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TITLE PwrBlade+™ Connector System		PAGE 1 of 10	REVISION H
		AUTHORIZED BY ZHENHUA LIU	DATE 13 May, 15
CLASSIFICATION UNRESTRICTED			

1.0 OBJECTIVE

This specification defines the performance, test, quality, and reliability requirement of the PwrBlade+™ Connector System.

2.0 SCOPE

This specification is applicable to the termination characteristic of separable right angle and vertical plugs when mated to the right angle and vertical receptacles.

3.0 GENERAL

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4.0 APPLICABLE DOCUMENTS

4.1 Other Standard and Specification

- 4.1.1 UL-94 : Flammability
- 4.1.2 EIA-364: Electrical Connector/Socket Test Procedure Including Environmental Classifications
- 4.1.3 MIL-STD-1344A: Federal Specifications, Test Methods for Electrical Connectors.

4.2 FCI Specifications

- 4.2.1 BUS-03-601 Current Rating
- 4.2.2 GS-14 -1502 Package Specification
- 4.2.3 GS-20-141 Application Specification

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5.0 REQUIREMENTS

5.1 Qualification

Connectors furnished under this specification shall be capable of meeting the qualification test requirements specified herein.

5.2 Material

The material for each component shall be as specified herein or equivalent.

High/Low Power Contacts - High Conductivity Copper alloy.

Signal contacts - Copper alloy.

Housing Resin– Glass filled, Nylon, or other high performance resin rated flame retardant 94V-0 in accordance with UL-94.

5.3 Finish

Standard PwrBlade+ contact plating refer to FCI 10116351.

5.4 Design and Construction

Connectors shall be of the design, construction and physical dimensions specified on the applicable product drawings.

5.5 Workmanship includes freedom from blistering, cracks, discoloration, etc.

5.6 Operating temperature range: -40°C~125°C


5.7 Examination of product-EIA-364-18, visual and dimensions inspection per product drawing, meet requirements of product drawing.

6.0 ELECTRICAL CHARACTERISTICS

6.1 **Low Level Contact Resistance (LLCR)** – The low level contact resistance shall not exceed
 High Power contacts: 10 milliohm initially and 20milliohm final
 Low Power contacts: 15 milliohm initially and 20milliohm final
 Signal contacts: 20milliohm final
 after environmental exposure when measured in accordance with EIA-364-23 .The following details shall apply,


- a) Test Voltage – 20 millivolts DC max open circuit volatge.
- b) Test Current – Not to exceed 100 milliamps.

6.2 **Contact resistance at rated current**– The contact resistance at rated current shall not exceed 0.7 milliohm for high power contact and 1.5 milliohm for low power contact initially or after mating cycles and environmental exposure when measured in accordance with EIA 364 TP06. Test

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current is 30A for 12 high power contacts at 6.35mm pitch, 16A for 8 low power contacts show in Table 1A.

- 6.3 **Insulation Resistance** – The insulation resistance of mated connectors shall not be less than 1,000 megohms for power contacts and 500 megohms for signal initially and after environmental exposure when measured in accordance with EIA 364 TP21.
- a) Test Voltage 500 volts DC.
 - b) Electrification time – 2 minutes.
 - c) Points of Measurement – Between adjacent contacts.
- 6.4 **Dielectric Withstanding Voltage** – There shall be no evidence of arc-over, insulation breakdown, or excessive leakage current (>1 Milliampere) when mated connectors are tested in accordance with EIA-364-20. The following details apply.
- a) Test Voltage – 1000 volts, DC for signal and low power contacts.
 - b) Test Voltage – 2500 volts, DC for high power contacts.
 - c) Test Duration – 60 seconds.
 - d) Test Condition – 760 Torr - sea level.
 - e) Points of Measurement – Between adjacent contacts.

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6.5 **Current Rating** – Refer to table 1, the temperature rise above ambient shall not exceed 30°C at any point in the system at specified amperes (Table 1A&1B) when mated connectors are tested in accordance with EIA-364-70, method 1. The following detail shall apply:

- a) Ambient Conditions – Still air at 25°C
- b) Stabilize at a single current level until 3 readings at 5 minutes intervals are within 1°C.
- c) Test with single energized contact and with all adjacent power contacts energized.

Table 1A: Rated current table (amperes),

Note: Connectors are applied to test boards with 2 layers X 2 ounce copper power plane


Types	Pitch (mm)	Single Contact	4 adjacent Contacts	8 adjacent Contacts	12 adjacent Contacts
High Power Contact	7.62	50	42	N.A.	N.A.
High Power Contact	6.35	50	38	33	30
High Power Contact	5.08	50	36	31	28
Low Power Contact	2.92	30.	19	16	N.A.

Table 1B: Rated current table (amperes)

Note: Connectors are applied to test boards with 10 layers X 2 ounce copper power plane

Types	Pitch (mm)	Single Contact	4 adjacent Contacts	8 adjacent Contacts	12 adjacent Contacts
High Power Contact	7.62	75	67	N.A.	N.A.
High Power Contact	6.35	75	63	48	45
High Power Contact	5.08	75	58	45	43
Low Power Contact	2.92	49	28	27	N.A.

