Project Number: Design Qualification Test Report	Tracking Code: 1090589_Report_Rev_1
Requested by: David Brock	Date: 6/2/2017
Part #: HSEC8-20-01-L-DP-A-K/EDGE CARD	
Part description: HSEC8/CARD	Tech: Donnie Baldwin
Test Start: 3/14/2017	Test Completed: 4/13/2017

DESIGN QUALIFICATION TEST REPORT

HSEC8/CARD
HSEC8-20-01-L-DP-A-K/EDGE CARD

REVISION HISTORY

DATA	REV.NUM.	DESCRIPTION	ENG
6/2/2017	**1**	**Initial Issue**	**KH**

CERTIFICATION

All instruments and measuring equipment were calibrated to National Institute for Standards and Technology (NIST) traceable standards according to IS0 10012-l and ANSI/NCSL 2540-1, as applicable.

SCOPE

To perform the following tests: Design Qualification test. Please see test plan.

APPLICABLE DOCUMENTS

Standards: EIA Publication 364

TEST SAMPLES AND PREPARATION

1) All materials were manufactured in accordance with the applicable product specification.
2) All test samples were identified and encoded to maintain traceability throughout the test sequences.
3) After soldering, the parts to be used for LLCR testing were cleaned according to TLWI-0001.
4) Either an automated cleaning procedure or an ultrasonic cleaning procedure may be used.
5) The automated procedure is used with aqueous compatible soldering materials.
6) Parts not intended for testing LLCR are visually inspected and cleaned if necessary.
7) Any additional preparation will be noted in the individual test sequences.
8) Solder Information: Lead Free
9) Samtec Test PCBs used: PCB-107940-TST/PCB-107941-TST/ PCB-107942-TST/ PCB-107943-TST

FLOWCHARTS

Gas Tight

Group 1
HSEC8-20-01-L-DP-A
0.056" EDGE CARD
8 Assemblies
Min Card

Step	Description
1.	LLCR (2)
2.	Gas Tight (1)
3.	LLCR (2) Max Delta = 15 mOhm

(1) Gas Tight = EIA-364-36

(2) LLCR = EIA-364-23
Open Circuit Voltage = 20 mV Max
Test Current = 100 mA Max

Normal Force

Group 1
HSEC8-20-01-L-DP-A
0.068" EDGE CARD
8 Contacts Minimum
Signal Without Thermals

Step	Description
1.	Contact Gaps
2.	Normal Force (1) Expected Force at Max Deflection = 54 g Deflection = 0.023 "

Group 2
HSEC8-20-01-L-DP-A
0.068" EDGE CARD
8 Contacts Minimum
Signal With Thermals

Step	Description
1.	Contact Gaps
2.	Thermal Age (2)
3.	Contact Gaps
4.	Normal Force (1) Expected Force at Max Deflection = 54 g Deflection = 0.023 "

(1) Normal Force = EIA-364-04

(2) Thermal Age = EIA-364-17
Test Condition = 4 (105°C)
Time Condition = B (250 Hours)

FLOWCHARTS Continued

Thermal Aging

Group 1 HSEC8-20-01-L-DP-A 0.068" EDGE CARD 8 Assemblies Max Card		Group 2 HSEC8-20-01-L-DP-A 0.056" EDGE CARD 8 Assemblies Min Card	
Step	**Description**	**Step**	**Description**
1.	Contact Gaps	1.	Contact Gaps
2.	Mating/Unmating Force (2)	2.	Mating/Unmating Force (2)
3.	LLCR (1)	3.	LLCR (1)
4.	Thermal Age (3)	4.	Thermal Age (3)
5.	LLCR (1) Max Delta = 15 mOhm	5.	LLCR (1) Max Delta = 15 mOhm
6.	Mating/Unmating Force (2)	6.	Mating/Unmating Force (2)
7.	Contact Gaps	7.	Contact Gaps

(1) LLCR = EIA-364-23
Open Circuit Voltage = 20 mV Max
Test Current = 100 mA Max

(2) Mating/Unmating Force = EIA-364-13

(3) Thermal Age = EIA-364-17
Test Condition = 4 (105°C)
Time Condition = B (250 Hours)

FLOWCHARTS Continued

Mating/Unmating/Durability

Group 1 HSEC8-20-01-L-DP-A 0.068" EDGE CARD 8 Assemblies Max Card		Group 2 HSEC8-20-01-L-DP-A 0.056" EDGE CARD 8 Assemblies Min Card		Group 3 HSEC8-56-01-L-DP-A 0.068" EDGE CARD 8 Assemblies Max Card		Group 4 HSEC8-08-01-L-DP-A 0.068" EDGE CARD 8 Assemblies Max Card	
Step	**Description**	**Step**	**Description**	**Step**	**Description**	**Step**	**Description**
1.	Contact Gaps	1.	Contact Gaps	1.	Contact Gaps	1.	Contact Gaps
2.	LLCR (2)	2.	LLCR (2)	2.	Mating/Unmating Force (3)	2.	Mating/Unmating Force (3)
3.	Mating/Unmating Force (3)	3.	Mating/Unmating Force (3)	3.	Cycles Quantity = 25 Cycles	3.	Cycles Quantity = 25 Cycles
4.	Cycles Quantity = 25 Cycles	4.	Cycles Quantity = 25 Cycles	4.	Mating/Unmating Force (3)	4.	Mating/Unmating Force (3)
5.	Mating/Unmating Force (3)	5.	Mating/Unmating Force (3)				
6.	Contact Gaps	6.	Contact Gaps				
7.	LLCR (2) Max Delta = 15 mOhm	7.	LLCR (2) Max Delta = 15 mOhm				
8.	Thermal Shock (4)	8.	Thermal Shock (4)				
9.	LLCR (2) Max Delta = 15 mOhm	9.	LLCR (2) Max Delta = 15 mOhm				
10.	Humidity (1)	10.	Humidity (1)				
11.	LLCR (2) Max Delta = 15 mOhm	11.	LLCR (2) Max Delta = 15 mOhm				
12.	Mating/Unmating Force (3)	12.	Mating/Unmating Force (3)				

(1) Humidity = EIA-364-31
Test Condition = B (240 Hours)
Test Method = III (+25°C to +65°C @ 90% RH to 98% RH)
Test Exceptions: ambient pre-condition and delete steps 7a and 7b

(2) LLCR = EIA-364-23
Open Circuit Voltage = 20 mV Max
Test Current = 100 mA Max

(3) Mating/Unmating Force = EIA-364-13

(4) Thermal Shock = EIA-364-32
Exposure Time at Temperature Extremes = 1/2 Hour
Method A, Test Condition = I (-55°C to +85°C)
Test Duration = A-3 (100 Cycles)

FLOWCHARTS Continued

IR/DWV

Pin-to-Pin

Group 1 HSEC8-20-01-L-DP-A 0.056" EDGE CARD 2 Assemblies		Group 2 HSEC8-20-01-L-DP-A 2 Assemblies		Group 3 HSEC8-20-01-L-DP-A 0.056" EDGE CARD 2 Assemblies	
Step	**Description**	**Step**	**Description**	**Step**	**Description**
1.	DWV Breakdown (2)	1.	DWV Breakdown (2)	1.	IR (4)
				2.	DWV at Test Voltage (1)
				3.	Thermal Shock (5)
				4.	IR (4)
				5.	DWV at Test Voltage (1)
				6.	Humidity (3)
				7.	IR (4)
				8.	DWV at Test Voltage (1)

Row-to-Row

Group 4 HSEC8-20-01-L-DP-A 0.056" EDGE CARD 2 Assemblies		Group 5 HSEC8-20-01-L-DP-A 2 Assemblies		Group 6 HSEC8-20-01-L-DP-A 0.056" EDGE CARD 2 Assemblies	
Step	**Description**	**Step**	**Description**	**Step**	**Description**
1.	DWV Breakdown (2)	1.	DWV Breakdown (2)	1.	IR (4)
				2.	DWV at Test Voltage (1)
				3.	Thermal Shock (5)
				4.	IR (4)
				5.	DWV at Test Voltage (1)
				6.	Humidity (3)
				7.	IR (4)
				8.	DWV at Test Voltage (1)

Pin-to-Ground

Group 7 HSEC8-20-01-L-DP-A 0.056" EDGE CARD 2 Assemblies		Group 8 HSEC8-20-01-L-DP-A 2 Assemblies		Group 9 HSEC8-20-01-L-DP-A 0.056" EDGE CARD 2 Assemblies	
Step	**Description**	**Step**	**Description**	**Step**	**Description**
1.	DWV Breakdown (2)	1.	DWV Breakdown (2)	1.	IR (4)
				2.	DWV at Test Voltage (1)
				3.	Thermal Shock (5)
				4.	IR (4)
				5.	DWV at Test Voltage (1)
				6.	Humidity (3)
				7.	IR (4)
				8.	DWV at Test Voltage (1)

(1) DWV at Test Voltage = EIA-364-20
Test Condition = 1 (Sea Level)
DWV test voltage is equal to 75% of the lowest breakdown voltage
Test voltage applied for 60 seconds

(2) DWV Breakdown = EIA-364-20
Test Condition = 1 (Sea Level)
DWV test voltage is equal to 75% of the lowest breakdown voltage
Test voltage applied for 60 seconds

(3) Humidity = EIA-364-31
Test Condition = B (240 Hours)
Test Method = III (+25°C to +65°C @ 90% RH to 98% RH)
Test Exceptions: ambient pre-condition and delete steps 7a and 7b

(4) IR = EIA-364-21
Test Condition = 500 Vdc, 2 Minutes Max

(5) Thermal Shock = EIA-364-32
Exposure Time at Temperature Extremes = 1/2 Hour
Method A, Test Condition = I (-55°C to +85°C)
Test Duration = A-3 (100 Cycles)

FLOWCHARTS Continued

Current Carrying Capacity

Group 1
HSEC8-56-01-L-DP-A
0.056" EDGE CARD
2 Pins Powered
Signal

Step	Description
1.	CCC (1) Rows = 2 Number of Positions = 1

Group 2
HSEC8-56-01-L-DP-A
0.056" EDGE CARD
4 Pins Powered
Signal

Step	Description
1.	CCC (1) Rows = 2 Number of Positions = 2

Group 3
HSEC8-56-01-L-DP-A
0.056" EDGE CARD
6 Pins Powered
Signal & Ground

Step	Description
1.	CCC (1) Rows = 2 Number of Positions = 3

Group 4
HSEC8-56-01-L-DP-A
0.056" EDGE CARD
8 Pins Powered
Signal & Ground

Step	Description
1.	CCC (1) Rows = 2 Number of Positions = 4

Group 5
HSEC8-56-01-L-DP-A
0.056" EDGE CARD
2 Pins Powered
Ground

Step	Description
1.	CCC (1) Rows = 2 Number of Positions = 1

Group 6
HSEC8-56-01-L-DP-A
0.056" EDGE CARD
172 Pins Powered
Signal & Ground

Step	Description
1.	CCC (1) Rows = 2 Number of Positions = 86

(1) CCC = EIA-364-70
Method 2, Temperature Rise Versus Current Curve
(TIN PLATING) - Tabulate calculated current at RT, 65°C, 75°C and 95°C after derating 20% and based on 105°C
(GOLD PLATING) - Tabulate calculated current at RT, 85°C, 95°C and 115°C after derating 20% and based on 125°C

FLOWCHARTS Continued

Mechanical Shock/Random Vibration/LLCR

Group 1 HSEC8-20-01-L-DP-A 0.056" EDGE CARD 8 Assemblies Min Card		Group 2 HSEC8-20-01-L-DP-A 0.068" EDGE CARD 8 Assemblies Max Card	
Step	**Description**	**Step**	**Description**
1.	LLCR (1)	1.	LLCR (1)
2.	Mechanical Shock (2)	2.	Mechanical Shock (2)
3.	Random Vibration (3)	3.	Random Vibration (3)
4.	LLCR (1) Max Delta = 15 mOhm	4.	LLCR (1) Max Delta = 15 mOhm

(1) LLCR = EIA-364-23
Open Circuit Voltage = 20 mV Max
Test Current = 100 mA Max

(2) Mechanical Shock = EIA-364-27
Test Condition = C (100 G Peak, 6 milliseconds, Half Sine)
Number of Shocks = 3 Per Direction, Per Axis, 18 Total

(3) Random Vibration = EIA-364-28
Condition = VB (7.56 gRMS Average, 2 Hours/Axis)

Mechanical Shock/Random Vibration/Event Detection

Group 1 HSEC8-20-01-L-DP-A 0.056" EDGE CARD 60 Points Min Card	
Step	**Description**
1.	Nanosecond Event Detection (Mechanical Shock) (1)
2.	Nanosecond Event Detection (Random Vibration) (2)

(1) Nanosecond Event Detection (Mechanical Shock)
Use EIA-364-87 for Nanosecond Event Detection:
Test Condition = F (50 nanoseconds at 10 ohms)
Use EIA-364-27 for Mechanical Shock:
Test Condition = C (100 G Peak, 6 milliseconds, Half Sine)
Number of Shocks = 3 Per Direction, Per Axis, 18 Total

(2) Nanosecond Event Detection (Random Vibration)
Use EIA-364-87 for Nanosecond Event Detection:
Test Condition = F (50 nanoseconds at 10 ohms)
Use EIA-364-28 for Random Vibration:
Condition = VB (7.56 gRMS Average, 2 Hours/Axis)

ATTRIBUTE DEFINITIONS

The following is a brief, simplified description of attributes.

THERMAL:

1) EIA-364-17, *Temperature Life with or without Electrical Load Test Procedure for Electrical Connectors.*
2) Test Condition at 105° C.
3) Test Time Condition B for 250 hours.
4) All test samples are pre-conditioned at ambient.
5) All test samples are exposed to environmental stressing in the mated condition.

THERMAL SHOCK:

1) EIA-364-32, *Thermal Shock (Temperature Cycling) Test Procedure for Electrical Connectors.*
2) Test Condition: -55°C to +85°C
3) Test Time: ½ hour dwell at each temperature extreme
4) Number of Cycles: 100
5) All test samples are pre-conditioned at ambient.
6) All test samples are exposed to environmental stressing in the mated condition.

HUMIDITY:

1) Reference document: EIA-364-31, *Humidity Test Procedure for Electrical Connectors.*
2) Test Condition B, 240 Hours.
3) Method III, +25° C to + 65° C, 90% to 98% Relative Humidity excluding sub-cycles 7a and 7b.
4) All samples are pre-conditioned at ambient.
5) All test samples are exposed to environmental stressing in the mated condition.

