



<b>Product Name:</b>	Pwrblade			
	Pwrblade			
<b>Product Manager:</b>	Henry Xie			
<b>Subject:</b>	Notification of Planned Change			
<b>Distribution:</b>	Active and Contract Customers of Pwrblade related business			
<b>Type of Change:</b>	Design Change			
<b>Change Description:</b>	<p>Subject: PwrBlade® Signal Contacts will move to Performance Based Plating and new Opposing Beams design (with new EON for press fit tail version) of Receptacle Signal Contact introduction.</p> <p>Nature of Change: With the continual escalation of gold and other precious metals, FCI will move to Performance Based Plating while continuing to meet the existing PwrBlade® product specification. This important move gives FCI the option to supply PwrBlade® products with either gold based plating or FCI's GXT™ palladium nickel alloy with gold flash plating on the Signal contacts of PwrBlade® connectors, for both the Header AND Receptacle signal contacts for all configurations (R/A header, vertical header, R/A receptacle and vertical receptacle). The end result allows FCI to maintain competitive pricing on PwrBlade® connectors with no change in performance to serve customers.</p> <p>In addition to the PwrBlade® product family signal contacts moving to performance based plating, FCI is also changing the signal contacts design in the receptacle connectors from the Hertz design into new Opposing Beams design with the purpose to better insure that the connectors mate optimally based on better positioning of the contacts. With this change a new EON design is applied together for press fit tail Receptacle signal contact accordingly. The Receptacle change will further insure that the same high performance that the PwrBlade® connector family has historically provided will continue into the future, this feature will be applied for all performance based plating versions of PwrBlade® receptacle connectors since this PCN effective date onwards. See attached file in the PCN package that illustrates the change of the receptacle signal contact.</p> <p>PwrBlade® header signal contact design remains not changing, only the plating is changing into performance based plating.</p> <p>FCI related customer prints are being updated to reflect Performance Based Plating rather than one plating type. FCI developed GXT in the 1980's and has used the plating on numerous connector families for over 25 years. Both gold and GXT plating variations have been fully tested to meet identical requirements. The product specification file and test report are attached for reference.</p> <p>The part numbers affective keeps no change for this PCN.</p> <p>Implementation Date: FCI may begin shipping PwrBlade® product with the GXT plated Signal contacts July 8th, 2013 or onwards. Please note that either gold based or GXT based signal contact products may ship depending upon price fluctuations in the precious metal markets from this date or onwards. FCI will begin shipping the Receptacle connectors with the new Opposing beams design signal contacts (and New EON for Press Fit tail version Receptacle) from this same date or onwards.</p> <p>Affected Part Numbers: See list attached, the affected P/Ns including, but not limited to these P/Ns in attached list with current marking, may including any more P/Ns that are to be created /active after release of this PCN. GXT plating options covers signal contacts of all PNs, new Opposing beams design feature change covers the signal contacts of all receptacle connectors only, new EON design covers press fit tail version of all receptacle connectors only.</p>			
	<b>Reason for Change:</b>	FCI to keep competitive for the Pwrblade connector business, avoid price up to customers during the recent fact of plating material cost remains high that with the trend to keep at high level in future.		
	<b>Affected Parts:</b>	see attached list		
	<b>Effective Date of Change:</b>	July	26	2013
	<b>Last Time Buy Date:</b>	N/A	N/A	N/A
<b>Last Disty Return Date:</b>	N/A	N/A	N/A	
<b>Last Time Shipment Date</b>	N/A	N/A	N/A	
<b>Datasheet Attached?</b>	Yes			
<b>Qual/Test Data Attached?</b>	Yes			
<b>Samples Availability Date:</b>	April	26	2013	
<b>Available Alternatives?</b>	No			
<b>Questions?</b>	Contact your local FCI Representative, , or Product Marketing Manager			
	Henry Xie / FCI DG Product Manager			
	Tel:86-769-88669255			
	Email: henry.xie@fci.com			

PCN	Item Number	Change	Effective Date	Last Time Buy Date	Last Disty return date	Replacement Part	Alternate Part	Comments
PCN13021	51219-XX001	DESIGN CHANGE	26-Jul-13					
PCN13021	51219-XX002	DESIGN CHANGE	26-Jul-13					
PCN13021	51219-XX002LF	DESIGN CHANGE	26-Jul-13					
PCN13021	51261-XX001	DESIGN CHANGE	26-Jul-13					
PCN13021	51261-XX001LF	DESIGN CHANGE	26-Jul-13					
PCN13021	51401-XX001	DESIGN CHANGE	26-Jul-13					
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PCN13021	51402-XX001	DESIGN CHANGE	26-Jul-13					
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PCN13021	51413-XX001LF	DESIGN CHANGE	26-Jul-13					
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PCN13021	51970-004LF	DESIGN CHANGE	26-Jul-13

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### 1.0 **OBJECTIVE**

This specification defines the performance, test, quality and reliability requirements of the PwrBlade Connector System.

