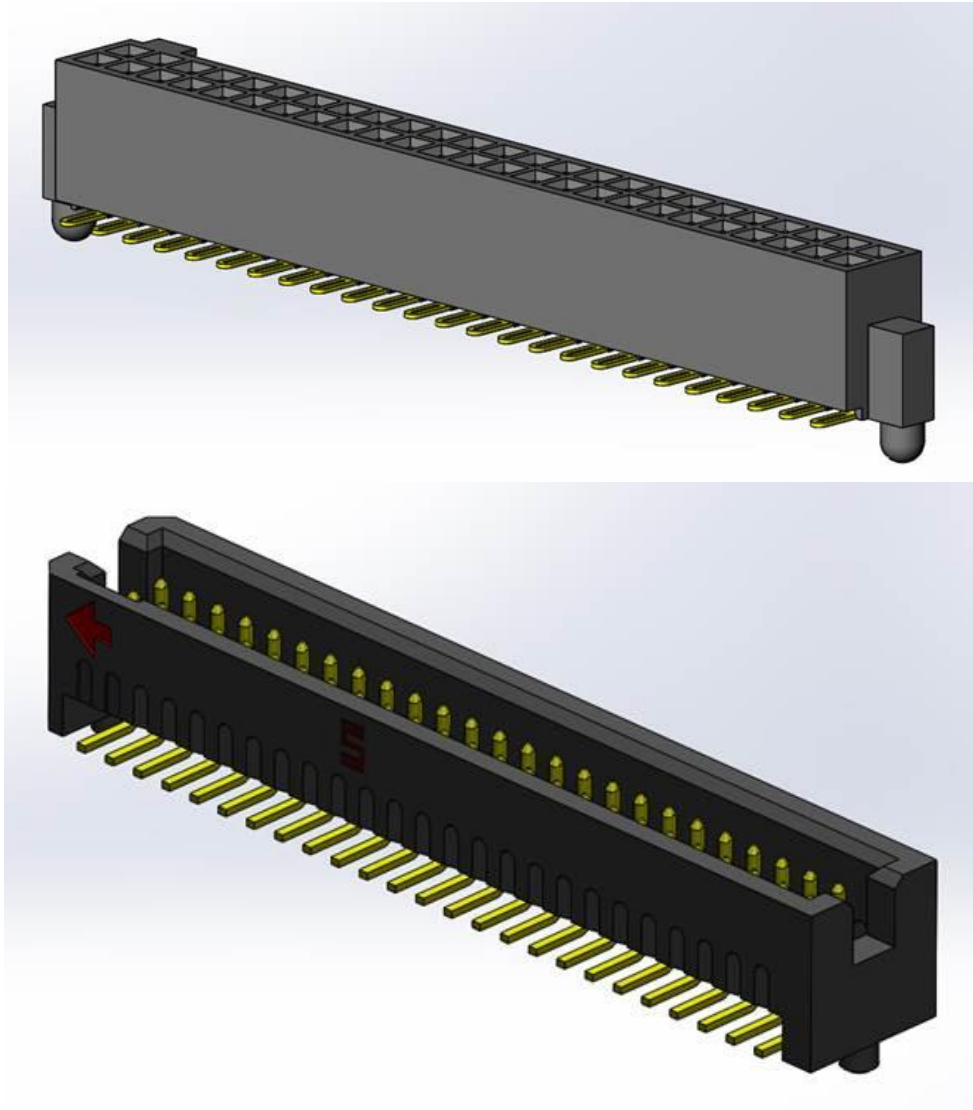




Project Number: Mixed Flowing Gas test report	Tracking Code: 1946939_Report_Rev_1
Requested by: Kason He	Date: 5/24/2019
Part #: SFM-125-02-S-D-A/TFM-125-02-S-D-A	
Part description: SFM-TFM	Tech: Keney Chen
Test Start: 3/18/2019	Test Completed: 4/3/2019



(Actual part not depicted)

MIXED FLOWING GAS TEST REPORT

SFM/TFM

SFM-125-02-S-D-A/TFM-125-02-S-D-A

Tracking Code: 1946939_Report_Rev_1	Part #: SFM-125-02-S-D-A/TFM-125-02-S-D-A
Part description: SFM/TFM	

REVISION HISTORY

DATE	REV.NUM.	DESCRIPTION	ENG
5/23/2019	1	Initial Issue	KC

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: Mixed Flowing Gas per EIA-364-65 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-109761-TST

FLOWCHARTS

Mixed Flowing Gas

Group 1

SFM-125-02-S-D-A

TFM-125-02-S-D-A

8 Assemblies

Step	Description
1.	Plating Thickness Verification (4)
2.	LLCR (1)
3.	Cycles Quantity = 20 Cycles
4.	LLCR (1) Max Delta = 15 mOhm
5.	Mixed Flowing Gas Unmated (2) Duration = 7 Days <i>Note: 1/2 Samples Mated 1/2 Samples Unmated</i>
6.	LLCR (1) Max Delta = 15 mOhm
7.	Mixed Flowing Gas Mated (2) Duration = 7 Days <i>Note: All Samples Mated</i>
8.	LLCR (1) Max Delta = 15 mOhm
9.	Cycles Quantity = 1 Cycles
10.	LLCR (1) Max Delta = 15 mOhm

(1) LLCR = EIA-364-23

Open Circuit Voltage = 20 mV Max
Test Current = 100 mA Max

(2) Mixed Flowing Gas Mated = EIA-364-65

Environmental Conditions = Class IIA

(3) Mixed Flowing Gas Unmated = EIA-364-65

Environmental Conditions = Class IIA

(4) Plating Thickness Verification

Measure, verify, and document plating thickness on both male and female (one group only)
Plating thickness to be measured on loose pins used during assembly

ATTRIBUTE DEFINITIONS

The following is a brief, simplified description of attributes.

