



Project Number: Design Qualification Test Report		Tracking Code: 161625_Report_Rev_2	
Requested by: Travis Newton		Date: 10/17/2015	Product Rev: 0
Part #: ACP-12-04-H-00.25-T-T-M-4/ACR-12-04-H-00.25-S-S1-M-4		Lot #: N/A	Tech: Clay Taylor Eng: Eric Mings
Part description: ACP / ACR			Qty to test: 60
Test Start: 09/10/2011	Test Completed: 10/06/2011		



Design Qualification Test Report

ACP / ACR

ACP-12-04-H-00.25-T-T-M-4/ACR-12-04-H-00.25-S-S1-M-4

Tracking Code: 161625_Report_Rev_2	Part #: ACP-12-04-H-00.25-T-T-M-4/ACR-12-04-H-00.25-S-S1-M-4
Part description: ACP /ACR	

REVISION HISTORY

DATA	REV.NUM.	DESCRIPTION	ENG
10/15/2015	2	Add the IR-DWV pin- closest metallic hardware data	PC

CERTIFICATION

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

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SCOPE

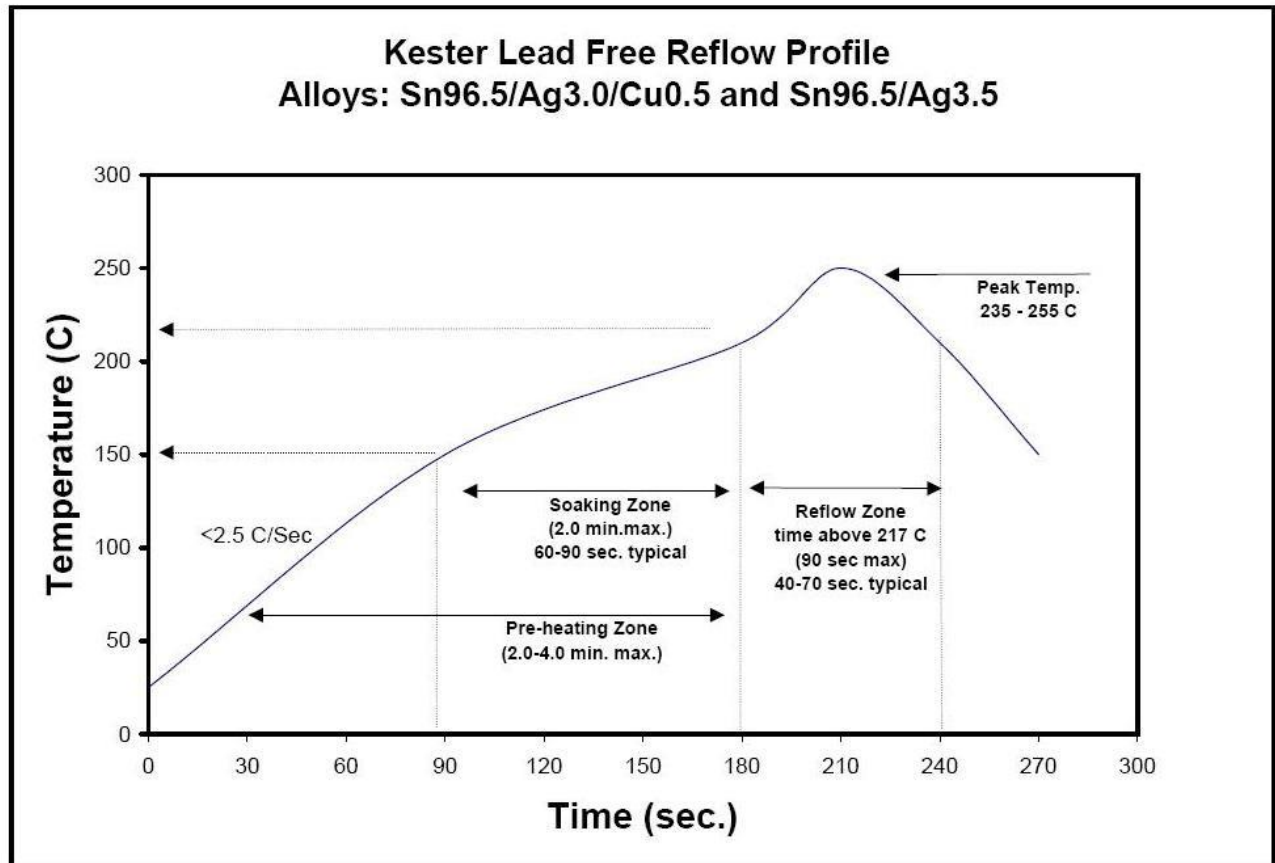
To perform the following tests: Design Qualification Test, Please see test plan.

