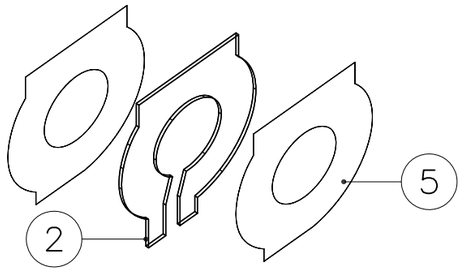
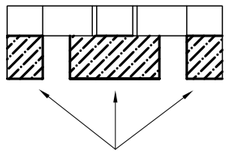
PREPARAZIONE BANDELLE
Foil preparation

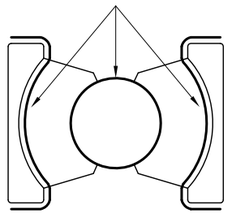
APPLICARE SULLE BANDELLE IN RAME RIF.2 IL PARTICOLARE IN KAPTON ADESIVO RIF.5 SU AMBO I LATI
Apply on each copper foil ref.2, the kapton adhesive tape ref.5 on eanch side



PREPARAZIONE NUCLEI
Core preparation

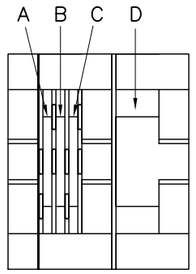


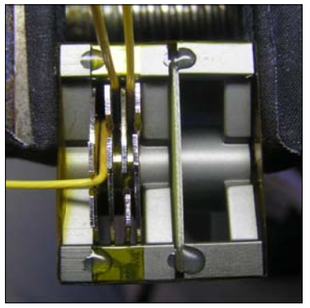
NASTRARE UN SEMINUCLEO SULLA GAMBA CENTRALE ED INTERNAMENTE SULLE GAMBE LATERALI MEDIANTE KAPTON RIF.4
Apply kapton tape ref.4 on central leg and internally to lateral legs

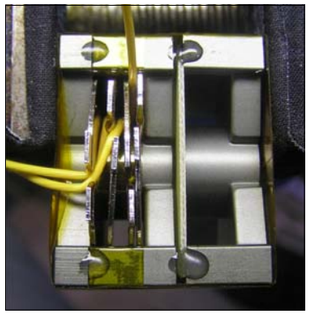


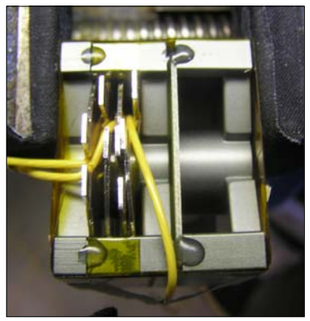
AVVOLGIMENTO
WInding

AVVOLGERE DIRETTAMENTE SUL NUCLEO NELLE CAVE A,B,C,D:
Wind directly on the core on slots A,B,C,D

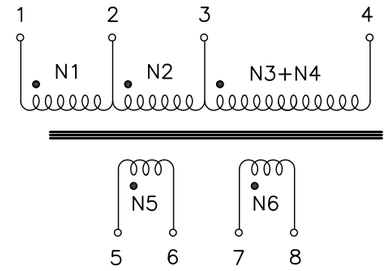








SCHEMA ELETTRICO
Electrical diagram



POSIZIONE AVVOLGIMENTI
Positioning

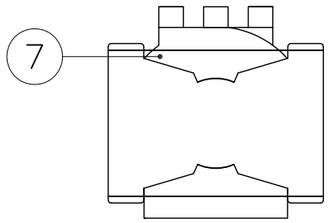
N1 NELLA CAVA A – N1 on slot A
N2 NELLA CAVA B – N2 on slot B
N3 NELLA CAVA C – N4 on slot C
N4 NELLA CAVA D – N4 on slot C
INSERIRE GLI INIZI DI N1, N2 E N3 E SAGOMARE N1 COME IN FOTO
Insert the begin of N1, N2 E N3 and bend N1 as showed in pictures

