE KIT)		18, 19 & 20
800F-1000	.015/ .030 with .040 Modified Horizontal	
800F-1200	.015/ .025 with .040 Modified Horizontal	
800F-2000	.025/ .035 with .040 Modified Horizontal	
800F-3000	.030/ .045 with .060 Modified Horizontal	
800F-4000	.045/ .062 with .060 Modified Horizontal	

= requires purchase of secondary exit chute package

* = available on machines after 9/1/89 or CF8s upgraded with extended stroke capability in Stations 4&5

LOCK-IN KIT (6 PIECE DIE KIT)		18, 19 & 20
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800P-0900	Lock-In Kit with .015/.030 (AA) Dimple
800P-1000	Lock-In Kit with .015/ .030 (A) Dimple
800P-1100	Lock-In Kit with .015/ .030 (B) Dimple
800P-1200	Lock-In Kit with .015/ .030 (C) Dimple
800P-1300	Lock-In Kit with .015/ .030 (D) Dimple
800P-2900	Lock-In Kit with .030/.045 (AA) Dimple
800P-3000	Lock-In Kit with .030/ .045 (A) Dimple
800P-3100	Lock-In Kit with .030/ .045 (B) Dimple
800P-3200	Lock-In Kit with .030/ .045 (C) Dimple
800P-3300	Lock-In Kit with .030/ .045 (D) Dimple
800P-3900	Lock-In Kit with .045/.062 (AA) Dimple
800P-4000	Lock-In Kit with .045/ .062 (A) Dimple
800P-4100	Lock-In Kit with .045/ .062 (B) Dimple
800P-4200	Lock-In Kit with .045/ .062 (C) Dimple
800P-4300	Lock-In Kit with .045/ .062 (D) Dimple

FLUSHMOUNT LOCK-IN (14 PIECE KIT)		21 & 22
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800M-1000	.015 / .030 with .040 Modified Horizontal
800M-3000	.030 / .045 with .060 Modified Horizontal
800M-4000	.045 / .062 with .060 Modified Horizontal

LOCK-IN KIT WITH KNIFE (14 PIECE DIE KIT)	* #	23 & 24
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800G-1000	.015 / .030 (.030/ .040 Protrusion)
800G-1100	.015 / .030 (.045/ .055 Protrusion)
800G-1200	.015 / .025 (.045/ .055 Protrusion) w/.040 modified horizontal
800G-2000	.025 / .035 (.045/ .055 Protrusion) w/.040 modified horizontal
800G-3000	.030 / .045 (.030/ .040 Protrusion)
800G-3100	.030 / .045 (.045/ .055 Protrusion)
800G-4000	.045 / .062 (.030/ .040 Protrusion)
800G-4100	.045 / .062 (.045/ .055 Protrusion)

= requires purchase of secondary exit chute package
* = available on machines after 9/1/89 or CF8s upgraded with extended stroke capability in Stations 4&5

TYPE & P/N	DESCRIPTION	PAGES
LOCK-IN KIT WITH KNIFE (6 PIECE DIE KIT)		* # 23 & 24
800R-0900	.015/.030 (AA) Dimple (.045/ .055 Protrusion)	
800R-1000	.015/ .030 (A) Dimple (.045/ .055 Protrusion)	
800R-1100	.015/ .030 (B) Dimple (.045/ .055 Protrusion)	
800R-1200	.015/ .030 (C) Dimple (.045/ .055 Protrusion)	
800R-1300	.015/ .030 (D) Dimple (.045/ .055 Protrusion)	
800R-2900	.030/.045 (AA) Dimple (.045/ .055 Protrusion)	
800R-3000	.030/ .045 (A) Dimple (.045/ .055 Protrusion)	
800R-3100	.030/ .045 (B) Dimple (.045/ .055 Protrusion)	
800R-3200	.030/ .045 (C) Dimple (.045/ .055 Protrusion)	
800R-3300	.030/ .045 (D) Dimple (.045/ .055 Protrusion)	
800R-3900	.045/.062 (AA) Dimple (.045/ .055 Protrusion)	
800R-4000	.045/ .062 (A) Dimple (.045/ .055 Protrusion)	
800R-4100	.045/ .062 (B) Dimple (.045/ .055 Protrusion)	
800R-4200	.045/ .062 (C) Dimple (.045/ .055 Protrusion)	
800R-4300	.045/ .062 (D) Dimple (.045/ .055 Protrusion)	
STAND OFF DIE SET (4 PIECE)		25 & 26
800E-1000	.015/ .030 Stand Off Die Set	
800E-3000	.030/ .045 Stand Off Die Set	
800E-4000	.045/ .062 Stand Off Die Set	
STAND OFF DIE SET (6 PIECE)		25 & 26
800E-1100	.015/ .030 with 040 Modified Horizontal Dies	
800E-3100	.030/ .045 with 060 Modified Horizontal Dies	
800E-4100	.045/ .064 with 060 Modified Horizontal Dies	
STAND OFF DIE SET WITH KNIFE (6 PIECE)		* # 27 & 28
800S-1000	.015/ .030 with .040 Modified Horizontal Dies (.045/ .055 Protrusion)	
800S-3000	.030/ .045 with .060 Modified Horizontal Dies (.045/ .055 Protrusion)	
800S-4000	.045/ .062 with .060 Modified Horizontal Dies (.045/ .055 Protrusion)	
SECONDARY CUTTING DIES		* 29 & 30
800K-0000	Secondary Cutting Dies	
830-705	Secondary Exit Chute Package	
830-700	Secondary Exit Chute Kit (includes Shields)	

= requires purchase of secondary exit chute package

* = available on machines after 9/1/89 or CF8s upgraded with extended stroke capability in Stations 4&5

SPECIAL DOUBLE DIMPLE DIES WITH SECONDARY CUT (6 PIECE)		31
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800N-6000	with .030 Modified Horizontal Die, Flush Mount only (.050/ .060 Protrusion)
800N-7000	with .030 Modified Horizontal Die, Stand-Off, Lock-In (.050/ .060 Protrusion)
800N-8000	with .030 Modified Horizontal Die, Stand-Off, Lock-In (.050/ .060 Protrusion)
800N-9000	with .040 Modified Horizontal Die, Stand-Off, Lock-In (.050/ .060 Protrusion)

HALF PIN		33 & 34
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800T-6040	.020 Station #6
800T-7040	.020 Station #7
800T-6060	.030 Station #6
800T-7060	.030 Station #7
800T-6070	.035 Station #6
800T-7070	.035 Station #7
800T-6080	.040 Station #6
800T-7080	.040 Station #7
800T-6100	.050 Station #6
800T-7100	.050 Station #7
800T-6120	.060 Station #6
800T-7120	.060 Station #7
800T-6140	.070 Station #6
800T-7140	.070 Station #7
800T-6160	.080 Station #6
800T-7160	.080 Station #7

= requires purchase of secondary exit chute package

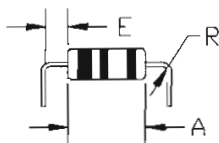
* = available on machines after 9/1/89 or CF8s upgraded with extended stroke capability in Stations 4&5

HORIZONTAL BEND DIES.

HORIZONTAL BEND DIES FORM COMPONENT LEAD WIRES AT 90° TO PRODUCE A HORIZONTAL CONFIGURATION.

MEASUREMENTS IN MILLIMETERS

HORIZONTAL BEND DIES ARE PLACED
IN STATIONS 6 & 7.



WHEN SELECTING DIES DETERMINE (E) DIMENSION.
TO FIND MINIMUM CENTER-TO-CENTER DISTANCE
ADD BODY LENGTH (A) + 2(E) + 1 LEAD DIA.

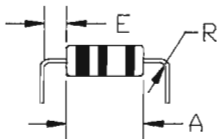
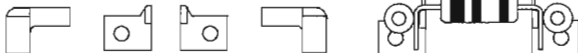
.030 HORIZONTAL DIE SET	E = 1.52 MIN.	RADIUS = 0.38
.040 HORIZONTAL DIE SET	E = 1.78 MIN.	RADIUS = 0.76
.060 HORIZONTAL DIE SET	E = 2.29 MIN.	RADIUS = 1.14
.080 HORIZONTAL DIE SET	E = 2.79 MIN.	RADIUS = 1.65
.100 HORIZONTAL DIE SET	E = 3.30 MIN.	RADIUS = 2.16

HORIZONTAL BEND DIES,

HORIZONTAL BEND DIES FORM COMPONENT LEAD WIRES AT 90° TO PRODUCE A HORIZONTAL CONFIGURATION.

MEASUREMENTS IN INCHES

HORIZONTAL BEND DIES ARE PLACED
IN STATIONS 6 & 7.



WHEN SELECTING DIES DETERMINE (E) DIMENSION.
TO FIND MINIMUM CENTER-TO-CENTER DISTANCE
ADD BODY LENGTH (A) + 2(E) + 1 LEAD DIA.

