

BS EN 60424-5:2009



BSI British Standards

Ferrite cores – Guide on the limits of surface irregularities —

Part 5: Planar-cores

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National foreword

This British Standard is the UK implementation of EN 60424-5:2009. It is identical to IEC 60424-5:2009.

The UK participation in its preparation was entrusted to Technical Committee EPL/51, Transformers, inductors, magnetic components and ferrite materials.

A list of organizations represented on this committee can be obtained on request to its secretary.

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ISBN 978 0 580 60181 1

ICS 29.100.10

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This British Standard was published under the authority of the Standards Policy and Strategy Committee on 31 July 2009

Amendments issued since publication

Amd. No.	Date	Text affected
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English version

**Ferrite cores -
Guide on the limits of surface irregularities -
Part 5: Planar-cores
(IEC 60424-5:2009)**

Noyaux ferrites -
Guide relatif aux limites
des irrégularités de surface -
Partie 5: Noyaux planaires
(CEI 60424-5:2009)

Ferritkerne -
Leitfaden für Grenzwerte von sichtbaren
Beschädigungen der Kernoberfläche -
Teil 5: Planarkerne
(IEC 60424-5:2009)

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Europäisches Komitee für Elektrotechnische Normung

Central Secretariat: Avenue Marnix 17, B - 1000 Brussels

Foreword

The text of document 51/947/FDIS, future edition 1 of IEC 60424-5, prepared by IEC TC 51, Magnetic components and ferrite materials, was submitted to the IEC-CENELEC parallel vote and was approved by CENELEC as EN 60424-5 on 2009-04-01.

The following dates were fixed:

- latest date by which the EN has to be implemented
at national level by publication of an identical
national standard or by endorsement (dop) 2010-01-01
- latest date by which the national standards conflicting
with the EN have to be withdrawn (dow) 2012-04-01

Annex ZA has been added by CENELEC.

Endorsement notice

The text of the International Standard IEC 60424-5:2009 was approved by CENELEC as a European Standard without any modification.

Annex ZA
(normative)

**Normative references to international publications
with their corresponding European publications**

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

NOTE When an international publication has been modified by common modifications, indicated by (mod), the relevant EN/HD applies.

<u>Publication</u>	<u>Year</u>	<u>Title</u>	<u>EN/HD</u>	<u>Year</u>
IEC 60424-1	- ¹⁾	Ferrite cores - Guide on the limits of surface irregularities - Part 1: General specification	EN 60424-1	1999 ²⁾
IEC 62317-9	- ¹⁾	Ferrite cores - Dimensions - Part 9: Planar cores	EN 62317-9	2006 ²⁾

¹⁾ Undated reference.

²⁾ Valid edition at date of issue.



IEC 60424-5

Edition 1.0 2009-02

INTERNATIONAL STANDARD

**Ferrite cores – Guide on the limits of surface irregularities –
Part 5: Planar-cores**

INTERNATIONAL
ELECTROTECHNICAL
COMMISSION

PRICE CODE

N

ICS 29.100.10

ISBN 2-8318-1032-6

CONTENTS

FOREWORD.....	3
1 Scope.....	5
2 Normative references	5
3 Limits of surface irregularities.....	6
3.1 Chips and ragged edges.....	6
3.1.1 Chips and ragged edges on the mating surfaces (see Figures 1, 2 and 3).....	6
3.1.2 Chips and ragged edges on other surfaces.....	7
3.2 Cracks.....	10
3.3 Flash.....	10
3.4 Pull-out	10
Figure 1 – Chip location for planar EL-core.....	6
Figure 2 – Chip location for low profile E-core.....	6
Figure 3 – Chip location for low profile ER-core	6
Figure 4 – Cracks and pull-out location for planar EL-core.....	10
Figure 5 – Cracks and pull-out location for low profile E-core.....	11
Figure 6 – Cracks and pull-out location for low profile ER-core	11
Figure 7 – Reference dimensions for EL-core	11
Figure 8 – Reference dimensions for E-core	12
Figure 9 – Reference dimensions for ER-core.....	13
Table 1 – Allowable areas of chips in mm ² for planar EL-core.....	7
Table 2 – Allowable areas of chips in mm ² for low profile E-core	8
Table 3 – Allowable areas of chips in mm ² for low profile ER-core.....	8
Table 4 – Area and length reference for visual inspection	9
Table 5 – Limits of cracks for planar EL-core	12
Table 6 – Limits of cracks for low profile E-core	13
Table 7 – Limits of cracks for low profile ER-core	14