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.

Mixed Flowing Gas:

- 1) EIA-364-65B, *Mixed Flowing Test Procedure For Electrical Connectors Contacts And Sockets*.
- 2) To adequately evaluate the risk of corrosion, the Mixed Flowing Gas test shall be done with the gas mixtures in below table.

Table 1 - Environmental classes

Class	Relative humidity, %	Temperature, °C	Concentration, ppb			
			Cl ₂	NO ₂	H ₂ S	SO ₂
I	Discontinued as a test procedure.					
II	Superseded by class IIA					
IIA	70 ± 2	30 ± 1	10 ± 3	200 ± 50	10 ± 5	100 ± 20
III	Superseded by class IIIA					
IIIA	70 ± 2	30 ± 1	20 ± 5	200 ± 50	100 ± 20	200 ± 50
IV	75 ± 2	40 ± 2	30 ± 5	200 ± 50	200 ± 20	N/A

- 3) The mated and unmated exposure is done in parallel for qualification at Class IIA conditions.
- 4) Exposure time for mated and unmated is 14 days

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 +1000 mOhms: ----- Unstable
 - f. >+1000 mOhms: ----- Open Failure

RESULTS**LLCR Mixed Flowing Gas Group (192 LLCR test points)**

- **Initial** -----8.76 mOhms Max
- **Durability, 20 Cycles**
 - <= +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 +1000 mOhms -----0 Points ----- Unstable
 - >+1000 mOhms -----0 Points ----- Open Failure
- **7 Days Mixed Flowing Gas (with 4 Samples Unmated & 4 Samples Mated During Exposure)**
 - <= +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 +1000 mOhms -----0 Points ----- Unstable
 - >+1000 mOhms -----0 Points ----- Open Failure
- **14 Days Total Mixed Flowing Gas (with All 8 Samples Mated During Exposure)**
 - <= +5.0 mOhms ----- 190 Points ----- Stable
 - +5.1 to +10.0 mOhms -----2 Points ----- Minor
 - +10.1 to +15.0 mOhms -----0 Points ----- Acceptable
 - +15.1 to +50.0 mOhms -----0 Points ----- Marginal
 - +50.1 to +1000 mOhms -----0 Points ----- Unstable
 - >+1000 mOhms -----0 Points ----- Open Failure
- **1 Cycle**
 - <= +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 +1000 mOhms -----0 Points ----- Unstable
 - >+1000 mOhms -----0 Points ----- Open Failure

DATA SUMMARIES**LLCR Mixed Flowing Gas Group**

- 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. $\leq +5.0$ 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 $+1000$ mOhms -----Unstable
 - f. $> +1000$ mOhms: -----Open Failure

LLCR Measurement Summaries by Pin Type					
Date	3/18/2019	3/20/2019	3/27/2019	4/3/2019	4/3/2019
Room Temp (Deg C)	23	23	23	23	23
Rel Humidity (%)	50	52	50	50	50
Technician	Keney Chen	Keney Chen	Keney Chen	Keney Chen	Keney Chen
mOhm values	Actual Initial	Delta 20 Cycles	Delta 7days MFG	Delta 14days MFG	Delta 1Cycle
Pin Type 1: Signal					
Average	7.27	0.28	0.88	1.44	1.49
St. Dev.	0.35	0.27	0.65	1.00	0.88
Min	6.52	0.00	0.01	0.05	0.02
Max	8.76	1.69	3.98	7.32	4.99
Summary Count	192	192	192	192	192
Total Count	192	192	192	192	192

LLCR Delta Count by Category						
mOhms	Stable	Minor	Acceptable	Marginal	Unstable	Open
	≤ 5	>5 & ≤ 10	>10 & ≤ 15	>15 & ≤ 50	>50 & ≤ 1000	>1000
20 Cycles	192	0	0	0	0	0
7days MFG	192	0	0	0	0	0
14days MFG	190	2	0	0	0	0
1Cycle	192	0	0	0	0	0

EQUIPMENT AND CALIBRATION SCHEDULES**Equipment #:** HZ-TCT-01**Description:** Normal force analyzer**Manufacturer:** Mecmesin Multitester**Model:** Mecmesin Multitester 2.5-i**Serial #:** 08-1049-04**Accuracy:** Last Cal: 3/7/2019, Next Cal: 3/6/2020**Equipment #:** HZ-MO-05**Description:** Micro-ohmmeter**Manufacturer:** Keithley**Model:** 3706**Serial #:** 1285188**Accuracy:** Last Cal: 9/26/2018, Next Cal: 9/25/2019**Equipment #:** DG-MFG-01**Description:** Mixed Flow Gas Chamber**Manufacturer:** Yamasaki**Model:** GH-180**Serial #:** 715**Accuracy:** Last Cal: 12/5/2018, Next Cal: 12/4/2019