MECHANICAL SHOCK (Specified Pulse):

1) Reference document: EIA-364-27, *Mechanical Shock Test Procedure for Electrical Connectors*
2) Test Condition C
3) Peak Value: 100 G
4) Duration: 6 Milliseconds
5) Wave Form: Half Sine
6) Velocity: 12.3 ft/s
7) Number of Shocks: 3 Shocks / Direction, 3 Axis (18 Total)

VIBRATION:

1) Reference document: EIA-364-28, *Vibration Test Procedure for Electrical Connectors*
2) Test Condition V, Letter B
3) Power Spectral Density: 0.04 G^2 / Hz
4) G 'RMS': 7.56
5) Frequency: 50 to 2000 Hz
6) Duration: 2.0 Hours per axis (3 axis total)

NANOSECOND-EVENT DETECTION:

1) Reference document: EIA-364-87, *Nanosecond-Event Detection for Electrical Connectors*
2) Prior to test, the samples were characterized to assure the low nanosecond event being monitored will trigger the detector.
3) After characterization it was determined the test samples could be monitored for 50 nanosecond events

MATING/UNMATING:

1) Reference document: EIA-364-13, *Mating and Unmating Forces Test Procedure for Electrical Connectors*.
2) The full insertion position was to within 0.003" to 0.004" of the plug bottoming out in the receptacle to prevent damage to the system under test.
3) One of the mating parts is secured to a floating X-Y table to prevent damage during cycling.

ATTRIBUTE DEFINITIONS Continued

The following is a brief, simplified description of attributes

NORMAL FORCE (FOR CONTACTS TESTED IN THE HOUSING):

1) Reference document: EIA-364-04, *Normal Force Test Procedure for Electrical Connectors*.
2) The contacts shall be tested in the connector housing.
3) If necessary, a "window" shall be made in the connector body to allow a probe to engage and deflect the contact at the same attitude and distance (plus 0.05 mm [0.002"]) as would occur in actual use.
4) The connector housing shall be placed in a holding fixture that does not interfere with or otherwise influence the contact force or deflection.
5) Said holding fixture shall be mounted on a floating, adjustable, X-Y table on the base of the Dillon TC^2, computer controlled test stand with a deflection measurement system accuracy of 5.0 µm (0.0002").
6) The nominal deflection rate shall be 5 mm (0.2")/minute.
7) Unless otherwise noted a minimum of five contacts shall be tested.
8) The force/deflection characteristic to load and unload each contact shall be repeated five times.
9) The system shall utilize the TC^2 software in order to acquire and record the test data.
10) The permanent set of each contact shall be measured within the TC^2 software.
11) The acquired data shall be graphed with the deflection data on the X-axis and the force data on the Y-axis and a print out will be stored with the Tracking Code paperwork.

TEMPERATURE RISE (Current Carrying Capacity, CCC):

1) EIA-364-70, *Temperature Rise versus Current Test Procedure for Electrical Connectors and Sockets*.
2) When current passes through a contact, the temperature of the contact increases as a result of I^2R (resistive) heating.
3) The number of contacts being investigated plays a significant part in power dissipation and therefore temperature rise.
4) The size of the temperature probe can affect the measured temperature.
5) Copper traces on PC boards will contribute to temperature rise:
    a. Self heating (resistive)
    b. Reduction in heat sink capacity affecting the heated contacts
6) A de-rating curve, usually 20%, is calculated.
7) Calculated de-rated currents at four temperature points are reported:
    a. Ambient
    b. 85^{o} C
    c. 95^{o} C
    d. 115^{o} C
8) Typically, neighboring contacts (in close proximity to maximize heat build up) are energized.
9) The thermocouple (or temperature measuring probe) will be positioned at a location to sense the maximum temperature in the vicinity of the heat generation area.
10) A computer program, *TR 803.exe*, ensures accurate stability for data acquisition.
11) Hook-up wire cross section is larger than the cross section of any connector leads/PC board traces, jumpers, etc.
12) Hook-up wire length is longer than the minimum specified in the referencing standard.

ATTRIBUTE DEFINITIONS Continued

The following is a brief, simplified description of attributes

LLCR:

1) EIA-364-23, *Low Level Contact Resistance Test Procedure for Electrical Connectors and Sockets.*
2) A computer program, *LLCR 221.exe*, ensures repeatability for data acquisition.
3) The following guidelines are used to categorize the changes in LLCR as a result from stressing
    a. <= +5.0 mOhms: ---------- Stable
    b. +5.1 to +10.0 mOhms: ---------- Minor
    c. +10.1 to +15.0 mOhms: ---------- Acceptable
    d. +15.1 to +50.0 mOhms: ---------- Marginal
    e. +50.1 to +2000 mOhms: ---------- Unstable
    f. >+2000 mOhms:---------- Open Failure

GAS TIGHT:

To provide method for evaluating the ability of the contacting surfaces in preventing penetration of harsh vapors which might lead to oxide formation that may degrade the electrical performance of the contact system.

1) EIA-364-23, *Low Level Contact Resistance Test Procedure for Electrical Connectors and Sockets.*
2) A computer program, *LLCR 221.exe*, ensures repeatability for data acquisition.
3) The following guidelines are used to categorize the changes in LLCR as a result from stressing
    a. <= +5.0 mOhms:---------- Stable
    b. +5.1 to +10.0 mOhms: ---------- Minor
    c. +10.1 to +15.0 mOhms: ---------- Acceptable
    d. +15.1 to +50.0 mOhms: ---------- Marginal
    e. +50.1 to +2000 mOhms:---------- Unstable
    f. >+2000 mOhms: ---------- Open Failure
4) Procedure:
    a. Reference document: EIA-364-36, *Test Procedure for Determination of Gas-Tight Characteristics for Electrical Connectors, Sockets and/or Contact Systems.*
    b. Test Conditions:
        i. Class II--- Mated pairs of contacts assembled to their plastic housings.
        ii. Reagent grade Nitric Acid shall be used of sufficient volume to saturate the test chamber
        iii. The ratio of the volume of the test chamber to the surface area of the acid shall be 10:1.
        iv. The chamber shall be saturated with the vapor for at least 15 minutes before samples are added.
        v. Exposure time, 55 to 65 minutes.
        vi. The samples shall be no closer to the chamber walls than 1 inches and no closer to the surface of the acid than 3 inches.
        vii. The samples shall be dried after exposure for a minimum of 1 hour.
        viii. Drying temperature 50^{o} C
        ix. The final LLCR shall be conducted within 1 hour after drying.

ATTRIBUTE DEFINITIONS Continued

The following is a brief, simplified description of attributes

INSULATION RESISTANCE (IR):

To determine the resistance of insulation materials to leakage of current through or on the surface of these materials when a DC potential is applied.

1) PROCEDURE:
    a. Reference document: EIA-364-21, *Insulation Resistance Test Procedure for Electrical Connectors*.
    b. Test Conditions:
        i. Between Adjacent Contacts or Signal-to-Ground
        ii. Electrification Time 2.0 minutes
        iii. Test Voltage (500 VDC) corresponds to calibration settings for measuring resistances.
2) MEASUREMENTS:
3) When the specified test voltage is applied (VDC), the insulation resistance shall not be less than 5000 megohms.

DIELECTRIC WITHSTANDING VOLTAGE (DWV):

To determine if the sockets can operate at its rated voltage and withstand momentary over potentials due to switching, surges, and other similar phenomenon. Separate samples are used to evaluate the effect of environmental stresses so not to influence the readings from arcing that occurs during the measurement process.

1) PROCEDURE:
    a. Reference document: EIA-364-20, *Withstanding Voltage Test Procedure for Electrical Connectors*.
    b. Test Conditions:
        i. Between Adjacent Contacts or Signal-to-Ground
        ii. Barometric Test Condition 1
        iii. Rate of Application 500 V/Sec
        iv. Test Voltage (VAC) until breakdown occurs
2) MEASUREMENTS/CALCULATIONS
    a. The breakdown voltage shall be measured and recorded.
    b. The dielectric withstanding voltage shall be recorded as 75% of the minimum breakdown voltage.
    c. The working voltage shall be recorded as one-third (1/3) of the dielectric withstanding voltage (one-fourth of the breakdown voltage).

RESULTS

Temperature Rise, CCC at a 20% de-rating

Signal pin

- **CCC for a 30°C Temperature Rise----------2.7 A per contact with 2 contacts (2x1) powered**
- **CCC for a 30°C Temperature Rise----------2.2 A per contact with 4 contacts (2x2) powered**

Signal & Ground pin

- **CCC for a 30°C Temperature Rise----------1.8 A per contact with 6 contacts (2x3) powered**
- **CCC for a 30°C Temperature Rise----------1.7 A per contact with 8 contacts (2x4) powered**
- **CCC for a 30°C Temperature Rise----------0.8 A per contact with 172 contacts (2x86) powered**

Ground pin

- **CCC for a 30°C Temperature Rise----------2.9 A per contact with 2 contacts (2x1) powered**

Mating – Unmating Forces

Thermal aging Group---Card 0.068”

- **Initial**
  - **Mating**
    - **Min ---------- 4.39 lbs**
    - **Max---------- 5.27 lbs**
  - **Unmating**
    - **Min ---------- 2.65 lbs**
    - **Max---------- 3.55 lbs**
- **After Thermal**
  - **Mating**
    - **Min ---------- 3.19 lbs**
    - **Max---------- 3.84 lbs**
  - **Unmating**
    - **Min ---------- 2.17 lbs**
    - **Max---------- 2.49 lbs**

Thermal aging Group---Card 0.056”

- **Initial**
  - **Mating**
    - **Min ---------- 3.27 lbs**
    - **Max---------- 4.16 lbs**
  - **Unmating**
    - **Min ---------- 2.18 lbs**
    - **Max---------- 3.18 lbs**
- **After Thermal**
  - **Mating**
    - **Min ---------- 2.26 lbs**
    - **Max---------- 3.05 lbs**
  - **Unmating**
    - **Min ---------- 1.60 lbs**
    - **Max---------- 2.11 lbs**

RESULTS Continued

Mating – Unmating Forces

Mating/Unmating Durability Group 1

HSEC8-20-01-L-DP-A-K/EDGE CARD---0.068”

- **Initial**
  - **Mating**
    - **Min ---------- 3.69 lbs**
    - **Max---------- 4.55 lbs**
  - **Unmating**
    - **Min ---------- 2.31 lbs**
    - **Max---------- 3.54 lbs**
- **After 25 Cycles**
  - **Mating**
    - **Min ---------- 4.43 lbs**
    - **Max---------- 6.05 lbs**
  - **Unmating**
    - **Min ---------- 3.05 lbs**
    - **Max---------- 4.58 lbs**
- **Humidity**
  - **Mating**
    - **Min ---------- 2.41 lbs**
    - **Max---------- 3.55 lbs**
  - **Unmating**
    - **Min ---------- 1.99 lbs**
    - **Max---------- 2.80 lbs**

Mating/Unmating Durability Group 2

HSEC8-20-01-L-DP-A-K/EDGE CARD---0.056”

- **Initial**
  - **Mating**
    - **Min ---------- 2.89 lbs**
    - **Max---------- 4.00 lbs**
  - **Unmating**
    - **Min ---------- 1.95 lbs**
    - **Max---------- 3.03 lbs**
- **After 25 Cycles**
  - **Mating**
    - **Min ---------- 3.02 lbs**
    - **Max---------- 4.92 lbs**
  - **Unmating**
    - **Min ---------- 2.41 lbs**
    - **Max---------- 3.19 lbs**
- **Humidity**
  - **Mating**
    - **Min ---------- 2.17 lbs**
    - **Max---------- 2.60 lbs**
  - **Unmating**
    - **Min ---------- 1.75 lbs**
    - **Max---------- 2.26 lbs**

RESULTS Continued

Mating – Unmating Forces

Mating/Unmating Basic

HSEC8-56-01-L-DP-A-K/EDGE CARD---0.068”

- **Initial**
  - **Mating**
    - **Min ---------- 8.89 lbs**
    - **Max---------- 10.66 lbs**
  - **Unmating**
    - **Min ---------- 6.73 lbs**
    - **Max---------- 8.88 lbs**
- **After 25 Cycles**
  - **Mating**
    - **Min ---------- 8.92 lbs**
    - **Max---------- 12.84 lbs**
  - **Unmating**
    - **Min ---------- 8.29 lbs**
    - **Max---------- 9.36 lbs**

HSEC8-08-01-L-DP-A-K/EDGE CARD---0.068”

- **Initial**
  - **Mating**
    - **Min ---------- 1.43 lbs**
    - **Max---------- 1.70 lbs**
  - **Unmating**
    - **Min ---------- 1.07 lbs**
    - **Max---------- 1.23 lbs**
- **After 25 Cycles**
  - **Mating**
    - **Min ---------- 1.26 lbs**
    - **Max---------- 1.89 lbs**
  - **Unmating**
    - **Min ---------- 1.24 lbs**
    - **Max---------- 1.57 lbs**

Normal Force at 0.023 inch deflection

Signal Pin

- **Initial**
  - **Min----------80.70 gf Set ----- 0.0037 inch**
  - **Max ----------86.50 gf Set ----- 0.0049 inch**
- **Thermal**
  - **Min----------61.30 gf Set----- 0.0054 inch**
  - **Max ----------72.70 gf Set----- 0.0070 inch**

Ground Pin

- **Initial**
  - **Min----------75.80 gf Set ----- 0.0038 inch**
  - **Max ----------84.30 gf Set ----- 0.0048 inch**
- **Thermal**
  - **Min----------52.10 gf Set----- 0.0074 inch**
  - **Max ----------66.10 gf Set----- 0.0085 inch**

RESULTS Continued

Insulation Resistance minimums, IR

Pin to Pin

- **Initial**
  - **Mated----------45000 Meg Ω ---------- Passed**
  - **Unmated ----------45000 Meg Ω ---------- Passed**
- **Thermal Shock**
  - **Mated----------45000 Meg Ω ---------- Passed**
  - **Unmated ----------45000 Meg Ω ---------- Passed**
- **Humidity**
  - **Mated----------45000 Meg Ω ---------- Passed**
  - **Unmated ----------34000 Meg Ω ---------- Passed**