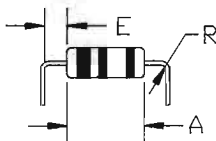
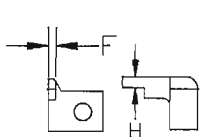
.030 HORIZONTAL DIE SET E= .060 MIN. RADIUS= .015
.040 HORIZONTAL DIE SET E= .070 MIN. RADIUS= .030
.060 HORIZONTAL DIE SET E= .090 MIN. RADIUS= .045
.080 HORIZONTAL DIE SET E= .110 MIN. RADIUS= .065
.100 HORIZONTAL DIE SET E= .130 MIN. RADIUS= .085

MODIFIED HORIZONTAL BEND DIES.

MODIFIED HORIZONTAL DIES HAVE A RELIEF GROUN IN THEM TO ALLOW FOR THE BENDING OF LEADS WITH STAND-OFF OR LOCK-IN DIMPLES.

MEASUREMENTS IN MILLIMETERS

MODIFIED HORIZONTAL BEND DIES ARE PLACED
IN STATIONS 6 & 7.



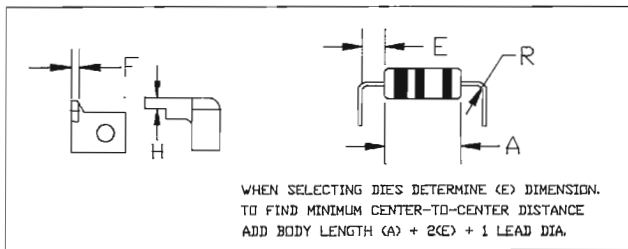
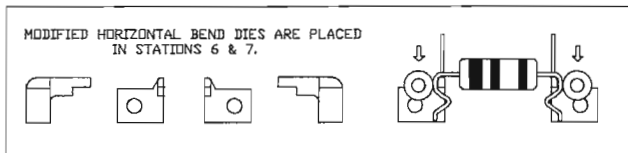
WHEN SELECTING DIES DETERMINE (E) DIMENSION,
TO FIND MINIMUM CENTER-TO-CENTER DISTANCE
ADD BODY LENGTH (A) + 2(E) + 1 LEAD DIA.

.030 HORIZONTAL DIE SET	E= 1.52 MIN.	RADIUS= 0.38	H=1.02	F=0.76
.040 HORIZONTAL DIE SET	E= 1.78 MIN.	RADIUS= 0.76	H AND F=1.02	
.060 HORIZONTAL DIE SET	E= 2.29 MIN.	RADIUS= 1.14	H AND F=1.52	
.080 HORIZONTAL DIE SET	E= 2.79 MIN.	RADIUS= 1.65	H AND F=2.03	
.100 HORIZONTAL DIE SET	E= 3.30 MIN.	RADIUS= 2.16	H AND F=2.54	

MODIFIED HORIZONTAL BEND DIES.

MODIFIED HORIZONTAL DIES HAVE A RELIEF GROUN IN THEM TO ALLOW FOR THE BENDING OF LEADS WITH STAND-OFF OR LOCK-IN DIMPLES.

MEASUREMENTS IN INCHES



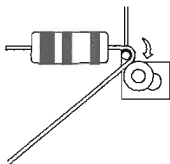
.030 HORIZONTAL DIE SET	E= .060 MIN.	RADIUS= .015	H=.040	F=.030
.040 HORIZONTAL DIE SET	E= .070 MIN.	RADIUS= .030	H AND F=.040	
.060 HORIZONTAL DIE SET	E= .090 MIN.	RADIUS= .045	H AND F=.060	
.080 HORIZONTAL DIE SET	E= .110 MIN.	RADIUS= .065	H AND F=.080	
.100 HORIZONTAL DIE SET	E= .130 MIN.	RADIUS= .085	H AND F=.100	

PIN DIES.

PIN DIES FORM COMPONENT LEADS AT ANGLES GREATER THAN 90° AND ARE USED IN THE FORMING OF VERTICAL OR SPECIAL UNDERFORMING CONFIGURATIONS.



PIN DIES ARE PLACED IN STATIONS 6 & 7,
FOR DOING VERTICAL BENDS,
PIN DIES ARE PLACED IN STATIONS 6 AND 7
FOR UNDERFORMING.



PIN DIES MAY BE ORDERED SEPARATELY
OR IN PAIRS AND ARE AVAILABLE IN
THE FOLLOWING DIAMETERS

.040 DIE RADIUS= 0.51

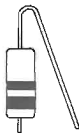
.060 DIE RADIUS= 0.76

.080 DIE RADIUS= 1.02

.100 DIE RADIUS= 1.27

MEASUREMENTS
IN MILLIMETERS

A COMMON FORM PRODUCED
USING A PIN DIE

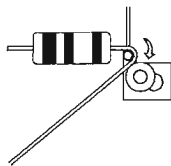


PIN DIES.

PIN DIES FORM COMPONENT LEADS AT ANGLES GREATER THAN 90° AND ARE USED IN THE FORMING OF VERTICAL OR SPECIAL UNDERFORMING CONFIGURATIONS.



PIN DIES ARE PLACED IN STATIONS 6 & 7.
FOR DOING VERTICAL BENDS.
PIN DIES ARE PLACED IN STATIONS 6 AND 7
FOR UNDERFORMING.



PIN DIES MAY BE ORDERED SEPARATELY
OR IN PAIRS AND ARE AVAILABLE IN
THE FOLLOWING DIAMETERS

.040 DIE RADIUS= .020

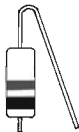
.060 DIE RADIUS= .030

.080 DIE RADIUS= .040

.100 DIE RADIUS= .050

MEASUREMENTS IN
INCHES

A COMMON FORM PRODUCED
USING A PIN DIE



VERTICAL PARALLEL DIES.

VERTICAL PARALLEL DIES WORK IN CONJUNCTION WITH PIN DIES
FOR VERTICAL COMPONENT PLACEMENT WHEN MOUNTING TO A P.C.B.OARD

MEASUREMENTS IN MILLIMETERS

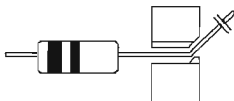
VERTICAL PARALLEL DIES ARE ORDERED AS KITS. A KIT CONTAINS SEVEN DIES THAT WILL FORM LEAD WIRE DIAMETERS OF 0.38 THROUGH 1.52.

VERTICAL PARALLEL DIE KIT:

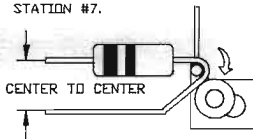
1 - 1530 ST	} USE .060 PIN DIE	} VERTICAL PARALLEL DIES.
1 - 1530 5B		
1 - 3060 ST	} USE .080 PIN DIE	
1 - 3045 5B		
1 - 4560 5B	} PIN DIES.	
1 - .060		
1 - .080		

* (TOP DIE FOR 3045 & 4564)

VERTICAL PARALLEL DIES
ARE PLACED IN STATION #5.

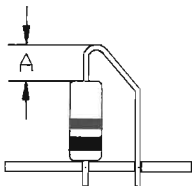


PIN DIE IS PLACED IN
STATION #7.



1530 DIES CAN PRODUCE A 5.08 C-C MIN.
WITH 0.38-0.76 WIRE DIA.

3060 DIES CAN PRODUCE A 7.62 C-C MIN.
WITH 0.76-1.52 WIRE DIA.



FLUSH MOUNT
VERTICAL CONFIGURATION

WHEN USING 1530 DIES DIMENSION (A) = 3.18 MIN.

WHEN USING 3045 DIES DIMENSION (A) = 4.06 MIN.

WHEN USING 4560 DIES DIMENSION (A) = 4.45 MIN.

VERTICAL PARALLEL DIES.

VERTICAL PARALLEL DIES WORK IN CONJUNCTION WITH PIN DIES FOR VERTICAL COMPONENT PLACEMENT WHEN MOUNTING TO A P.C.BOARD

MEASUREMENTS IN INCHES

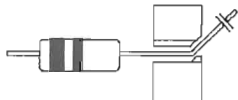
VERTICAL PARALLEL DIES ARE ORDERED AS KITS. A KIT CONTAINS SEVEN DIES THAT WILL FORM LEAD WIRE DIAMETERS OF .015 THROUGH .064.

VERTICAL PARALLEL DIE KIT:

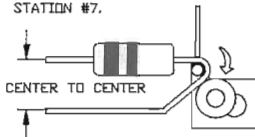
1 - 1530 5T	} USE .060 PIN DIE	} VERTICAL PARALLEL DIES.
1 - 1530 5B		
1 - 3060 5T	} USE .080 PIN DIE	
1 - 3045 5B		
1 - 4560 5B		
1 - .060	} PIN DIES.	
1 - .080		

* (TOP DIE FOR 3045 & 4564)

VERTICAL PARALLEL DIES ARE PLACED IN STATION #5.