INTERNATIONAL ELECTROTECHNICAL COMMISSION

**FERRITE CORES –
GUIDE ON THE LIMITS OF SURFACE IRREGULARITIES –**
Part 5: Planar-cores

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The text of this standard is based on the following documents:

FDIS	Report on voting
51/947/FDIS	51/950/RVD

Full information on the voting for the approval of this standard can be found in the report on voting indicated in the above table.

This publication has been drafted in accordance with the ISO/IEC Directives, Part 2.

A list of all parts of the IEC 60424 series, under the general title *Ferrite cores – Guide on the limits of surface irregularities*, can be found on the IEC website.

The committee has decided that the contents of this publication will remain unchanged until the maintenance result date indicated on the IEC web site under "<http://webstore.iec.ch>" in the data related to the specific publication. At this date, the publication will be

- reconfirmed,
- withdrawn,
- replaced by a revised edition, or
- amended.

A bilingual version of this publication may be issued at a later date.

FERRITE CORES – GUIDE ON THE LIMITS OF SURFACE IRREGULARITIES –

Part 5: Planar-cores

1 Scope

This part of IEC 60424 gives guidance on allowable limits of surface irregularities applicable to planar-cores in accordance with the relevant generic specification defined in IEC 60424-1.

The relations between the main dimensions of planar E-, ER- and EL-cores differ from those of standard cores. For example, the width of planar cores is larger while the total height is much smaller. Also the thickness of the legs is in most cases smaller than compared to standard cores. Therefore the concept of fixed reference dimensions to determine the length of crack limits yield crack lengths which are not acceptable for this type of core. This part of IEC 60424 follows another concept which relates the crack length to dimensions of the surface on which the crack occurs.

Also the concept to determine the maximum area of chips based on the total mating surface fails in the case of planar cores. The outer legs of planar cores are much thinner than those of standard cores which makes overlapping and gluing much more difficult. A single chip of maximum size on the outer leg may risk the functionality of the core set. Therefore this standard uses as a reference the mating surface on which the chip occurs.

Windings of planar cores are often PCB's which are glued to the inner surfaces of the planar core. For this reason the inner surfaces of the planar cores need to have a better quality than the inner surfaces of standard cores. This was taken into account by reducing the maximum allowable area of pull outs in the inner surfaces.

This standard is considered as a sectional specification useful in the negotiation between ferrite core manufacturers and users about surface irregularities.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

IEC 60424-1, *Ferrite cores – Guide on the limits of surface irregularities – Part 1: General specification*