### 2.0 **SCOPE**


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

### 3.0 **GENERAL**

If there is conflict between the product drawings and specifications, the drawing takes precedence.

This document is composed of the following sections:

<u>Paragraph</u>	<u>Title</u>
1.0	OBJECTIVE
2.0	SCOPE
3.0	GENERAL
4.0	APPLICABLE DOCUMENTS
5.0	REQUIREMENTS
5.1	Qualification
5.2	Material
5.3	Finish
5.4	Design and construction
5.5	Workmanship
6.0	ELECTRICAL CHARACTERISTICS
7.0	MECHANICAL CHARACTERISTICS
8.0	ENVIRONMENTAL CONDITIONS
9.0	QUALITY ASSURANCE PROVISIONS
9.1	Equipment Calibration
9.2	Inspection Conditions
9.3	Sample Quality and Description
9.4	Acceptance
9.5	Qualification Testing
9.6	Re-qualification Testing
10.0	Reference Documents
Table 1	Qualification Testing Matrix

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#### 4.0 APPLICABLE DOCUMENTS

- 4.1 Specifications
  - 4.1.1 Applicable FCI power blade product drawings
- 4.2 Federal Specifications
  - 4.2.1 MIL-STD-1344A: Test Methods for Electrical Connectors
- 4.3 Other Standards and Specifications
  - 4.3.1 UL 94 V-0: Flammability
  - 4.3.2 EIA 364: Test Procedures for Electrical Connectors, Sockets and Coaxial Contacts
- 4.4 FCI Specifications:
  - 4.4.1 BUS-03-601: Current Rating/30°C Temperature Rise
  - 4.4.2 BUS-03-404: Normal Force Measurement
  - 4.4.3 BUS-12-090: HPC Product Specification
  - 4.4.4 BUS-12-111: HPC Solderless (Press fit) Right Angle Receptacle


#### 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.

Power Contacts – High Performance Copper Alloy  
Signal Header Contacts – Copper Alloy  
Signal Receptacle Contacts – Copper Alloy  
Receptacle and Plug Housings - Glass Filled HTN (High Temperature Nylon)

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5.3 Finish

Refer to plating specification 10064183.

5.4 Design and Construction

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

5.4.1 See drawing numbers 51700, 51720, 51740, 51760 and 51866 for test connector configurations.

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

**ELECTRICAL CHARACTERISTICS**

6.1 Signal tested at Low Level (LLCR) – The low level contact resistance shall not exceed 20 milliohm after environmental exposure when measured in accordance with EIA 364 TP 06. The following details shall apply:

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


6.2 Power tested at Specified Current – The contact resistance at a specified current shall not exceed 0.7 milliohm end of life when measured in accordance with EIA 364 TP06. Test Current 30 amperes DC

6.3 Insulation Resistance – the insulation resistance of mated connectors shall not be less than 10,000 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 TP 20. The following details apply:

- a. Test Voltage – 2500 volts DC (power), 1000 volts DC (signal)
- b. Test Duration – 60 seconds.
- c. Test Condition – (760 Torr – sea level).
- d. Points of measurement – Between adjacent Contacts

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6.5 Current Rating – The temperature rise above ambient shall not exceed 30° C at any point in the system when all power contacts are powered with each contact being powered at 30 amperes or only one power contact is powered to 48 amperes. The temperature rise above ambient shall not exceed 30° C at any point in the system when all signal contacts are powered with each contact being powered at 1.0 amperes or only one signal contact is powered at 3.0 amperes. The following details shall apply:

- a. Ambient conditions – Still air at 25 °C
- b. Reference – FCI Test Specification BUS-03-601

## 7.0 MECHANICAL CHARACTERISTICS

7.1 Mating/Unmating Force – The force to mate a receptacle connector and compatible header shall not exceed 25 ounces per power contact and 3.5 ounces per signal contact. The unmating force shall not be less than 8 ounces per power contact and .64 ounces per signal contact. The following details shall apply:


- a. Cross Head Speed – 1 inch per minute
- b. Lubrication – None
- c. Utilize free floating fixtures
- d. Reference EIA 364-13

7.2 Normal Force – The contact normal force shall not be less than 350 grams per beam for the power contacts and 50 grams (nor greater than 120 grams) per beam for the signal contacts when tested in accordance with FCI Test Specification BUS-03-404.

7.3 Contact Retention – Individual power and signal contacts shall withstand an axial retention load of 3 pounds. Individual signal receptacle contacts will withstand an axial load of 6 pounds minimum to seat further into housing.