Row to Row

- **Initial**
  - **Mated----------45000 Meg Ω ---------- Passed**
  - **Unmated ----------45000 Meg Ω ---------- Passed**
- **Thermal Shock**
  - **Mated----------45000 Meg Ω ---------- Passed**
  - **Unmated ----------45000 Meg Ω ---------- Passed**
- **Humidity**
  - **Mated----------45000 Meg Ω ---------- Passed**
  - **Unmated ----------45000 Meg Ω ---------- Passed**

Pin to Ground

- **Initial**
  - **Mated----------45000 Meg Ω ---------- Passed**
  - **Unmated ----------45000 Meg Ω ---------- Passed**
- **Thermal Shock**
  - **Mated----------45000 Meg Ω ---------- Passed**
  - **Unmated ----------45000 Meg Ω ---------- Passed**
- **Humidity**
  - **Mated----------45000 Meg Ω ---------- Passed**
  - **Unmated ----------45000 Meg Ω ---------- Passed**

Dielectric Withstanding Voltage minimums, DWV

- **Minimums**
  - **Breakdown Voltage----------954 VAC**
  - **Test Voltage ----------720 VAC**
  - **Working Voltage ----------235 VAC**

Pin to Pin

- **Initial DWV ----------Passed**
- **Thermal DWV----------Passed**
- **Humidity DWV----------Passed**

Row to Row

- **Initial DWV ----------Passed**
- **Thermal DWV----------Passed**
- **Humidity DWV----------Passed**

Pin to Ground

- **Initial DWV ----------Passed**
- **Thermal DWV----------Passed**
- **Humidity DWV----------Passed**

RESULTS Continued

LLCR Gas Tight (192 LLCR test points)

- **Initial ---------- 7.38 mOhms Max**
- **Gas-Tight**
  - **<= +5.0 mOhms ---------- 192 Points ---------- Stable**
  - **+5.1 to +10.0 mOhms ---------- 0 Points ---------- Minor**
  - **+10.1 to +15.0 mOhms ---------- 0 Points ---------- Acceptable**
  - **+15.1 to +50.0 mOhms ---------- 0 Points ---------- Marginal**
  - **+50.1 to +2000 mOhms ---------- 0 Points ---------- Unstable**
  - **>+2000 mOhms ---------- 0 Points ---------- Open Failure**

LLCR Thermal Aging (160 signal and 32 ground LLCR test points)

Group 1---Card 0.068”

Signal Pin

- **Initial ---------- 7.15 mOhms Max**
- **Thermal Aging**
  - **<= +5.0 mOhms ---------- 160 Points ---------- Stable**
  - **+5.1 to +10.0 mOhms ---------- 0 Points ---------- Minor**
  - **+10.1 to +15.0 mOhms ---------- 0 Points ---------- Acceptable**
  - **+15.1 to +50.0 mOhms ---------- 0 Points ---------- Marginal**
  - **+50.1 to +2000 mOhms ---------- 0 Points ---------- Unstable**
  - **>+2000 mOhms ---------- 0 Points ---------- Open Failure**

Ground Pin

- **Initial ---------- 7.23 mOhms Max**
- **Thermal Aging**
  - **<= +5.0 mOhms ---------- 32 Points ---------- Stable**
  - **+5.1 to +10.0 mOhms ---------- 0 Points ---------- Minor**
  - **+10.1 to +15.0 mOhms ---------- 0 Points ---------- Acceptable**
  - **+15.1 to +50.0 mOhms ---------- 0 Points ---------- Marginal**
  - **+50.1 to +2000 mOhms ---------- 0 Points ---------- Unstable**
  - **>+2000 mOhms ---------- 0 Points ---------- Open Failure**

Group 2---Card 0.056”

Signal Pin

- **Initial ---------- 6.92 mOhms Max**
- **Thermal Aging**
  - **<= +5.0 mOhms ---------- 160 Points ---------- Stable**
  - **+5.1 to +10.0 mOhms ---------- 0 Points ---------- Minor**
  - **+10.1 to +15.0 mOhms ---------- 0 Points ---------- Acceptable**
  - **+15.1 to +50.0 mOhms ---------- 0 Points ---------- Marginal**
  - **+50.1 to +2000 mOhms ---------- 0 Points ---------- Unstable**
  - **>+2000 mOhms ---------- 0 Points ---------- Open Failure**

Ground Pin

- **Initial ---------- 7.05 mOhms Max**
- **Thermal Aging**
  - **<= +5.0 mOhms ---------- 32 Points ---------- Stable**
  - **+5.1 to +10.0 mOhms ---------- 0 Points ---------- Minor**
  - **+10.1 to +15.0 mOhms ---------- 0 Points ---------- Acceptable**
  - **+15.1 to +50.0 mOhms ---------- 0 Points ---------- Marginal**
  - **+50.1 to +2000 mOhms ---------- 0 Points ---------- Unstable**
  - **>+2000 mOhms ---------- 0 Points ---------- Open Failure**

RESULTS Continued

LLCR Durability (160 signal and 32 ground LLCR test points)

Group 1---Card 0.068"

Signal Pin

- **Initial ---------- 6.77 mOhms Max**
- **Durability, 25 Cycles**
  - **<= +5.0 mOhms ---------- 160 Points ---------- Stable**
  - **+5.1 to +10.0 mOhms ---------- 0 Points ---------- Minor**
  - **+10.1 to +15.0 mOhms ---------- 0 Points ---------- Acceptable**
  - **+15.1 to +50.0 mOhms ---------- 0 Points ---------- Marginal**
  - **+50.1 to +2000 mOhms ---------- 0 Points ---------- Unstable**
  - **>+2000 mOhms ---------- 0 Points ---------- Open Failure**
- **Thermal**
  - **<= +5.0 mOhms ---------- 160 Points ---------- Stable**
  - **+5.1 to +10.0 mOhms ---------- 0 Points ---------- Minor**
  - **+10.1 to +15.0 mOhms ---------- 0 Points ---------- Acceptable**
  - **+15.1 to +50.0 mOhms ---------- 0 Points ---------- Marginal**
  - **+50.1 to +2000 mOhms ---------- 0 Points ---------- Unstable**
  - **>+2000 mOhms ---------- 0 Points ---------- Open Failure**
- **Humidity**
  - **<= +5.0 mOhms ---------- 160 Points ---------- Stable**
  - **+5.1 to +10.0 mOhms ---------- 0 Points ---------- Minor**
  - **+10.1 to +15.0 mOhms ---------- 0 Points ---------- Acceptable**
  - **+15.1 to +50.0 mOhms ---------- 0 Points ---------- Marginal**
  - **+50.1 to +2000 mOhms ---------- 0 Points ---------- Unstable**
  - **>+2000 mOhms ---------- 0 Points ---------- Open Failure**

Ground Pin

- **Initial ---------- 7.25 mOhms Max**
- **Durability, 25 Cycles**
  - **<= +5.0 mOhms ---------- 32 Points ---------- Stable**
  - **+5.1 to +10.0 mOhms ---------- 0 Points ---------- Minor**
  - **+10.1 to +15.0 mOhms ---------- 0 Points ---------- Acceptable**
  - **+15.1 to +50.0 mOhms ---------- 0 Points ---------- Marginal**
  - **+50.1 to +2000 mOhms ---------- 0 Points ---------- Unstable**
  - **>+2000 mOhms ---------- 0 Points ---------- Open Failure**
- **Thermal**
  - **<= +5.0 mOhms ---------- 32 Points ---------- Stable**
  - **+5.1 to +10.0 mOhms ---------- 0 Points ---------- Minor**
  - **+10.1 to +15.0 mOhms ---------- 0 Points ---------- Acceptable**
  - **+15.1 to +50.0 mOhms ---------- 0 Points ---------- Marginal**
  - **+50.1 to +2000 mOhms ---------- 0 Points ---------- Unstable**
  - **>+2000 mOhms ---------- 0 Points ---------- Open Failure**
- **Humidity**
  - **<= +5.0 mOhms ---------- 32 Points ---------- Stable**
  - **+5.1 to +10.0 mOhms ---------- 0 Points ---------- Minor**
  - **+10.1 to +15.0 mOhms ---------- 0 Points ---------- Acceptable**
  - **+15.1 to +50.0 mOhms ---------- 0 Points ---------- Marginal**
  - **+50.1 to +2000 mOhms ---------- 0 Points ---------- Unstable**
  - **>+2000 mOhms ---------- 0 Points ---------- Open Failure**

RESULTS Continued

Group 2---Card 0.056”

Signal Pin

- **Initial ---------- 8.08 mOhms Max**
- **Durability, 25 Cycles**
  - **<= +5.0 mOhms ---------- 160 Points ---------- Stable**
  - **+5.1 to +10.0 mOhms ---------- 0 Points ---------- Minor**
  - **+10.1 to +15.0 mOhms ---------- 0 Points ---------- Acceptable**
  - **+15.1 to +50.0 mOhms ---------- 0 Points ---------- Marginal**
  - **+50.1 to +2000 mOhms ---------- 0 Points ---------- Unstable**
  - **>+2000 mOhms ---------- 0 Points ---------- Open Failure**
- **Thermal**
  - **<= +5.0 mOhms ---------- 160 Points ---------- Stable**
  - **+5.1 to +10.0 mOhms ---------- 0 Points ---------- Minor**
  - **+10.1 to +15.0 mOhms ---------- 0 Points ---------- Acceptable**
  - **+15.1 to +50.0 mOhms ---------- 0 Points ---------- Marginal**
  - **+50.1 to +2000 mOhms ---------- 0 Points ---------- Unstable**
  - **>+2000 mOhms ---------- 0 Points ---------- Open Failure**
- **Humidity**
  - **<= +5.0 mOhms ---------- 160 Points ---------- Stable**
  - **+5.1 to +10.0 mOhms ---------- 0 Points ---------- Minor**
  - **+10.1 to +15.0 mOhms ---------- 0 Points ---------- Acceptable**
  - **+15.1 to +50.0 mOhms ---------- 0 Points ---------- Marginal**
  - **+50.1 to +2000 mOhms ---------- 0 Points ---------- Unstable**
  - **>+2000 mOhms ---------- 0 Points ---------- Open Failure**

Ground Pin

- **Initial ---------- 7.55 mOhms Max**
- **Durability, 25 Cycles**
  - **<= +5.0 mOhms ---------- 32 Points ---------- Stable**
  - **+5.1 to +10.0 mOhms ---------- 0 Points ---------- Minor**
  - **+10.1 to +15.0 mOhms ---------- 0 Points ---------- Acceptable**
  - **+15.1 to +50.0 mOhms ---------- 0 Points ---------- Marginal**
  - **+50.1 to +2000 mOhms ---------- 0 Points ---------- Unstable**
  - **>+2000 mOhms ---------- 0 Points ---------- Open Failure**
- **Thermal**
  - **<= +5.0 mOhms ---------- 32 Points ---------- Stable**
  - **+5.1 to +10.0 mOhms ---------- 0 Points ---------- Minor**
  - **+10.1 to +15.0 mOhms ---------- 0 Points ---------- Acceptable**
  - **+15.1 to +50.0 mOhms ---------- 0 Points ---------- Marginal**
  - **+50.1 to +2000 mOhms ---------- 0 Points ---------- Unstable**
  - **>+2000 mOhms ---------- 0 Points ---------- Open Failure**
- **Humidity**
  - **<= +5.0 mOhms ---------- 32 Points ---------- Stable**
  - **+5.1 to +10.0 mOhms ---------- 0 Points ---------- Minor**
  - **+10.1 to +15.0 mOhms ---------- 0 Points ---------- Acceptable**
  - **+15.1 to +50.0 mOhms ---------- 0 Points ---------- Marginal**
  - **+50.1 to +2000 mOhms ---------- 0 Points ---------- Unstable**
  - **>+2000 mOhms ---------- 0 Points ---------- Open Failure**

RESULTS Continued

LLCR Shock & Vibration (160 signal and 32 ground LLCR test points)

Group 1---Card 0.056"

Signal Pin

- **Initial ---------- 7.87 mOhms Max**
- **Shock &Vibration**
  - **<= +5.0 mOhms ---------- 160 Points ---------- Stable**
  - **+5.1 to +10.0 mOhms ---------- 0 Points ---------- Minor**
  - **+10.1 to +15.0 mOhms ---------- 0 Points ---------- Acceptable**
  - **+15.1 to +50.0 mOhms ---------- 0 Points ---------- Marginal**
  - **+50.1 to +2000 mOhms ---------- 0 Points ---------- Unstable**
  - **>+2000 mOhms ---------- 0 Points ---------- Open Failure**

Ground Pin

- **Initial ---------- 9.28 mOhms Max**
- **Shock &Vibration**
  - **<= +5.0 mOhms ---------- 32 Points ---------- Stable**
  - **+5.1 to +10.0 mOhms ---------- 0 Points ---------- Minor**
  - **+10.1 to +15.0 mOhms ---------- 0 Points ---------- Acceptable**
  - **+15.1 to +50.0 mOhms ---------- 0 Points ---------- Marginal**
  - **+50.1 to +2000 mOhms ---------- 0 Points ---------- Unstable**
  - **>+2000 mOhms ---------- 0 Points ---------- Open Failure**

Mechanical Shock & Random Vibration:

- **Shock**
  - **No Damage ---------- ---------- Pass**
  - **50 Nanoseconds ---------- ---------- Pass**
- **Vibration**
  - **No Damage ---------- ---------- Pass**
  - **50 Nanoseconds ---------- ---------- Pass**

Group 2---Card 0.068"

Signal Pin

- **Initial ---------- 7.83 mOhms Max**
- **Shock &Vibration**
  - **<= +5.0 mOhms ---------- 160 Points ---------- Stable**
  - **+5.1 to +10.0 mOhms ---------- 0 Points ---------- Minor**
  - **+10.1 to +15.0 mOhms ---------- 0 Points ---------- Acceptable**
  - **+15.1 to +50.0 mOhms ---------- 0 Points ---------- Marginal**
  - **+50.1 to +2000 mOhms ---------- 0 Points ---------- Unstable**
  - **>+2000 mOhms ---------- 0 Points ---------- Open Failure**

Ground Pin

- **Initial ---------- 7.51 mOhms Max**
- **Shock &Vibration**
  - **<= +5.0 mOhms ---------- 32 Points ---------- Stable**
  - **+5.1 to +10.0 mOhms ---------- 0 Points ---------- Minor**
  - **+10.1 to +15.0 mOhms ---------- 0 Points ---------- Acceptable**
  - **+15.1 to +50.0 mOhms ---------- 0 Points ---------- Marginal**
  - **+50.1 to +2000 mOhms ---------- 0 Points ---------- Unstable**
  - **>+2000 mOhms ---------- 0 Points ---------- Open Failure**

