



QUALIFICATION TEST REPORT

CONNECTOR, AMPLIMITE[®],
.050 SERIES, SLIMLINE

501-255

Rev. 0

Product Specification: 108-1366 Rev. 0
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Corporate Test Laboratory Harrisburg, Pennsylvania

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Qualification Test Report

1. Introduction

1.1 Purpose

Testing was performed on AMP 050 Series Slimline AMPLIMITE Connector to determine its conformance to the requirements of AMP Product Specification 108-1366 Rev. O.

1.2 Scope

This report covers the electrical, mechanical, and environmental performance of the 050 Series Slimline AMPLIMITE Connector manufactured by the Capital Goods Business Unit. The testing was performed between January 27, 1992 and June 24, 1994. Testing was performed by both the Capital Goods Business Sector Test Engineering Lab and the Corporate Test Lab.

1.3 Conclusion

The 050 Series Slimline AMPLIMITE Connector meets the electrical, mechanical, and environmental performance requirements of AMP Product Specification 108-1366 Rev. O.

1.4 Product Description

This connector family consists of printed circuit board mounted shielded receptacles, vertical, right angle, and stackable right angle and shielded plug cable connectors. The contacts are phosphor bronze with gold plating in the contact area.

1.5 Test Samples

The test samples were randomly selected from normal current production lots, and the following part numbers were used for test:

<u>Test Group</u>	<u>Quantity</u>	<u>Part Nbr</u>	<u>Description</u>
1,2,4	5 ea	750821-1	Stacked Receptacle
3,5	5 ea	786200-1	Stacked Receptacle
1,2,3,4	5 ea	750833-1	Cable Mount Plug
1	5 ea	750852-8	Backshell Kit
2	5 ea	750852-7	Backshell Kit
2	5 ea	750850-7	Backshell Kit

1.6 Qualification Test Sequence

Test or Examination	Test Groups				
	1	2	3	4	5
Examination of Product	1,9	1,6	1,5	1,9	1,3
Termination Resistance, Dry Circuit	3,7	2,5	2,4		
Dielectric Withstanding Voltage				4,8	
Insulation Resistance				3,7	
Capacitance				2	
Vibration	5				
Physical Shock	6				
Mating Force	2				
Unmating Force	8				
Durability	4	3			
Solderability					2
Thermal Shock				5	
Humidity-Temperature Cycling				6	
Mixed Flowing Gas			3		
Temperature Life		4			

The numbers indicate sequence in which tests were performed.

2. Summary of Testing

2.1 Examination of Product - All Groups

All samples submitted for testing were selected from normal current production lots. They were inspected and accepted by the Product Assurance Department of the Capital Goods Business Unit.

2.2 Termination Resistance, Dry Circuit - Groups 1,2,3

All termination resistance measurements, taken at 100 milliamperes DC and 50 millivolts open circuit voltage had a maximum resistance of 25 milliohms.

Test Group	Nbr of Samples	Condition	Min	Max	Mean
1	30	Initial	11.43	16.80	13.44
		After Mechanical	11.26	16.39	13.47
2	260	Initial	3.16	16.63	9.14
		After Temp Life	3.56	17.84	9.73
3	30	Initial	4.37	10.69	6.96
		After Mixed Gas	4.55	11.24	7.47

All values in milliohms

2.3 Dielectric Withstanding Voltage - Group 4

No dielectric breakdown or flashover occurred when a test voltage was applied between adjacent contacts.

2.4 Insulation Resistance - Group 4

All insulation resistance measurements were greater than 1,000 megohms.

2.5 Capacitance - Group 4

All capacitance measurements were less than 3.0 picofarads.

2.6 Vibration - Group 1

No discontinuities of the contacts were detected during vibration. Following vibration, no cracks, breaks, or loose parts on the connector assemblies were visible.

2.7 Physical Shock - Group 1

No discontinuities of the contacts were detected during physical shock. Following physical shock testing, no cracks, breaks, or loose parts on the connector assemblies were visible.

2.8 Mating Force - Group 1

All mating force measurements were less than 21 pounds.

2.9 Unmating Force - Group 1

All unmating force measurements were greater than 1.5 pounds.

2.10 Durability - Groups 1,2

No physical damage occurred to the samples as a result of mating and unmating the connector 500 times.

2.11 Solderability - Group 5

The contact leads had a minimum of 95% solder coverage.

2.12 Thermal Shock - Group 4

No evidence of physical damage to either the contacts or the connector was visible as a result of thermal shock.

2.13 Humidity-Temperature Cycling - Group 4

No evidence of physical damage to either the contacts or the connector was visible as a result of exposure to humidity-temperature cycling.

2.14 Mixed Flowing Gas - Group 3

No evidence of physical damage to either the contacts or the connector was visible as a result of exposure to the pollutants of mixed flowing gas.

2.15 Temperature Life - Group 2

No evidence of physical damage to either the contacts or the connector was visible as a result of exposure to an elevated temperature.