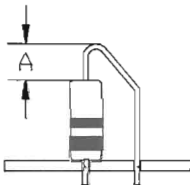


PIN DIE IS PLACED IN STATION #7.



1530 DIES CAN PRODUCE A .200 C-C MIN. WITH .015-.030 WIRE DIA.

3060 DIES CAN PRODUCE A .300 C-C MIN. WITH .030-.060 WIRE DIA.



FLUSH MOUNT
VERTICAL CONFIGURATION

WHEN USING 1530 DIES DIMENSION (A) = .125 MIN.

WHEN USING 3045 DIES DIMENSION (A) = .160 MIN.

WHEN USING 4560 DIES DIMENSION (A) = .175 MIN.

TYPE 2A MILITARY STRESS RELIEF DIES

FOR 0.38 - 1.02 WIRE DIAMETERS
MEASUREMENTS IN MILLIMETERS

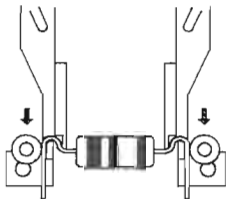
DOUBLE HUMP



FORMING PLATES



SUPPLIED
ALLEN
WRENCH



MSR-2A KIT CONTAINS 7 DIES
4 FORMING PLATES, MOUNTING
SCREWS, AND MOUNTING WRENCH

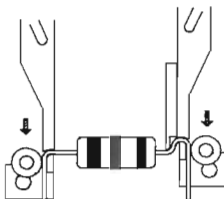
6 SPECIAL HORIZONTAL DIES
WITH A BLADE THICKNESS OF .030,
.040 AND .060 FOR DOUBLE HUMP

DIE MARKED SE IS USED IN
STATION 6 FOR A SINGLE HUMP

FORMING PLATES ARE .060 AND
.075 THICK. THE .060 IS FOR CLOSE
CENTER TO CENTER AND LEAD DIA.
OF 0.38 TO 0.76. THE .075 PLATE
IS USED FOR CENTER TO CENTER
OVER 11.43 AND WHEN USING LEAD
DIA. UP TO 1.02.

SINGLE HUMP

FOR SINGLE HUMP
PLACE S.E. DIE IN STA. 6



TYPE 2A MILITARY STRESS RELIEF DIES

FOR .015 - .040 WIRE DIAMETERS
MEASUREMENTS IN INCHES

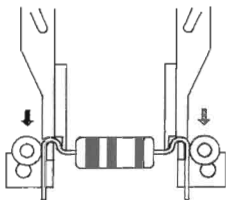
DOUBLE HUMP



FORMING PLATES



SUPPLIED
ALLEN
WRENCH



MSR-2A KIT CONTAINS 7 DIES
4 FORMING PLATES, MOUNTING
SCREWS, AND MOUNTING WRENCH

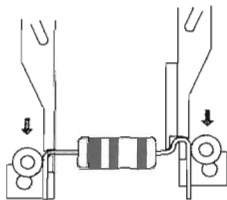
6 SPECIAL HORIZONTAL DIES
WITH A BLADE THICKNESS OF .030,
.040 AND .060 FOR DOUBLE HUMP

DIE MARKED SE IS USED IN
STATION 6 FOR A SINGLE HUMP

FORMING PLATES ARE .060 AND
.075 THICK. THE .060 IS FOR CLOSE
CENTER TO CENTER AND LEAD DIA.
OF .015 TO .030. THE .075 PLATE
IS USED FOR CENTER TO CENTER
OVER .450 AND WHEN USING LEAD
DIA. UP TO .040.

SINGLE HUMP

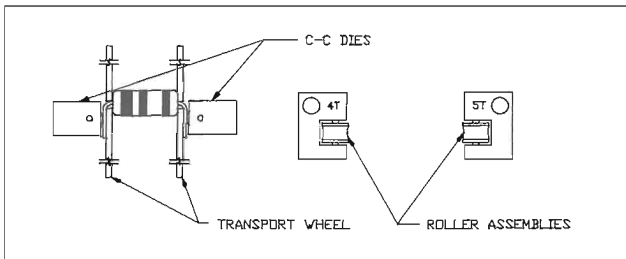
FOR SINGLE HUMP
PLACE S.E. DIE IN STA. 6



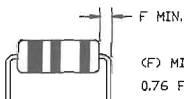
CENTER TO CENTER DIES

CENTER TO CENTER DIES ARE DESIGNED TO PRODUCE A 90° BEND CLOSE TO THE COMPONENT BODY WHERE MINIMUM C-C DIMENSIONS ARE REQUIRED. C-C DIES ARE USED EXCLUSIVELY FOR HORIZONTAL CONFIGURATIONS.

MEASUREMENTS IN MILLIMETERS



C-C DIES USE ROLLER ASSEMBLIES AND THE TRANSPORT WHEEL TO BEND LEADS AT 90°. C-C DIES ARE PLACED IN STATIONS 4 & 5 AND ARE ADJUSTED BY STATION DIAL SETS TO ACCOMMODATE COMPONENT BODY LENGTHS.

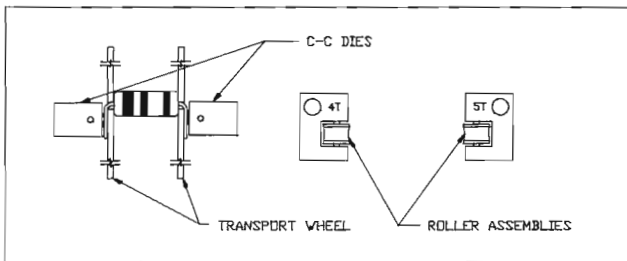


(F) MINIMUMS CAN BE DETERMINED BY ADDING 0.76 FOR THE TRANSPORT WHEEL + LEAD WIRE DIAMETER.

CENTER TO CENTER DIES

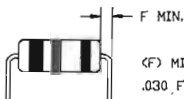
CENTER TO CENTER DIES ARE DESIGNED TO PRODUCE A 90° BEND CLOSE TO THE COMPONENT BODY WHERE MINIMUM C-C DIMENSIONS ARE REQUIRED. C-C DIES ARE USED EXCLUSIVELY FOR HORIZONTAL CONFIGURATIONS.

MEASUREMENTS IN INCHES



C-C DIES USE ROLLER ASSEMBLIES AND THE TRANSPORT WHEEL TO BEND LEADS AT 90°.

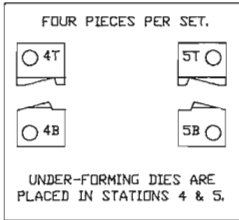
C-C DIES ARE PLACED IN STATIONS 4 & 5 AND ARE ADJUSTED BY STATION DIAL SETS TO ACCOMMODATE COMPONENT BODY LENGTHS.



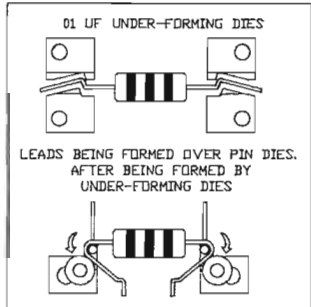
(F) MINIMUMS CAN BE DETERMINED BY ADDING .030 FOR THE TRANSPORT WHEEL + LEAD WIRE DIAMETER.

UNDER-FORMING DIES.

UNDER-FORMING DIES BEND COMPONENT LEADS UNDERNEATH THE COMPONENT BODY RESULTING IN A CENTER TO CENTER DISTANCE THAT IS LESS THAN THE COMPONENT BODY LENGTH.



MEASUREMENTS
IN MILLIMETERS

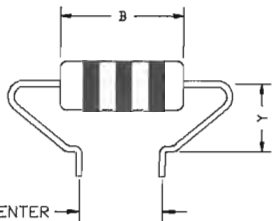


2.29 IS THE MINIMUM BETWEEN BODY AND INSIDE RADIUS, ALLOWING
0.76 CLEARANCE FOR TRANSPORT WHEEL AND 1.52 FOR PIN DIE.

THE COMPONENTS AXIAL CENTER INCREASES AS
CENTER TO CENTER DECREASES.

THE CHART BELOW SHOWS INCREASES IN (Y) FOR 0.38, 0.51, 0.64 AND
0.76 LEAD DIAMETERS. THE CHART STARTS WHERE THE CENTER TO CENTER
DISTANCE IS THE SAME AS THE BODY LENGTH. FOR SMALLER CENTER TO CENTER
DISTANCES EQUATE (B - CENTER TO CENTER DISTANCE = X).