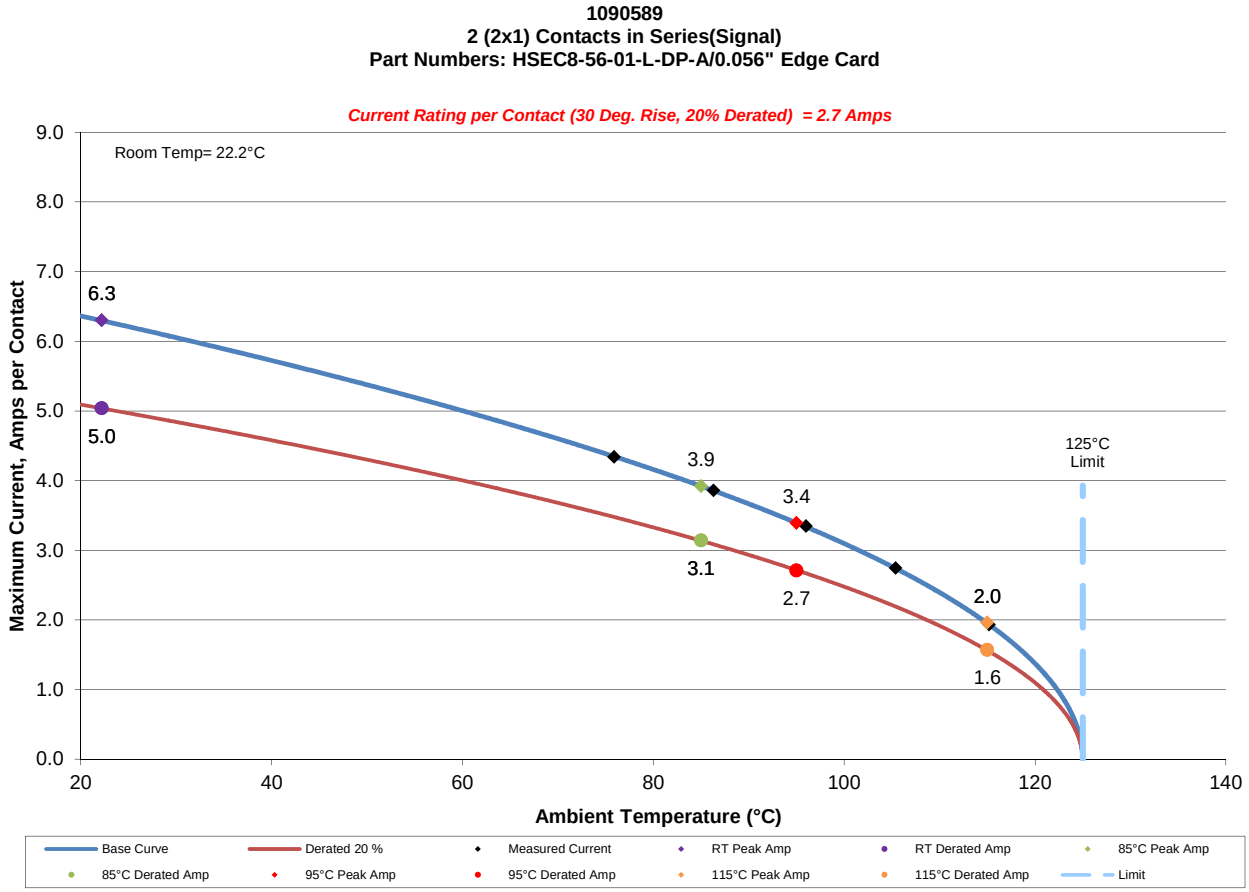
DATA SUMMARIES

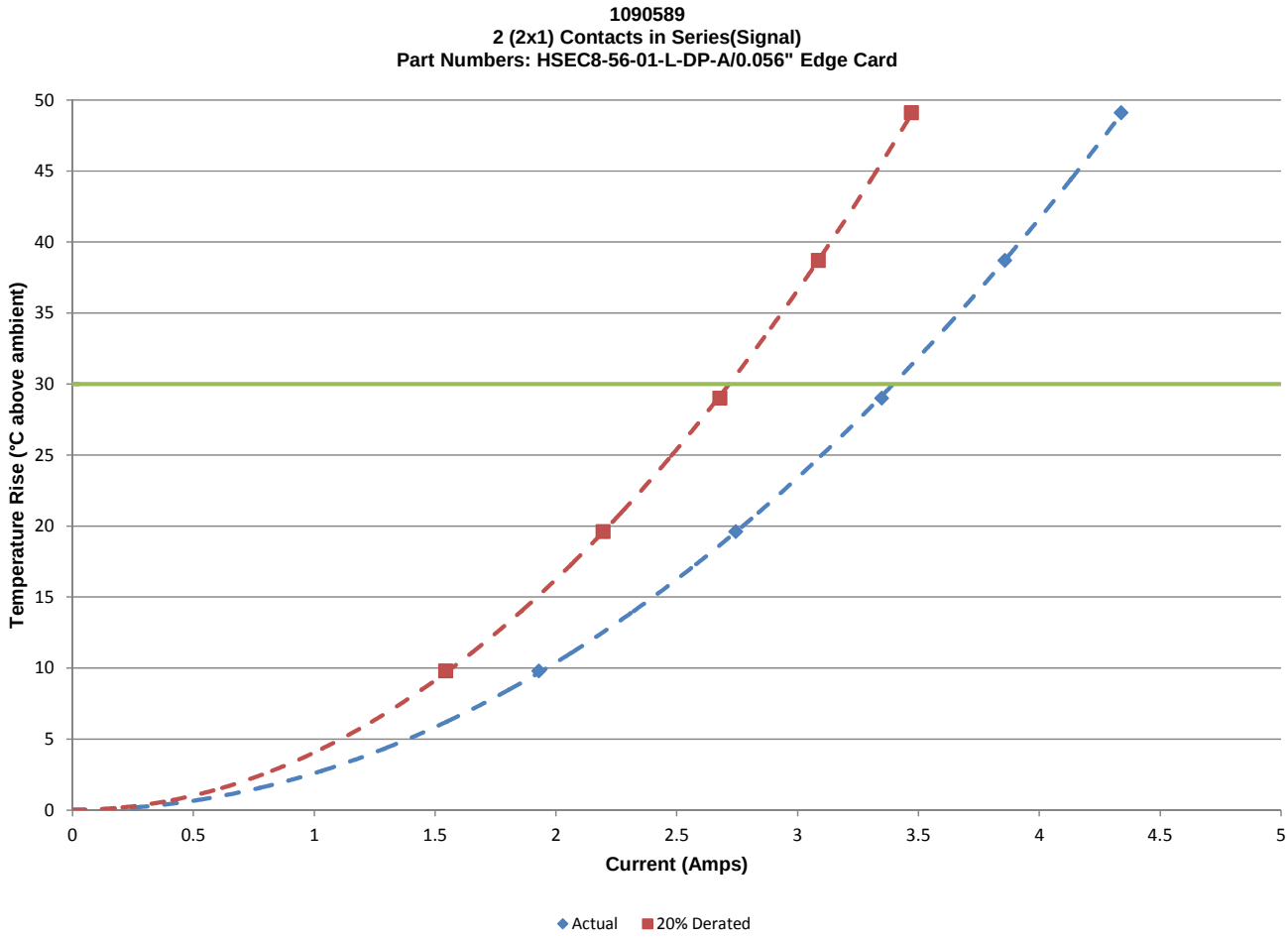
TEMPERATURE RISE (Current Carrying Capacity, CCC):

1) High quality thermocouples whose temperature slopes track one another were used for temperature monitoring.
2) The thermocouples were placed at a location to sense the maximum temperature generated during testing.
3) Temperature readings recorded are those for which three successive readings, 15 minutes apart, differ less than 1° C (computer controlled data acquisition).
4) Adjacent contacts were powered:

Signal pin

a. Linear configuration with 2 adjacent conductors/contacts powered

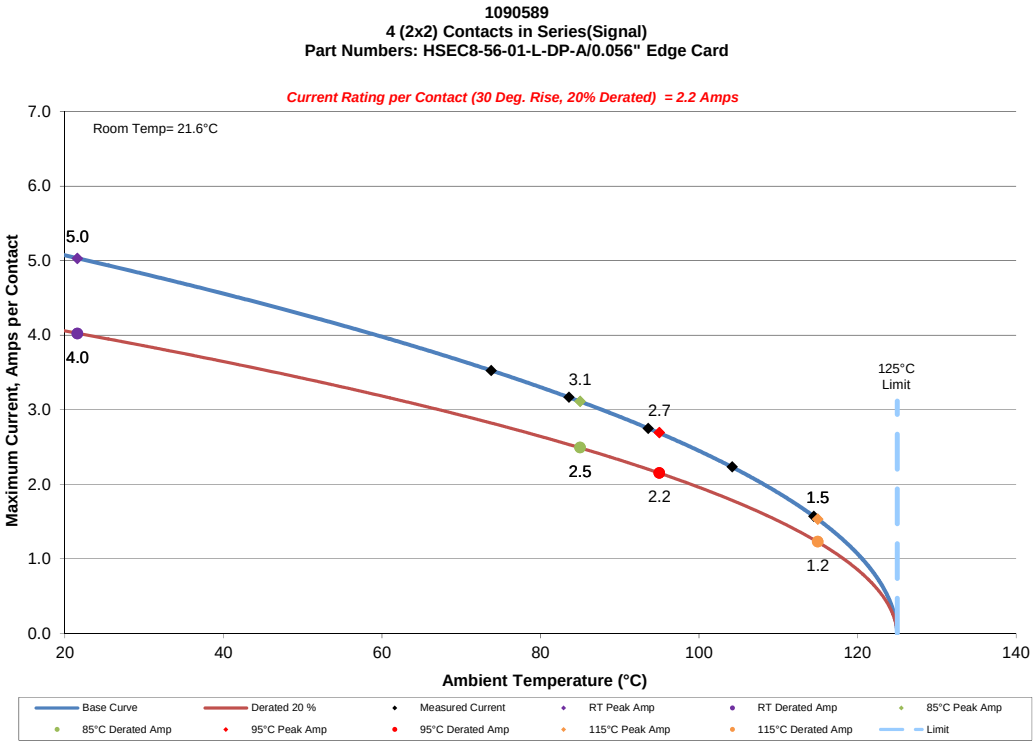


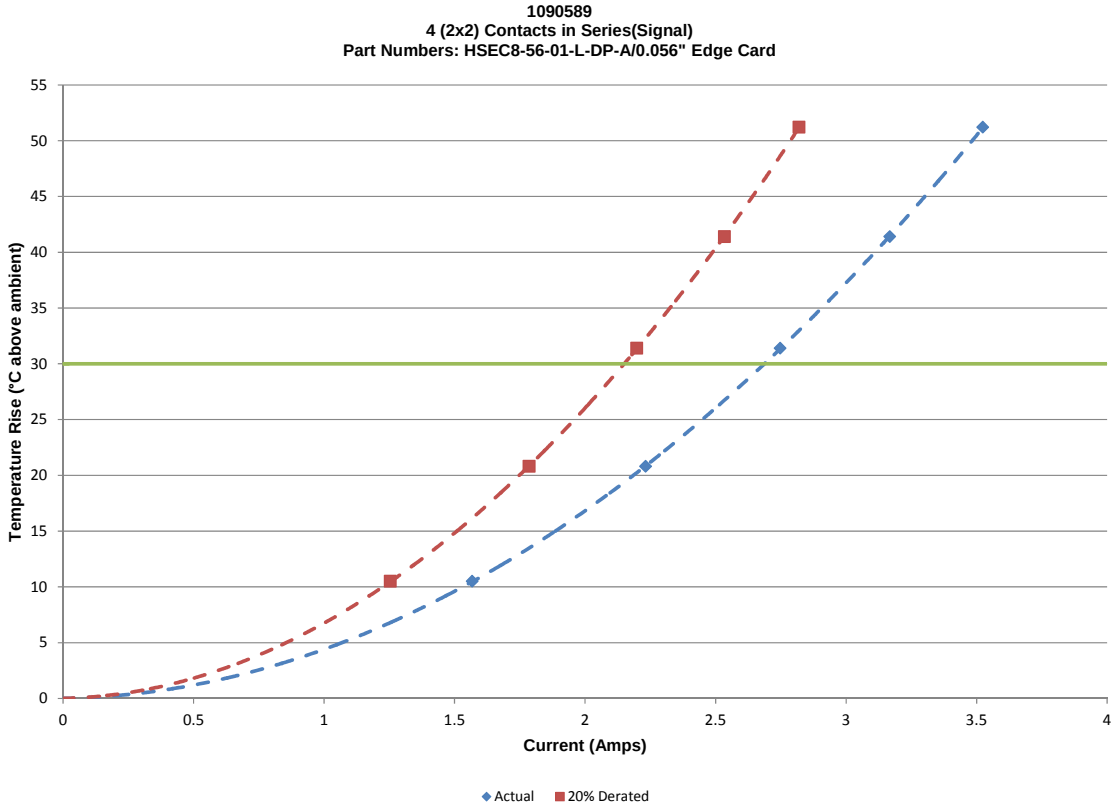

1090589
2 (2x1) Contacts in Series(Signal)
Part Numbers: HSEC8-56-01-L-DP-A/0.056" Edge Card
Temperature Rise (°C above ambient)
Current (Amps)
0
5
10
15
20
25
30
35
40
45
50
0
0.5
1
1.5
2
2.5
3
3.5
4
4.5
5
Actual
20% Derated