3. Test Methods

3.1 Examination of Product

Product drawings and inspection plans were used to examine the samples. They were examined visually and functionally.

3.2 Termination Resistance, Low Level

Termination resistance measurements at low level current were made using a four terminal measuring technique (Figure 1). The test current was maintained at 100 milliamperes DC with an open circuit voltage of 50 millivolts DC.

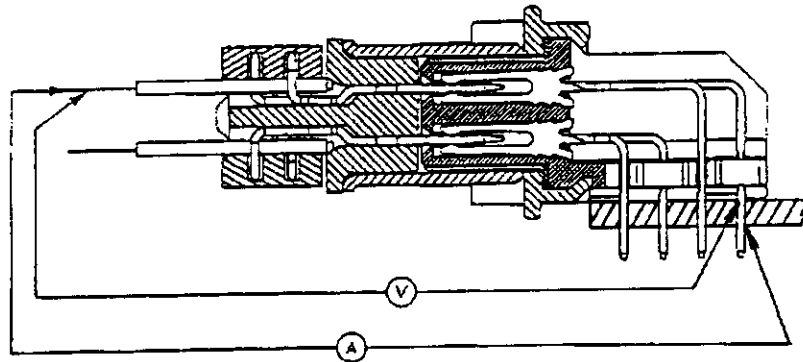


Figure 1
Typical Termination Resistance Measurement Points

3.3 Dielectric Withstanding Voltage

A test potential of 500 vac was applied between the adjacent contacts. This potential was applied for one minute and then returned to zero.

3.4 Insulation Resistance

Insulation resistance was measured between adjacent contacts, using a test voltage of 500 volts DC. This voltage was applied for two minutes before the resistance was measured.

3.5 Capacitance

Capacitance was measured between the adjacent contacts of mated connectors, using a test frequency of 1.0 MHz.

3.6 Vibration, Random

Mated connectors were subjected to a random vibration test, specified by a random vibration spectrum, with excitation frequency bounds of 50 and 2000 hertz. The power spectral density at 50 hz is $0.01 \text{ G}^2/\text{Hz}$. The spectrum slopes up at 6 dB per octave to a PSD of $0.04 \text{ G}^2/\text{Hz}$ at 100 Hz. The spectrum is flat at $0.04 \text{ G}^2/\text{Hz}$ from 100 to 1000 Hz. The spectrum slopes down at 6 dB per octave to the upper bound frequency of 2000 Hz, at which the PSD is $0.01 \text{ G}^2/\text{Hz}$. The root-mean square amplitude of the excitation was 7.56 GRMS. The connectors were monitored for discontinuities greater than one microsecond, using a current of 100 milliamperes in the monitoring circuit.

3.7 Physical Shock

Mated connectors were subjected to a physical shock test, having a half-sine waveform of 30 gravity units (g peak) and a duration of 11 milliseconds. Three shocks in each direction were applied along the three mutually perpendicular planes, for a total of 18 shocks. The connectors were monitored for discontinuities greater than one microsecond, using a current of 100 milliamperes in the monitoring circuit.

3.8 Mating Force

The force required to mate individual connectors was measured, using a free floating fixture with a maximum rate of travel at 1.0 inch/minute.

3.9 Unmating Force

The force required to unmate individual connectors was measured using a free floating fixture with a maximum rate of travel at 1.0 inch/minute.

3.10 Durability

Connectors were mated and unmated 500 times at a rate not exceeding 800 per hour.

3.11 Solderability

Connector assembly contact solder tails were subjected to a solderability test by immersing them in a nonactivated rosin flux for 5 to 10 seconds, allowed to drain for 10 to 60 seconds, then held over molten solder without contact for 2 seconds. The solder tails were then immersed in the molten solder at a rate of approximately one inch per second, held for 3 to 5 seconds, then withdrawn. After cleaning in isopropyl alcohol, the samples were visually examined for solder coverage. The solder used for testing was 60/40 tin lead composition and was maintained at a temperature of 245°C.

3.12 Thermal Shock

Mated connectors were subjected to 25 cycles of temperature extremes with each cycle consisting of 30 minutes at each temperature. The temperature extremes were -55°C and 105°C. The transition between temperatures was less than one minute.

3.13 Humidity-Temperature Cycling

Mated connectors were exposed to 10 cycles of humidity-temperature cycling. Each cycle lasted 24 hours and consisted of cycling the temperature between 25°C and 65°C twice while the relative humidity was held at 95%. During five of the first nine cycles, the connectors were exposed to a cold shock at -10°C for 3 hours.

3.14 Mixed Flowing Gas, Class III

Mated connectors were exposed for 20 days to a mixed flowing gas Class III exposure. Class III exposure is defined as a temperature of 30°C and a relative humidity of 75% with the pollutants of C_1H_4 at 20 ppb, NO_2 at 200 ppb, and H_2S at 100 ppb. Samples were preconditioned with 10 cycles of durability.

3.15 Temperature Life

Mated samples were exposed to a temperature of 70°C for 500 hours.

4. Validation

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