



FINE RIBBON WEDGE SLOT SIZE CONSIDERATIONS

ADVANCED TECHNOLOGY FOR
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SHEET

- SCOPE: A guide to help specify the correct feed slot size for a given ribbon size on MPP tools.

MPP Fine Ribbon Wedge Tool: Please use this information as a guide to help determine and select the correct slot size for the fine ribbon wedge you require. You will need to know the size of the ribbon you are using and required bond foot length (BL).

Ribbon Code Table

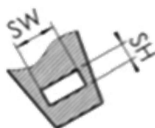
Ribbon width inches	Ribbon thickness (inches)				
	.0005	.0010	.0015	.0020	.0030
.0010	Z1	Z2	Z3	Z4	Z5
.0020	A1	A2	A3	A4	A5
.0030	B1	B2	B3	B4	B5
.0040	C1	C2	C3	C4	C5
.0050	D1	D2	D3	D4	D5
.0060	E1	E2	E3	E4	E5
.0070	F1	F2	F3	F4	F5
.0080	G1	G2	G3	G4	G5
.0090	H1	H2	H3	H4	H5
.0100	J1	J2	J3	J4	J5
.0110	K1	K2	K3	K4	K5
.0120	L1	L2	L3	L4	L5
.0130	M1	M2	M3	M4	M5
.0140	N1	N2	N3	N4	N5
.0150	P1	P2	P3	P4	P5
.0160	Q1	Q2	Q3	Q4	Q5
.0170	R1	R2	R3	R4	R5
.0180	S1	S2	S3	S4	S5
.0190	T1	T2	T3	T4	T5
.0200	U1	U2	U3	U4	U5

Step 1

Find which code relates to your ribbon width and thickness.

For example, 0.002" width and 0.0005" thickness gives you A1.

This gives you your slot size in your wedge.



4WR WEDGE MODEL

Code +BL	FR inches µm	BR inches µm	Slot Size		S (throat Size)		Width W inches µm
			SH inches µm	SW inches µm	For 30°/45° inches µm	For 60° inches µm	
A120	.0010	.0003	.0020	.0030	.0150	.0120	.0050
	25	8	51	76	381	305	127
A125	.0010	.0003	.0020	.0030	.0150	.0120	.0050
	25	8	51	76	381	305	127
A220	.0010	.0003	.0025	.0030	.0150	.0120	.0050
	25	8	64	76	381	305	127
A225	.0010	.0003	.0025	.0030	.0150	.0120	.0050
	25	8	64	76	381	305	127
B120	.0010	.0003	.0020	.0050	.0150	.0120	.0065
	25	8	51	127	381	305	165
B125	.0010	.0003	.0020	.0050	.0150	.0120	.0065
	25	8	51	127	381	305	165
B225	.0010	.0003	.0025	.0050	.0150	.0120	.0065
	25	8	64	127	381	305	165
C225	.0010	.0003	.0025	.0060	.0180	.0140	.0075
	25	8	64	152	457	356	191
C230	.0010	.0003	.0025	.0060	.0180	.0140	.0075
	25	8	64	152	457	356	191
C240	.0010	.0003	.0025	.0060	.0180	.0140	.0075
	25	8	64	152	457	356	191
D230	.0010	.0003	.0030	.0070	.0180	.0180	.0085
	25	8	76	178	457	457	216
D330	.0010	.0003	.0035	.0070	.0180	.0180	.0085
	25	8	89	178	457	457	216
D440	.0010	.0003	.0040	.0070	.0180	.0180	.0085
	25	8	102	178	457	457	216
G240	.0010	.0003	.0030	.0110	.0180	.0180	.0125
	25	8	76	279	457	457	318
J450	.0010	.0003	.0040	.0135	.0180	.0180	.0150
	25	8	102	343	457	457	381

Step 2

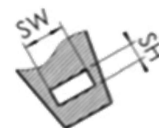
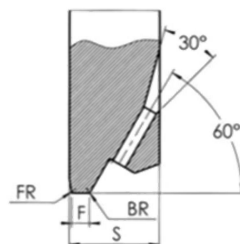
Once you have the code, cross reference it to the wedge model table.

You will need to have an idea of what bond length is necessary for the application.

Using the example from above - A1 - you can see there are two choices to select.