- a. Rate of 0.5 inches/minute without dislodging from the housing cavity.
- b. Test 30 contacts
- c. As per MIL-STD-1344A, Method 2007.1.

7.4 Individual Pin Insertion/Retention Force - The force required to insert an individual compliant pin into a plated through hole in a printed circuit board at a rate of 0.2 inches/minute shall not exceed 6 pounds for signal receptacle contacts, 21 pounds for signal header pins and 25 pounds per tail for power contacts. The retention force in the axial direction opposite that of insertion shall not be less than 1.5 pounds for signal receptacle contacts, 3 pounds for signal header pins and 5 pounds per tail for power contacts.

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## 7.5 PCB Hole Deformation Radius

Power Contacts – cross-section parallel to board surface. Photograph and measure the hole deformation (deformation on board material) radius at a point .010” from the surface, and the center of the compliant pin section. Include 10 holes. The average (of 10 holes) hole deformation radius shall be no greater than 0.0015” when measured from the drilled hole. The absolute maximum deformation radius shall not exceed 0.002”.

### Signal Contacts

Signal Receptacle Contacts – Reference FCI BUS-12-111 – HPC Solderless (Press Fit) Right Angle Receptacles

Signal Header Contacts – Same as the requirement for Power Contacts above

7.6 PCB Hole Wall Damage – Cross-section perpendicular to the board surface, and through the compliant section wear track. Photograph and measure the copper thickness remaining between the compliant section and the printed wiring board laminate. Include 10 holes. The minimum average (of 10 holes) copper thickness remaining between the compliant pin and the printed wiring board laminate shall not be less than 0.0003”. In addition there shall be no copper cracks, separations between conductive interfaces, or laminate-to-copper separations.

7.7 Board Lock Retention to Housing- Individual board locks shall withstand an axial load of 3 pounds minimum.

- Rate of 0.5 inches/minute without dislodging from the housing cavity.
- Test 30 board locks

## **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 paragraphs 6.0 and 7.0 as detailed in Table 1 test sequences. Unless otherwise specified, assemblies shall be mated during exposure.

### 8.1 Thermal Shock – EIA 364 TP 32

- a. Test condition – 36 cycles
- b. Temperature Range - -20 to +80 ° C
- c. Time at Each Temperature – To refer to EIA 364 TP 32 based on product mass
- d. Transfer Time – 5 minutes, maximum

### 8.2 Humidity, Steady State – EIA 364 TP 31, Method II

- a. Relative Humidity – 95%
- b. Temperature +40 ° C
- c. Test Duration – 96 hours

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8.3 High Temperature Life, EIA 364 TP 17

- a. Test Duration – 21 Days
- b. Temperature 105 ° C
- c. Pre-condition – Perform number of durability cycles specified for product

8.4 Environmental Sequence:

Phase I – Thermal Shock, EIA 364-32

- a. Test Duration – 36 cycles
- b. Temperature Range – Between -20 and +80 ° C
- c. Time at Each Temperature – To refer to EIA 364-32 based on product mass
- d. Transfer Time – 5 minutes, maximum

Phase II – Humidity, EIA 364-31, Method II

- a. Test Duration – 10 days
- b. Relative Humidity – 95%
- c. Temperature – 40 deg C

Phase III – High Temperature Life, EIA 364-17

- a. Test Duration – 21days
- b. Temperature – 105 deg C
- c. Pre-condition – Perform number of durability cycles specified for product

8.5 Industrial Mixed Flowing Gas (IMFG) – EIA 364-65

- a. Class – IIA
- b. Duration – 20 days
- c. Mated
- d. Test contact resistance after 10 and 20 days


8.6 Vibration Sinusoidal – EIA 364 TP 28

- a. Condition – III
- b. Vibration Amplitude – 0.06” DA or ± 15G
- c. Frequency Range – 10 to 2000 to 10 Hz
- d. Sweep Time and Duration – 20 minutes per cycle, 4 hours along each of three orthogonal axes (12 hours total)
- e. Mounting – rigidly mount assemblies
- f. No Discontinuities of greater than 10 nano-seconds

8.7 Mechanical Shock – EIA 364-27

- a. Condition I (50G, 11 millisecond half sine wave)
- b. Shocks – 3 shocks in both directions along each of three orthogonal axes (18 total)
- c. Mounting – rigidly mount assemblies
- d. No discontinuities of greater than 10 nano-seconds



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8.8 Durability – Standard laboratory procedure as applicable to the specific product

- a. Number of Cycles – 200
- b. Cycling rate – 5 inches per minute

8.9 Solderability – ANSI-J-002, Test Condition A

- a. Steam aging – 4 hours
- b. Pcb termination area was evaluated and meets the requirements of ANSI-J-002.

8.10 Resistance to Solder Heat – EIA 364-56

- a. Test Condition – E
- b. There shall be no evidence of physical or mechanical damage.