DATA SUMMARIES Continued

Signal pin

b. Linear configuration with 4 adjacent conductors/contacts powered

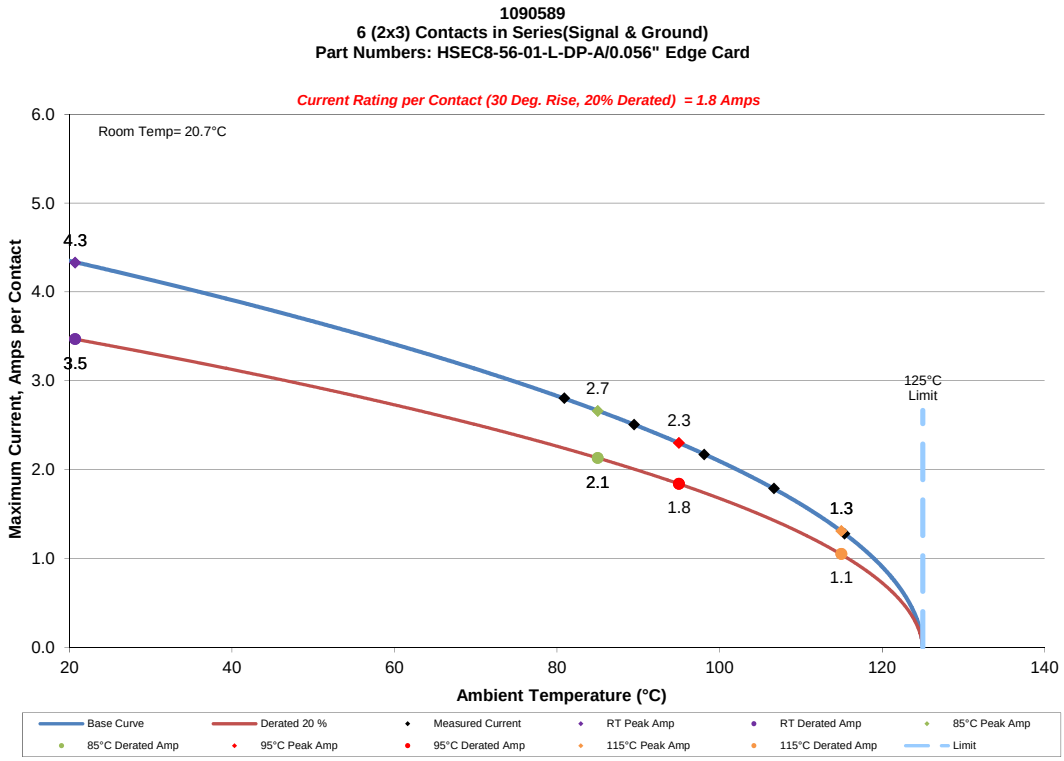


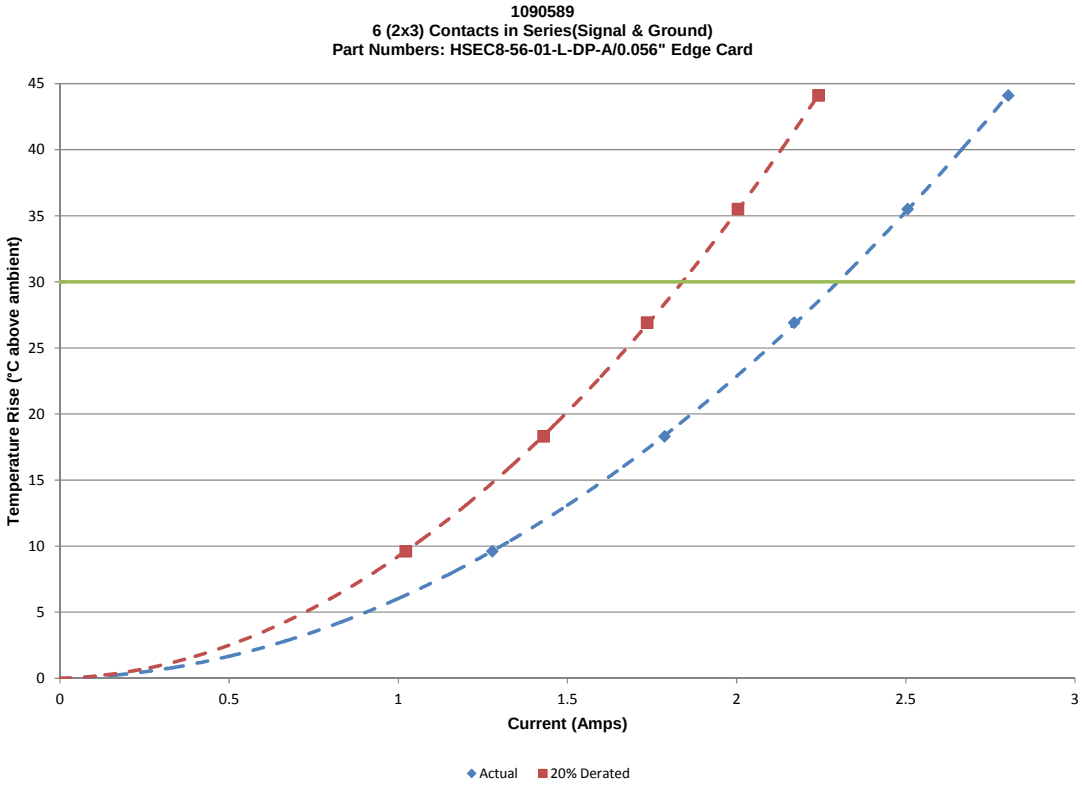


DATA SUMMARIES Continued

Signal & Ground pin

c. Linear configuration with 6 adjacent conductors/contacts powered

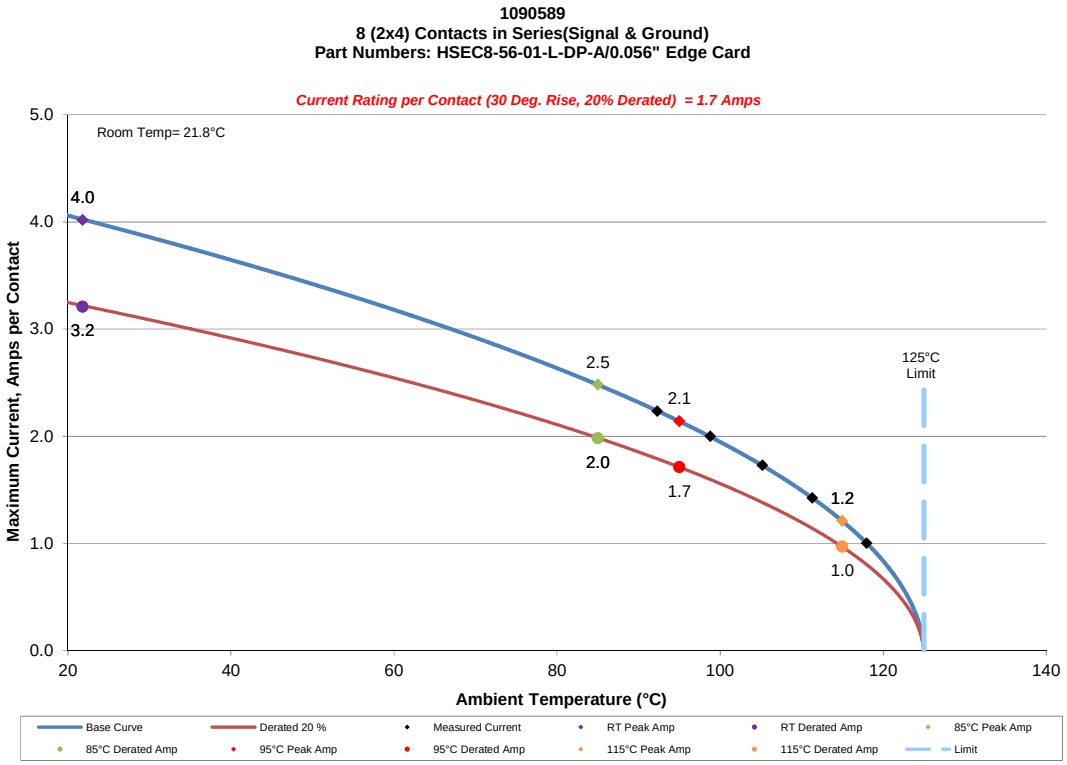


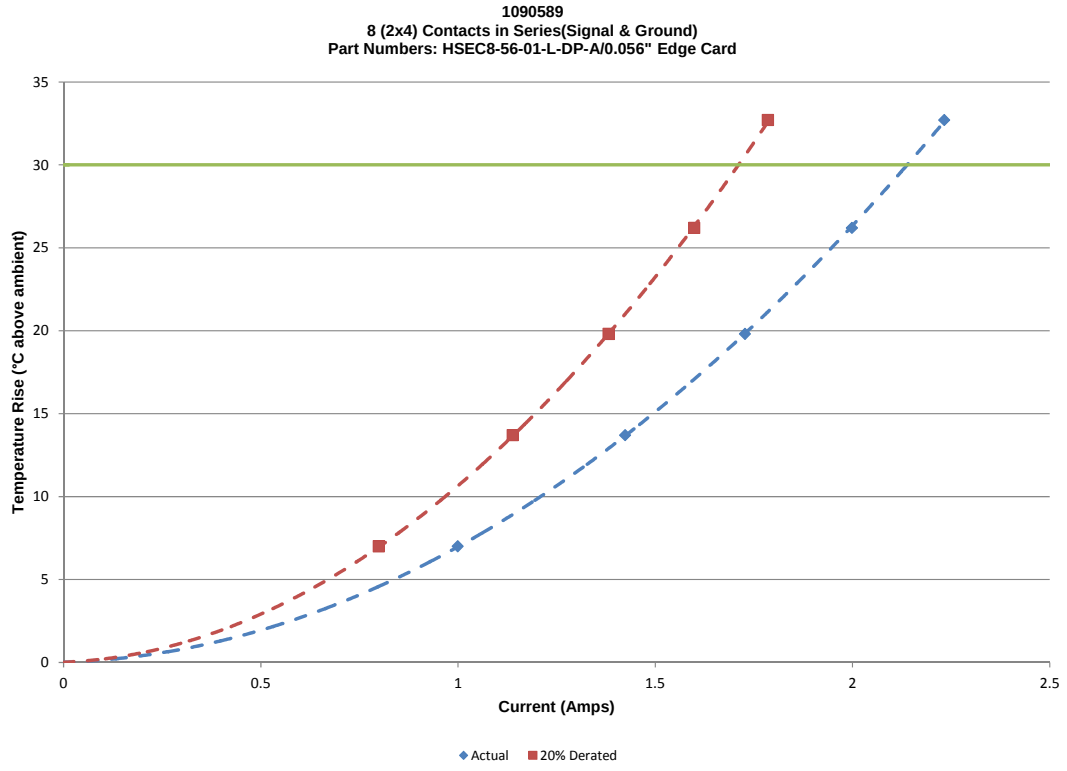


DATA SUMMARIES Continued

Signal & Ground pin

d. Linear configuration with 8 adjacent conductors/contacts powered

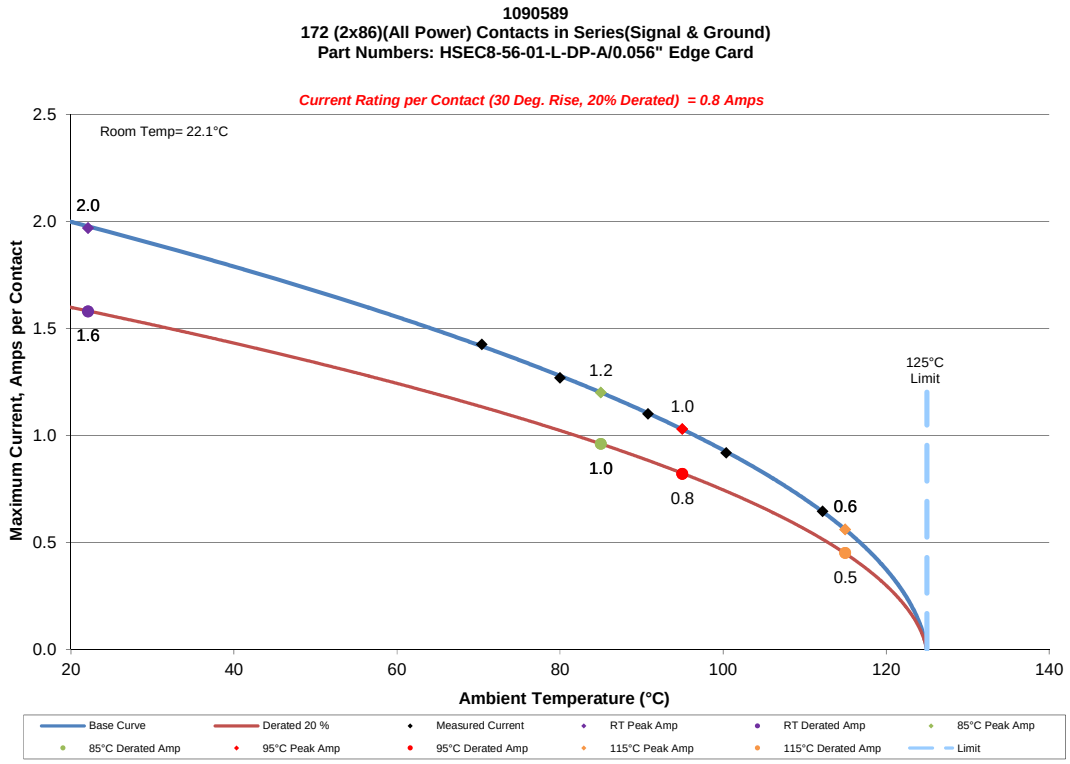


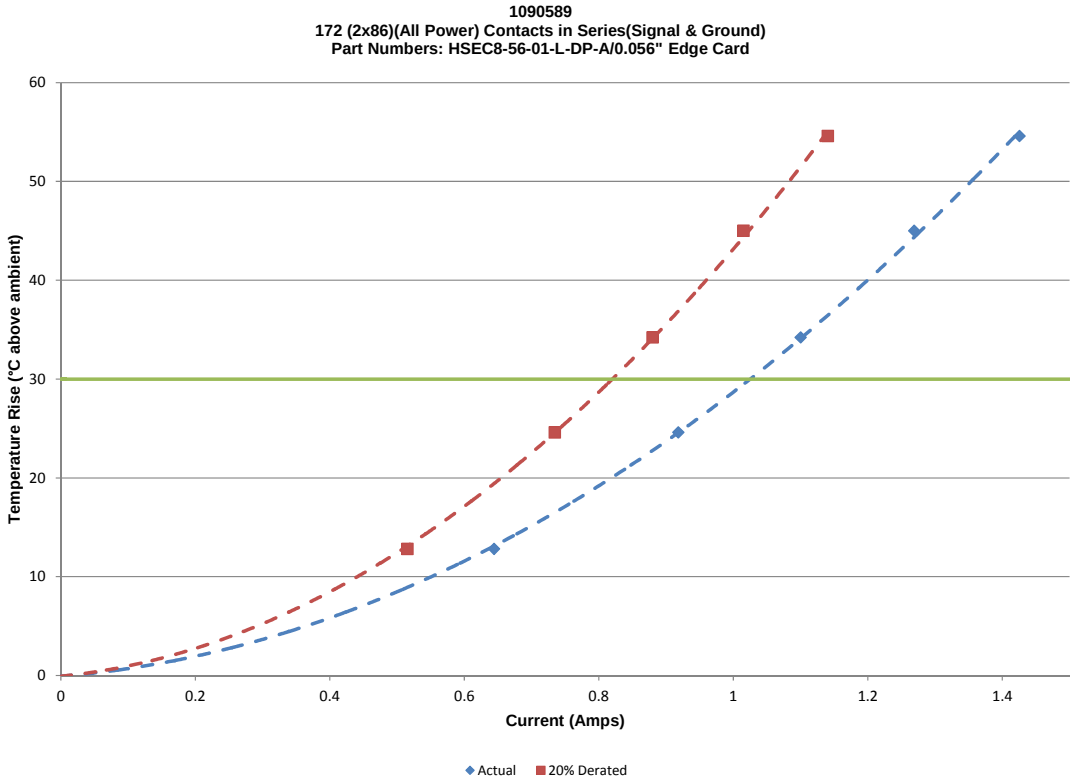


DATA SUMMARIES Continued

Signal & Ground pin

e. Linear configuration with all adjacent conductors/contacts powered

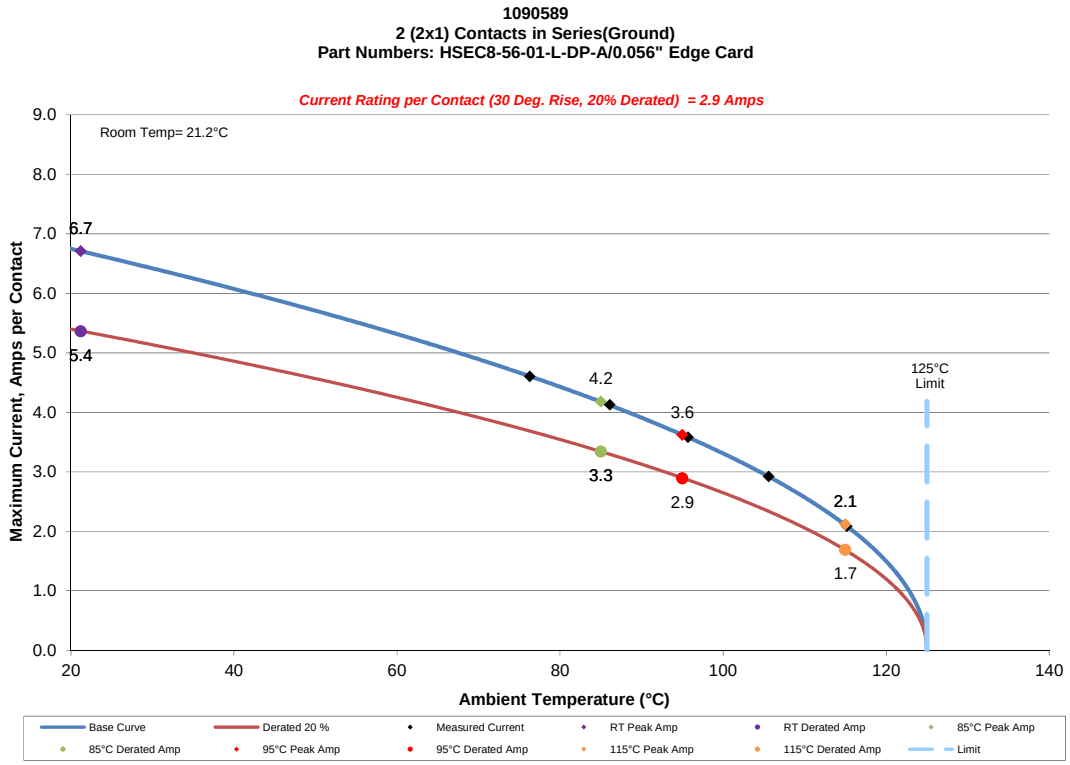


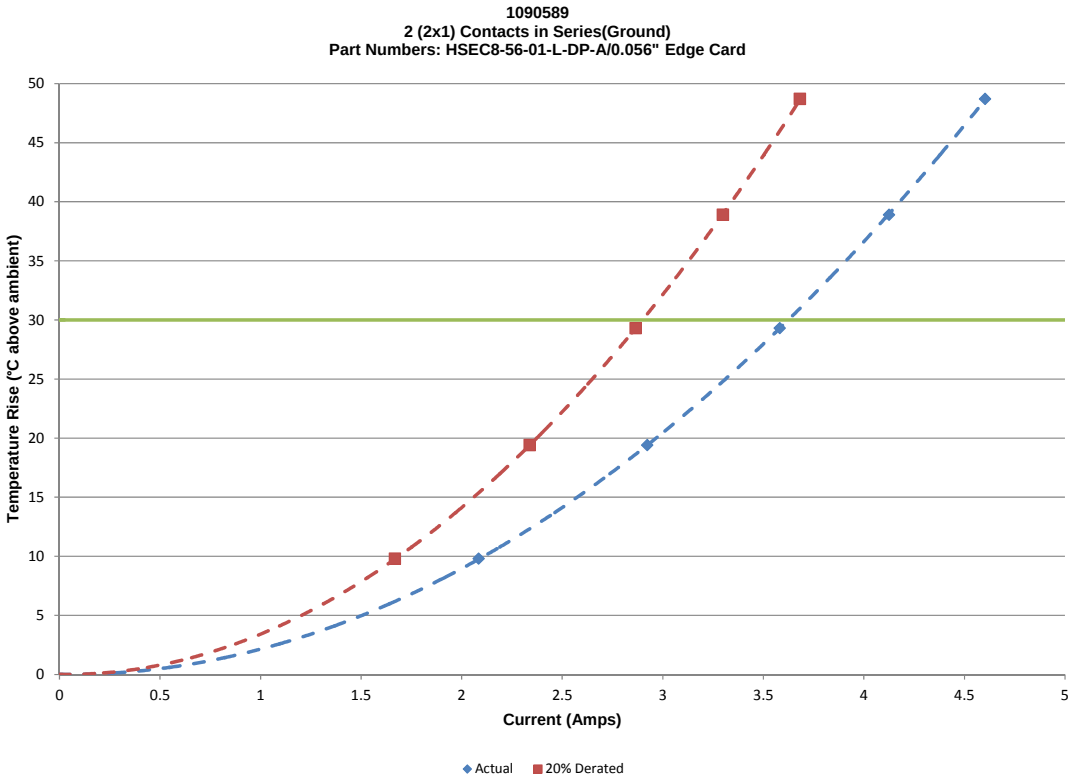


DATA SUMMARIES Continued

Ground Pin

f. Linear configuration with 2 adjacent conductors/contacts powered





DATA SUMMARIES Continued

MATING/UNMATING:

Thermal Aging Group—Card 0.068”

	Initial				After Thermals			
	Mating		**Unmating**		**Mating**		**Unmating**	
	Newtons	Force (Lbs)	Newtons	Force (Lbs)	Newtons	Force (Lbs)	Newtons	Force (Lbs)
Minimum	19.52	4.39	11.80	2.65	14.19	3.19	9.65	2.17
Maximum	23.45	5.27	15.81	3.55	17.08	3.84	11.07	2.49
Average	21.59	**4.85**	12.98	**2.92**	16.23	**3.65**	10.44	**2.35**
St Dev	1.50	0.34	1.34	0.30	0.93	0.21	0.53	0.12
Count	8	8	8	8	8	8	8	8

Thermal Aging Group--- Card 0.056”

	Initial				After Thermals			
	Mating		**Unmating**		**Mating**		**Unmating**	
	Newtons	Force (Lbs)	Newtons	Force (Lbs)	Newtons	Force (Lbs)	Newtons	Force (Lbs)
Minimum	14.53	3.27	9.71	2.18	10.04	2.26	7.09	1.60
Maximum	18.50	4.16	14.15	3.18	13.56	3.05	9.38	2.11
Average	16.39	**3.69**	11.20	**2.52**	11.81	**2.66**	8.35	**1.88**
St Dev	1.33	0.30	1.31	0.29	1.18	0.27	0.72	0.16
Count	8	8	8	8	8	8	8	8

DATA SUMMARIES Continued

MATING/UNMATING:

Mating/Unmating Durability Group—Card 0.068”