SAGOMARE N2 COME IN FOTO
Bend N2 as showed in pictures

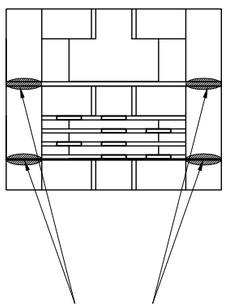
SAGOMARE N3 COME IN FOTO
Bend N3 as showed in pictures

MONTAGGIO
Assembling

APPLICARE 3 PEZZI DI KAPTON RIF.7 PER TRAFERRO.
Apply 3 piece of kapton ref.7 to gap cores



ASSIEMARE I NUCLEI MEDIANTE 2 GIRI DI KAPTON RIF.7
Fix the cores with 2 turns of kapton tape ref.7



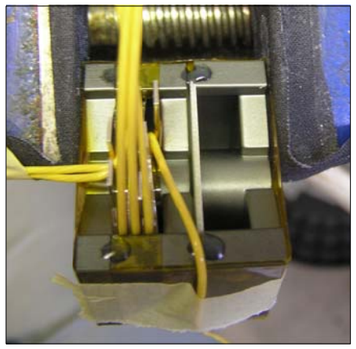
BLOCCARE NUCLEO/NUCLEO MEDIANTE 8 PUNTI DI COLLA RIF.11+12
Block cores with 8 point of glue ref.11+12

REV Rev	DATA APPR Appr. Date	RIF. MOD. Ref. Mod.	DESCRIZIONE MODIFICA Description of modification	REDAZIONE Editing	VERIFICA E APPROVAZIONE Check and approval
01	27.09.16		EMISSIONE – Release	C. Picciani	D. Di Giorgio

I.C.E. TRANSFORMERS

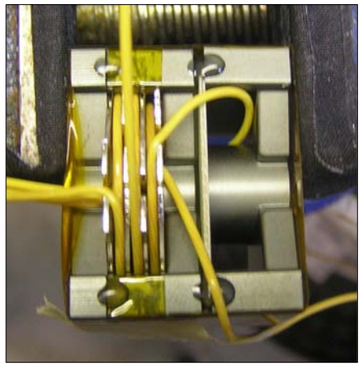
Mod. AQ 05.09

DESCRIZIONE–Description	Transformer/Choke PQI 35/23 (800W Server Main Transformer)			
DOCUMENTO–Document	CODICE–Part Number	REV.–Revision	DATA EMISSIONE–Release date	PAG.–Page
P.F.	8065.1103.001	01	27.09.16	1/2



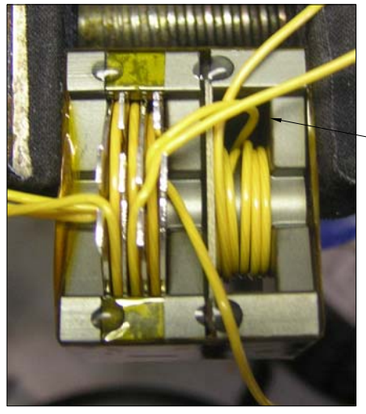
AVVOLGERE I TRE FILI CONTEMPORANEAMENTE ESEGUENDO:
5 SPIRE PER N1 (CAVA A)
6 SPIRE PER N2 (CAVA B)
5 SPIRE PER N3 (CAVA C)

Wind the wires at the same times with:
5 turns for N1 (slot A)
6 turns for N2 (slot B)
5 turns for N3 (slot C)