8.11 Operating temperature – -20 ° C to 105 ° C

## 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 ISO 9000

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

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9.3 Sample Quality and Description

R/A Header P/N 51720, Vertical Receptacle P/N 51740 and R/A Receptacle P/N 51760

P/N For lead free test, use 517*0 - *****LF	Type	1	2	3	4	5	6	7	8	9	10	11	12	13	14
51720-11008410AA__	Ass'y	6	3	O	6	6	3	3	O	6	2	3	3	0	0
51740-11008410AA__	Ass'y	0	3	M	0	0	0	0	M	0	0	0	0	0	0
51740-11008410CC__	Ass'y	3	0	I	3	3	0	3	I	3	0	0	0	9	0
51760-11008410AA__	Ass'y	3	0	T	3	3	3	0	T	3	2	3	3	0	12
SK-44146-002	PCB	0	0	T	0	0	0	0	T	0	0	0	0	0	0
SK-44147-002	PCB	0	0	E	0	0	0	0	E	0	0	0	0	9	0
SK-44148-002	PCB	0	0	D	0	0	0	0	D	0	0	0	0	0	0
SK-44146-012	PCB	6	3		6	0	3	3		6	0	0	0	0	0
SK-44147-012	PCB	3	3		3	0	0	3		3	0	0	0	9	0
SK-44148-012	PCB	3	0		3	0	3	0		3	0	0	0	0	0

Vertical Header P/N 51700, R/A Receptacle Press Fit P/N 51866 and Vertical Receptacle P/N 51740 (mated to 51700 for qualification testing)

P/N For lead free test, use 517*0 - *****LF	Type	1	2	3	4	5	6	7	8	9	11	12	13	14
51546-001021__	contact			O		O			O		O		12	
51700-11008410AA__	Ass'y		3	M		M	3		M	4	M	3		
51700-11008410CC__	Ass'y	3		I	3	I		6	I		4	I		
SK-44145-002 (2 oz)	PCB			T		T			T	2	2	T		
SK-44145-012 (5 oz)	PCB	3	3	E	3	E	3	6	E	2	2	E		1
51866-002__	Ass'y	3	3	D	3	D			D	4		D		
51740-1108410AA__	Ass'y						3	6			4			
SK-44148-002 (2 oz)	PCB									2				
SK-44148-012 (5 oz)	PCB	3	3							2				
SK-44147-002 (2 oz)	PCB										2			
SK-44147-012 (5 oz)	PCB						3	6			2			

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9.4 Acceptance

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

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


9.5 Qualification Testing

Qualification testing shall be performed on sample units predicted with equipment and procedures normally used in production. Test sequence is as shown in Table 1.

9.6 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 1.

- a. A significant design change is made to the existing product that impacts the product form, fit or function. Examples 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.
- b. A significant event occurs during production or end use requiring corrective action to be taken relative to the product design or manufacturing process.
- c. A significant change is made to the manufacturing process that impacts the product form, fit or function.

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**Test Sequence Table 1**

Test	PAR	Test Group													
		1	2	3	4	5	6	7	8	9	10	11	12	13	14
<b>Examination of Product</b>	5.5	<b>Test Sequence</b>													
		1 20	1 12	O M	1 8	1 8	1 3	1 8	O M	1 3	1 3	1 1	1 3	1 13	1 3
<b>Contact Resistance Low Level</b>	6.1	3 6 9 14 17	3 6 10	I T T E D	2 6			2 6	I T T E D					3 6 9	
<b>Contact Resistance At specified current</b>	6.2	4 7 10 15 18	4 7 11		3 7			3 7							
<b>Insulation Resistance</b>	6.3					2 6									
<b>Dielectric Withstanding Voltage</b>	6.4					3 7									
<b>Current Rating</b>	6.5									2					
<b>Mating/Unmating Force</b>	7.1	2 11 13 19	2 8												
<b>Normal Force</b>	7.2						2								
<b>Contact Insertion/ Retention</b>	7.3											2			
<b>Individual Pin Insertion (new pin for each insertion)</b>	7.4													2 5 8	
<b>Individual Pin Retention</b>	7.4													4 7 10	
<b>PCB Hole Deformation Radius</b>	7.5													11	
<b>PCB Hole Wall Damage</b>	7.6													12	
<b>Board Lock Retention</b>	7.7														2
<b>Thermal Shock</b>	8.1					4									
<b>Humidity, Steady State</b>	8.2					5									
<b>Hi Temperature Life</b>	8.3							5							
<b>Environmental Sequence Phase I</b>	8.4	5													
<b>Phase II</b>		8													
<b>Phase III</b>		16													
<b>Ind. Mixed Flowing Gas</b>	8.5		9												
<b>Vibration</b>	8.6				4										
<b>Mechanical Shock</b>	8.7				5										
<b>Durability</b>	8.8	12	5					4							
<b>Solderability</b>	8.9										2				
<b>Res. To Soldering Heat</b>	8.10											2			