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 and DWV/IR 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 and DWV/IR 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) Re-Flow Time/Temp: See accompanying profile.
- 10) Samtec Test PCBs used: PCB-103219-TST-XX

TYPICAL OVEN PROFILE (Soldering Parts to Test Boards)

FLOWCHARTS**Durability/Mating/Unmating/Gaps**

TEST STEP	GROUP A1 8 Assemblies
02	LLCR-1
03	Forces - Mating / Unmating
04	25 Cycles
05	Forces - Mating / Unmating
06	25 Cycles (50 Total)
07	Forces - Mating / Unmating
08	25 Cycles (75 Total)
09	Forces - Mating / Unmating
10	25 Cycles (100 Total)
11	Forces - Mating / Unmating
12	Clean w/Compressed Air
14	LLCR-2
15	Thermal Shock (Mated and Undisturbed)
16	LLCR-3
17	Cyclic Humidity (Mated and Undisturbed)
18	LLCR-4
19	Forces - Mating / Unmating

Thermal Shock = EIA-364-32, Table II, Test Condition I:

-55°C to +85°C 1/2 hour dwell, 100 cycles

Humidity = EIA-364-31, Test Condition B (240 Hours)

and Method III (+25°C to +65°C @ 90% RH to 98% RH)

ambient pre-condition and delete steps 7a and 7b

Mating / Unmating Forces = EIA-364-13

LLCR = EIA-364-23, LLCR

20 mV Max, 100 mA Max

Use Keithley 580 or 3706 in 4 wire dry circuit mode

FLOWCHARTS Continued**IR & DWV**

TEST STEP	GROUP A1 2 Mated Sets Break Down Pin-to-Pin	GROUP A2 2 Unmated of Part # Being Tested Break Down Pin-to-Pin	GROUP A3 2 Unmated of Mating Part # Break Down Pin-to-Pin	GROUP B1 2 Mated Sets Pin-to-Pin
01	DWV/Break Down Voltage	DWV/Break Down Voltage	DWV/Break Down Voltage	IR & DWV at test voltage (on both mated sets and on each connector unmated)
02				Thermal Shock (Mated and Undisturbed)
03				IR & DWV at test voltage (on both mated sets and on each connector unmated)
04				Cyclic Humidity (Mated and Undisturbed)
05				IR & DWV at test voltage (on both mated sets and on each connector unmated)

DWV on Group B1 to be performed at Test Voltage

DWV test voltage is equal to 75% of the lowest break down voltage from Groups A1, A2 or A3

Thermal Shock = EIA-364-32, Table II, Test Condition I:

-55°C to +85°C 1/2 hour dwell, 100 cycles

Humidity = EIA-364-31, Test Condition B (240 Hours)

and Method III (+25°C to +65°C @ 90% RH to 98% RH)

ambient pre-condition and delete steps 7a and 7b

IR = EIA-364-21

DWV = EIA-364-20, Test Condition 1

FLOWCHARTS Continued

IR/DWV

Pin-to-Closest Metallic Hardware

Group 1	Group 2	Group 3	Group 4
ACR-12-04-G-00.25-T-BC-M-1	ACR-12-04-G-00.25-T-BC-M-1		ACR-12-04-G-00.25-T-BC-M-1
ACP-12-04-G-00.25-S-BC-M-1		ACP-12-04-G-00.25-S-BC-M-1	ACP-12-04-G-00.25-S-BC-M-1
2 Assemblies	2 Assemblies	2 Assemblies	2 Assemblies

Step	Description	Step	Description	Step	Description	Step	Description
1.	DWV Breakdown (2)	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)

Current Carrying Capacity - Array

TEST STEP	GROUP A1 3 Mated Assemblies All Contacts Powered
01	CCC

(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

CCC, Temp rise = EIA-364-70

ATTRIBUTE DEFINITIONS

The following is a brief, simplified description of attributes.