X	Y			
B-(C-C)	0.38	0.51	0.64	0.76
.000	3.81	4.06	4.32	4.57
0.51	4.83	5.08	5.33	5.59
1.02	5.84	6.10	6.35	6.60
1.52	6.86	7.11	7.37	7.62
2.03	7.87	8.13	8.38	8.64
2.54	8.89	9.14	9.40	9.65

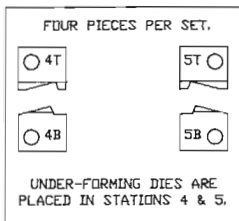


13

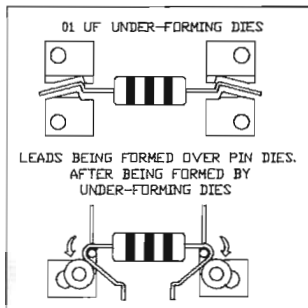
CENTER TO CENTER

UNDER-FORMING DIES.

UNDER-FORMING DIES BEND COMPONENT LEADS UNDERNEATH THE COMPONENT BODY RESULTING IN A CENTER TO CENTER DISTANCE THAT IS LESS THAN THE COMPONENT BODY LENGTH.



MEASUREMENTS IN INCHES

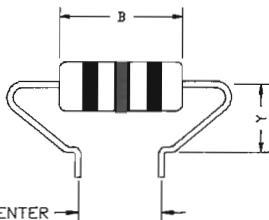


.090 IS THE MINIMUM BETWEEN BODY AND INSIDE RADIUS, ALLOWING .030 CLEARANCE FOR TRANSPORT WHEEL AND .060 FOR PIN DIE.

THE COMPONENTS AXIAL CENTER INCREASES AS CENTER TO CENTER DECREASES.

THE CHART BELOW SHOWS INCREASES IN (Y) FOR .015, .020, .025 AND .030 LEAD DIAMETERS. THE CHART STARTS WHERE THE CENTER TO CENTER DISTANCE IS THE SAME AS THE BODY LENGTH. FOR SMALLER CENTER TO CENTER DISTANCES EQUATE C_B - CENTER TO CENTER DISTANCE = X.

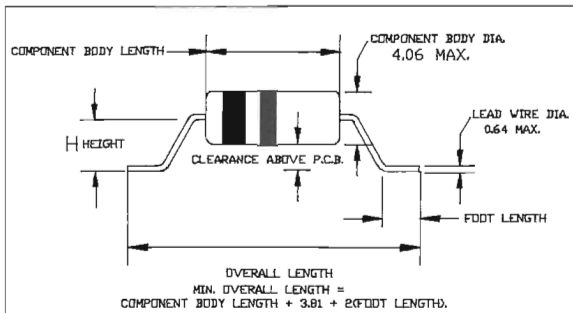
X	Y			
B-(C-C)	.015	.020	.025	.030
.000	.150	.160	.170	.180
.020	.190	.200	.210	.220
.040	.230	.240	.250	.260
.060	.270	.280	.290	.300
.080	.310	.320	.330	.340
.100	.350	.360	.370	.380



REFLOW DIES.

REFLOW DIES FORM LEAD WIRES INTO SURFACE MOUNT CONFIGURATIONS. THEY PROVIDE A SLIGHT FLATTENING OF THE LEADS IN THE (FOOT) DIMENSION WHICH STABILIZES THE COMPONENT WHEN SURFACE MOUNTING ON A P.C. BOARD. REFLOW DIES ARE ALSO AVAILABLE WITH KNIVES TO CUT CONTROLLED (FOOT) DIMENSION LENGTHS. *

MEASUREMENTS IN MILLIMETERS

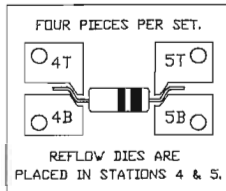
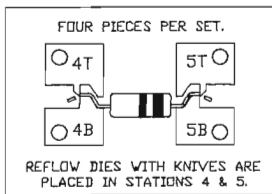


REFLOW DIES ARE IDENTIFIED BY SIZES A THROUGH D.

A0.76	B0.89	C1.02	D1.14	E1.27	F1.40	G1.52	H1.65	I1.78
J2.03	K2.29	L2.54	M2.79	N3.05	D3.30			

A-D DIRECTLY RELATE TO THE (H) DIMENSION.
(H) = 1/2 THE BODY DIA. + CLEARANCE IF NEEDED.

* SPECIAL ORDER DIES.

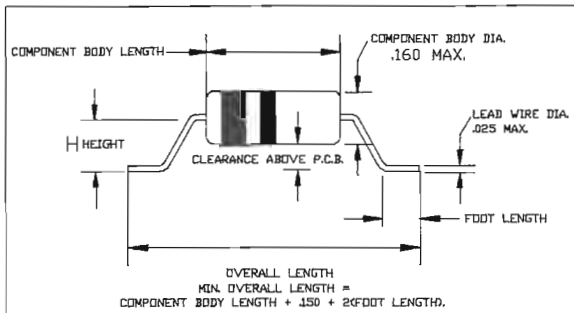


WHEN ORDERING REFLOW DIES WITH KNIVES, BODY LENGTH, OVERALL LENGTH AND THE (H) DIMENSION MUST BE SUPPLIED.

REFLOW DIES.

REFLOW DIES FORM LEAD WIRES INTO SURFACE MOUNT CONFIGURATIONS. THEY PROVIDE A SLIGHT FLATTENING OF THE LEADS IN THE (FOOT) DIMENSION WHICH STABILIZES THE COMPONENT WHEN SURFACE MOUNTING ON A P.C. BOARD. REFLOW DIES ARE ALSO AVAILABLE WITH KNIVES TO CUT CONTROLLED (FOOT) DIMENSION LENGTHS. *

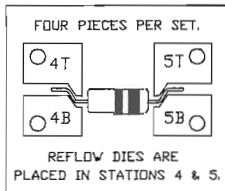
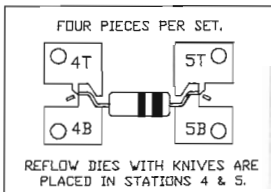
MEASUREMENTS IN INCHES



REFLOW DIES ARE IDENTIFIED BY SIZES A THROUGH O.
 A:030 B:035 C:040 D:045 E:050 F:055 G:060 H:065 I:070
 J:080 K:090 L:100 M:110 N:120 O:130

A-O DIRECTLY RELATE TO THE (H) DIMENTION.
 (H) = 1/2 THE BODY DIA. + CLEARANCE IF NEEDED.

* SPECIAL ORDER DIES.



WHEN ORDERING REFLOW DIES WITH KNIVES, BODY LENGTH, OVERALL LENGTH AND THE (H) DIMENSION MUST BE SUPPLIED.

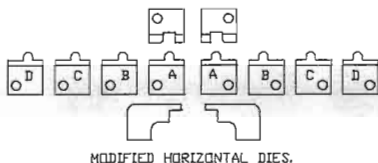
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LOCK-IN DIES,

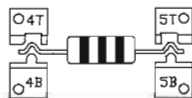
LOCK-IN DIES FORM A CONTROLLED DIMPLE INTO LEAD WIRE(S). THESE DIES ARE AVAILABLE TO ACCOMMODATE VARIOUS LEAD WIRE AND P.C.BOARD HOLE DIA. AND CAN BE ORDERED AS KITS OR SEPARATELY. USED IN CONJUNCTION WITH OTHER CF-8 DIES THEY PROVIDE THE LOCK-IN FOR A STAND-OFF OR VERTICAL CONFIGURATION.

(SELECT LOCK-IN DIES AS PER WIRE AND P.C.BOARD HOLE DIA. SEE PAGE 19 AND 20)

A DIE KIT CONTAINS 2 TOPS AND 8 BOTTOMS, AND 2 MODIFIED HORIZONTAL DIES.



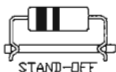
MODIFIED HORIZONTAL DIES.



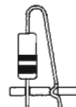
LOCK-IN DIES ARE PLACED IN STATIONS 4 & 5.

MODIFIED HORIZONTAL DIES ARE PLACED IN STATIONS 6 & 7.

SOME COMMON FORMS THAT INCORPORATE LOCK-IN DIES.



STAND-OFF



VERTICAL CONFIGURATION

LOCK-IN DIE KITS

FOR 1.59 P.C.BOARD

THE 1530 KIT CONTAINS DIES
FOR 0.38,0.51,0.64,0.76 WIRE DIA.
AND 2 MODIFIED HORIZONTAL .040 DIES.

P.C.BOARD HOLE DIA.

LEAD WIRE DIA.	P.C.BOARD HOLE DIA.			
	A	B	C	D
0.38	0.51	0.64	0.76	0.89
0.51	0.64	0.76	0.89	1.02
0.64	0.76	0.89	1.02	1.14
0.76	0.89	1.02	1.14	1.27

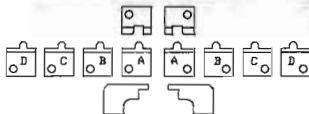
THE 3045 KIT CONTAINS DIES
FOR 0.76,0.89,1.02,1.14 WIRE DIA.
AND 2 MODIFIED HORIZONTAL .060 DIES.

