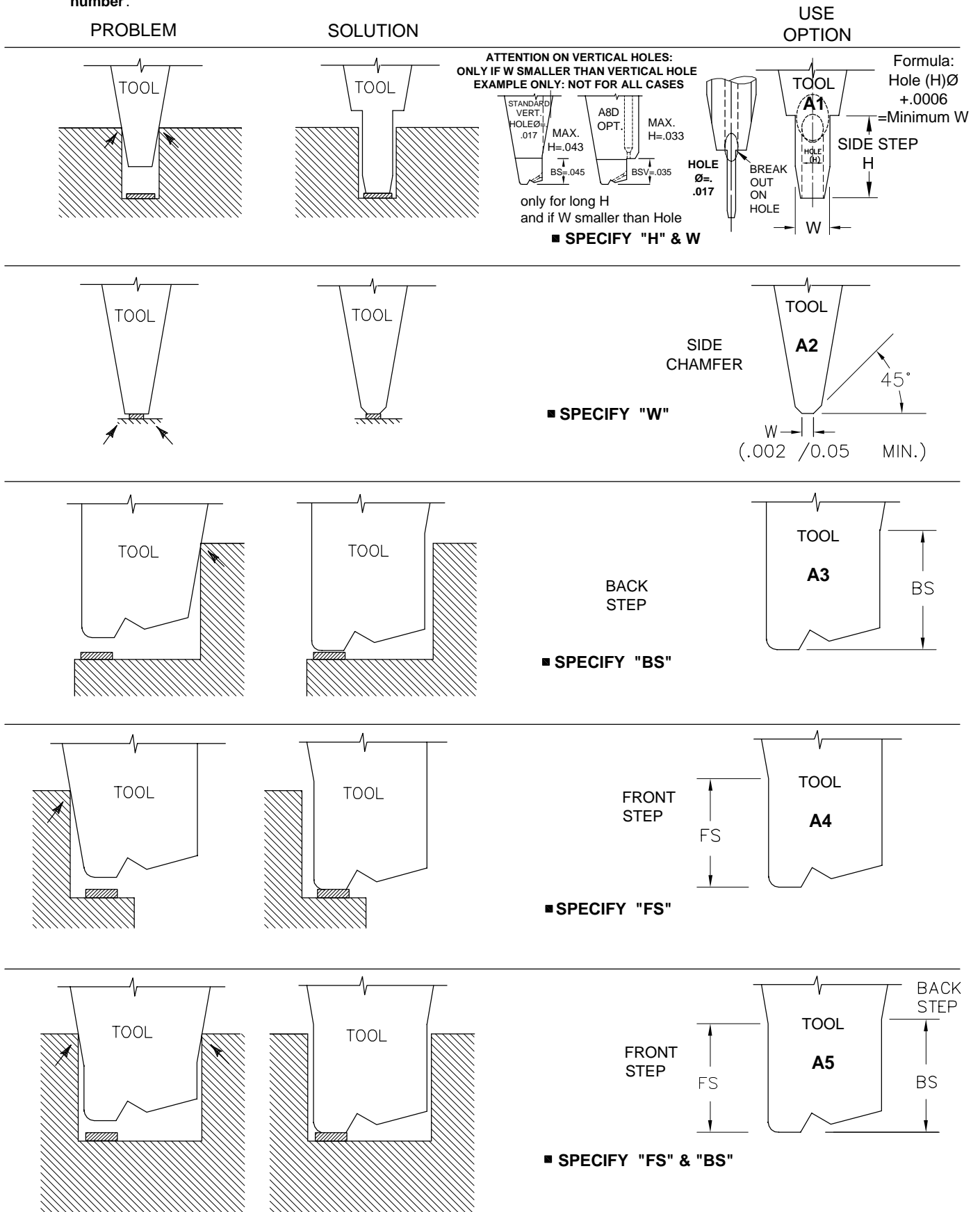


OPTIONS



Below are shown various problem situations that can occur during bonding operations and their solutions. When choosing an option, please note the corresponding option number (A1, A2, etc.) when completing the part number from the Ordering Information sections. **These option numbers should appear as the last item in the part number.**



OPTIONS



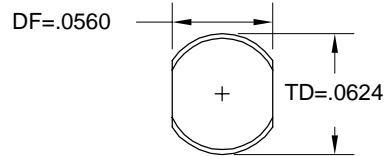
Below are shown various problem situations that can occur during bonding operations and their solutions. When choosing an option, please note the corresponding option number (A1, A2, etc.) when completing the part number from the Ordering Information sections. **These option numbers should appear as the last item in the part number.**

