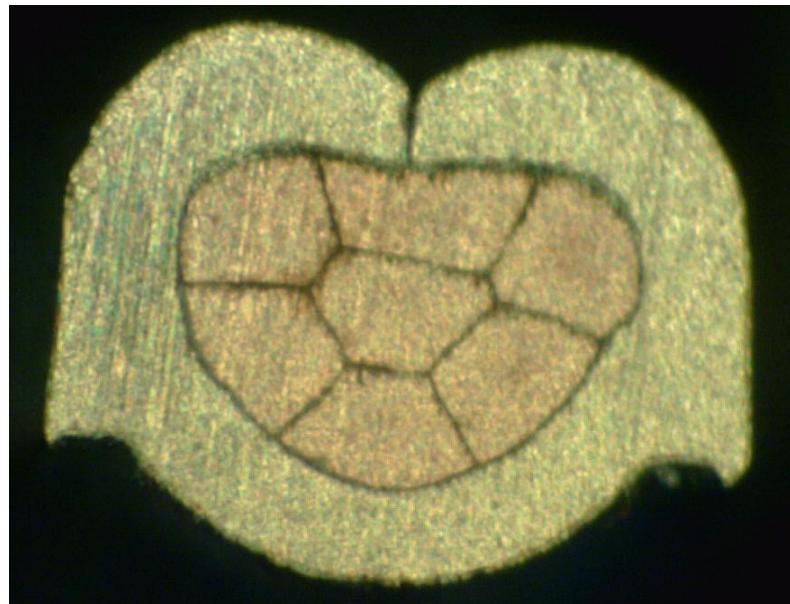




Project Number: Crimp Characterization Testing	Tracking Code: 213167		
Requested by: Bryon Saylor	Date: 8/15/2012	Product Rev:	
Part #: C-281-2426-CRIMP-24-DWC	Lot #:	Tech: Aaron McKim	Eng: Eric Mings
Part description: Individual Crimp Contacts with Wire Attached			Qty to test:
Test Start: 8/13/2012	Test Completed: 8/15/2012		

CRIMP HEIGHT CHARACTERIZATION SUMMARY REPORT



C-281-2426-CRIMP-24-DWC
Used In: S2SD

REVISION HISTORY

DATE	REV. NUM.	DESCRIPTION	ENG
8/15/2012	1	Initial Issue	AM

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 characterize initial mechanical and electrical crimp performance vs. crimp height.

APPLICABLE DOCUMENTS

Standards: EIA Publication 364

USCAR2-5

USCAR FCLT

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) Test samples were not cleaned prior to testing.
- 4) Any additional preparation will be noted in the individual test sequences.
- 5) Two hundred and twenty (220) contacts with wires crimped were submitted for this evaluation. (see flow chart for sample distribution)

FLOWCHARTS

Wire Crimp Height Verification - LLCR / Pull Test

TEST STEP	GROUPS A1 - A11 10 Crimps
01	Visual Inspection
02	Measure crimp height via crimp micrometers
03	LLCR
04	Pull-out force

Crimp Manufacturing Instructions:

Cable length to be 6" minimum

Insulation crimp to not constrain jacket

Pull-out Force: EIA-364-38C

LLCR: EIA-364-23

20 mV Max, 100 mA Max

Use Keithley 580 or 3706 in 4 wire dry circuit mode

Wire Crimp Height Verification - Cross Section

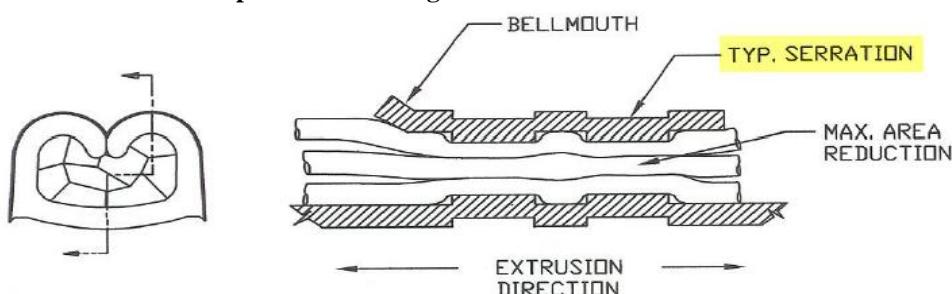
TEST STEP	GROUPS A1 - A11 3 Crimps
01	Visual Inspection
02	Measure crimp height via crimp micrometers
03	** Cross Section
04	Photos of Crimps
05	Count / Verify # of Strands
06	*** Examine for compliance with Pass/Fail criteria

Crimp Manufacturing Instructions:

Cable length to be 6" minimum

Insulation crimp to not constrain jacket

* Cross section to be performed through the serration area shown below



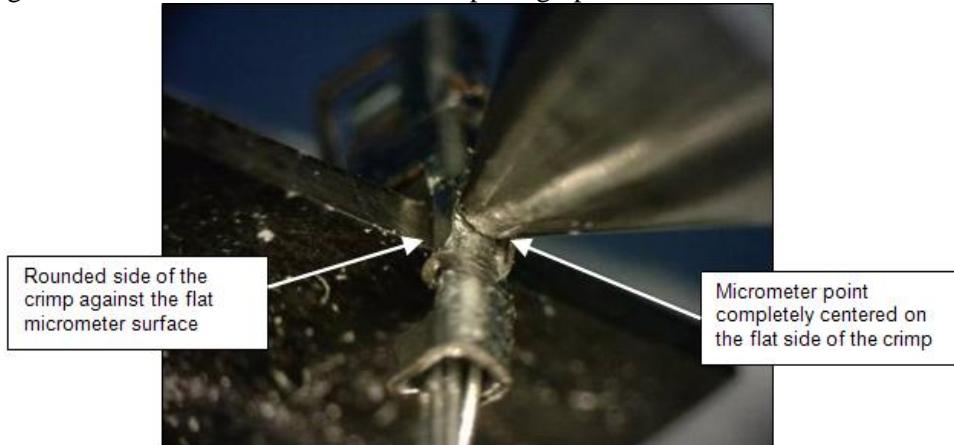
** Examine for compliance with PASS/FAIL criteria: No broken/missed wires, voids, cracks in the contact material or other applicable defects shall be allowed.

ATTRIBUTE DEFINITIONS

The following is a brief, simplified description of attributes.

CRIMP HEIGHT:

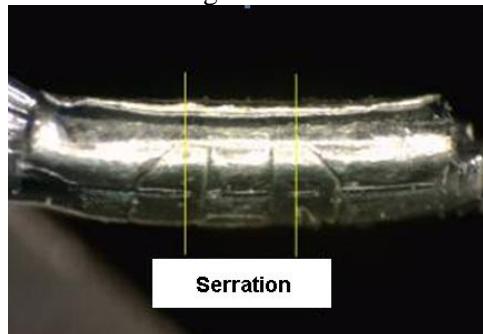
- 1) Crimp heights shall be measured as shown in the photograph below:



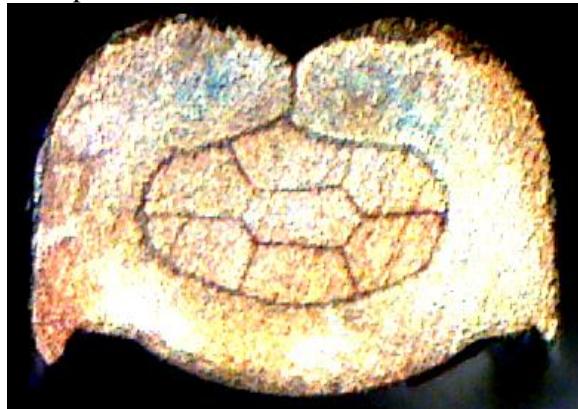
- 2) The crimp heights shall be measured on samples that have not been cross-sectioned. The above photograph was used to provide a clear view of the measurement point without the rest of the sample impeding the view.

CROSS-SECTION:

- 1) Contacts shall be cross-sectioned and polished without being potted.
- 2) The location of the cross-section shall be through one of the serrations designated in the below photograph.

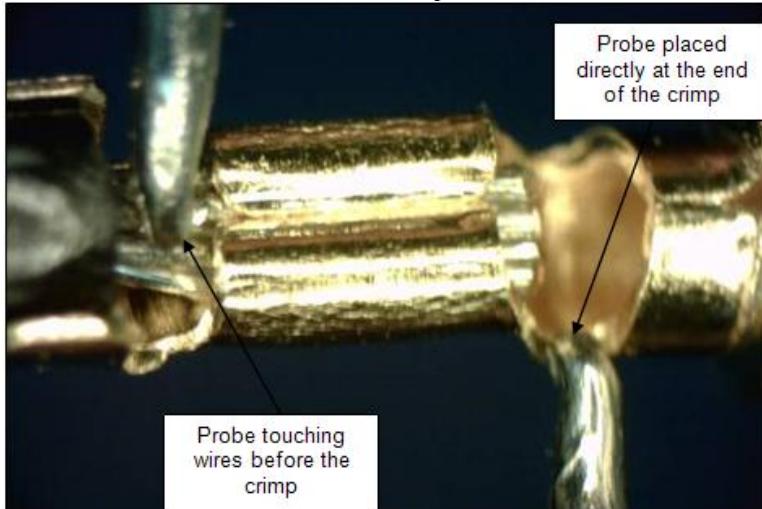


- 3) Polished crimp contact cross-sections shall be etched in a mild etchant to provide contrast for the microscopic examination.
- 4) Etched samples shall be examined under 40X magnification.
- 5) The final cross-section shall be presented as follows:



LOW LEVEL CONTACT RESISTANCE (LLCR):

- 1) The LLCR shall be measured and recorded in accordance with EIA-364-23A, *Low Level Contact Resistance Test Procedure for Electrical Connectors and Sockets*.
- 2) A four wire, Kelvin measurement shall be made at the probe locations indicated in the below photograph:



- 3) Test Conditions:
 - a. Maximum Open Circuit Voltage: 20 mV
 - b. Maximum Test Current: 100 mA

CRIMP PULL FORCE:

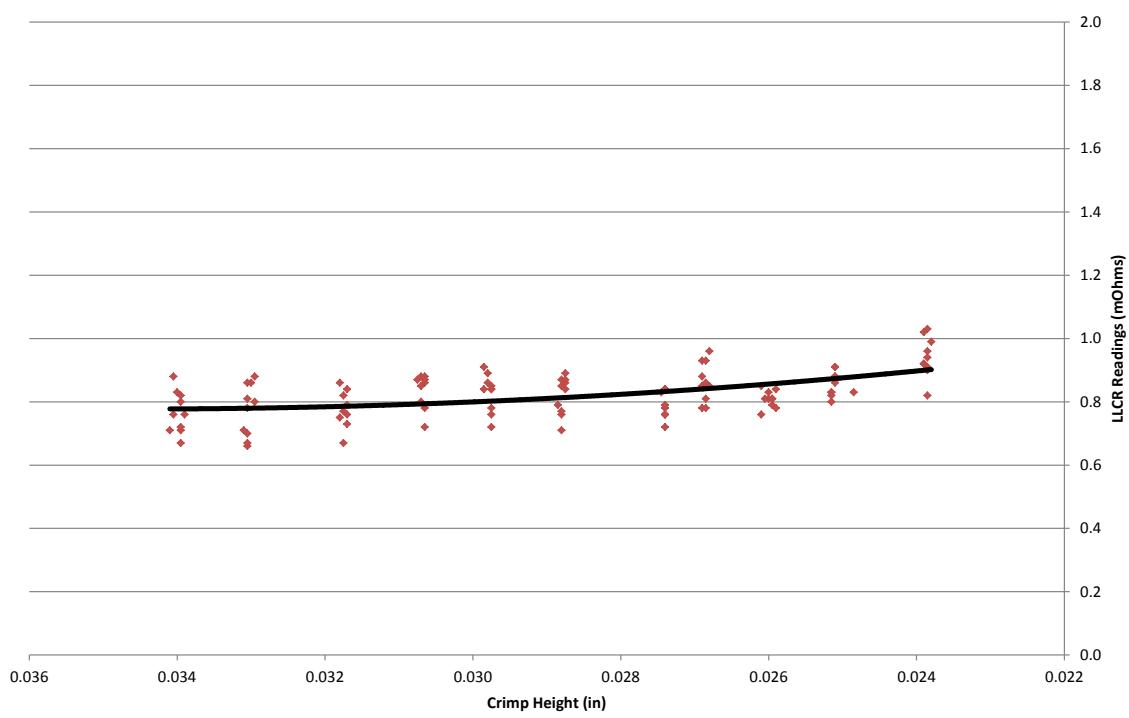
- 1) The test was performed in accordance with EIA-364-08B.
- 2) Secure contact near center and pull wire at 0°, in-line with contact.
- 3) The test stand speed shall be 25 ±6 mm.

EIA-364-08B defines the types of separation resulting from this test as follows:

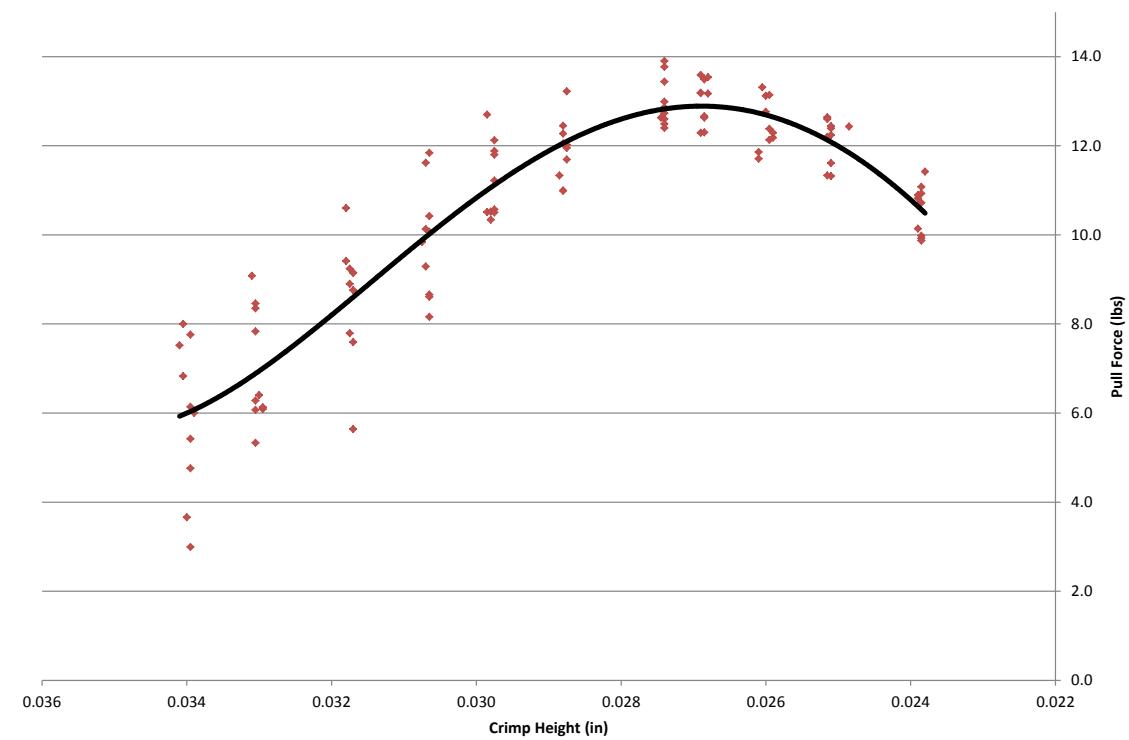
- 1) Slip (pull out).
- 2) Conductor broken in crimp area (some or all).
- 3) Contact broke in crimp area (some or all).
- 4) Conductor broken outside crimp area.
- 5) Contact broken outside crimp area.

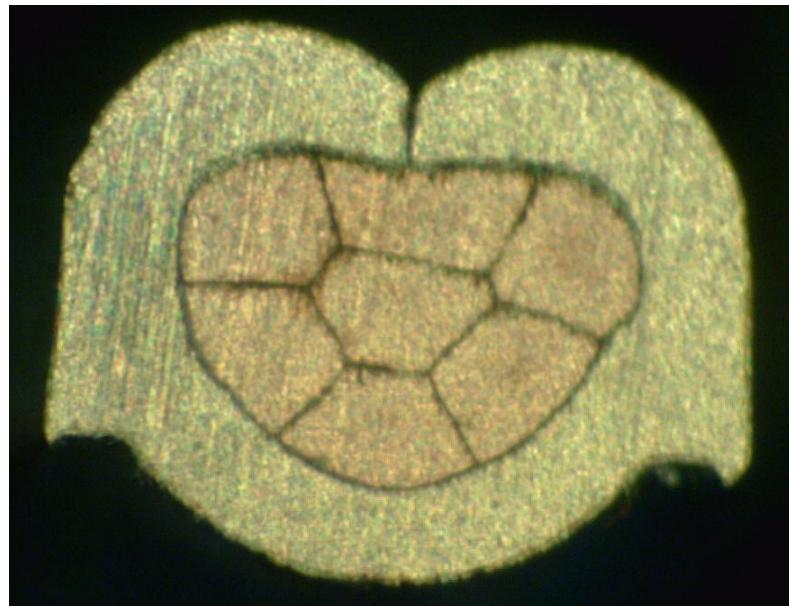
TEST RESULTS

Crimp LLCR Readings



Pull Force Readings



CROSS-SECTION PHOTO:

Typical sample at nominal height

EQUIPMENT AND CALIBRATION SCHEDULES

Equipment #: MC-41

Description: Crimp Micrometer

Manufacturer: Mitutoyo

Model: 342-371

Serial #: 05020827

Accuracy: See Manual

... Last Cal: 06/09/2012, Next Cal: 06/09/2013

Equipment #: MO-01

Description: Micro-Ohmmeter

Manufacturer: Keithley

Model: 580

Serial #: 0772740

Accuracy: See Manual

... Last Cal: 03/27/2012, Next Cal: 03/27/2013

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

... Last Cal: 05/03/2012, Next Cal: 05/03/2013

Equipment #: LC-250N-2

Description: 250 Newton Load Cell

Manufacturer: Mecmesin

Model: ILC – Load Cell

Serial #: 07-0029-02

Accuracy: See Manual

... Last Cal: 7/10/2012, Next Cal: 1/1/2013