**Report DL-2011-06-033D CR**

PwrBlade® Connector Receptacle Signal Contact Redesign Qualification Testing  
GXT Plated Receptacle Mated with GXT Plated Header  
08 May, 2012

**PURPOSE**

Qualification testing was performed on GXT plated PwrBlade® connectors, whose Receptacle signal contact was redesigned, to assess the conformance to FCI product specification GS-12-149, (Rev. U, Jun 2<sup>nd</sup> 2010). Testing was performed, and result reported, under Laboratory Test number DL-2011-06-033.

**CONCLUSIONS**

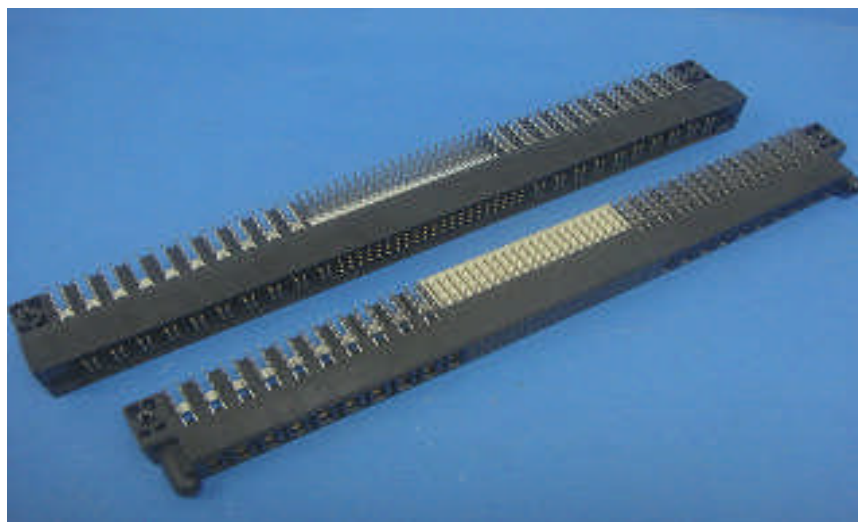
The tested results showed that the redesigned PwrBlade® connector met the requirements of FCI product specification GS-12-149U. The test results in this report relate only to the items tested.

**SAMPLE DESCRIPTION**

Samples submitted consisted of 51720 series STB (solder to board) R/A Header and 51760 series Press-fit R/A Receptacle. Prior to testing, the samples were examined at low magnification and judged to be acceptable for testing. The details of the submitted samples are given in Table 1 and illustrated in Figure 1.

**Table 1 Identity of Submitted Test Samples**

Item	Description	Part #	Lot #	Contact Plating
1	PwrBlade® RA Header Assemblies	51720-11008410AALF	DG	GXT
2	PwrBlade® RA Receptacle Assemblies	51760-11008410CALF	DG	GXT



**Figure1 Test sample- PwrBlade® R/A Header and Receptacle**

## REFERENCE DOCUMENT

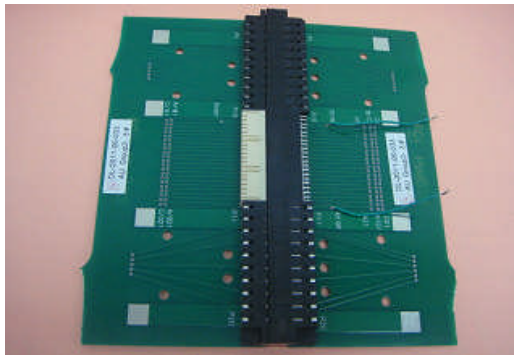
The requirements for product qualification are established by the product specifications with reference to a variety of test methods. FCI qualification and other pertinent documents are listed in Table 2.