Types	Pitch (mm)	Single Contact	24 adjacent Contacts	48 adjacent Contacts
Signal Contact	2.54	3	1.5	1

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6.6 **Voltage Rating** – see table 2

Table 2: Rated voltage table

Table 2	PwrBlade+ Maximum Working Voltage Vs. Minimum Creep Distance (Reference UL 60950-1 Second Edition Table 2N)					
Type	Contact Pitch	Pollution Degree (office Environment)	Material Group (Base on UL Rating)	MCD (mm)	Maximum Working Voltage (AC RMS)	Maximum Working Voltage (DC/AC Peak)
Signal	2.54 [.100"]	2	II	0.94	88	124
Signal – High Power	3.81 [.150"]			1.98	281	397
	4.45 [.175"]			2.62	376	531
	5.08 [.200"]			3.25	456	644
	5.72 [.225"]			3.89	541	764
	6.35 [.250"]			4.52	633	895
Signal – Low Power	2.73 [.107"]			2.22	322	455
	3.37 [.132"]			2.86	407	575
	4.00 [.157"]			3.49	486	687
	4.64 [.182"]			4.13	576	814
	5.27 [.207"]			4.76	670	947
High Power	5.08 [.200"]			2.06	295	417
	6.35 [.250"]			3.33	466	659
	7.62 [.300"]			4.60	645	912
High Power – Low Power	4.00 [.157"]			2.28	330	467
	4.64 [.182"]			2.92	415	586
	5.27 [.207"]			3.55	493	697
	5.91 [.232"]			4.19	585	827
	6.54 [.257"]	4.82	679	960		
Low Power	2.92 [.115"]	2.52	363	513		

7.0 MECHANICAL CHARACTERISTICS

7.1 **Mating/Unmating Force** – The force to mate/unmate a receptacle and compatible plug.

Table 3: Mating/unmating force


	Per High power Contact	Per Low power contacts	Per Signal contacts
Mating force (Max.)	5N [18 ounce]	1N [3.6ounce]	1N [3.6ounce]
Unmating force (Min.)	2.2N [8 ounce]	0.5N [1.8 ounce]	0.2N [0.64 ounces]

The following details shall apply:

7.1.1) Cross head speed – 12.7mm [0.5 in] per minute

7.1.2) Lubrication – None

7.1.3) Utilize free floating fixtures.

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7.1.4) Reference EIA 364-13

7.2 **Compliant Pin Insertion**

Contact types	Insertion force per compliant pin
Plug/ receptacle high power contact	111.2N[25lbf] maximum
Plug/receptacle low power contact	111.2N[25lbf] maximum
Plug signal contact	93.4N[21lbf] maximum
Receptacle signal contact	27N[6 lbf] maximum

7.2.1 Per EIA-364-5

7.2.2 Measure force necessary to correctly apply a specimen to a printed circuit board at a maximum rate of 12.7mm per minute.

7.3 **Radial hole distortion** – 0.070mm [.00276 in] maximum radial distortion. 0.008mm [.00032 in] minimum copper hole wall remaining. The following details shall apply:

7.3.1 Per EIA-364-96

7.3.2 Measure at 0.2 to 0.5mm [.008 to .020 in] depth.

7.4 **Compliant Pin Retention**

Contact types	Retention force per compliant pin
Plug/ receptacle high power contact	6.7N[1.5lbf] minimum
Plug/receptacle low power contact	6.7N[1.5lbf] minimum
Plug signal contact	6.7N[1.5lbf] minimum
Receptacle signal contact	6.7N[1.5lbf] minimum

7.4.1 Per EIA-364-5

7.4.2 Measure force necessary to remove a correctly applied specimen from its printed circuit board at a maximum rate of 12.7mm per minute.

7.5 **Component heat resistance to wave soldering**– Shall meet visual requirements, show no physical damage, and meet requirements of additional tests as specified in the TABLE 4: QUALIFICATION TESTING SEQUENCE.


7.6 **Solderability dip test**– EIA-364-52, solderable area shall have a minimum of 95% solder coverage.

7.7 **Vibration, random** – EIA-364-28

7.7.1) Test procedure – VII, test condition letter E.

7.7.2) Subject mated specimens to 4.90G's rms between 20-500Hz.

7.7.3) Mounting – To eliminate relative motion, both mating halves should be rigidly fixed.

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7.7.4) Duration – 15 minutes in each of 3 mutually perpendicular planes.

7.7.5) No evidence of physical damage, No interruptions > 1.0 microsecond.

7.8 **Mechanical Shock** – EIA 364-27

7.8.1) Condition A (50G, 11 millisecond half sine wave)

7.8.2) Shocks – 3 shocks in both directions along each of three orthogonal axes. (18 total)

7.8.3) Mounting – Rigidly mount assemblies.

7.8.4) No discontinuities of greater than 1.0 microsecond.

7.9 **Durability** – Standard laboratory procedure as applicable to the specific product EIA-364-09

7.9.1) Number of cycles – 500.

7.9.2) Maximum cycling rate – 500 cycles per hour.