HSEC8-20-01-L-DP-A-K/EDGE CARD

	Initial				After 25 Cycles			
	Mating		**Unmating**		**Mating**		**Unmating**	
	Newtons	Force (Lbs)	Newtons	Force (Lbs)	Newtons	Force (Lbs)	Newtons	Force (Lbs)
Minimum	16.40	3.69	10.27	2.31	19.70	4.43	13.55	3.05
Maximum	20.24	4.55	15.74	3.54	26.91	6.05	20.37	4.58
Average	18.07	**4.06**	11.83	**2.66**	22.47	**5.05**	15.85	**3.56**
St Dev	1.28	0.29	1.67	0.37	2.51	0.57	1.96	0.44
Count	8	8	8	8	8	8	8	8

	After Humidity			
	Mating		**Unmating**	
	Newtons	Force (Lbs)	Newtons	Force (Lbs)
Minimum	10.73	2.41	8.87	1.99
Maximum	15.77	3.55	12.46	2.80
Average	12.83	**2.88**	10.49	**2.36**
St Dev	1.79	0.40	1.28	0.29
Count	8	8	8	8

Mating/Unmating Durability Group—Card 0.056”

HSEC8-20-01-L-DP-A-K/EDGE CARD

	Initial				After 25 Cycles			
	Mating		**Unmating**		**Mating**		**Unmating**	
	Newtons	Force (Lbs)	Newtons	Force (Lbs)	Newtons	Force (Lbs)	Newtons	Force (Lbs)
Minimum	12.87	2.89	8.66	1.95	13.45	3.02	10.72	2.41
Maximum	17.79	4.00	13.46	3.03	21.86	4.92	14.19	3.19
Average	15.29	**3.44**	10.76	**2.42**	18.46	**4.15**	12.44	**2.80**
St Dev	1.86	0.42	1.54	0.35	2.69	0.60	1.24	0.28
Count	8	8	8	8	8	8	8	8

	After Humidity			
	Mating		**Unmating**	
	Newtons	Force (Lbs)	Newtons	Force (Lbs)
Minimum	9.64	2.17	7.80	1.75
Maximum	11.57	2.60	10.05	2.26
Average	10.54	**2.37**	8.79	**1.98**
St Dev	0.62	0.14	0.75	0.17
Count	8	8	8	8

DATA SUMMARIES Continued

Mating/Unmating Basic—Card 0.068"
HSEC8-56-01-L-DP-A-K/EDGE CARD

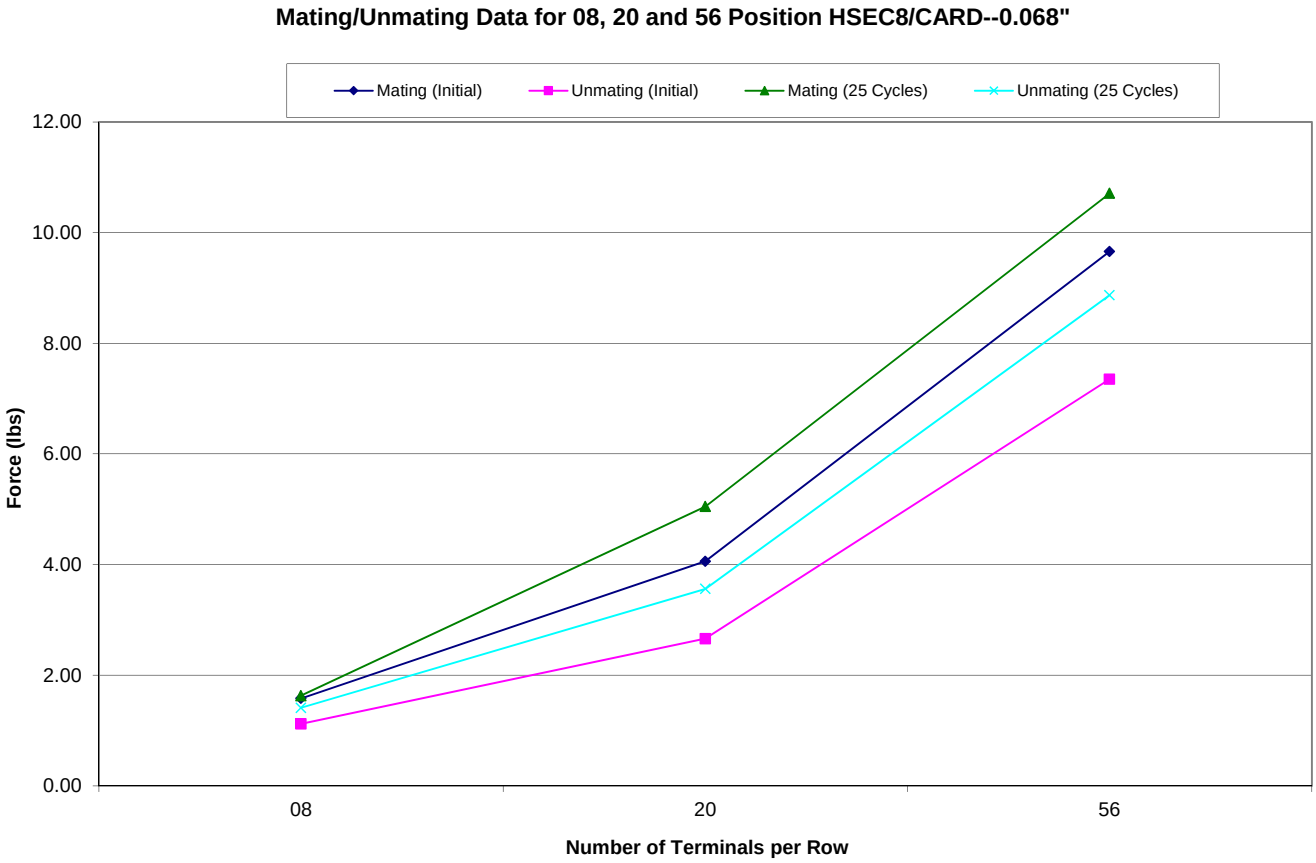
	Initial				After 25 Cycles			
	Mating		**Unmating**		**Mating**		**Unmating**	
	Newtons	Force (Lbs)	Newtons	Force (Lbs)	Newtons	Force (Lbs)	Newtons	Force (Lbs)
Minimum	39.56	8.89	29.92	6.73	39.67	8.92	36.86	8.29
Maximum	47.40	10.66	39.48	8.88	57.10	12.84	41.64	9.36
Average	42.95	**9.66**	32.70	**7.35**	47.63	**10.71**	39.46	**8.87**
St Dev	2.59	0.58	3.07	0.69	6.33	1.42	1.89	0.42
Count	8	8	8	8	8	8	8	8