IEC 62317-9, *Ferrite cores – Dimensions – Part 9: Planar-cores*

3 Limits of surface irregularities

3.1 Chips and ragged edges

3.1.1 Chips and ragged edges on the mating surfaces (see Figures 1, 2 and 3)

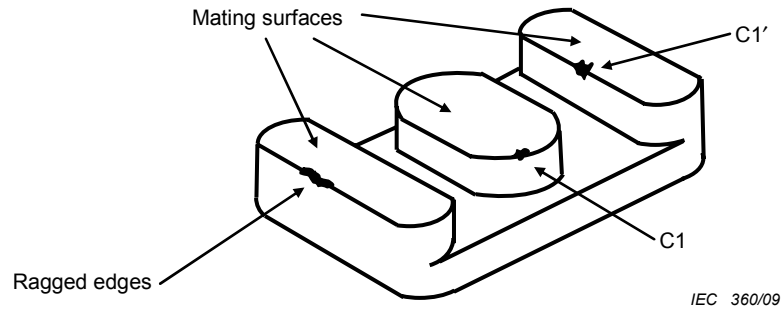


Figure 1 – Chip location for planar EL-core

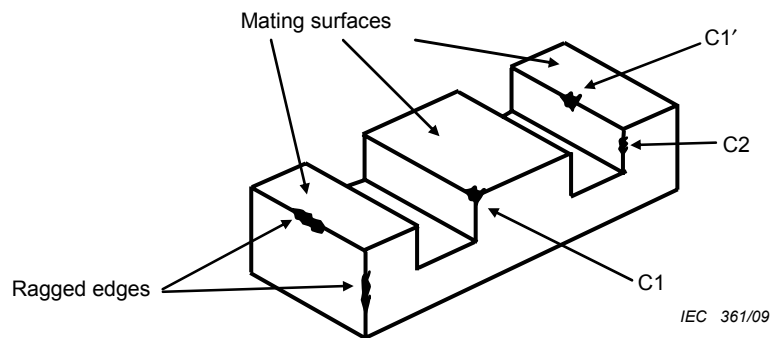


Figure 2 – Chip location for low profile E-core

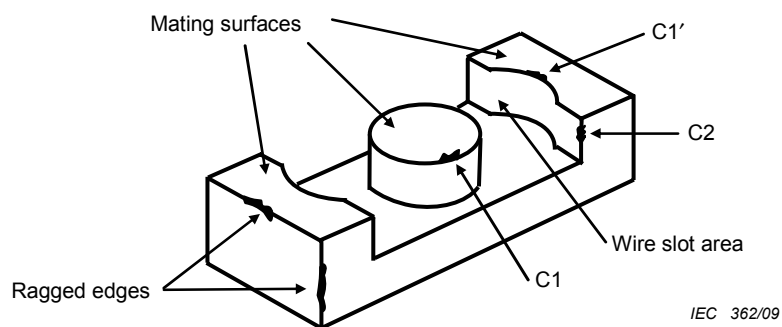


Figure 3 – Chip location for low profile ER-core

Areas of the chips located on the mating surfaces (C1 and C1' irregularities in Figures 1, 2 and 3) shall not exceed the following limits:

- the cumulative area of the chips shall be less than 4 % of the relevant mating surface. The mating surface of each outer leg and centre post is considered separately; the allowable areas are rounded to the figures in Table 4 (Area and length reference for visual inspection) and the minimum allowable area is taken as 0,5 mm² to be distinguishable to the naked eye;

- the total area of all chips on all mating surfaces shall not exceed the value given for “overall chipping on the mating surface” in Tables 1, 2 or 3;
- the total length of the ragged edges shall be less than 25 % of the perimeter of the relevant mating surface.

3.1.2 Chips and ragged edges on other surfaces

- the allowable chipping areas are doubled as compared to the limits for the whole mating surfaces (see Table 1 for planar EL-cores, Table 2 for low profile E-cores, Table 3 for low profile ER-cores);
- the total length of the ragged edges shall be less than 25 % of the perimeter of the smaller adjoining surface;
- chips and ragged edges are not acceptable on the ridge of the clamping recess area;
- chips and ragged edges are not acceptable on the inner edges of wire slot area. (C2 irregularity in Figures 2 and 3)

The core sizes given in Tables 1, 2 and 3 correspond to the cores defined in IEC 62317-9, and area and length reference for visual inspection are given in Table 4.

