



Project Number: Design Qualification Test Report		Tracking Code: 211294_Report_Rev_1	
Requested by: Travis Newton		Date: 10/19/2012	Product Rev: A
Part #: ACP-22-04-H-00334-T-BC-P-4/ACR-22-04-H-00.5-S-BC-P-4		Lot #: N/A	Tech: Craig Ryan Eng: Eric Mings
Part description: ACP /ACR			Qty to test: 45
Test Start: 8/3/2012	Test Completed: 8/24/2012		



Design Qualification Test Report

ACP \ ACR

ACP-22-04-H-00334-T-BC-P-4/ACR-22-04-H-00.5-S-BC-P-4

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

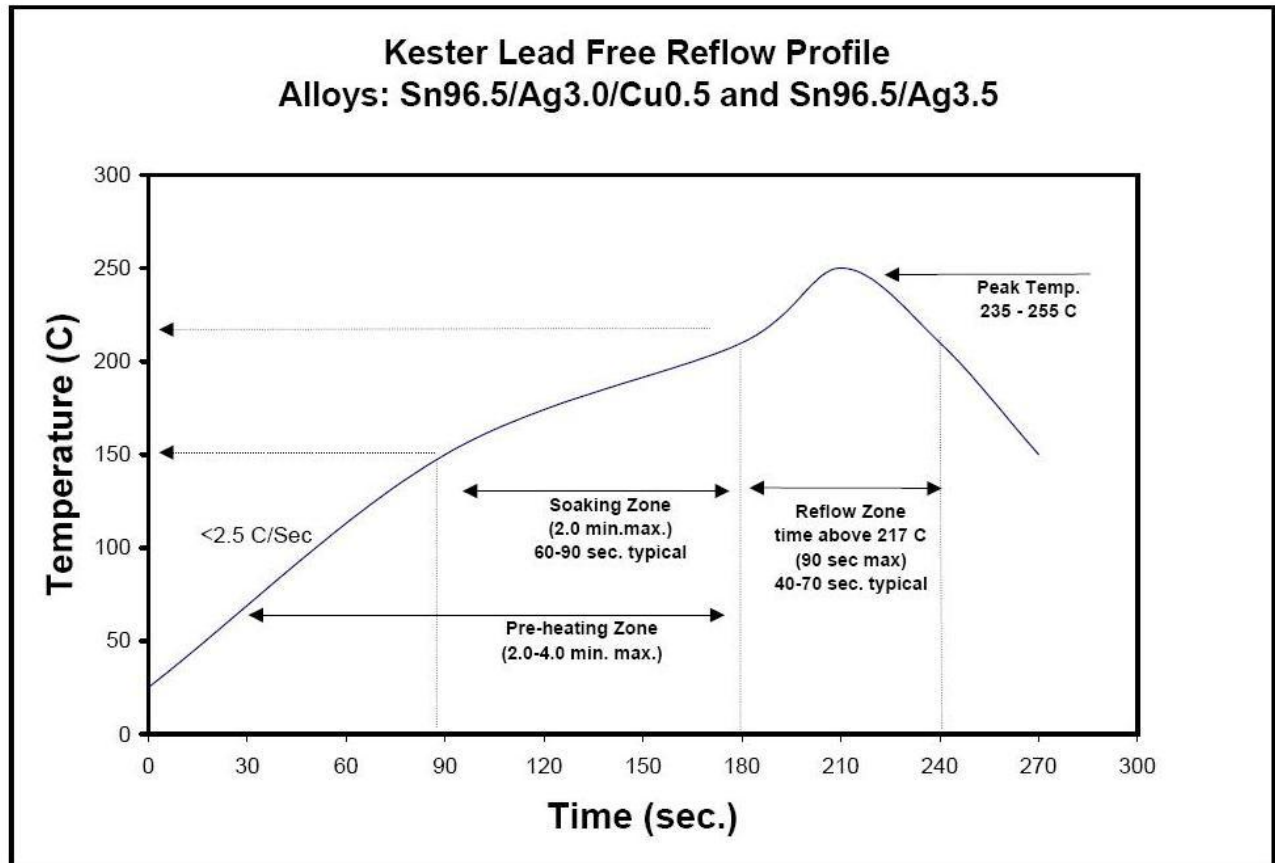
To perform the following tests: Design Qualification Test, Please see test plan.