PROBLEM	SOLUTION	USE OPTION
		<p>■ SPECIFY "C"</p> <p>A6 or choose C-SERIES</p>
		<p>■ SPECIFY "T"</p> <p>A7</p>
	<p>BACK STEP VERTICAL</p>	<p>A8D</p> <p>DBS = .400 STANDARD BSV = .035</p>
<p>IF OTHER THAN STANDARD, SPECIFY "BSV" & "DBS" MINIMUM "BSV" IS .035 in. (.89mm) FOR 45° HOLE AND BS = .050 in. (1.27mm) FOR 52° HOLE.</p>		<p>A8D OPTION, NOT SUITABLE FOR F & K DELVOTEC AND HESSE & KNIPPS MACHINES</p>
		<p>BACK CHAMFER</p> <p>■ SPECIFY "C" AND ANGLE IF OTHER THAN STANDARD 45°</p> <p>A9</p>

OPTIONS

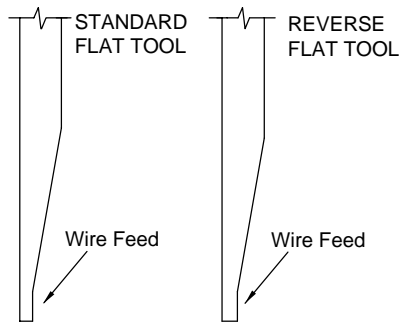


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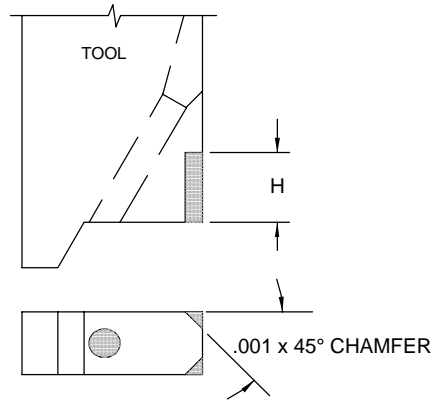


**A10 OPTION
(DOUBLE FLAT)**

Flat This Side Flat This Side



**A12 OPTION
(REVERSE FLAT)**



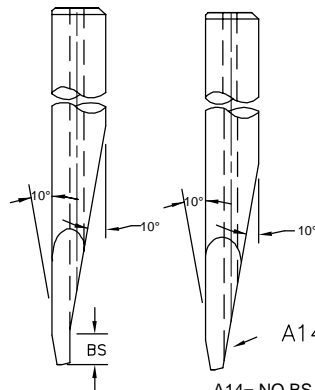
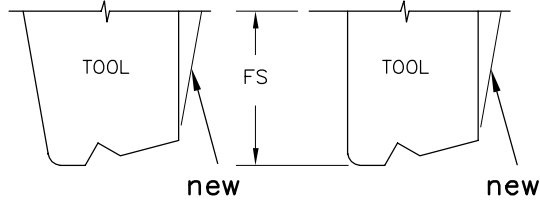
**A13 OPTION
(CHAMFER)**

■ SPECIFY (H)

NO BACK STEP FOR VERTICAL HOLE

EXAMPLE KS SERIES

EXAMPLE CS SERIES



**A14 OPTION
(NO BACK STEP)
FOR VERTICAL HOLE**

A14= NO BS FOR VERTICAL HOLES

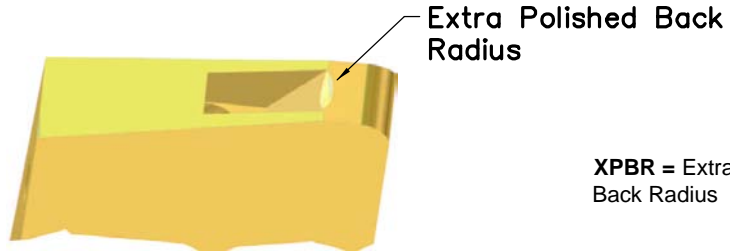
OPTIONS



Below are shown various problem situations that can occur during bonding operations and their solutions. When choosing an option, please note the corresponding option number (A1, A2, etc.) when completing the part number from the Ordering Information sections. These option numbers should appear as the last item in the part number.