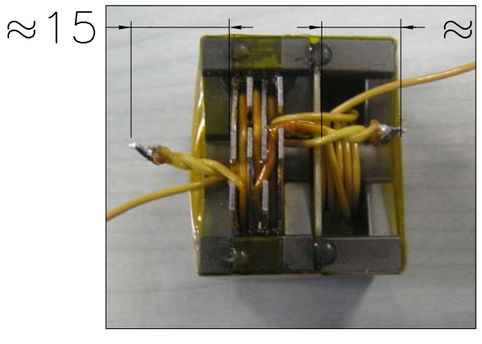
SAGOMARE LA FINE DI N1 COME IN FOTO
LASCIARE VOLANTE LA FINE DI N2
SAGOMARE LA FINE DI N3 COME IN FOTO ED UTILIZZARLA PER REALIZZARE ULTERIORI 6 SPIRE ALL'INTERNO DELLA CAVA "D", PER REALIZZARE L'AVVOLGIMENTO N4

Bend the finish of N1 as showed in picture.
Don't bend the finish of N2.
Bend the finish of N3 as showed in picture and use it to make additional 6 turns inside the slot "d" to complete winding n4



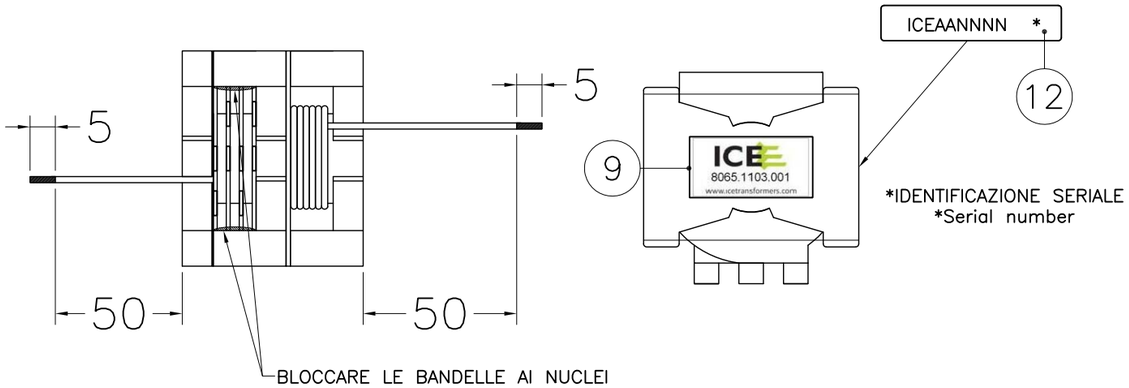
NASTRARE IL TEX-E CON KAPTON SUGLI ATTRAVERSAMENTI
FAR PASSARE LA FINE DI N4 COME IN FOTO
SAGOMARE LA FINE DI N3 COME IN FOTO

Apply kapton tape on crossing of Tex-e
Pass the finish of N4 as showed in picture
Bend the finish of N3 as showed in pictures

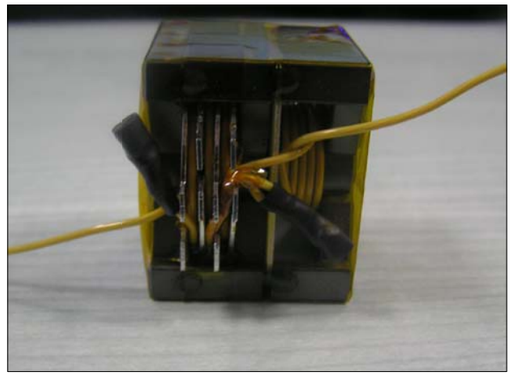


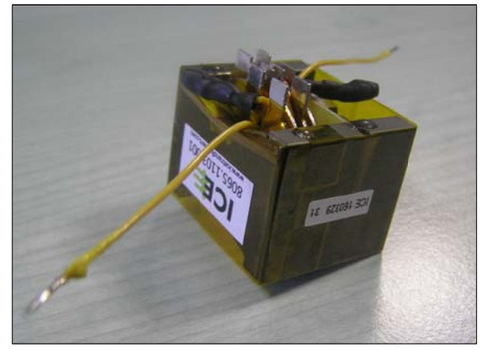
STAGNARE LE USCITE
RIFILARE E COLLEGARE FRA DI LORO LE USCITE 2 E 3
APPLICARE TERMORESTRINGENTE RIF.8 SULLE USCITE 2-3