P.C.BOARD HOLE DIA.

LEAD WIRE DIA.	P.C.BOARD HOLE DIA.			
	A	B	C	D
0.76	1.02	1.14	1.27	1.40
0.89	1.14	1.27	1.40	1.52
1.02	1.27	1.40	1.52	1.65
1.14	1.40	1.52	1.65	1.78

MEASUREMENTS IN MILLIMETERS

A DIE KIT CONTAINS 2 TOPS AND 8 BOTTOMS. AND 2
MODIFIED HORIZONTAL DIES.



MODIFIED HORIZONTAL DIES.

THE 4560 KIT CONTAINS DIES
FOR 1.14,1.27,1.40,1.52 WIRE DIA.
AND 2 MODIFIED HORIZONTAL .060 DIES.

P.C.BOARD HOLE DIA.

LEAD WIRE DIA.	P.C.BOARD HOLE DIA.			
	A	B	C	D
1.14	1.40	1.52	1.65	1.78
1.27	1.52	1.65	1.78	1.91
1.40	1.65	1.78	1.91	2.03
1.52	1.78	1.91	2.03	2.16

FOR 0.79 P.C.BOARD

THE 1525 KIT CONTAINS DIES
FOR 0.38,0.51,0.64 WIRE DIA.
AND 2 MODIFIED HORIZONTAL .030 DIES.

P.C.BOARD HOLE DIA.

LEAD WIRE DIA.	P.C.BOARD HOLE DIA.			
	A	B	C	D
0.38	0.51	0.64	0.76	0.89
0.51	0.64	0.76	0.89	1.02
0.64	0.76	0.89	1.02	1.14

THE 2535 KIT CONTAINS DIES
FOR 0.64,0.76,0.89 WIRE DIA.
AND 2 MODIFIED HORIZONTAL .040 DIES.

P.C.BOARD HOLE DIA.

LEAD WIRE DIA.	P.C.BOARD HOLE DIA.			
	A	B	C	D
0.64	0.76	0.89	1.02	1.14
0.76	0.89	1.02	1.14	1.27
0.89	1.02	1.14	1.27	1.40

LOCK-IN DIE KITS

FOR .062 P.C.BOARD

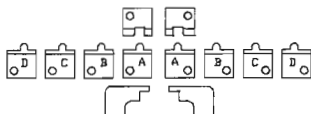
THE 1530 KIT CONTAINS DIES FOR .015,.020,.025,.030 WIRE DIA. AND 2 MODIFIED HORIZONTAL .040 DIES.

P.C.BOARD HOLE DIA.
A B C D

LEAD WIRE DIA.	.015	.020	.025	.030	.035
	.020	.025	.030	.035	.040
	.025	.030	.035	.040	.045
	.030	.035	.040	.045	.050

MEASUREMENTS IN INCHES

A DIE KIT CONTAINS 2 TOPS AND 8 BOTTOMS. AND 2 MODIFIED HORIZONTAL DIES.



MODIFIED HORIZONTAL DIES.

THE 3045 KIT CONTAINS DIES FOR .030,.035,.040,.045 WIRE DIA. AND 2 MODIFIED HORIZONTAL .060 DIES.

P.C.BOARD HOLE DIA.
A B C D

LEAD WIRE DIA.	.030	.040	.045	.050	.055
	.035	.045	.050	.055	.060
	.040	.050	.055	.060	.065
	.045	.055	.060	.065	.070

THE 4560 KIT CONTAINS DIES FOR .045,.050,.055,.060 WIRE DIA. AND 2 MODIFIED HORIZONTAL .060 DIES.

P.C.BOARD HOLE DIA.
A B C D

LEAD WIRE DIA.	.045	.055	.060	.065	.070
	.050	.060	.065	.070	.075
	.055	.065	.070	.075	.080
	.060	.070	.075	.080	.085

FOR .031 P.C.BOARD

THE 1525 KIT CONTAINS DIES FOR .015,.020,.025 WIRE DIA. AND 2 MODIFIED HORIZONTAL .030 DIES.

P.C.BOARD HOLE DIA.
A B C D

LEAD WIRE DIA.	.015	.020	.025	.030	.035
	.020	.025	.030	.035	.040
	.025	.030	.035	.035	.045

THE 2535 KIT CONTAINS DIES FOR .025,.030,.035 WIRE DIA. AND 2 MODIFIED HORIZONTAL .040 DIES.

P.C.BOARD HOLE DIA.
A B C D

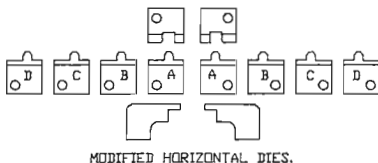
LEAD WIRE DIA.	.025	.030	.035	.040	.045
	.030	.035	.040	.045	.050
	.035	.040	.045	.050	.055

FLUSH MOUNT LOCK-IN DIES.

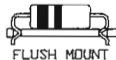
FLUSH MOUNT LOCK-IN DIES FORM A CONTROLLED DIMPLE INTO LEAD WIRE(S), THIS ALLOWS A COMPONENT TO BE HORIZONTALLY MOUNTED ON A P.C.BOARD WITH AN IN HOLE LOCK-IN. DIES CAN BE ORDERED AS KITS OR IN PARTIAL KITS, EACH DIE SET COVERS A GIVEN WIRE AND P.C.BOARD HOLE RANGE. (SEE CHART BELOW).

MEASUREMENTS IN MILLIMETERS

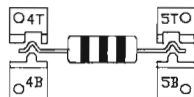
A DIE KIT CONTAINS 2 TOPS AND 8 BOTTOMS, AND 2 MODIFIED HORIZONTAL DIES.



A COMMON FORM THAT USES THE FLUSH MOUNT LOCK-IN FORM.



NOTE: CUT-OFF, LOCK-IN DIES CAN BE ORDERED WITH PROTRUSION RANGE OF 0.76-1.02 FOR 1.59 P.C.BOARD AND 1.14-1.40 FOR P.C.BOARD.



LOCK-IN DIES ARE PLACED IN STATIONS 4 & 5.

MODIFIED HORIZONTAL DIES ARE PLACED IN STATIONS 6 & 7.

FOR 1.59 P.C.BOARD

THE 1530 KIT CONTAINS DIES FOR 0.38,0.51,0.64,0.76 WIRE DIA. AND 2 MODIFIED HORIZONTAL .040 DIES.

P.C.BOARD HOLE DIA.

LEAD WIRE DIA.	P.C.BOARD HOLE DIA.			
	A	B	C	D
0.38	0.51	0.64	0.76	.035
0.51	0.64	0.76	.035	1.02
0.64	0.76	.035	1.02	1.14
0.76	.035	1.02	1.14	1.27

THE 3045 KIT CONTAINS DIES FOR 0.76,0.89,1.02,1.14 WIRE DIA. AND 2 MODIFIED HORIZONTAL .060 DIES.

P.C.BOARD HOLE DIA.

LEAD WIRE DIA.	P.C.BOARD HOLE DIA.			
	A	B	C	D
0.76	1.02	1.14	1.27	1.40
0.89	1.14	1.27	1.40	1.52
1.02	1.27	1.40	1.52	1.65
1.14	1.40	1.52	1.65	1.78

THE 4560 KIT CONTAINS DIES FOR 1.14,1.27,1.40,1.52 WIRE DIA. AND 2 MODIFIED HORIZONTAL .060 DIES.

P.C.BOARD HOLE DIA.

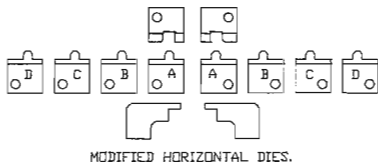
LEAD WIRE DIA.	P.C.BOARD HOLE DIA.			
	A	B	C	D
1.14	1.40	1.52	1.65	1.78
1.27	1.52	1.65	1.78	1.91
1.40	1.65	1.78	1.91	2.03
1.52	1.78	1.91	2.03	2.16

FLUSH MOUNT LOCK-IN DIES.

FLUSH MOUNT LOCK-IN DIES FORM A CONTROLLED DIMPLE INTO LEAD WIRE(S). THIS ALLOWS A COMPONENT TO BE HORIZONTALLY MOUNTED ON A P.C. BOARD WITH AN IN HOLE LOCK-IN. DIES CAN BE ORDERED AS KITS OR IN PARTIAL KITS. EACH DIE SET COVERS A GIVEN WIRE AND P.C. BOARD HOLE RANGE. (SEE CHART BELOW).

MEASUREMENTS IN INCHES

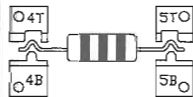
A DIE KIT CONTAINS 2 TOPS AND 8 BOTTOMS, AND 2 MODIFIED HORIZONTAL DIES.



