




NUMBER GS-12-625	TYPE Product Specification		
TITLE Terminal block- Plug and Socket, Fixed Plug		PAGE 3 of 8	REVISION D
		AUTHORIZED BY Jason Hsu	DATE Nov. 11 <sup>th</sup> , 2009
		CLASSIFICATION <b>Unrestricted</b>	

### 3.0 REQUIREMENTS

#### 3.1 Design and Construction

Connectors shall be of the design, construction and physical dimensions specified on the applicable product drawings and shall consider the requirements mentioned on IEC 998-2-1 paragraph 10, relevant to clamping units.

#### 3.2 Materials, Dimensions, Plating and Markings

All of these items are described on the individual drawings.

#### 3.3 Ratings

Voltage rating, current rating, operation temperature and rated screw torque are described on the individual drawings.

#### 3.4 Performance and Test Description

Product is designed to meet the electrical, mechanical and environment performance requirement list in section 3.5.

Unless otherwise specified, all tests shall be performed at ambient environmental conditions per IEC 160.

#### 3.5 Test Requirements and Procedures Summary

3.5.1 ELECTRICAL REQUIREMENTS		
DESCRIPTION	TEST CONDITION	REQUIREMENT
3.5.1.1 Product Examination	Visual, dimensional and functional	Meet requirements of product drawing.
3.5.1.2 Low Level Contact Resistance	Mated connectors, apply a maximum voltage of 0.2 V between wire pole and terminated terminal.	20 milliohms maximum.
3.5.1.3 Insulation resistance	IEC 60998-1, paragraph 13e 13.3. Initial 1000Volts DC, or 500Volts DC after environment test applied between two adjacent contact with measurements made 1 minute after the application of the voltage.	1) 5000 MΩ Min. initial. 2) 5 MΩ minimum after environment test.
3.5.1.4 Dielectric Withstanding Voltage	IEC 60998-1, paragraph 13e 13.4. Apply 1.6K VAC, Test between adjacent contacts of connector assemblies.	No breakdown; Current leakage < 5 mA


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	Samples were measured after salt is removed by running water.	
3.5.3.5 Fire Test (Glow wire test)	Specimens with no visible flame and no sustained glowing; or flames and glowing on the specimen extinguished 30 seconds after the removal of the glow wire.	IEC 60695-2-10,-2-11,-2-12 Apply the glow-wire once for no longer than 5 seconds.

#### 4.0 QUALITY ASSUREANCE PROVISIONS

##### 4.1 Equipment Calibration

All test equipment and inspection facilities used in the performance of any test shall be maintained in a calibration system in accordance with QS9000.

##### 4.2 Inspection Conditions

Unless otherwise specified, all inspections shall be performed under the following conditions:


- a) Temperature: 25+/- 5°C
- b) Relative Humidity: 30% to 60%
- c) Barometric Pressure: Local ambient

##### 4.3 Acceptance

- 4.3.1 Electrical and Mechanical requirements shall be as indicated in Paragraphs 3.5 using test data and appropriate statistical techniques.
- 4.3.2 Failures attributed to equipment, test setup or operator error shall not disqualify the product.

##### 4.4 Qualification Testing

Qualification testing shall be performed on sample units predicted with equipment and procedures normally used in production. Test sequence are shown in Table 1(Pluggable plug), Table 2(pluggable socket), and Table3(Fixed plug).

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**TABLE 1: QUALIFICATION TESTING SEQUENCE for Pluggable Plug**

TEST	PARA	Test Group							
		A	B	C	D	E	F	G	H
		Test Sequence							
Product examination	3.5.1.1	1	1	1	1	1	1	1	1
LLCR	3.5.1.2	2						3	
Insulation Resistance	3.5.1.3	3			3	3	3	4	
Dielectric withstanding voltage	3.5.1.4	4		4	4	4	4		
Mating/Un-mating force	3.5.2.1 3.5.2.2		2						
Torque	3.5.2.5		3						
Wire Pull Strength	3.5.2.4			2					
Temperature rise	3.5.1.5			3					
humidity test	3.5.3.3				2				
Heat resistance	3.5.3.1					2			
Cold resistance	3.5.3.2						2		
Salt Spray	3.5.3.4							2	
Fire Test (Glow wire test)	3.5.3.5								2
Qualification connector per group		3	3	3	3	3	3	3	3

**TABLE 2: QUALIFICATION TESTING SEQUENCE-Pluggable Socket**


TEST	PARA	Test Group							
		A	B	C	D	E	F	G	H
		Test Sequence							
Product examination	3.5.1.1	1	1	1	1	1	1	1	1
Insulation Resistance	3.5.1.3	2		3	3	3			
Dielectric withstanding voltage	3.5.1.4	3		4	4	4			
Pin Retention (Pull force)	3.5.2.6		2						
Humidity	3.5.3.3			2					
Heat resistance	3.5.3.1				2				
Cold resistance	3.5.3.2					2			
Salt Spray	3.5.3.4						2		
Fire Test (Glow wire test)	3.5.3.5							2	
Solder ability	3.5.2.7								2

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Qualification connector per group	3	3	3	3	3	3	3	3	3
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**TABLE 3: QUALIFICATION TESTING SEQUENCE-Fixed Plug**

TEST	PARA	Test Group									
		A	B	C	D	E	F	G	H	J	
		Test Sequence									
Product examination	3.5.1.1	1	1	1	1	1	1	1	1	1	
LLCR	3.5.1.2	2						3			
Insulation Resistance	3.5.1.3	3			3	3	3	4			
Dielectric withstanding voltage	3.5.1.4	4		4	4	4	4				
Torque	3.5.2.5		2								
Wire Pull Strength	3.5.2.4			2							
Temperature rise	3.5.1.5			3							
humidity test	3.5.3.3				2						
Heat resistance	3.5.3.1					2					
Cold resistance	3.5.3.2						2				
Salt Spray	3.5.3.4							2			
Solder ability	3.5.2.7								2		
Fire Test (Glow wire test)	3.5.3.5									2	
Qualification connector per group		3	3	3	3	3	3	3	3	3	

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**REVISION RECORD**

REV	PAGE	DESCRIPTION	ECR#	DATE
A	All	Initial Release	DG09-0204	Nov 11 <sup>th</sup> , 2009
B	3	3.5.2.7 solderability test, Temperature change form 260 +/- 5 °C to 250 +/- 10°C	T09-1162	Dec 17 <sup>th</sup> , 2009
C	All	Add phase-2 product series	T10-0079	Jun 15 <sup>th</sup> , 2010
D	2	Add p/n 20020336		Jan 31 <sup>th</sup> , 2010

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