THERMAL SHOCK:

- 1) EIA-364-32, *Thermal Shock (Temperature Cycling) Test Procedure for Electrical Connectors*.
- 2) Test Condition 1: -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.

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.

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:
 - a. When the specified test voltage is applied (VDC), the insulation resistance shall not be less than 1000 megohms.

ATTRIBUTE DEFINITIONS

The following is a brief, simplified description of attributes.

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. Rate of Application 500 V/Sec
 - iii. 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).

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° C
 - c. 95° C
 - d. 115° 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

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) The following guidelines are used to categorize the changes in LLCR as a result from stressing
 - a. $\leq +5.0$ 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

RESULTS

Temperature Rise, CCC at a 20% de-rating

- CCC for a 30°C Temperature Rise ----- 1.8 A per contact with All contact powered (ACP cable bundle)

Mating&Unmating durability force:

- **Initial**
 - **Mating**
 - Min ----- 3.58 Lbs
 - Max----- 3.93 Lbs
 - **Unmating**
 - Min ----- 1.50 Lbs
 - Max----- 1.78 Lbs
- **After 25 Cycles**
 - **Mating**
 - Min ----- 3.74 Lbs
 - Max----- 4.38 Lbs
 - **Unmating**
 - Min ----- 2.00 Lbs
 - Max----- 2.62 Lbs
- **After 50 Cycles**
 - **Mating**
 - Min ----- 3.81 Lbs
 - Max----- 4.36 Lbs
 - **Unmating**
 - Min ----- 2.17 Lbs
 - Max----- 2.92 Lbs
- **After 75 Cycles**
 - **Mating**
 - Min ----- 3.83 Lbs
 - Max----- 4.41 Lbs
 - **Unmating**
 - Min ----- 2.27 Lbs
 - Max----- 3.05 Lbs
- **After 100 Cycles**
 - **Mating**
 - Min ----- 3.87 Lbs
 - Max----- 4.45 Lbs
 - **Unmating**
 - Min ----- 2.41 Lbs
 - Max----- 3.23 Lbs
- **After Humidity**
 - **Mating**
 - Min ----- 2.10 Lbs
 - Max----- 3.12 Lbs
 - **Unmating**
 - Min ----- 1.35 Lbs
 - Max----- 1.54 Lbs

RESULTS Continued

LLCR Durability (64 signal LLCR test points)

- **Initial** ----- 56.63 mOhms Max
- **After 100 Cycles**
 - <= +5.0 mOhms -----64 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
- **After thermal shock**
 - <= +5.0 mOhms -----64 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
- **After humidity**
 - <= +5.0 mOhms -----64 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
 - >+2000 mOhms -----0 Points ----- Open Failure

Insulation Resistance minimums, IR

Pin-Pin

- **Initial**
 - Mated ----- 100000 Meg Ohms ----- Pass
 - Unmated ----- 100000 Meg Ohms ----- Pass
- **Thermal**
 - Mated ----- 100000 Meg Ohms ----- Pass
 - Unmated ----- 100000 Meg Ohms ----- Pass
- **Humidity**
 - Mated ----- 1800 Meg Ohms ----- Pass
 - Unmated ----- 1200 Meg Ohms ----- Pass

Pin- closest metallic hardware

- **Initial**
 - Mated ----- 450000 Meg Ohms ----- Pass
 - Unmated ----- 450000 Meg Ohms ----- Pass
- **Thermal**
 - Mated ----- 450000 Meg Ohms ----- Pass
 - Unmated ----- 450000 Meg Ohms ----- Pass
- **Humidity**
 - Mated ----- 7400 Meg Ohms ----- Pass
 - Unmated ----- 9400 Meg Ohms ----- Pass

RESULTS Continued

Dielectric Withstanding Voltage minimums, DWV

- **Minimums**
 - Breakdown Voltage -----726 VAC
 - Test Voltage -----545 VAC
 - Working Voltage -----180 VAC