A COMMON FORM THAT USES THE FLUSH MOUNT LOCK-IN FORM.



NOTE: CUT-OFF, LOCK-IN DIES CAN BE ORDERED WITH PROTRUSION RANGE OF .030-.040 FOR .062 P.C. BOARD AND .045-.055 FOR P.C. BOARD.



LOCK-IN DIES ARE PLACED IN STATIONS 4 & 5.

MODIFIED HORIZONTAL DIES ARE PLACED IN STATIONS 6 & 7.

FOR .062 P.C. BOARD

THE 1530 KIT CONTAINS DIES FOR .015, .020, .025, .030 WIRE DIA. AND 2 MODIFIED HORIZONTAL .040 DIES.

P.C. BOARD HOLE DIA.

LEAD WIRE DIA.	P.C. BOARD HOLE DIA.			
	A	B	C	D
.015	.020	.025	.030	.035
.020	.025	.030	.035	.040
.025	.030	.035	.040	.045
.030	.035	.040	.045	.050

THE 3045 KIT CONTAINS DIES FOR .030, .035, .040, .045 WIRE DIA. AND 2 MODIFIED HORIZONTAL .060 DIES.

P.C. BOARD HOLE DIA.

LEAD WIRE DIA.	P.C. BOARD HOLE DIA.			
	A	B	C	D
.030	.040	.045	.050	.055
.035	.045	.050	.055	.060
.040	.050	.055	.060	.065
.045	.055	.060	.065	.070

THE 4560 KIT CONTAINS DIES FOR .045, .050, .055, .060 WIRE DIA. AND 2 MODIFIED HORIZONTAL .060 DIES.

P.C. BOARD HOLE DIA.

LEAD WIRE DIA.	P.C. BOARD HOLE DIA.			
	A	B	C	D
.045	.055	.060	.065	.070
.050	.060	.065	.070	.075
.055	.065	.070	.075	.080
.060	.070	.075	.080	.085

CUT-OFF, LOCK-IN DIES.

CUT-OFF, LOCK-IN DIES PRODUCE THE SAME FORM AS LOCK-IN DIES WITH THE ADDITION OF A KNIFE WHICH IS MANUFACTURED AS PART OF THE DIE. THIS KNIFE MAKES IT POSSIBLE TO CONTROL THE LENGTH OF PROTRUSION THROUGH THE P.C.BOARD AT A RANGE OF 1.14-1.40 FOR A 1.59 P.C.BOARD.*

MEASUREMENTS IN MILLIMETERS

FOR 1.59 P.C.BOARD

THE 1530 KIT CONTAINS DIES FOR 0.38,0.51,0.64,0.76 WIRE DIA. AND 2 MODIFIED HORIZONTAL .040 DIES.

P.C.BOARD HOLE DIA.

LEAD WIRE DIA.	P.C.BOARD HOLE DIA.				
	A	B	C	D	
0.38	0.51	0.64	0.76	0.89	
0.51	0.64	0.76	0.89	1.02	
0.64	0.76	0.89	1.02	1.14	
0.76	0.89	1.02	1.14	1.27	

THE 3045 KIT CONTAINS DIES FOR 0.76,0.89,1.02,1.14 WIRE DIA. AND 2 MODIFIED HORIZONTAL .060 DIES.

P.C.BOARD HOLE DIA.

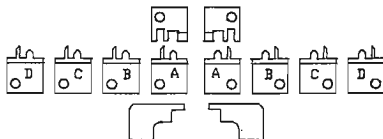
LEAD WIRE DIA.	P.C.BOARD HOLE DIA.				
	A	B	C	D	
0.76	1.02	1.14	1.27	1.40	
.035	1.14	1.27	1.40	1.52	
1.02	1.27	1.40	1.52	1.65	
1.14	1.40	1.52	1.65	1.78	

THE 4560 KIT CONTAINS DIES FOR 1.14,1.27,1.40,1.52 WIRE DIA. AND 2 MODIFIED HORIZONTAL .060 DIES.

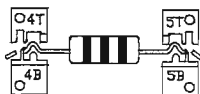
P.C.BOARD HOLE DIA.

LEAD WIRE DIA.	P.C.BOARD HOLE DIA.				
	A	B	C	D	
1.14	1.40	1.52	1.65	1.78	
1.27	1.52	1.65	1.78	1.91	
1.40	1.65	1.78	1.91	2.03	
1.52	1.78	1.91	2.03	2.16	

A DIE KIT CONTAINS 2 TOPS AND 8 BOTTOMS, AND 2 MODIFIED HORIZONTAL DIES.



MODIFIED HORIZONTAL DIES.



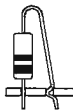
CUT-OFF, LOCK-IN DIES ARE PLACED IN STATIONS 4 & 5.

MODIFIED HORIZONTAL DIES ARE PLACED IN STATIONS 6 & 7.

SOME COMMON FORMS THAT INCORPORATE CUT-OFF, LOCK-IN DIES.



STAND-OFF



VERTICAL CONFIGURATION

*CUT-OFF, LOCK-IN DIES CAN ALSO BE ORDERED WITH PROTRUSION RANGES OF 0.76-1.02 FOR 1.59 P.C.BOARD AND 1.14-1.40 FOR 0.79 P.C.BOARD

NOTE: EXTREME CARE MUST BE TAKEN WHEN INSTALLING THESE DIES, SO AS NOT TO DAMAGE THE CUTTING SURFACE.

CUT-OFF, LOCK-IN DIES.

CUT-OFF, LOCK-IN DIES PRODUCE THE SAME FORM AS LOCK-IN DIES WITH THE ADDITION OF A KNIFE WHICH IS MANUFACTURED AS PART OF THE DIE. THIS KNIFE MAKES IT POSSIBLE TO CONTROL THE LENGTH OF PROTRUSION THROUGH THE P.C.BOARD AT A RANGE OF .045-.055 FOR A .062 P.C.BOARD.*

MEASUREMENTS IN INCHES

FOR .062 P.C.BOARD

THE 1530 KIT CONTAINS DIES FOR .015,.020,.025,.030 WIRE DIA. AND 2 MODIFIED HORIZONTAL .040 DIA.

LEAD WIRE DIA.	P.C.BOARD HOLE DIA.			
	A	B	C	D
.015	.020	.025	.030	.035
.020	.025	.030	.035	.040
.025	.030	.035	.040	.045
.030	.035	.040	.045	.050

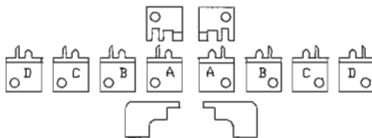
THE 3045 KIT CONTAINS DIES FOR .030,.035,.040,.045 WIRE DIA. AND 2 MODIFIED HORIZONTAL .060 DIA.

LEAD WIRE DIA.	P.C.BOARD HOLE DIA.			
	A	B	C	D
.030	.040	.045	.050	.055
.035	.045	.050	.055	.060
.040	.050	.055	.060	.065
.045	.055	.060	.065	.070

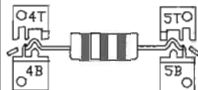
THE 4560 KIT CONTAINS DIES FOR .045,.050,.055,.060 WIRE DIA. AND 2 MODIFIED HORIZONTAL .060 DIA.

LEAD WIRE DIA.	P.C.BOARD HOLE DIA.			
	A	B	C	D
.045	.055	.060	.065	.070
.050	.060	.065	.070	.075
.055	.065	.070	.075	.080
.060	.070	.075	.080	.085

A DIE KIT CONTAINS 2 TOPS AND 8 BOTTOMS. AND 2 MODIFIED HORIZONTAL DIES.



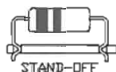
MODIFIED HORIZONTAL DIES.



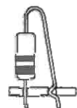
CUT-OFF, LOCK-IN DIES ARE PLACED IN STATIONS 4 & 5.

MODIFIED HORIZONTAL DIES ARE PLACED IN STATIONS 6 & 7.

SOME COMMON FORMS THAT INCORPORATE CUT-OFF, LOCK-IN DIES.



STAND-OFF



VERTICAL CONFIGURATION

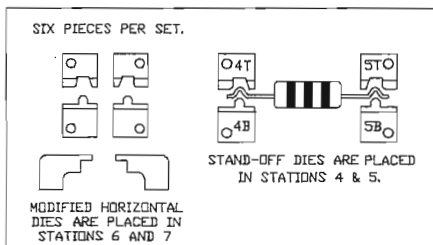
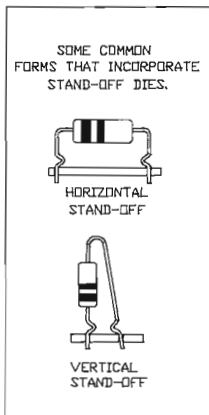
*CUT-OFF, LOCK-IN DIES CAN ALSO BE ORDERED WITH PROTRUSION RANGES OF .030-.040 FOR .062 P.C.BOARD AND .045-.055 FOR .031 P.C.BOARD

NOTE: EXTREME CARE MUST BE TAKEN WHEN INSTALLING THESE DIES, SO AS NOT TO DAMAGE THE CUTTING SURFACE.