Tin the exit connection
Cut and connect the exit 2-3
Apply thermo retractable ref.8 on exit 2-3



BLOCCARE LE BANDELLE AI NUCLEI
MEDIANTE RIF.10+11
Fix foil to core with ref.10+11





2011/65/UE (RoHS-2) Compliant

DIMENSIONI IN MILLIMETRI
Dimensions in millimeters

COLLAUDO ELETTRICO – Electrical checking

N°.	TIPO DI PROVA – Test	CONDIZIONI DI PROVA – Test Conditions	LIMITI – Limits
1	INDUTTANZA Inductance	1-4 @ 10 kHz – 100 mV	170.7 ÷ 181.3 µH
2	RAPPORTO SPIRE Tuurns ratio	TRA TUTTI GLI AVVOLGIMENTI Between all windings @ 10 kHz – 100 mV	< 1 SPIRA < 1 Turn
3	RIGIDITA' DIELETTRICA Dielectric strenght	1+2+3+4/5+6+7+8 @ 3750V – 50Hz – 1sec	SUPERARE LA PROVA Pass the test
4	RIGIDITA' DIELETTRICA Dielectric strenght	5+6+7+8/NUCLEO @ 300V – 50Hz – 1sec	SUPERARE LA PROVA Pass the test

REV Rev	DATA APPR Appr. Date	RIF. MOD. Ref. Mod.	DESCRIZIONE MODIFICA Description of modification	REDAZIONE Editing	VERIFICA E APPROVAZIONE Check and approval
01	27.09.16		EMISSIONE – Release	C. Picciani	D. Di Giorgio

I.C.E. TRANSFORMERS

Mod. AQ 05.09

DESCRIZIONE–Description	Transformer/Choke PQI 35/23 (800W Server Main Transformer)			
DOCUMENTO–Document	CODICE–Part Number	REV.–Revision	DATA EMISSIONE–Release date	PAG.–Page
P.F.	8065.1103.001	01	27.09.16	2/2

TRANSFORMERS

Bill of Material Item: 8065.1103.001 *Transformer/Choke PQI 35/23 800W Server Main Transformenr*

Variant	Upd. Last	Execution	Approval
0000	07/11/2016	1027 DI GIORGIO DAVIDE 12/07/2016	1027 DI GIORGIO DAVIDE 12/07/2016

Components

Ref.	Component			Quantity	Notes
01	0904.1313.001	Core set PQI35/23 DMR-95 AL8400±25% PQI35/23 - DMR-95 Ungapped	N	2	
02	0120.0000.256	Copper foil thickness 0.60mm	N	4	
03	1009.0201.003	Triple Insulated LITZ Wire 7x0.30mm TEX-ELZ 7/0.30 - E206440	M	3	
04	1606.2203.004	Adhesive kapton tape H7mm th.0.07mm Tape 5413 - E230409	CM	15,8	
05	0120.0000.257	Adhesive kapton insulator th.0.025mm	N	4	
06	0122.0100.270	Plate FR4 th.0.7mm 26x35mm E41625	N	1	
07	1606.2201.035	Adhesive kapton tape H=26mm th.0.05mm type 911-32 - E175868	CM	40	
08	1610.0003.001	Thermoretractable sleeve 3.2/1.6mm	N	0,025	
09	3206.0702.008	PVC label 24x12mm	N	1	
10	1910.0102.004	Epoxy resin 36-T	KG	0	
11	1909.0103.002	Activator for epoxy resin IN1005	KG	0	
12	3206.0119.001	Polyester label 7816 - MH16411	N	1	