Table 1 – Allowable areas of chips in mm² for planar EL-core

Core size	Chipping on mating surface of one outer leg	Chipping on mating surface of centre post	Overall chipping on mating surface	Other surfaces
EL 11 × 2,0	0,5	0,5	1,5	3,0
EL 11 × 3,0	0,5	0,5	1,5	3,0
EL 13 × 2,2	0,5	1,0	2,0	4,0
EL 13 × 3,2	0,5	1,0	2,0	4,0
EL 15,5 × 2,9	0,5	1,0	2,0	4,0
EL 15,5 × 4,4	0,5	1,0	2,0	4,0
EL 18 × 3,7	1,0	2,0	4,0	8,0
EL 18 × 5,7	1,0	2,0	4,0	8,0
EL 20 × 3,8	1,0	2,0	4,0	8,0
EL 20 × 5,8	1,0	2,0	4,0	8,0
EL 22 × 4,0	1,5	2,5	5,5	11,0
EL 22 × 6,0	1,5	2,5	5,5	11,0
EL 25 × 4,3	1,5	3,5	6,5	13,0
EL 25 × 6,3	1,5	3,5	6,5	13,0

Table 2 – Allowable areas of chips in mm² for low profile E-core

Core size	Chipping on mating surface of one outer leg	Chipping on mating surface of centre post	Overall chipping on mating surface	Other surfaces
E 14 × 3,5 × 5	0,5	0,5	1,5	3,0
E 18 × 4 × 10	1,0	1,5	3,5	7,0
E 22 × 6 × 16	1,5	3,0	6,0	12,0
E 32 × 6 × 20	2,5	5,0	10,0	20,0
E 38 × 8 × 25	3,5	8,0	15,0	30,0
E 43 × 10 × 28	4,5	9,0	18,0	36,0
E 58 × 11 × 38	6,0	12,5	24,5	49,0
E 64 × 10 × 50	10,0	20,0	40,0	80,0
E 102 × 20 × 38	12,5	20,0	45,0	90,0

Table 3 – Allowable areas of chips in mm² for low profile ER-core

Core size	Chipping on mating surface of one outer leg	Chipping on mating surface of centre post	Overall chipping on mating surface	Other surfaces
ER 9,5 × 2,5 × 5	0,5	0,5	1,5	3,0
ER 11 × 2,5 × 6	0,5	0,5	1,5	3,0
ER 13 × 3 × 9	0,5	1,0	2,0	4,0
ER 14,5 × 3 × 7	0,5	1,0	2,0	4,0
ER 18 × 3 × 10	0,5	1,0	2,0	4,0
ER 20 × 6 × 14	1,5	2,0	5,0	10,0
ER 23 × 3,6 × 13	1,0	2,0	4,0	8,0
ER 23 × 5 × 13	1,0	2,0	4,0	8,0
ER 25 × 6 × 15	1,5	3,0	6,0	12,0
ER 30 × 8 × 20	2,5	4,0	9,0	18,0
ER 32 × 5 × 21	2,0	4,0	8,0	16,0
ER 32 × 6 × 25	2,5	5,0	10,0	20,0
ER 35 × 10 × 26	3,5	7,0	14,0	28,0
ER 40 × 10 × 28	4,0	7,0	15,0	30,0

Table 4 – Area and length reference for visual inspection

Surface	A	B	C	D	E	Surface	A	B	C	D	E
0,5 mm ²						12,5 mm ²					
1,0 mm ²						15,0 mm ²					
1,5 mm ²						17,5 mm ²					
2,0 mm ²						20,0 mm ²					
2,5 mm ²						25,0 mm ²					
3,0 mm ²						30,0 mm ²					
3,5 mm ²						35,0 mm ²					
4,0 mm ²						40,0 mm ²					
4,5 mm ²						45,0 mm ²					
5,0 mm ²						50,0 mm ²					
6,0 mm ²											
7,0 mm ²											
8,0 mm ²											
9,0 mm ²											
10,0 mm ²											

Echelle 1:1

1 mm 2 mm 3 mm 4 mm

5 mm 7,5 mm 10 mm

3.2 Cracks

Different cracks are shown in Figures 4, 5 and 6. In principle three different types of cracks can be distinguished.