STAND-OFF DIES.

STAND-OFF DIES FORM A CONTROLLED DIMPLE INTO LEAD WIRE(S). THESE DIES ARE AVAILABLE TO ACCOMMODATE VARIOUS LEAD WIRE SIZES AND P.C.BOARD HOLE DIAMETERS. USED IN CONJUNCTION WITH OTHER CF-8 DIES, FORMS SUCH AS HORIZONTAL STAND-OFF AND VERTICAL STAND-OFF CAN BE PRODUCED.

MEASUREMENTS IN MILLIMETERS



DIES ARE SELECTED BY WIRE DIAMETERS.

SET 1530 FORMS WIRE DIAMETERS 0.38 THROUGH 0.76

SET 3045 FORMS WIRE DIAMETERS 0.76 THROUGH 1.14

SET 4560 FORMS WIRE DIAMETERS 1.14 THROUGH 1.52

SIX PIECE DIE KITS INCLUDE:

1530 FORMING DIES AND .040 MODIFIED HORIZONTALS

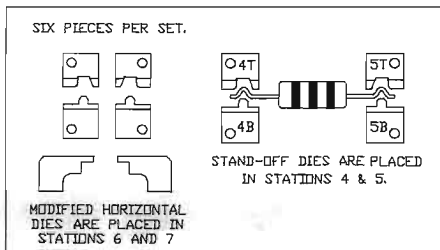
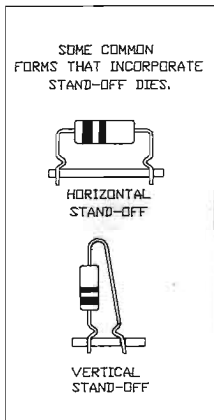
3045 FORMING DIES AND .060 MODIFIED HORIZONTALS

4560 FORMING DIES AND .060 MODIFIED HORIZONTALS

STAND-OFF DIES.

STAND-OFF DIES FORM A CONTROLLED DIMPLE INTO LEAD WIRE(S). THESE DIES ARE AVAILABLE TO ACCOMMODATE VARIOUS LEAD WIRE SIZES AND P.C.BOARD HOLE DIAMETERS. USED IN CONJUNCTION WITH OTHER CF-8 DIES, FORMS SUCH AS HORIZONTAL STAND-OFF AND VERTICAL STAND-OFF CAN BE PRODUCED.

MEASUREMENTS IN INCHES



DIES ARE SELECTED BY WIRE DIAMETERS.

SET 1530 FORMS WIRE DIAMETERS .015 THROUGH .030

SET 3045 FORMS WIRE DIAMETERS .030 THROUGH .045

SET 4560 FORMS WIRE DIAMETERS .045 THROUGH .060

SIX PIECE DIE KITS INCLUDE,

1530 FORMING DIES AND .040 MODIFIED HORIZONTALS

3045 FORMING DIES AND .060 MODIFIED HORIZONTALS

4560 FORMING DIES AND .060 MODIFIED HORIZONTALS

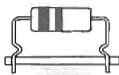
STAND-OFF CUT-OFF DIES.

STAND-OFF CUT-OFF DIES PRODUCE THE SAME FORMS AS STAND-OFF DIES WITH THE ADDITION OF A SECONDARY CUT-OFF KNIFE. THIS KNIFE MAKES IT POSSIBLE TO CONTROL BELOW BOARD PROTRUSION OF L27-152 FOR A 1.59 P.C.BOARD.

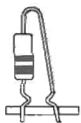
SHORTER PROTRUSIONS OF 0.76-1.02 FOR A 1.59 P.C.BOARD CAN BE SPECIAL ORDERED

MEASUREMENTS IN MILLIMETERS

SOME COMMON FORMS THAT INCORPORATE STAND-OFF CUT-OFF DIES.

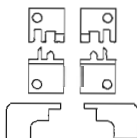


HORIZONTAL
STAND-OFF CUT-OFF

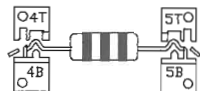


VERTICAL
STAND-OFF CUT-OFF

SIX PIECES PER SET.



MODIFIED HORIZONTAL
DIES ARE PLACED IN
STATIONS 6 AND 7



STAND-OFF CUT-OFF DIES
ARE PLACED
IN STATIONS 4 & 5.

[CARE MUST BE TAKEN
WHEN INSTALLING DIES
TO NOT DAMAGE KNIVES]

DIES ARE SELECTED BY WIRE DIAMETERS.

SET 1530 FORMS WIRE DIAMETERS	0.38 THROUGH 0.76
SET 3045 FORMS WIRE DIAMETERS	0.76 THROUGH 1.14
SET 4560 FORMS WIRE DIAMETERS	1.14 THROUGH 1.52

SIX PIECE DIE KITS INCLUDE:

1530 FORMING DIES AND .040 MODIFIED HORIZONTALS

3045 FORMING DIES AND .060 MODIFIED HORIZONTALS

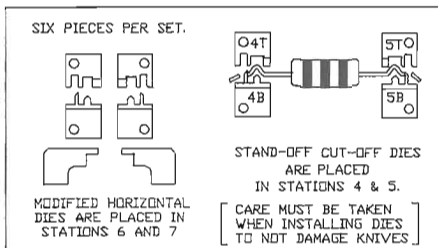
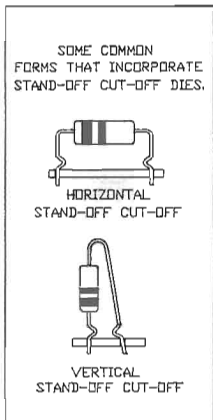
4560 FORMING DIES AND .060 MODIFIED HORIZONTALS

STAND-OFF CUT-OFF DIES.

STAND-OFF CUT-OFF DIES PRODUCE THE SAME FORMS AS STAND-OFF DIES WITH THE ADDITION OF A SECONDARY CUT-OFF KNIFE. THIS KNIFE MAKES IT POSSIBLE TO CONTROL BELOW BOARD PROTRUSION OF .050-.060 FOR A .062 P.C.BOARD.

SHORTER PROTRUSIONS OF .030-.040 FOR A .062 P.C.BOARD CAN BE SPECIAL ORDERED

MEASUREMENTS IN INCHES



DIES ARE SELECTED BY WIRE DIAMETERS.

SET 1530 FORMS WIRE DIAMETERS .015 THROUGH .030

SET 3045 FORMS WIRE DIAMETERS .030 THROUGH .045

SET 4560 FORMS WIRE DIAMETERS .045 THROUGH .060

SIX PIECE DIE KITS INCLUDE:

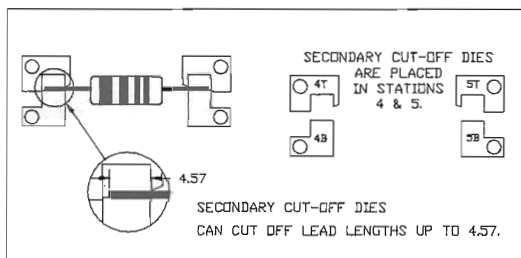
1530 FORMING DIES AND .040 MODIFIED HORIZONTALS

3045 FORMING DIES AND .060 MODIFIED HORIZONTALS

4560 FORMING DIES AND .060 MODIFIED HORIZONTALS

SECONDARY CUT-OFF DIES.

SECONDARY CUT-OFF DIES ARE KNIVES THAT WILL REDUCE THE LEAD LENGTH TO A CONTROLLED DISTANCE FROM THE COMPONENT BODY.

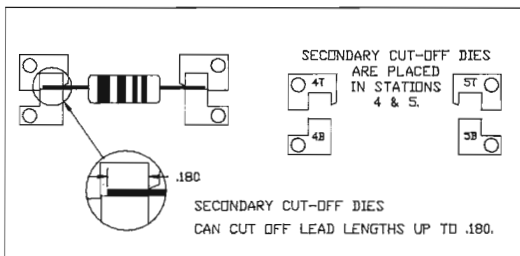


THESE DIES REQUIRE A EXIT CHUTE AND A MODIFIED LEXAN GUARD. THE EXIT CHUTE IS TO GUIDE THE CUT LEAD FROM THE CRIMPING DIE POSITION, WITHOUT FALLING AND INTERFERING WITH THE BENDING DIE STATION. THE MODIFIED GUARD ALLOWS THE SCRAP LEADS TO BE DEPOSITED OUTSIDE OF THE MACHINE.