A120 – 0.002" x 0.0005" Slot Size – 0.020" BL

A125 - 0.002" x 0.0005" Slot Size – 0.025" BL

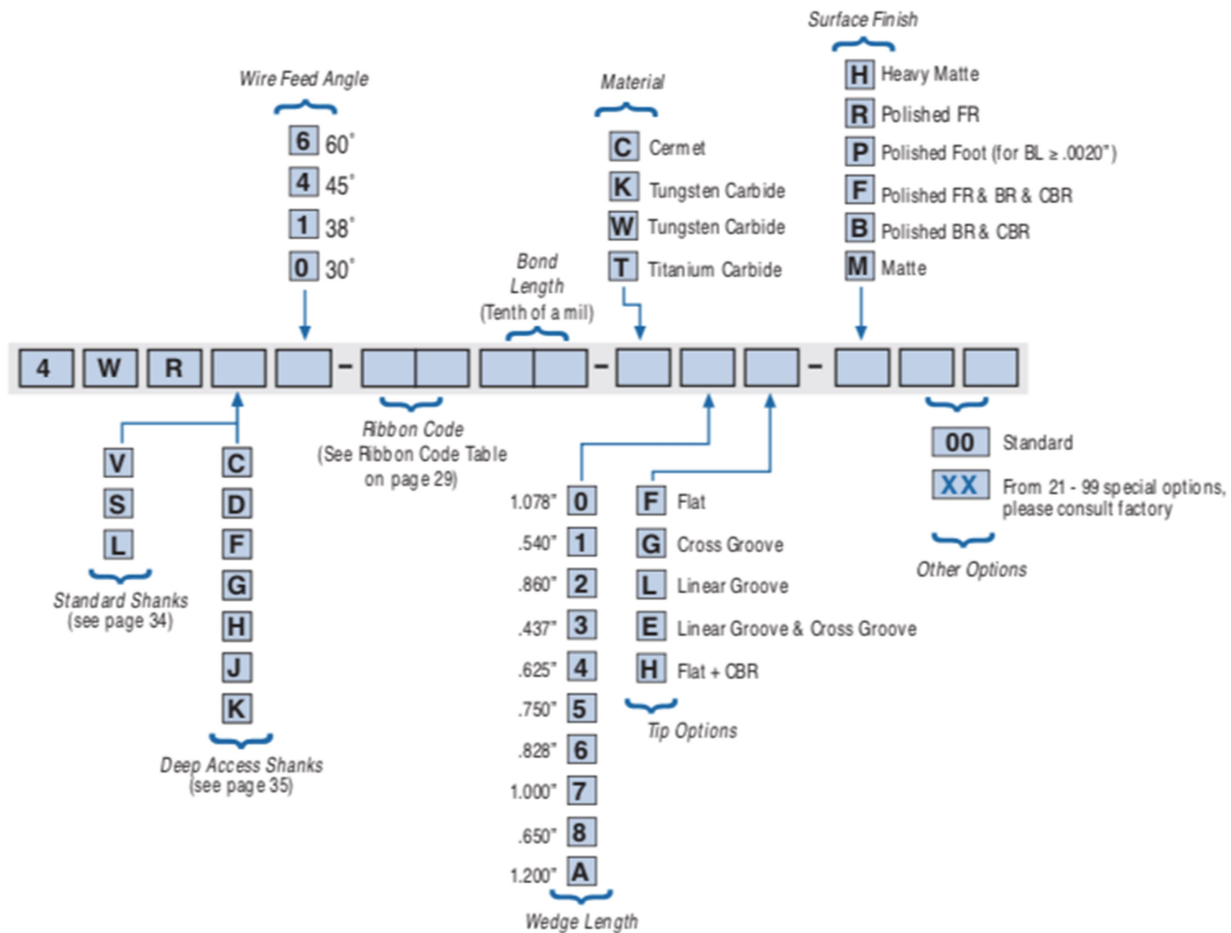


Step 3

Once you have your four digit code for the ribbon (A120 for example), the specification of the wedge tool then has to be defined.

This includes features such as the Wire Feed Angle, Shank Style, Surface Finish, Wedge Length, etc.

These can all be found in the chart below and within wedge catalogues.



Below are some dimension drawings which explain in more detail what the key features of a wedge are.