**Table 2 Reference Documents**

Document ID	Title	Rev. Level (Date)
FCI GS-12-149	Product Specification, PwrBlade® Connector System	U (2010 Jun)
EIA/ECA-364-18	Visual and Dimensional Inspection Test Procedure for Electrical Connectors and Sockets	B (2007 Feb)
EIA/ECA-364-23	Low Level Contact Resistance Test Procedure for Electrical Connectors and Sockets	C (2006 Jun)
EIA/ECA-364-21	Insulation Resistance Test Procedure for Electrical Connectors, Sockets, and coaxial contacts	D (2008 Mar)
EIA-364-20	Dielectric Withstanding Voltage Test Procedure for Electrical Connector	D (2008 Mar)
EIA/ECA-364-70	Temperature Rise versus Current Test Procedure for Electrical Connectors and Sockets	B (2007 Jun)
EIA/ECA-364-13	Mating and Unmating force Test Procedure for Electrical Connectors and Sockets	D (2007 Jul)
EIA/ECA-364-29	Contact Retention Test Procedure for Electrical Connectors	C (2006 Aug)
EIA-364-96	Plating through Hole integrity Test Procedure for Electrical Connectors	(2002 Nov)
EIA-364-32	Thermal shock (Temperature Cycling) Test Procedure for Electrical Connectors and Sockets	E (2008 May)
EIA-364-31	Humidity Test Procedure for Electrical Connectors and Sockets	C (2008 Nov)
EIA-364-17	Temperature Life With or without Electrical Load Test Procedure for Electrical Connectors and Sockets	B (1999 Jun)
EIA-364-65	Mixed Flowing Test Procedure for Electrical Connectors and Sockets	B (2009 Dec)
EIA-364-28	Vibration Test Procedure for Electrical Connectors and Sockets	F (2011 Jan)
EIA-364-27	Mechanical Shock (Specified Pulse) Test Procedure for Electrical Connectors and Sockets	C (2011 Jun)
EIA-364-09	Durability Test Procedure for Electrical Connectors and Sockets	C (1999 Jun)
EIA-364-87	Nanosecond Event Detection Test Procedure for Electrical Connectors, Contacts and Sockets	A(2009 May)
IPC/ECA J-STD-002	Solderability Test for Component Leads, Terminations, Lugs, Terminals and Wires	C ( Dec 2007 )

## TEST DESCRIPTIONS

Preparatory to testing, as needed, for Groups 1, 2, 4 & 7 the submitted header and receptacle connectors were mounted to 2oz thickness test printed wiring boards P/N SK-44146-002 and SK-44148-002 respectively for Low-Level contact resistance (LLCR) measuring and discontinuity monitoring. For Groups 9, connectors mounted onto 5oz thickness printed wiring boards P/N SK-44146-012 and SK-44148-012 respectively for current rating testing. All Header connectors were manually soldered onto PWBs and the Receptacle connectors were pressed into PWBs by machine. These test boards had circuitry to provide series connection through all signal terminals. Figure 2 shows an example of a test sample consisting of a mated pair of connectors mounted on test boards.



**Figure 2 Test sample Consisting of a Mate Pair of PwrBlade® Connectors Mounted on Test Boards**

Each mating pair of test connectors was assigned a sample number. Samples were labeled with the FCI “DL” test number, followed by test group number, and a sequential individual sample designation.

Testing was conducted in accordance with FCI product specification GS-12-149, Rev. U (Jun 2<sup>nd</sup> 2010) with some amendments to test sequence. Group1, 2, 4, 5, 7, 9, 10, 12&13, total nine (9) groups were performed for GXT to GXT plating. Contact resistance test for Power contact was omitted from all test sequence since the purpose of the testing was to evaluate the performance of Signal contacts only. The test sequences are given in Table 3.

**Table 3 Sequence of Applied Tests by Test Group**

Test	PAR	Test Group								
		1	2	4	5	7	9	10	12	13
Visual examination	5.5	1,15	1,9	1,7	1,8	1,6	1,3	1,3	1,3	1,13
LLCR	6.1	3,5,7,11,13	3,5,7	2,4,6		2,5				3,6,9
IR	6.3				2,6					
DWV	6.4				3,7					
Current Rating	6.5						2			
Mating/un-mating force	7.1	2,8,10,14	2,8							
Contact insertion/retention	7.3							2		
Individual pin insertion (new pin for each insertion)	7.4									2,5,8
Individual pin retention	7.4									4,7,10
PCB Hole Deformation Radius	7.5									11
PCB Hole Damage	7.6									12
Thermal shock	8.1				4					
Humidity	8.2				5					
High temp life	8.3					4				
Environment sequence	Phase I	8.4	4							
	Phase II	8.4	6							
	Phase III	8.4	12							
MFG	8.5		6							
Vibration	8.6			3						
Mechanical shock	8.7			5						
Durability	8.8	9	4			3				
Solderability	8.9							2		

Note: the numbers in the table indicate the sequence in which the tests were performed.