Pin - pin

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

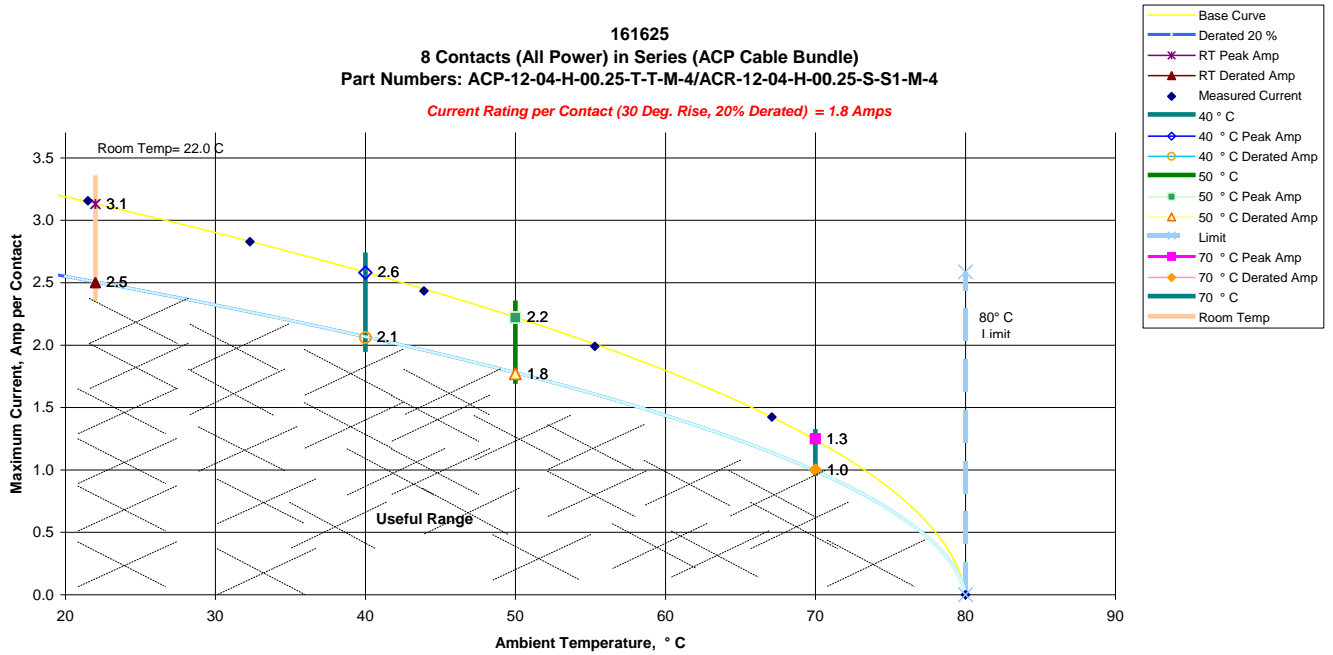
Pin - closest metallic hardware

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

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:
 - a. Linear configuration with 8 contacts Power (ACP Cable Bundle)



DATA SUMMARIES Continued**Mating/Unmating durability force:**

	Initial				25 Cycles			
	Mating		Unmating		Mating		Unmating	
	Newton's	Force (Lbs)	Newton's	Force (Lbs)	Newton's	Force (Lbs)	Newton's	Force (Lbs)
Minimum	15.92	3.58	6.67	1.50	16.64	3.74	8.90	2.00
Maximum	17.48	3.93	7.92	1.78	19.48	4.38	11.65	2.62
Average	16.77	3.77	7.30	1.64	18.16	4.08	9.91	2.23
St Dev	0.54	0.12	0.46	0.10	1.05	0.24	0.90	0.20
Count	8	8	8	8	8	8	8	8
	50 Cycles				75 Cycles			
	Mating		Unmating		Mating		Unmating	
	Newton's	Force (Lbs)	Newton's	Force (Lbs)	Newton's	Force (Lbs)	Newton's	Force (Lbs)
Minimum	16.95	3.81	9.65	2.17	17.04	3.83	10.10	2.27
Maximum	19.39	4.36	12.99	2.92	19.62	4.41	13.57	3.05
Average	17.95	4.04	10.96	2.46	18.18	4.09	11.99	2.70
St Dev	0.93	0.21	1.09	0.25	0.96	0.22	1.11	0.25
Count	8	8	8	8	8	8	8	8
	100 Cycles				After Humidity			
	Mating		Unmating		Mating		Unmating	
	Newton's	Force (Lbs)	Newton's	Force (Lbs)	Newton's	Force (Lbs)	Newton's	Force (Lbs)
Minimum	17.21	3.87	10.72	2.41	9.34	2.10	6.00	1.35
Maximum	19.79	4.45	14.37	3.23	13.88	3.12	6.85	1.54
Average	18.31	4.12	12.94	2.91	11.08	2.49	6.39	1.44
St Dev	0.92	0.21	1.36	0.31	1.39	0.31	0.33	0.07
Count	8	8	8	8	8	8	8	8

