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**PCB Mounted Circular Plastic Connector**

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**1. SCOPE**

## 1.1. Content

This specification covers performance, tests and quality requirements for the TE Connectivity (TE) printed circuit board mounted circular electrical connectors (plugs and receptacles) with removable crimp contacts. These connectors are designed for use in electronic, electric power and control circuits.

## 1.2. Classification

Connectors shall be of the following classes (pressurized receptacle; general purpose; and environment resisting general purpose with jacketed cable and interfacial seals) and shell size (23) specified on the applicable product drawing.

## 1.3. Qualification

When tests are performed on the subject product line, procedures specified in Figure 1 shall be used. All inspections shall be performed using the applicable inspection plan and product drawing.

## 1.4. Qualification Test Results

Successful qualification testing on the subject product line was completed on 29Feb00. The Qualification Test Report number for this testing is 501-483-5. This documentation is on file at and available from Engineering Practices and Standards (EPS).

**2. APPLICABLE DOCUMENTS**

The following documents form a part of this specification to the extent specified herein. Unless otherwise specified, the latest edition of the document applies. In the event of conflict between the requirements of this specification and the product drawing, the product drawing shall take precedence. In the event of conflict between the requirements of this specification and the referenced documents, this specification shall take precedence.

## 2.1. TE Documents

- 108-10024: Product Specification
- 109-197: Test Specification (TE Test Specifications vs EIA and IEC Test Methods)
- 501-483-5: Qualification Test Report

## 2.2. Commercial Standard

EIA-364: Electrical Connector/Socket Test Procedures Including Environmental Classifications

**3. REQUIREMENTS**

## 3.1. Design and Construction

Product shall be of the design, construction and physical dimensions specified on the applicable product drawing.

### 3.2. Materials

Materials used in the construction of this product shall be as specified on the applicable product drawing.

### 3.3. Ratings

- Voltage: 250 volts AC/DC
- Temperature: -55 to 105°C

### 3.4. Performance and Test Description

Product is designed to meet the electrical, mechanical and environmental performance requirements specified in Figure 1. Unless otherwise specified, all tests shall be performed at ambient environmental conditions per EIA-364.

### 3.5. Test Requirements and Procedures Summary

Test Description	Requirement	Procedure
Initial examination of product.	Meets requirements of product drawing.	EIA-364. Visual and dimensional inspection per product drawing.
Final examination of product.	Meets visual requirements.	EIA-364. Visual inspection.
<b>ELECTRICAL</b>		
Dry circuit resistance.	4 milliohms maximum change.	EIA-364-23. Subject specimens to 100 milliamperes maximum and 20 millivolts maximum open circuit voltage.
<b>MECHANICAL</b>		
Solderability.	Solderable area shall have a minimum of 95% solder coverage.	EIA-364-52. Subject contacts to solderability.
Vibration, sinusoidal.	No discontinuities of 1 microsecond or longer duration. See Note.	EIA-364-28, Condition IV. Subject mated specimens to 10-2000-10 Hz traversed in 20 minutes with 1.5 mm [0.06 in] maximum total excursion. 4 hours in each of 3 mutually perpendicular planes. See Figure 3.
Mechanical shock, specified pulse.	No discontinuities of 1 microsecond or longer duration. See Note.	EIA-364-27, Condition A. Subject mated specimens to 50 G's half-sine shock pulses of 11 milliseconds duration. 3 shocks in each direction applied along 3 mutually perpendicular planes, 18 total shocks. See Figure 3.

Figure 1 (continued)

Test Description	Requirement	Procedure
Durability.	See Note.	EIA-364-9. Manually mate and unmate specimens for 100 cycles at a maximum rate of 600 cycles per hour.
Mating torque.	2.26 N•m [20 in-lb] maximum.	EIA-364-13, Condition B. Measure force necessary to mate specimens.
Unmating force.	2.26 N•m [20 in-lb] maximum.	EIA-364-13, Condition B. Measure force necessary to unmate specimens.
<b>ENVIRONMENTAL</b>		
Humidity-temperature cycling.	See Note.	EIA-364-31. Subject specimens to 10, 24 hour cycles between 25 and 65°C at 95% RH.

**NOTE** *Shall meet visual requirements, show no physical damage, and meet requirements of additional tests as specified in the Product Qualification and Requalification Test Sequence shown in Figure 2.*

Figure 1 (end)

3.6. Product Qualification and Requalification Test Sequence

Test or Examination	Test Group (a)		
	1	2	3
	Test Sequence (b)		
Initial examination of product	1	1	1
Dry circuit resistance	3,7	2,4	
Solderability			2
Vibration	5		
Mechanical shock	6		
Durability	4		
Mating torque	2		
Unmating torque	8		
Humidity-temperature cycling		3	
Final examination of product	9	5	3

**NOTE** (a) See paragraph 4.1.A.  
(b) Numbers indicate sequence in which tests are performed.

Figure 2

#### 4. QUALITY ASSURANCE PROVISIONS

##### 4.1. Qualification Testing

###### A. Specimen Selection

Specimens shall be prepared in accordance with applicable Instruction Sheets and shall be selected at random from current production. All test groups shall each consist of a minimum of 5 specimens.

###### B. Test Sequence

Qualification inspection shall be verified by testing specimens as specified in Figure 2.

##### 4.2. Requalification Testing

If changes significantly affecting form, fit or function are made to the product or manufacturing process, product assurance shall coordinate requalification testing, consisting of all or part of the original testing sequence as determined by development/product, quality and reliability engineering.

##### 4.3. Acceptance

Acceptance is based on verification that the product meets the requirements of Figure 1. Failures attributed to equipment, test setup or operator deficiencies shall not disqualify the product. If product failure occurs, corrective action shall be taken and specimens resubmitted for qualification. Testing to confirm corrective action is required before resubmittal.

##### 4.4. Quality Conformance Inspection

The applicable quality inspection plan shall specify the sampling acceptable quality level to be used. Dimensional and functional requirements shall be in accordance with the applicable product drawing and this specification.

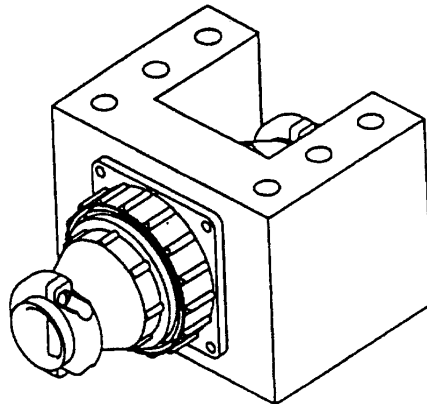


Figure 3  
Vibration & Mechanical Shock Mounting Fixture