- LLCR = Low Level Contact Resistance
- DWV = Dielectric Withstanding Voltage
- MFG = Industrial Mixed Flowing Gas
- IR = Insulation Resistance
- Temp = Temperature

**TEST METHODS/REQUIREMENTS**

**Table 4 Test Requirements**

Test Items	Clause	Test method	Condition	Requirement
Examination of product	5.5	EIA-364-18B	10x magnification	No detrimental condition
LLCR	6.1	EIA-364-23C	20mV,100mA	LLCR $\leq 20m\Omega$ EON LLCR $\leq 1m\Omega$ <sup>1</sup>
IR	6.3	EIA-364-21D	500V DC,2 minute	$\geq 500M\Omega$
DWV	6.4	EIA-364-20D	1000V DC,60s	No arcing, leakage current $\leq 1mA$
Current Rating	6.5	EIA-364-70B	Method 2, 30°C $\Delta T$	Powered all signal: $\geq 1A$ powered one signal: $\geq 3A$
Mating/ un-mating force	7.1	EIA-364-13D	1 inch/min	Mating force $\leq 22.5kgf$ Un-mating force $\geq 6.06kgf$ <sup>2</sup>
Contact insertion/retention	7.3	EIA-364-29C <sup>3</sup>	Method A, 0.5 inch/min , 30 contacts	Signal Receptacle: $\geq 3lb$
Individual pin insertion (new pin for each insertion)	7.4	GS-12-149§7.4	0.2 inch/min	$\leq 6lb$
Individual pin retention	7.4	GS-12-149§7.4	0.2 inch/min	$\geq 1.5lb$
PCB Hole Deformation Radius	7.5	EIA-364-96 GS-12-149§7.5	0.010" from PCB surface center of press-fit	0.0015" max avg. 0.002" max individual
PCB Hole Damage	7.6	EIA-364-96 GS-12-149§7.6	Center of press-fit	0.0003" min Cu thickness & No damage
Thermal shock	8.1	EIA-364-32E	-20~80°C, 36cycles	No damage
Humidity	8.2	EIA-364-31C	Method II Condition A 40°C, 95%RH, 96hours	No damage
High temp life	8.3	EIA-364-17B	Method A, condition 4, 105°C, 21days	No damage
Phase I (thermal shock)	8.4	EIA-364-32E	-20~80°C, 36cycles	No damage
Phase II (Humidity)	8.4	EIA-364-31C	Method II Condition B 40°C, 95%RH, 10days	No damage
Phase III (High Temp life )	8.4	EIA-364-17B	Method A, condition 4, 105°C, 21days	No damage
MFG	8.5	EIA-364-65B	Class IIA, 20days mated	No damage
Vibration	8.6	EIA-364-28F	Condition III, 10 to 2000 to 10Hz, 4 hours per axes.	No discontinuities >10ns
Mechanical shock	8.7	EIA-364-27C	Condition A <sup>4</sup> , 50G 11ms half-sine	No discontinuities >10ns
Durability	8.8	EIA-364-09C	200cycles, 5inch/min	No damage
Solderability	8.9	J-STD-002C <sup>5</sup>	Condition A1, 4 hours steam aging	Wet solder coverage $\geq 95\%$

<sup>1</sup> The requirement of EON LLCR referred to GR-1217-CORE.

<sup>2</sup> Mating force: 25oz\*20 power pin+3.5oz\*84 signal pin=794.00 oz=22.5kgf  
Unmating force: 8oz\*20 power pin+0.64oz\*84 signal pin=213.76 oz=6.06kgf

<sup>3</sup> EIA-364-29C was used instead of MIL-STD-1344 since the MIL-STD-1344 had been superseded by EIA-364 series standard.

<sup>4</sup> Condition A was used instead of Condition I since the requirement specified in GS-12-149U was 50G 11ms half sine wave.

<sup>5</sup> J-STD-002C test condition A1 was used instead of ANSI-J-002 test condition A.



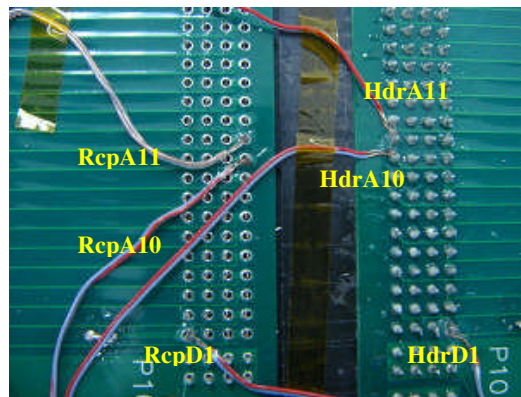
**Examination of Product(s)** - Samples were visually examined at 10X magnification, initially, to verify suitability for testing, and after testing, for any evidence of visual defects.

**LLCR-** Low Level Contact Resistance at the specified test current of 100mA Max and test voltage of 20mV Max open circuit were measured across the mated signal contacts in accordance with EIA-364-23C and GS-12-149U, section 6.1. The PWB circuitry provides a series circuit through all signal contacts.

**IR-** Insulation Resistance was tested between pairs of adjacent signal contacts on mated connectors (not mounted on PWBs) at the specified test voltage of 500V DC level, which was applied for 2 minutes. Testing was in accordance with EIA-364-21D and GS-12-149U, section 6.3. Eight pairs of adjacent signal contacts were tested.