- a) Cracks which are parallel to the magnetic flux path (S1, S2, S5, S5', S5''). These cracks are magnetically not critical. The maximum length of a single crack is 33 % (1/3) of the dimension of the relevant surface which is parallel to the crack. In the case of multiple cracks the maximum cumulative length doubles.
- b) Cracks which are perpendicular to the magnetic flux path (S3, S3', S3'', S4, S4'). These cracks are magnetically critical. They may reduce the relative cross section of the magnetic flux or add an additional air gap into the magnetic circuit. The maximum total length of cracks is 20 % (1/5) of the dimension of the relevant surface which is parallel to the crack.
- c) Cracks which go from one edge to another edge (S6). These cracks may cause chipping during the operation in the circuit. The loose particles may cause malfunctions in the circuit. Therefore this type of crack is not acceptable in any case.

The limits for cracks are given in Tables 5, 6 and 7.

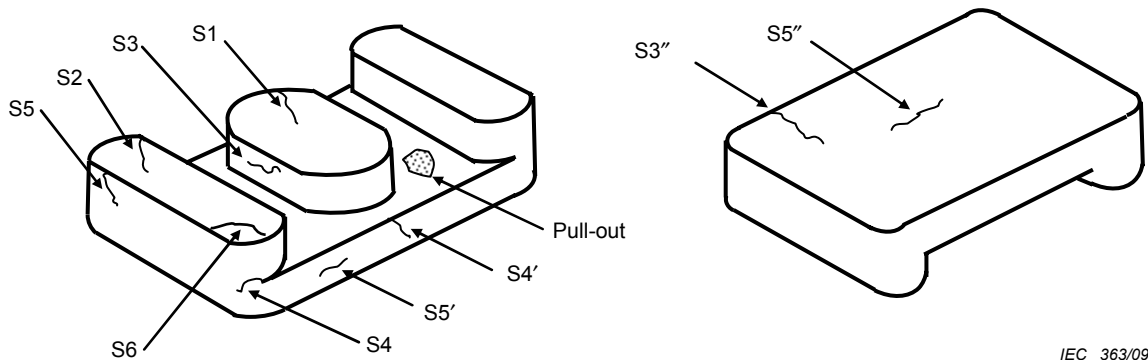
3.3 Flash

There shall be no flash extending from the core into the wire slot.

3.4 Pull-out

The pull-outs are applicable only for the inner surface where the PCB is seated (as shown in Figures 4, 5 and 6).

For planar EL-cores, low profile E-cores and low profile ER-cores, the cumulative area of pull-outs of the core shall be less than 20 % of the total respective surface area.