8.0 ENVIRONMENTAL CONDITIONS

After exposure to the following environmental conditions in accordance with the specified test procedure and/or details, the product shall show no physical damage and shall meet the applicable electrical and mechanical requirements of paragraph 6.0 and 7.0 as detailed in Table 4 test sequences. Unless otherwise specified, assemblies shall be mated during exposure.

8.1 **Thermal Shock** – EIA-364-32

8.1.1) Subject mated specimens to 36 cycles.

8.1.2) Temperature Range – 40 to 125°C.

8.1.3) Time at each temperature – 30 minutes minimum.

8.1.4) Transfer time – 5 minutes, maximum.

8.2 **Humidity-temperature cycling**– EIA-364-31, Method III.

8.2.1) Subject mated specimens to 10 cycles(10 days)

8.2.2) Relative Humidity – 80~100%

8.2.3) Temperature +25°C~+40°C

8.3 **Temperature Life** – EIA-364-17, Method A.


8.3.1) Test condition 5.

8.3.2) Test duration – 504 Hours.

8.3.3) Temperature 125°C.

8.4 **Mixed Flowing Gas (MFG)** – EIA 364-65

8.4.1) Class – IIA

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8.4.2) Duration – 14 days. (7 days mated, 7 days unmated)

9.0 **QUALITY ASSURANCE PROVISIONS**

9.1 **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.

9.2 **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

9.3 **Acceptance**

9.3.1 Electrical and Mechanical requirements shall be as indicated in Paragraphs 6.0 and 7.0 using test data and appropriate statistical techniques.

9.3.2 Failures attributed to equipment, test setup or operator error shall not disqualify the product.

9.4 **Qualification Testing**

9.4.1 Specimen selection
Specimens shall be prepared in accordance with applicable instruction sheets and shall be selected at random from current production.

9.4.2 Test Sequence-as specified in Table 4.

9.5 **Re-qualification Testing**

If any of the following conditions occur, the responsible product engineer shall initiate re-qualification testing consisting of the applicable parts of the test matrix, Table 4.

- d) A significant design change is made to the existing product that impacts the product form, fit or function. Example of significant changes shall include, but not be limited to, changes in the plating material composition or thickness, contact force or contact surface geometry, insulator design, contact base material or contact lubrication requirements.
- e) A significant event occurs during production or end use requiring corrective action to be taken relative to the product design or manufacturing process.
- f) A significant change is made to the manufacturing process that impacts the product form, fit or function.



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TABLE 4: QUALIFICATION TESTING SEQUENCE

TEST	PARA	Test Group (a)							
		1	2	3	4	5	6	7	8
		Test Sequence (c)							
Examination of Product	5.7	1,6	1,9	1,8	1,5	1,13	1,4	1,4	1,5
Low level contact resistance, Signal, high/low power contacts	6.1	2,5	3,7		2,4				
Low level contact resistance, High/low Power contacts only	6.1					2,6 8,10			
Contact Resistance at rated current, High/low power contacts only	6.2					12			
Insulation resistance	6.3			2,6					
Dielectric Withstanding Voltage	6.4			3,7					
Current Rating (Temperature rise vs current)	6.5					4,11			
Vibration, Random	7.7		5			9(d)			
Mechanical Shock	7.8		6						
Durability	7.9	3(e)	4			3(f)			
Mating Force	7.1		2						
Un-Mating Force	7.1		8						
Compliant pin insertion	7.2							2	2
Radial hole distortion	7.3							3	
Compliant pin retention	7.4								4
Component heat resistance to wave soldering	7.5						2		
Solderability dip test	7.6						3		
Thermal Shock	8.1			4					
Humidity-temperature cycling	8.2			5					
Temperature Life	8.3				3	7			3
Mixed Flowing Gas	8.4	4				5			

NOTE:

- (a) See paragraph 9.4.
- (b) Split into subgroups as needed for on and off board tests.
- (c) Numbers indicate sequence in which tests are performed.
- (d) Energize at current for 18°C temperature rise.
- (e) Precondition specimens with 5 durability cycles.
- (f) Precondition specimens with 25 durability cycles.

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REVISION RECORD

REV	PAGE	DESCRIPTION	ECN#	DATE
A	All	Initial Release	DG10-0140	Mar 3 rd , 10
B	All	Remove 4.3, Update 4.2, 5.2, 5.3, 6.2, 7.2, 7.4, Table 1, Table 4	ECR-ELX-T-004389	Jul 8 th , 11
C	2	Remove Signal Contact LLCR initial 15 milliohm	ECR-ELX-T-005060	Aug 15 th , 11
D	2,4	Updated 6.1, 6.2, 6.5	ECR-ELX-T007381	Oct 26 th , 11
E	5	Update 6.6, 7.1	ECR-ELX-T008000	Nov 22 nd , 11
F	1	Change section 4.2.1 from GES-03-601 to BUS-03-601	ELX-DG-011380-1	May 8 th , 12
G	All	Change unrestriction to unrestricted, page 1, change TALBE to TABLE, add 4.2.3 GS-20-141 Application Specification	ELX-DG-14063-1	Feb 15 th , 13
H	All	Change name description from "header" to "plug".		May 13 th , 15

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