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 6 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

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:
- 3) When the specified test voltage is applied (VDC), the insulation resistance shall not be less than 5000 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).

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. $\leq +5.0$ 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**Mating&Unmating durability force:**

- **Initial**
 - **Mating**
 - **Min** ----- 8.14 Lbs
 - **Max**-----10.16 Lbs
 - **Unmating**
 - **Min** ----- 2.59 Lbs
 - **Max**----- 6.83 Lbs
- **After 25 Cycles**
 - **Mating**
 - **Min** ----- 8.28 Lbs
 - **Max**-----12.75 Lbs
 - **Unmating**
 - **Min** ----- 3.17 Lbs
 - **Max**----- 9.54 Lbs
- **After 50 Cycles**
 - **Mating**
 - **Min** ----- 3.40 Lbs
 - **Max**-----13.24 Lbs
 - **Unmating**
 - **Min** ----- 3.40 Lbs
 - **Max**----- 9.65 Lbs
- **After 75 Cycles**
 - **Mating**
 - **Min** ----- 8.54 Lbs
 - **Max**-----14.03 Lbs
 - **Unmating**
 - **Min** ----- 3.33 Lbs
 - **Max**-----10.50 Lbs
- **After 100 Cycles**
 - **Mating**
 - **Min** ----- 8.86 Lbs
 - **Max**-----14.50 Lbs
 - **Unmating**
 - **Min** ----- 3.10 Lbs
 - **Max**-----10.73 Lbs
- **After Humidity**
 - **Mating**
 - **Min** ----- 8.33 Lbs
 - **Max**-----10.30 Lbs
 - **Unmating**
 - **Min** ----- 2.70 Lbs
 - **Max**----- 6.53 Lbs

RESULTS Continued**LLCR Durability****Signal (48 LLCR Test Points)**

- **Initial** -----170.53 mOhms Max
- **After 100 Cycles**
 - <= +5.0 mOhms -----48 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 -----48 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 -----48 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 (48 LLCR Test Points)

- **Initial** ----- 19.57 mOhms Max
- **After 100 Cycles**
 - <= +5.0 mOhms -----48 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 -----48 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 -----48 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

Insulation Resistance minimums, IR

Pin-Pin

- **Initial**
 - Mated----- 10000Meg Ω ----- Pass
 - Unmated ----- 10000Meg Ω ----- Pass
- **Thermal**
 - Mated----- 10000Meg Ω ----- Pass
 - Unmated ----- 10000Meg Ω ----- Pass
- **Humidity**
 - Mated----- 10000Meg Ω ----- Pass
 - Unmated ----- 10000Meg Ω ----- Pass

Pin-Ground

- **Initial**
 - Mated----- 10000Meg Ω ----- Pass
 - Unmated ----- 10000Meg Ω ----- Pass
- **Thermal**
 - Mated----- 10000Meg Ω ----- Pass
 - Unmated ----- 10000Meg Ω ----- Pass
- **Humidity**
 - Mated----- 10000Meg Ω ----- Pass
 - Unmated ----- 10000Meg Ω ----- Pass

Dielectric Withstanding Voltage minimums, DWV

- **Minimums**
 - Breakdown Voltage ----- 1200VAC
 - Test Voltage ----- 900VAC
 - Working Voltage ----- 300VAC