IEC 363/09

Figure 4 – Cracks and pull-out location for planar EL-core

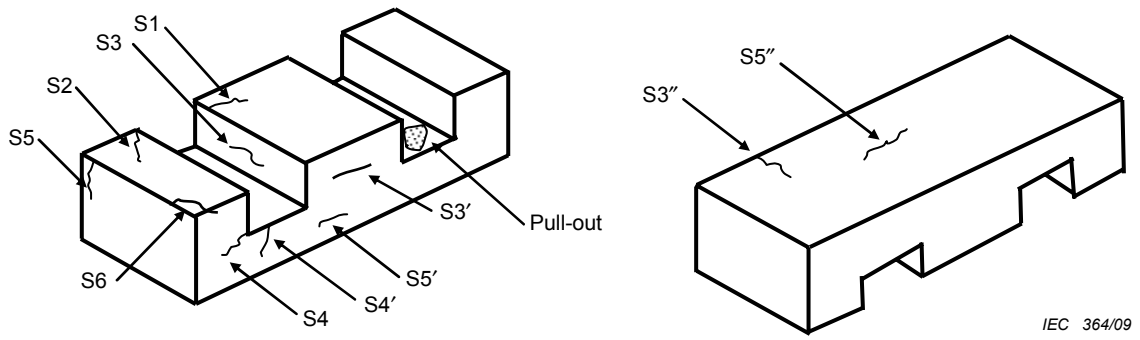


Figure 5 – Cracks and pull-out location for low profile E-core

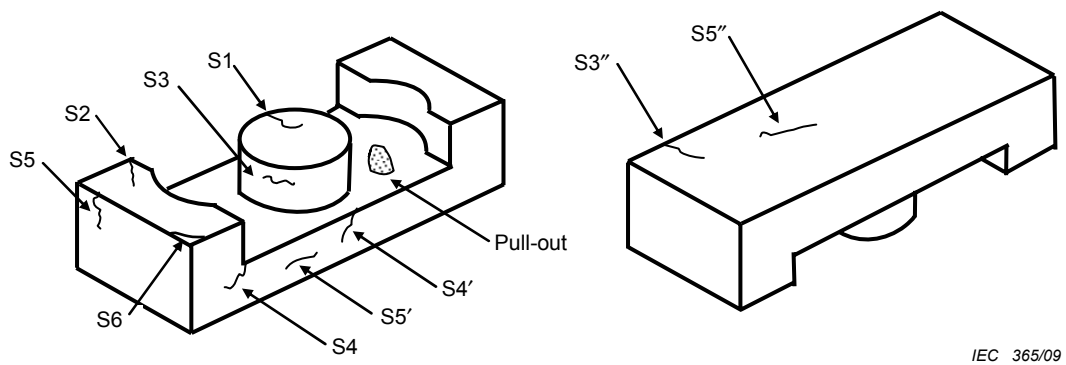


Figure 6 – Cracks and pull-out location for low profile ER-core

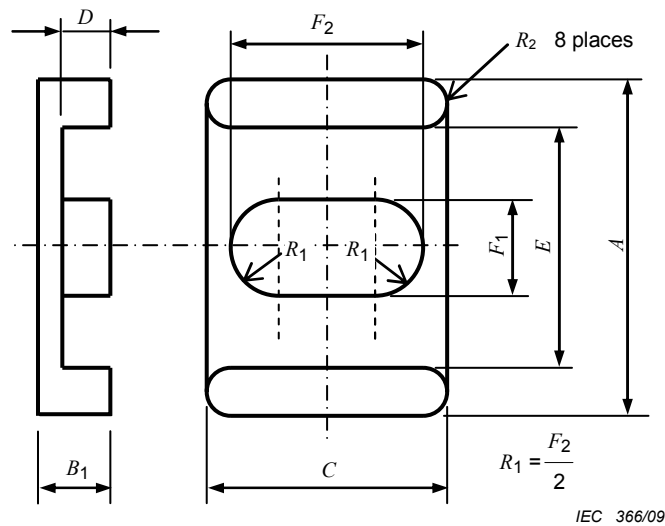
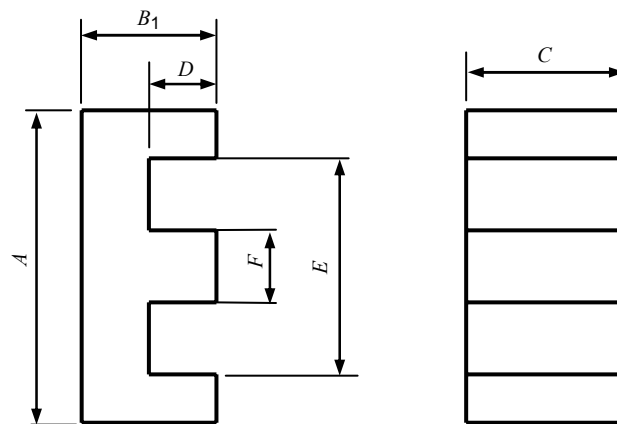


Figure 7 – Reference dimensions for EL-core

Table 5 – Limits of cracks for planar EL-core

Type ¹	Reference dimension ²	Limits for single crack	Limits for multiple cracks
S1	F_1	33 % (1/3) of reference dim.	66 % (2/3) of reference dim.
S2	$(A-E)/2$	33 % (1/3) of reference dim.	66 % (2/3) of reference dim.
S3	F_2	20 % (1/5) of reference dim.	20 % (1/5) of reference dim.
S3'	F_1	20 % (1/5) of reference dim.	20 % (1/5) of reference dim.
S3''	C	20 % (1/5) of reference dim.	20 % (1/5) of reference dim.
S4	$B_1 - D$	20 % (1/5) of reference dim.	20 % (1/5) of reference dim.
S4'	$B_1 - D$	20 % (1/5) of reference dim.	20 % (1/5) of reference dim.
S5	B_1	33 % (1/3) of reference dim.	66 % (2/3) of reference dim.
S5'	A	33 % (1/3) of reference dim.	66 % (2/3) of reference dim.
S5''	A	33 % (1/3) of reference dim.	66 % (2/3) of reference dim.
S6	Multiple edges	No cracks allowed	

¹ See Figure 4.
² See Figure 7.