DATA SUMMARIES Continued**INSULATION RESISTANCE (IR):**

Minimum	Pin to Pin		
	Mated	Unmated	Unmated
	ACP/ACR	ACP	ACR
Initial	100000	100000	100000
Thermal	100000	100000	100000
Humidity	1800	1200	100000

Minimum	Pin to Closest Metallic Hardware		
	Mated	Unmated	Unmated
	ACR/ACP	ACR	ACP
Initial	45000	45000	45000
Thermal	45000	45000	45000
Humidity	7400	45000	9400

DIELECTRIC WITHSTANDING VOLTAGE (DWV):

Voltage Rating Summary	
Minimum	ACP/ACR
Break Down Voltage	726
Test Voltage	545
Working Voltage	180

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

Pin to Closest Metallic Hardware	
Initial Test Voltage	Passed
After Thermal Test Voltage	Passed
After Humidity Test Voltage	Passed

DATA SUMMARIES Continued

LLCR Durability:

- 1) A total of 64 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. $\leq +5.0$ 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

LLCR Measurement Summaries by Pin Type				
Date	9/8/2011	9/16/2011	9/21/2011	10/3/2011
Room Temp (Deg C)	23	23	23	23
Rel Humidity (%)	47	33	48	32
Technician	Aaron McKim	Aaron McKim	Aaron McKim	Aaron McKim
mOhm values	Actual Initial	Delta 100 Cycles	Delta Therm Shck	Delta Humidity
Pin Type 1: Signal				
Average	54.19	1.37	1.58	1.45
St. Dev.	0.69	0.44	0.76	0.50
Min	52.97	0.01	0.01	0.00
Max	56.63	2.63	3.48	2.34
Summary Count	64	64	64	64
Total Count	64	64	64	64

LLCR Delta Count by Category						
mOhms	Stable	Minor	Acceptable	Marginal	Unstable	Open
	≤ 5	$>5 \ \& \ \leq 10$	$>10 \ \& \ \leq 15$	$>15 \ \& \ \leq 50$	$>50 \ \& \ \leq 1000$	>1000
100 Cycles	64	0	0	0	0	0
Therm Shck	64	0	0	0	0	0
Humidity	64	0	0	0	0	0

EQUIPMENT AND CALIBRATION SCHEDULES**Equipment #:** MO-11**Description:** Micro-ohmmeter**Manufacturer:** Keithley**Model:** 3706**Serial #:** 120169**Accuracy:** Last Cal: 2011-8-21, Next Cal: 2012-8-21**Equipment #:** TCT-01**Description:** Normal force analyzer**Manufacturer:** Mecmesin Multitester**Model:** Mecmesin Multitester 2.5-i**Serial #:** 08-1049-04**Accuracy:** Last Cal: 2012-4-28, Next Cal: 2013-4-27**Equipment #:** THC-01**Description:** Humidity transmitter**Manufacturer:** Thermtron**Model:** HMM30C**Serial #:** D0240037**Accuracy:** Last Cal: 2012-3-3, Next Cal: 2013-3-2**Equipment #:** MO-01**Description:** Micro-ohmmeter**Manufacturer:** Keithley**Model:** 2700**Serial #:** 1199807**Accuracy:** Last Cal: 2012-4-28, Next Cal: 2013-4-27**Equipment #:** PS-01**Description:** Power Supply**Manufacturer:** Agilent**Model:** 6031A**Serial #:** MY41000982**Accuracy:** Last Cal: 2012-4-28, Next Cal: 2013-4-27**Equipment #:** TSC-01**Description:** Thermal Shock transmitter**Manufacturer:** Keithley**Model:** 10-VT14994**Serial #:** VTS-3-6-6-SC/AC**Accuracy:** Last Cal: 2011-11-1, Next Cal: 2012-11-1