PROBLEM	SOLUTION	USE OPTION
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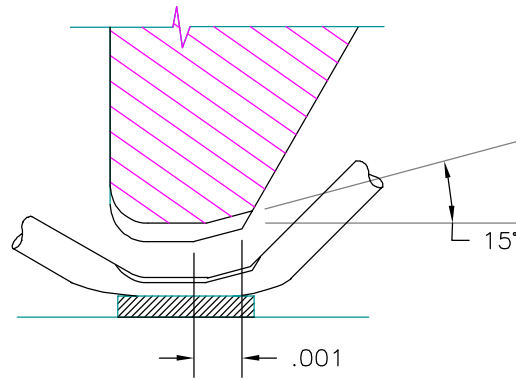
Heel Cracks



XPBR = Extra Polished Back Radius

Extra Polished Back Radius (Elliptical Back Radius)

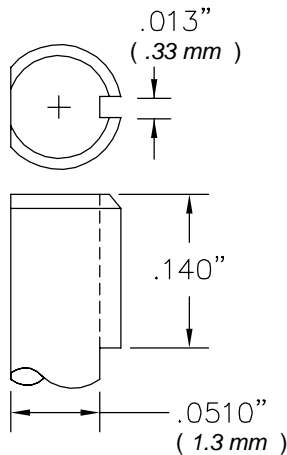
Heel Cracks



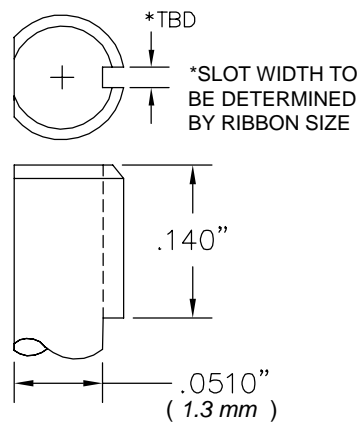
CBR = Chamfered Back Radius

CHAMFERED BACK RADIUS

FOR STANDARD WIRE



FOR RIBBON WIRE



S1 OPTION

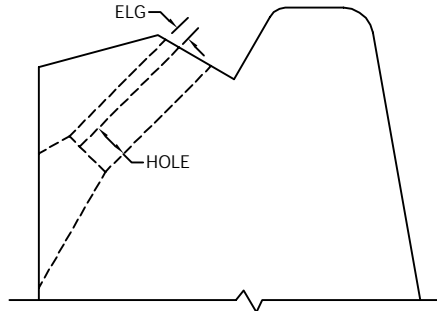
OPTIONS



Below are shown various problem situations that can occur during bonding operations and their solutions. When choosing an option, please note the corresponding option number (A1, A2, etc.) when completing the part number from the Ordering Information sections. These option numbers should appear as the last item in the part number.

PROBLEM	SOLUTION	USE OPTION
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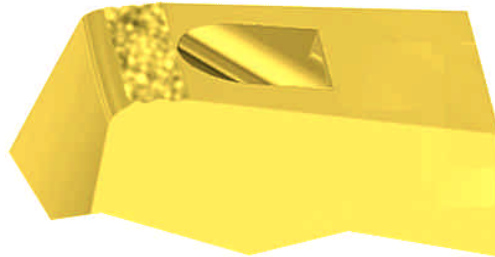
WIRE DRAGGING IN FEED



ELG=
HOLE BORE
ELONGATION

HOLE BORE ELONGATION			
STANDARD HOLE SIZE	WIRE Ø	SUGGESTED HOLE Ø MINIMUM	SUGGESTED HOLE ELONGATION (ELG)
15	.0007	.0013	.0004
20	.0010	.0017	.0006
25	.0013	.0022	.0006
30	.0015	.0025	.0010
35	.0020	.0030	.0010

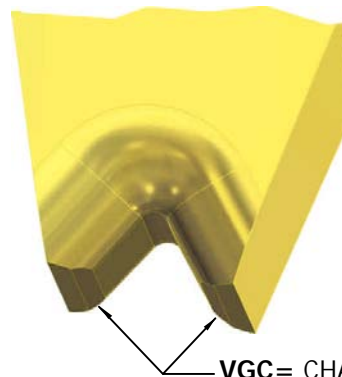
NO GRIP



ECM=
EXTRA COARSE
MATTE FINISH

ECM SURFACE ILLUSTRATION, REFERENCE ONLY

TOOL LIFE
WIRE RESIDUE BUILDUP



VGC= CHAMFER
ON VG
INCREASE TOOL LIFE