IEC 367/09

Figure 8 – Reference dimensions for E-core

Table 6 – Limits of cracks for low profile E-core

Type ¹	Reference dimension ²	Limits for single crack	Limits for multiple cracks
S1	F	33 % (1/3) of reference dim.	66 % (2/3) of reference dim.
S2	$(A-E)/2$	33 % (1/3) of reference dim.	66 % (2/3) of reference dim.
S3	C	20 % (1/5) of reference dim.	20 % (1/5) of reference dim.
S3'	F	20 % (1/5) of reference dim.	20 % (1/5) of reference dim.
S3''	C	20 % (1/5) of reference dim.	20 % (1/5) of reference dim.
S4	$B_1 - D$	20 % (1/5) of reference dim.	20 % (1/5) of reference dim.
S4'	$B_1 - D$	20 % (1/5) of reference dim.	20 % (1/5) of reference dim.
S5	B_1	33 % (1/3) of reference dim.	66 % (2/3) of reference dim.
S5'	A	33 % (1/3) of reference dim.	66 % (2/3) of reference dim.
S5''	A	33 % (1/3) of reference dim.	66 % (2/3) of reference dim.
S6	Multiple edges	No cracks allowed	

¹ See Figure 5.
² See Figure 8.

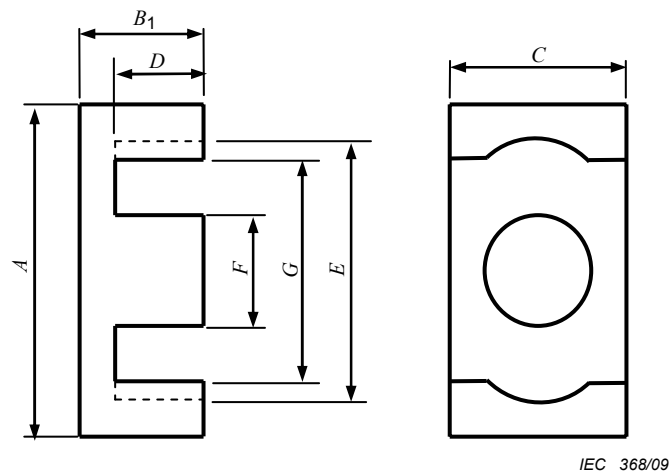
**Figure 9 – Reference dimensions for ER-core**

Table 7 – Limits of cracks for low profile ER-core

Type ¹	Reference dimension ²	Limits for single crack	Limits for multiple cracks
S1	F	33 % (1/3) of reference dim.	66 % (2/3) of reference dim.
S2	$(A-G)/2$	33 % (1/3) of reference dim.	66 % (2/3) of reference dim.
S3	F	20 % (1/5) of reference dim.	20 % (1/5) of reference dim.
S3''	C	20 % (1/5) of reference dim.	20 % (1/5) of reference dim.
S4	$B_1 - D$	20 % (1/5) of reference dim.	20 % (1/5) of reference dim.
S4'	$B_1 - D$	20 % (1/5) of reference dim.	20 % (1/5) of reference dim.
S5	B_1	33 % (1/3) of reference dim.	66 % (2/3) of reference dim.
S5'	A	33 % (1/3) of reference dim.	66 % (2/3) of reference dim.
S5''	A	33 % (1/3) of reference dim.	66 % (2/3) of reference dim.
S6	Multiple edges	No cracks allowed	
¹ See Figure 6. ² See Figure 9.			

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