Pin - Pin

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

Pin - Ground

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

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

	Initial				25 Cycles			
	Mating		Unmating		Mating		Unmating	
	New tons	Force (Lbs)	New tons	Force (Lbs)	New tons	Force (Lbs)	New tons	Force (Lbs)
Minimum	36.21	8.14	11.52	2.59	36.83	8.28	14.10	3.17
Maximum	45.19	10.16	30.38	6.83	56.71	12.75	42.43	9.54
Average	40.77	9.17	20.37	4.58	47.13	10.60	20.63	4.64
St Dev	3.17	0.71	5.46	1.23	6.35	1.43	9.19	2.07
Count	8	8	8	8	8	8	8	8
	50 Cycles				75 Cycles			
	Mating		Unmating		Mating		Unmating	
	New tons	Force (Lbs)	New tons	Force (Lbs)	New tons	Force (Lbs)	New tons	Force (Lbs)
Minimum	37.19	8.36	15.12	3.40	37.99	8.54	14.81	3.33
Maximum	58.89	13.24	42.92	9.65	62.41	14.03	46.70	10.50
Average	49.14	11.05	21.00	4.72	50.94	11.45	21.41	4.81
St Dev	7.18	1.61	9.19	2.07	7.64	1.72	10.53	2.37
Count	8	8	8	8	8	8	8	8
	100 Cycles				After Humidity			
	Mating		Unmating		Mating		Unmating	
	New tons	Force (Lbs)	New tons	Force (Lbs)	New tons	Force (Lbs)	New tons	Force (Lbs)
Minimum	39.41	8.86	13.79	3.10	37.05	8.33	12.01	2.70
Maximum	64.50	14.50	47.73	10.73	45.81	10.30	29.05	6.53
Average	52.05	11.70	21.40	4.81	42.44	9.54	19.84	4.46
St Dev	7.80	1.75	11.08	2.49	3.22	0.72	7.64	1.72
Count	8	8	8	8	8	8	8	8

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

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

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

DIELECTRIC WITHSTANDING VOLTAGE (DWV):

Voltage Rating Summary	
Minimum	ACP/ACR
Break Down Voltage	1200
Test Voltage	900
Working Voltage	300

Pin to Pin	
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 64 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 $+2000$ mOhms ----- Unstable
 - f. $>+2000$ mOhms:----- Open Failure

LLCR Measurement Summaries by Pin Type				
Date	8/3/2012	8/3/2012	8/8/2012	8/21/2012
Room Temp (Deg C)	22	22	22	22
Rel Humidity (%)	48	45	38	38
Technician	Craig Ryan	Craig Ryan	Craig Ryan	Craig Ryan
mOhm values	Actual Initial	Delta 100 Cycles	Delta Therm Shck	Delta Humidity
Pin Type 1: Signal				
Average	165.82	0.79	0.96	0.43
St. Dev.	1.80	0.33	0.32	0.38
Min	163.53	0.38	0.16	0.02
Max	170.53	2.05	1.49	1.81
Summary Count	48	48	48	48
Total Count	48	48	48	48
Pin Type 2: Ground				
Average	19.23	0.06	0.11	0.10
St. Dev.	0.21	0.03	0.05	0.04
Min	18.82	0.01	0.00	0.00
Max	19.57	0.12	0.23	0.18
Summary Count	48	48	48	48
Total Count	48	48	48	48

LLCR Delta Count by Category						
	Stable	Minor	Acceptable	Marginal	Unstable	Open
mOhms	≤ 5	>5 & ≤ 10	>10 & ≤ 15	>15 & ≤ 50	>50 & ≤ 1000	>1000
100 Cycles	96	0	0	0	0	0
Therm Shck	96	0	0	0	0	0
Humidity	96	0	0	0	0	0

EQUIPMENT AND CALIBRATION SCHEDULES**Equipment #:** MO-03**Description:** Micro-ohmmeter**Manufacturer:** Keithley**Model:** 580**Serial #:** 297288**Accuracy:** Last Cal: 2011-8-06, Next Cal: 2012-8-05**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

EQUIPMENT AND CALIBRATION SCHEDULES CONTINUED**Equipment #:** WATER-01**Description:** IP-67 1.0 Meter Water Column Chamber**Manufacturer:** Samtec Machine**Model:** N/A**Serial #:** N/A**Accuracy:** No Calibration Required**Equipment #:** DUST-01**Description:** IP-X6 Dust Tester**Manufacturer:** Samtec Machine**Model:** N/A**Serial #:** N/A**Accuracy:** No Calibration Required