Mating/Unmating Basic—Card 0.068"
HSEC8-08-01-L-DP-A-K/EDGE CARD

	Initial				After 25 Cycles			
	Mating		**Unmating**		**Mating**		**Unmating**	
	Newtons	Force (Lbs)	Newtons	Force (Lbs)	Newtons	Force (Lbs)	Newtons	Force (Lbs)
Minimum	6.38	1.43	4.78	1.07	5.62	1.26	5.53	1.24
Maximum	7.54	1.70	5.45	1.23	8.42	1.89	6.97	1.57
Average	7.01	**1.58**	5.00	**1.12**	7.24	**1.63**	6.26	**1.41**
St Dev	0.34	0.08	0.21	0.05	1.07	0.24	0.60	0.14
Count	8	8	8	8	8	8	8	8

DATA SUMMARIES Continued

Mating\Unmating Force Comparison



DATA SUMMARIES Continued

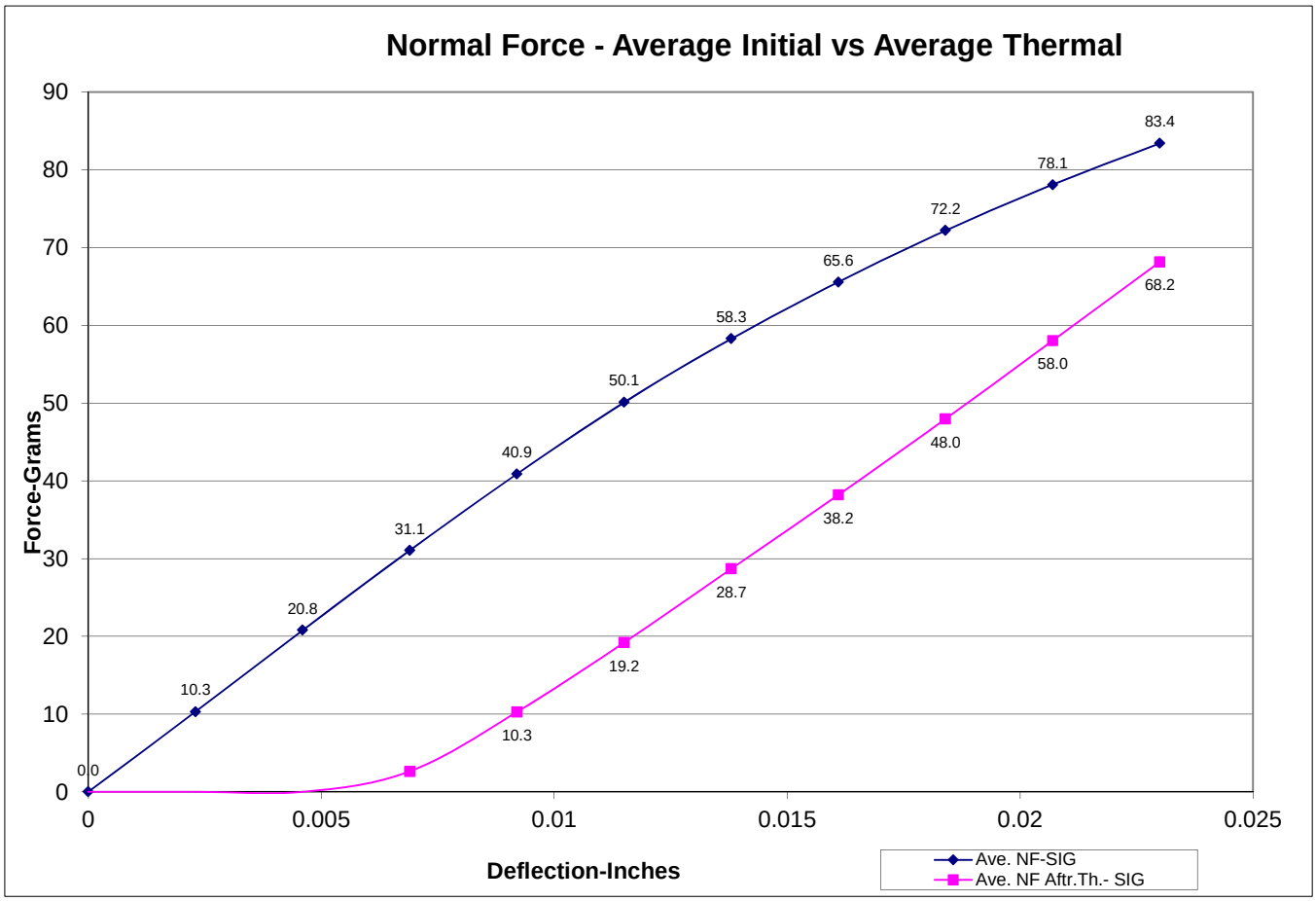
NORMAL FORCE (FOR CONTACTS TESTED IN THE HOUSING):

1) Calibrated force gauges are used along with computer controlled positioning equipment.
2) For Normal force 8-10 measurements are taken and the averages reported.

Signal Pin

Initial	Deflections in inches Forces in Grams										
	0.0023	0.0046	0.0069	0.0092	0.0115	0.0138	0.0161	0.0184	0.0207	0.0230	*SET*
Averages	**10.28**	**20.79**	**31.05**	**40.88**	**50.10**	**58.28**	**65.55**	**72.22**	**78.08**	**83.42**	**0.0044**
Min	8.00	17.50	27.60	36.70	46.10	54.60	61.90	68.40	74.70	80.70	0.0037
Max	11.40	22.30	32.80	42.60	52.00	59.90	67.40	74.70	80.70	86.50	0.0049
St. Dev	0.923	1.446	1.721	1.971	1.860	1.721	1.739	1.938	1.887	1.999	0.0004
Count	12	12	12	12	12	12	12	12	12	12	12

After Thermal	Deflections in inches Forces in Grams										
	0.0023	0.0046	0.0069	0.0092	0.0115	0.0138	0.0161	0.0184	0.0207	0.0230	*SET*
Averages	**0.00**	**0.00**	**2.62**	**10.27**	**19.19**	**28.68**	**38.19**	**47.96**	**58.04**	**68.16**	**0.0063**
Min	0.00	0.00	0.00	7.20	14.00	23.30	32.30	41.50	51.60	61.30	0.0054
Max	0.00	0.00	7.00	14.60	23.20	32.60	42.20	52.70	62.90	72.70	0.0070
St. Dev	0.000	0.000	2.098	2.172	2.736	2.894	3.016	3.305	3.434	3.544	0.0005
Count	12	12	12	12	12	12	12	12	12	12	12

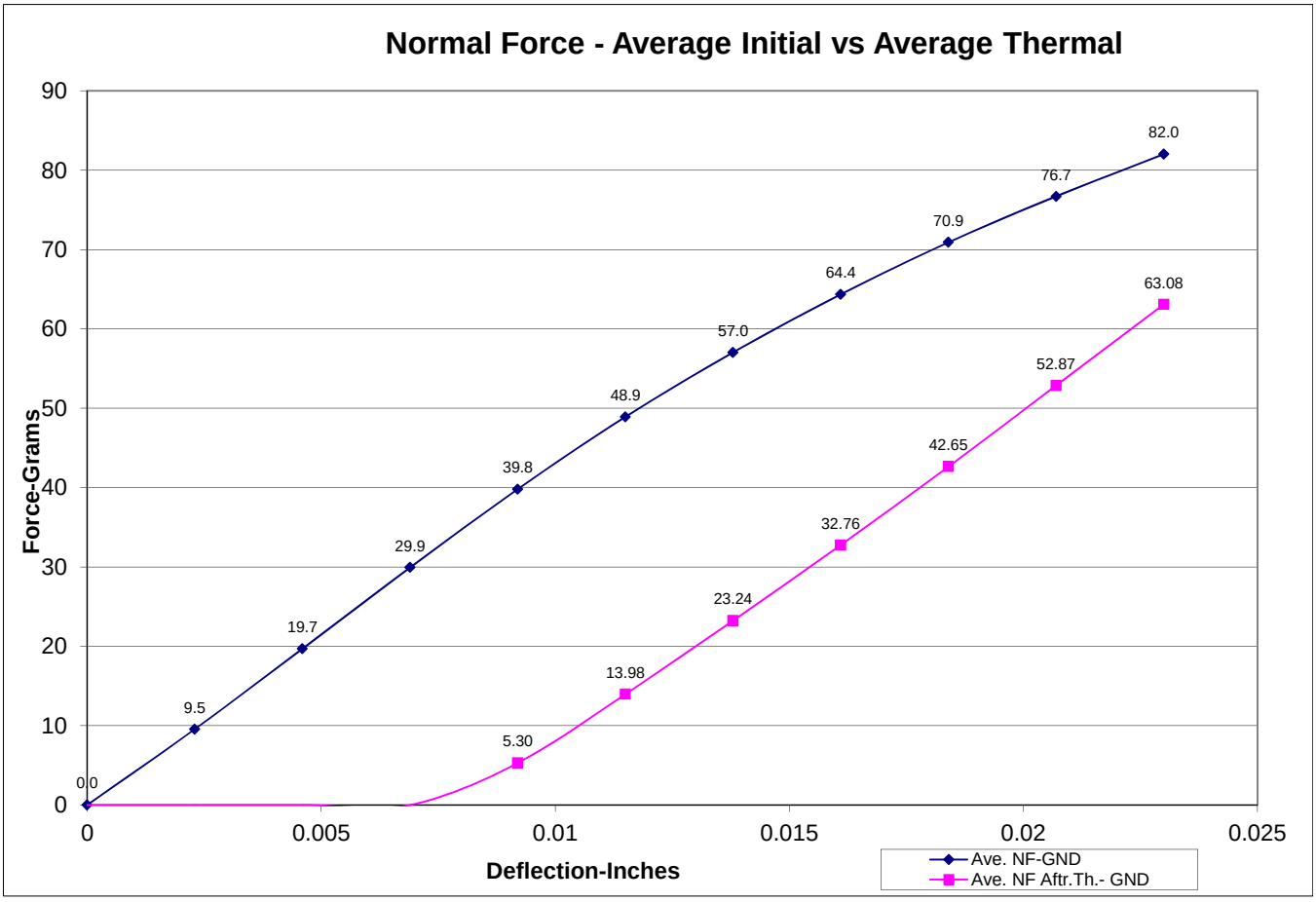


DATA SUMMARIES Continued

Ground Pin

Initial	Deflections in inches Forces in Grams										
	0.0023	0.0046	0.0069	0.0092	0.0115	0.0138	0.0161	0.0184	0.0207	0.0230	*SET*
Averages	**9.54**	**19.70**	**29.94**	**39.80**	**48.92**	**57.04**	**64.35**	**70.92**	**76.70**	**82.03**	**0.0045**
Min	6.50	13.70	22.60	31.90	40.90	48.80	55.80	63.30	69.60	75.80	0.0038
Max	10.60	21.30	31.90	41.80	51.00	59.40	66.70	73.10	79.20	84.30	0.0048
St. Dev	1.360	2.237	2.690	2.910	2.923	2.969	3.061	2.745	2.608	2.341	0.0003
Count	11	11	11	11	11	11	11	11	11	11	11

After Thermal	Deflections in inches Forces in Grams										
	0.0023	0.0046	0.0069	0.0092	0.0115	0.0138	0.0161	0.0184	0.0207	0.0230	*SET*
Averages	**0.00**	**0.00**	**0.00**	**5.30**	**13.98**	**23.24**	**32.76**	**42.65**	**52.87**	**63.08**	**0.0078**
Min	0.00	0.00	0.00	2.60	10.90	19.30	25.80	33.20	42.40	52.10	0.0074
Max	0.00	0.00	0.00	7.50	16.80	26.10	35.80	45.90	57.20	66.10	0.0085
St. Dev	0.000	0.000	0.000	1.334	1.619	2.029	2.734	3.384	3.746	3.758	0.0004
Count	12	12	12	12	12	12	12	12	12	12	12



DATA SUMMARIES Continued

INSULATION RESISTANCE (IR):

	Pin to Pin		
	Mated	Unmated	Unmated
Minimum	**HSEC8-DP/.056" Edge Card**	**HSEC8-DP**	**.056" Edge Card**
Initial	45000	45000	Not Tested
Thermal	45000	45000	Not Tested
Humidity	45000	34000	Not Tested

	Row to Row		
	Mated	Unmated	Unmated
Minimum	**HSEC8-DP/.056" Edge Card**	**HSEC8-DP**	**.056" Edge Card**
Initial	45000	45000	Not Tested
Thermal	45000	45000	Not Tested
Humidity	45000	45000	Not Tested

	Pin to Ground		
	Mated	Unmated	Unmated
Minimum	**HSEC8-DP/.056" Edge Card**	**HSEC8-DP**	**.056" Edge Card**
Initial	45000	45000	Not Tested
Thermal	45000	45000	Not Tested
Humidity	45000	45000	Not Tested

DIELECTRIC WITHSTANDING VOLTAGE (DWV):

Voltage Rating Summary	
Minimum	**HSEC8-DP/.056" Edge Card**
Break Down Voltage	954
Test Voltage	720
Working Voltage	235

Pin to Pin	
Initial Test Voltage	Passed
After Thermal Test Voltage	Passed
After Humidity Test Voltage	Passed

Row to Row	
Initial Test Voltage	Passed
After Thermal Test Voltage	Passed
After Humidity Test Voltage	Passed

Pin to Ground	
Initial Test Voltage	Passed
After Thermal Test Voltage	Passed
After Humidity Test Voltage	Passed

DATA SUMMARIES Continued

LLCR Durability:

1) A total of 192 points were measured.
2) EIA-364-23, *Low Level Contact Resistance Test Procedure for Electrical Connectors and Sockets.*
3) A computer program, *LLCR 221.exe*, ensures repeatability for data acquisition.
4) The following guidelines are used to categorize the changes in LLCR as a result from stressing.
   a. <= +5.0 mOhms: ---------- Stable
   b. +5.1 to +10.0 mOhms: ---------- Minor
   c. +10.1 to +15.0 mOhms: ---------- Acceptable
   d. +15.1 to +50.0 mOhms: ---------- Marginal
   e. +50.1 to +2000 mOhms ---------- Unstable
   f. >+2000 mOhms: ---------- Open Failure

HSEC8-20-01-L-DP-A-K/EDGE CARD----0.068"

	LLCR Measurement Summaries by Pin Type			
Date	3/16/2017	3/22/2017	4/3/2017	4/13/2017
Room Temp (Deg C)	22	23	22	22
Rel Humidity (%)	32	33	36	35
Technician	Troy Cook	Troy Cook	Troy Cook	Troy Cook
mOhm values	**Actual Initial**	**Delta 25 Cycles**	**Delta Therm Shck**	**Delta Humidity**
	Pin Type 1: Signal			
Average	5.92	0.39	0.37	0.40
St. Dev.	0.33	0.28	0.30	0.31
Min	5.18	0.00	0.00	0.00
Max	6.77	1.28	1.32	1.38
Summary Count	160	160	160	160
Total Count	160	160	160	160
	Pin Type 2: Ground			
Average	5.96	0.48	0.44	0.41
St. Dev.	0.56	0.36	0.31	0.34
Min	5.06	0.02	0.04	0.00
Max	7.25	1.50	1.08	1.19
Summary Count	32	32	32	32
Total Count	32	32	32	32

LLCR Delta Count by Category						
	Stable	**Minor**	**Acceptable**	**Marginal**	**Unstable**	**Open**
mOhms	**<=5**	**>5 & <=10**	**>10 & <=15**	**>15 & <=50**	**>50 & <=1000**	**>1000**
25 Cycles	**192**	**0**	**0**	**0**	**0**	**0**
Therm Shck	**192**	**0**	**0**	**0**	**0**	**0**
Humidity	**192**	**0**	**0**	**0**	**0**	**0**

DATA SUMMARIES Continued

HSEC8-20-01-L-DP-A-K/EDGE CARD----0.056”

	LLCR Measurement Summaries by Pin Type			
Date	3/16/2017	3/22/2017	4/3/2017	4/13/2017
Room Temp (Deg C)	23	23	22	22
Rel Humidity (%)	32	33	36	36
Technician	Troy Cook	Troy Cook	Troy Cook	Troy Cook
mOhm values	**Actual Initial**	**Delta 25 Cycles**	**Delta Therm Shck**	**Delta Humidity**
	Pin Type 1: Signal			
Average	6.11	0.41	0.60	0.55
St. Dev.	0.45	0.34	0.41	0.39
Min	5.38	0.00	0.03	0.00
Max	8.08	1.97	2.57	2.52
Summary Count	160	160	160	160
Total Count	160	160	160	160
	Pin Type 2: Ground			
Average	6.41	0.35	0.62	0.58
St. Dev.	0.43	0.36	0.39	0.35
Min	5.47	0.00	0.00	0.03
Max	7.55	1.56	1.50	1.40
Summary Count	32	32	32	32
Total Count	32	32	32	32

LLCR Delta Count by Category						
	Stable	**Minor**	**Acceptable**	**Marginal**	**Unstable**	**Open**
mOhms	**<=5**	**>5 & <=10**	**>10 & <=15**	**>15 & <=50**	**>50 & <=1000**	**>1000**
25 Cycles	**192**	**0**	**0**	**0**	**0**	**0**
Therm Shck	**192**	**0**	**0**	**0**	**0**	**0**
Humidity	**192**	**0**	**0**	**0**	**0**	**0**

DATA SUMMARIES Continued

LLCR Thermal Aging:

1) A total of 192 points were measured.
2) EIA-364-23, *Low Level Contact Resistance Test Procedure for Electrical Connectors and Sockets.*
3) A computer program, *LLCR 221.exe*, ensures repeatability for data acquisition.
4) The following guidelines are used to categorize the changes in LLCR as a result from stressing.
   a. <= +5.0 mOhms: ---------- Stable
   b. +5.1 to +10.0 mOhms:---------- Minor
   c. +10.1 to +15.0 mOhms: ---------- Acceptable
   d. +15.1 to +50.0 mOhms: ---------- Marginal
   e. +50.1 to +2000 mOhms: ---------- Unstable
   f. >+2000 mOhms:---------- Open Failure

HSEC8-20-01-L-DP-A-K/EDGE CARD----0.068"

	LLCR Measurement Summaries by Pin Type			
Date	3/17/2017	3/28/2017		
Room Temp (Deg C)	23	22		
Rel Humidity (%)	35	42		
Technician	Troy Cook	Troy Cook		
mOhm values	**Actual Initial**	**Delta Thermal**	**Delta**	**Delta**
	Pin Type 1: Signal			
Average	6.03	0.31		
St. Dev.	0.31	0.22		
Min	5.39	0.00		
Max	7.15	1.03		
Summary Count	160	160		
Total Count	160	160		
	Pin Type 2: Ground			
Average	5.89	0.26		
St. Dev.	0.39	0.21		
Min	5.36	0.00		
Max	7.23	0.73		
Summary Count	32	32		
Total Count	32	32		

LLCR Delta Count by Category						
	Stable	**Minor**	**Acceptable**	**Marginal**	**Unstable**	**Open**
mOhms	**<=5**	**>5 & <=10**	**>10 & <=15**	**>15 & <=50**	**>50 & <=1000**	**>1000**
Thermal	**192**	**0**	**0**	**0**	**0**	**0**

DATA SUMMARIES Continued

HSEC8-20-01-L-DP-A-K/EDGE CARD----0.056”

	LLCR Measurement Summaries by Pin Type			
Date	3/17/2017	3/28/2017		
Room Temp (Deg C)	23	22		
Rel Humidity (%)	35	43		
Technician	Troy Cook	Troy Cook		
mOhm values	**Actual Initial**	**Delta Thermal**	**Delta**	**Delta**
	Pin Type 1: Signal			
Average	6.06	0.34		
St. Dev.	0.32	0.23		
Min	5.44	0.00		
Max	6.92	0.96		
Summary Count	160	160		
Total Count	160	160		
	Pin Type 2: Ground			
Average	6.26	0.33		
St. Dev.	0.30	0.24		
Min	5.78	0.00		
Max	7.05	1.00		
Summary Count	32	32		
Total Count	32	32		

LLCR Delta Count by Category						
	Stable	**Minor**	**Acceptable**	**Marginal**	**Unstable**	**Open**
mOhms	**<=5**	**>5 & <=10**	**>10 & <=15**	**>15 & <=50**	**>50 & <=1000**	**>1000**
Thermal	**192**	**0**	**0**	**0**	**0**	**0**

DATA SUMMARIES Continued

LLCR Gas Tight:

1) A total of 192 points were measured.
2) EIA-364-23, *Low Level Contact Resistance Test Procedure for Electrical Connectors and Sockets.*
3) A computer program, *LLCR 221.exe*, ensures repeatability for data acquisition.
4) The following guidelines are used to categorize the changes in LLCR as a result from stressing.
   a. <= +5.0 mOhms: ---------- Stable
   b. +5.1 to +10.0 mOhms: ---------- Minor
   c. +10.1 to +15.0 mOhms: ---------- Acceptable
   d. +15.1 to +50.0 mOhms: ---------- Marginal
   e. +50.1 to +2000 mOhms: ---------- Unstable
   f. >+2000 mOhms: ---------- Open Failure

HSEC8-20-01-L-DP-A-K/EDGE CARD----0.056”

	LLCR Measurement Summaries by Pin Type			
Date	3/14/2017	3/14/2017		
Room Temp (Deg C)	23	22		
Rel Humidity (%)	35	33		
Technician	Troy Cook	Troy Cook		
mOhm values	**Actual Initial**	**Delta Acid Vapor**	**Delta**	**Delta**
	Pin Type 1: Signal			
Average	6.16	0.15		
St. Dev.	0.36	0.12		
Min	5.44	0.00		
Max	7.38	0.65		
Summary Count	192	192		
Total Count	192	192		

LLCR Delta Count by Category						
	Stable	**Minor**	**Acceptable**	**Marginal**	**Unstable**	**Open**
mOhms	**<=5**	**>5 & <=10**	**>10 & <=15**	**>15 & <=50**	**>50 & <=1000**	**>1000**
Acid Vapor	**192**	**0**	**0**	**0**	**0**	**0**

DATA SUMMARIES Continued

LLCR Shock &Vibration:

1). A total of 192 points were measured.
2). EIA-364-23, *Low Level Contact Resistance Test Procedure for Electrical Connectors and Sockets.*
3). The following guidelines are used to categorize the changes in LLCR as a result from stressing.
   a. <= +5.0 mOhms: ---------- Stable
   b. +5.1 to +10.0 mOhms: ---------- Minor
   c. +10.1 to +15.0 mOhms: ---------- Acceptable
   d. +15.1 to +50.0 mOhms: ---------- Marginal
   e. +50.1 to +2000 mOhms ---------- Unstable
   f. >+2000 mOhms: ---------- Open Failure

HSEC8-20-01-L-DP-A-K/EDGE CARD----0.056"

	LLCR Measurement Summaries by Pin Type			
Date	4/7/2017	4/13/2017		
Room Temp (Deg C)	22	20		
Rel Humidity (%)	30	35		
Technician	Troy Cook	Troy Cook		
mOhm values	**Actual Initial**	**Delta Shock-Vib**	**Delta**	**Delta**
	Pin Type 1: Signal			
Average	6.33	0.49		
St. Dev.	0.51	0.34		
Min	5.34	0.00		
Max	7.87	1.77		
Summary Count	160	160		
Total Count	160	160		
	Pin Type 2: Ground			
Average	6.57	0.39		
St. Dev.	0.72	0.30		
Min	5.30	0.01		
Max	9.28	1.60		
Summary Count	32	32		
Total Count	32	32		

LLCR Delta Count by Category						
	Stable	**Minor**	**Acceptable**	**Marginal**	**Unstable**	**Open**
mOhms	**<=5**	**>5 & <=10**	**>10 & <=15**	**>15 & <=50**	**>50 & <=1000**	**>1000**
Shock-Vib	**192**	**0**	**0**	**0**	**0**	**0**

Nanosecond Event Detection:

Shock and Vibration Event Detection Summary	
Contacts tested	60
Test Condition	C, 100g's, 6ms, Half-Sine
Shock Events	0
Test Condition	V-B, 7.56 rms g
Vibration Events	0
Total Events	0

DATA SUMMARIES Continued

HSEC8-20-01-L-DP-A-K/EDGE CARD----0.068”

	LLCR Measurement Summaries by Pin Type			
Date	4/5/2017	4/6/2017		
Room Temp (Deg C)	21	22		
Rel Humidity (%)	37	32		
Technician	Troy Cook	Troy Cook		
mOhm values	**Actual Initial**	**Delta Shock-Vib**	**Delta**	**Delta**
	Pin Type 1: Signal			
Average	6.17	0.47		
St. Dev.	0.46	0.30		
Min	5.38	0.01		
Max	7.83	1.31		
Summary Count	160	160		
Total Count	160	160		
	Pin Type 2: Ground			
Average	6.32	0.52		
St. Dev.	0.53	0.36		
Min	5.44	0.03		
Max	7.51	1.75		
Summary Count	32	32		
Total Count	32	32		

LLCR Delta Count by Category						
	Stable	**Minor**	**Acceptable**	**Marginal**	**Unstable**	**Open**
mOhms	**<=5**	**>5 & <=10**	**>10 & <=15**	**>15 & <=50**	**>50 & <=1000**	**>1000**
Shock-Vib	**192**	**0**	**0**	**0**	**0**	**0**

EQUIPMENT AND CALIBRATION SCHEDULES

Equipment #: TCT-04
Description: Dillon Quantrol TC21 25-1000 mm/min series test stand
Manufacturer: Dillon Quantrol
Model: TC2 I series test stand
Serial #: 04-1041-04
Accuracy: Speed Accuracy: +/- 5% of indicated speed; Speed Accuracy: +/- 5% of indicated speed;
… Last Cal: 05/29/2016, Next Cal: 05/29/2017

Equipment #: MO-11
Description: Switch/Multimeter
Manufacturer: Keithley
Model: 3706
Serial #: 120169
Accuracy: See Manual
… Last Cal: 09/11/2016, Next Cal: 09/11/2017

Equipment #: THC-05
Description: Temperature/Humidity Chamber (Chamber Room)
Manufacturer: Thermotron
Model: SM-8-3800
Serial #: 05 23 00 02
Accuracy: See Manual
… Last Cal: 11/14/2016, Next Cal: 05/31/2017

Equipment #: TSC-01
Description: Vertical Thermal Shock Chamber
Manufacturer: Cincinnati Sub Zero
Model: VTS-3-6-6-SC/AC
Serial #: 10-VT14993
Accuracy: See Manual
… Last Cal: 06/30/2016, Next Cal: 06/30/2017

Equipment #: HPT-01
Description: Hipot Safety Tester
Manufacturer: Vitrek
Model: V73
Serial #: 019808
Accuracy:
… Last Cal: 05/15/2016, Next Cal: 05/15/2017

Equipment #: PS-02
Description: Power Supply
Manufacturer: Hewlett-Packer
Model: 6033A
Serial #: N/A
Accuracy: See Manual
… Last Cal: NOT CALIBRATED

EQUIPMENT AND CALIBRATION SCHEDULES

Equipment #: SVC-01
Description: Shock & Vibration Table
Manufacturer: Data Physics
Model: LE-DSA-10-20K
Serial #: 10037
Accuracy: See Manual
… Last Cal: 04/22/2016, Next Cal: 04/22/2017

Equipment #: ACLM-01
Description: Accelerometer
Manufacturer: PCB Piezotronics
Model: 352C03
Serial #: 115819
Accuracy: See Manual
… Last Cal: 07/18/2016, Next Cal: 07/18/2017

Equipment #: ED-03
Description: Event Detector
Manufacturer: Analysis Tech
Model: 32EHD
Serial #: 1100604
Accuracy: See Manual
… Last Cal: 10/31/2016, Next Cal: 10/31/2017

Equipment #: MO-04
Description: Multimeter /Data Acquisition System
Manufacturer: Keithley
Model: 2700
Serial #: 0798688
Accuracy: See Manual
… Last Cal: 09/11/2016, Next Cal: 09/11/2017