MEASUREMENTS IN MILLIMETERS

SECONDARY CUT-OFF DIES.

SECONDARY CUT-OFF DIES ARE KNIVES THAT WILL REDUCE THE LEAD LENGTH TO A CONTROLLED DISTANCE FROM THE COMPONENT BODY.



THESE DIES REQUIRE A EXIT CHUTE AND A MODIFIED LEXAN GUARD. THE EXIT CHUTE IS TO GUIDE THE CUT LEAD FROM THE CRIMPING DIE POSITION, WITHOUT FALLING AND INTERFERING WITH THE BENDING DIE STATION. THE MODIFIED GUARD ALLOWS THE SCRAP LEADS TO BE DEPOSITED OUTSIDE OF THE MACHINE.

MEASUREMENTS IN INCHES

SPECIAL DOUBLE DIMPLE LOCK-IN DIES WITH KNIFE

MEASUREMENTS IN MILLIMETERS

THESE DIES PROVIDE A FLUSH MOUNT STAND OFF LOCK-IN FORM. EACH DIE COVERS
A WIRE RANGE AND P.C.BOARD HOLE SIZE RANGE.

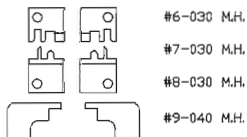
DIE SET #6 DOES A FLUSH MOUNT LOCK-IN ONLY.

DIE SETS #7,8 AND 9 DO A FLUSH MOUNT OR STAND-OFF LOCK-IN.

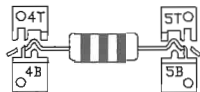
P.C.BOARD HOLE AND WIRE RANGES

DIE SET	P.C.BOARD HOLE	WIRE DIA.
6	0.95-1.15 M.M.	0.50-0.60 M.M.
7	1.00-1.30 M.M.	0.60-0.80 M.M.
8	0.80-1.10 M.M.	0.45-0.65 M.M.
9	1.00-1.30 M.M.	0.66-0.85 M.M.

SIX PIECES PER SET



MODIFIED HORIZONTAL DIES.



NOTE: CARE MUST BE TAKEN
WHEN INSTALLING DIES SO
AS NOT TO DAMAGE KNIVES

SPECIAL DOUBLE DIMPLE LOCK-IN DIES WITH KNIFE

MEASUREMENTS IN INCHES

THESE DIES PROVIDE A FLUSH MOUNT STAND OFF LOCK-IN FORM. EACH DIE COVERS
A WIRE RANGE AND P.C.BOARD HOLE SIZE RANGE.

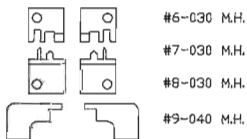
DIE SET #6 DOES A FLUSH MOUNT LOCK-IN ONLY..

DIE SETS #7,8 AND 9 DO A FLUSH MOUNT OR STAND-OFF LOCK-IN.

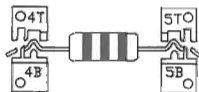
P.C.BOARD HOLE AND WIRE RANGES

DIE SET	P.C.BOARD HOLE	WIRE DIA.
6	.037-.045 IN.	.020-.024 IN.
7	.039-.051 IN.	.024-.031 IN.
8	.031-.043 IN.	.018-.026 IN.
9	.039-.051 IN.	.026-.033 IN.

SIX PIECES PER SET



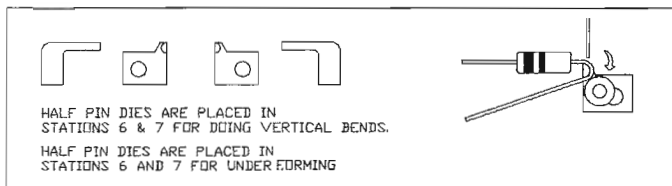
MODIFIED HORIZONTAL DIES.



NOTE: CARE MUST BE TAKEN
WHEN INSTALLING DIES SO
AS NOT TO DAMAGE KNIVES

HALF PIN DIES.

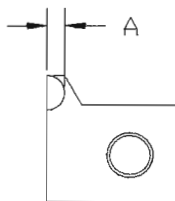
FOR CLOSE TO BODY VERTICAL BENDS



HALF PIN DIES MAY BE ORDERED SEPARATELY
OR IN PAIRS AND ARE AVAILABLE IN THE FOLLOWING DIAMETERS

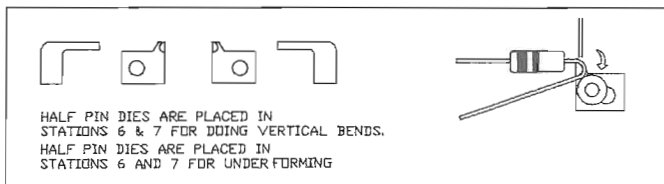
MEASUREMENTS IN MILLIMETERS

RADIUS A DIM.	PIN DIE
0.89	.070
1.02	.080
1.27	.100
1.52	.120
2.03	.160



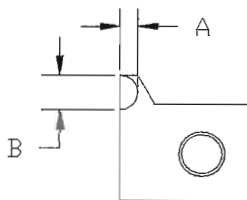
HALF PIN DIES,

FOR CLOSE TO BODY VERTICAL BENDS



HALF PIN DIES MAY BE ORDERED SEPARATELY
OR IN PAIRS AND ARE AVAILABLE IN THE FOLLOWING DIAMETERS
MEASUREMENTS IN INCHES

RADIUS A DIM.	PIN DIE B DIM.
.035	.070
.040	.080
.050	.100
.060	.120
.080	.160



Installation Instructions CF-8 Notched Plate Kit

P/N 800L-ONPK

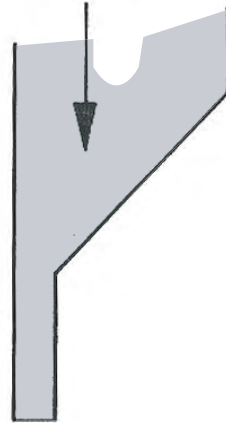
SUPPLIED
WRENCH



FORMING
PLATE

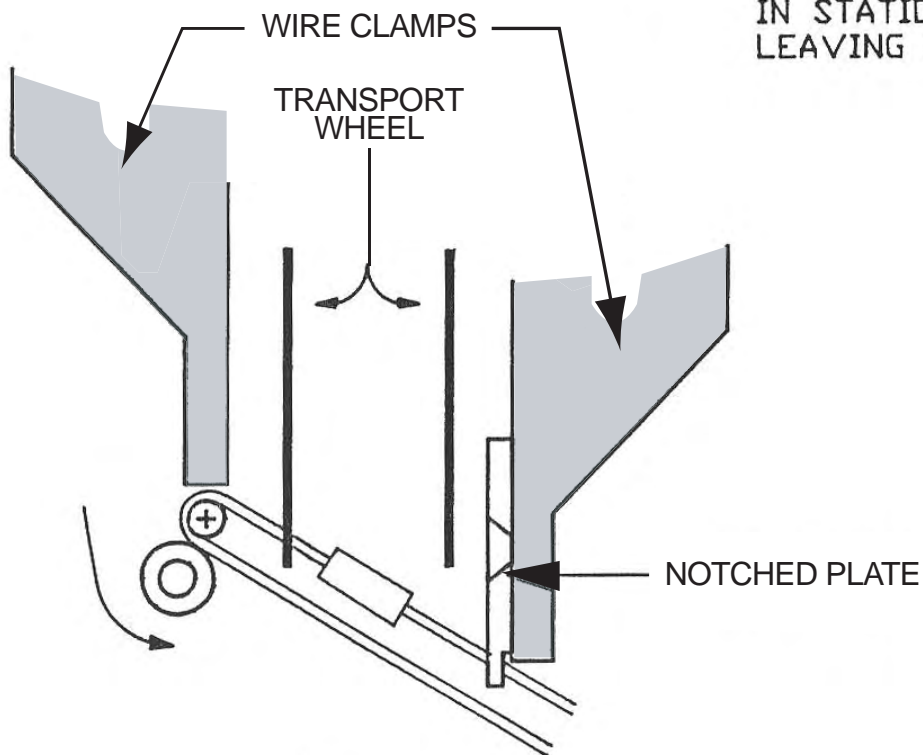


WIRE
CLAMP



1. OPEN STATIONS 6 & 7
REMOVE TRANSPORT WHEEL
ATTACH PLATE TO STATION 6
WIRE CLAMP INSIDE FACE.
USING SUPPLIED SCREWS
AND WRENCH

2. PLACE .060 PIN
IN STATION 7 WHILE
LEAVING STATION 6 EMPTY



3. STATION 7 | STATION 6

SET STROKE ON STAT. 9 TO 12
SET STROKE ON STAT. 8 TO 4
PART WILL FALL INTO PARTS BIN
AS THEY INDEX FROM PIN DIE.