**DWV-** Dielectric Withstanding Voltage was tested between pairs of adjacent signal contacts on mated connectors (not mounted on PWBs). Connections were made using test clips attached to opposite solder tail of the mated terminals (i.e., one connection on the header side and one connection on the receptacle side). Testing was conducted in accordance with EIA-364-20D and GS-12-149U, section 6.4. The potential was increased from zero at a rate (500v/s) to the specified 1000VDC level, which was applied for 60 second. Eight pairs of adjacent signal contacts were tested.

**Current Rating-** Current rating at the specified test temperature rise of 30°C above ambient was measured on three mated connectors in accordance with EIA-364-70B and GS-12-149U, sec 6.5. All signal contacts were energized simultaneously with sufficient current to produce a temperature 30°C higher than ambient. Thermocouples were attached (by thermally conductive adhesive) to the signal pin solder tail of 6 contacts (A10&11 and D1 of header and receptacle). The thermocouples were attached as shown in Figure 3. The current rating was taken as the minimum current required to attaining the specified temperature at any position in all tested connectors. Measurements were taken after warm-up of applied current, at a duration of activation deemed adequate for stabilization of measured resistance.



**Figure 3 Photo of Thermocouples location**

**Mating / Unmating Force-** Mating and unmating force were measured in accordance with EIA-364-13D and GS-12-149U Sec.7.1. The test samples were axially aligned to accomplish the mating and unmating function allowing for self-centering movement. Mating and un-mating of the connectors proceeded automatically with a crosshead speed set at 1 in/min. Forces were measured initially or after mechanical cycling or environmental exposure as required by the product specification.

**Contact Retention Force-** Contact retention was tested in accordance with EIA-364-29C and GS-12-149U Sec.7.3. The operation speed is 0.5 in/min. Thirty (30) of Receptacle signal contacts were tested.

**Individual Pin Insertion/ Retention force-** Individual pin insertion and retention of press-fit connectors was performed in accordance with GS-12-149U Sec.7.4. Individual pins (one at a time for signal terminal) were aligned to accomplish the insertion and extractions (three cycles) with pre-centering prior to test. Insertion and extraction of the pins proceeded automatically with crosshead speed set at 0.2 in/min, while forces were measured. Each insertion/ extraction was performed with virgin pins. The same PCB was used for all cycles. The press fit terminals were tested in each of two (2) PTH sizes (minimum and maximum) respectively.

**PCB hole Deformation Radius-** Hole Deformation was performed in accordance with EIA-364-96 and GS-12-149U Sec.7.5. Boards with minimum and maximum diameter holes, post-insertion and –retention testing were cross-sectioned parallel to the board surface, photographed and measured. Insertion / extraction cycles were performed on additional boards to provide the required number of samples. Holes deformation radius (10 holes total) was measured at .010” from the surface, and at the center of compliant pin section. Copper thickness between the compliant section and printed wiring board laminate was photographed and measured.

**PCB Hole Damage-** Hole wall damage was inspected in accordance with EIA-364-96 and GS-12-149U Sec.7.6. Boards with minimum and maximum diameter holes, post-insertion and –retention testing were cross-sectioned perpendicular to the board surface and through the compliant section wear track. Insertion / extraction cycles were performed on additional boards to provide the required number of samples.

**Thermal Shock/ Phase I (thermal shock)-**The Mated connectors were subjected to 36cycles of thermal extremes of -20°C and 80°C in accordance with EIA-364-32E and GS-12-149U Sec.8.1& 8.4. Dwell time was 30 minutes at each temperature. No electrical monitoring was performed during the exposure.

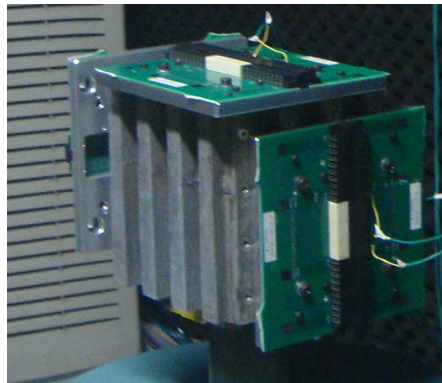
**Humidity/ Phase II (Humidity)-**The Mated connectors were subjected to humidity and temperature treatment in accordance with EIA-364-31C, Method II with temperature held to 40°C at 95% relative humidity (RH). The test duration differed for different test sequences (groups). Humidity (Group 5) consisted of 96 hours and Phase II (Group 1) consisted of 240 hours (10 days). The samples were not energized or monitored electrically during the exposure.

**High Temperature Life/ Phase III (High Temperature Life) -** The mated connectors were exposed an elevated temperature in accordance with GS-12-149U Sec.8.3 & 8.4 requirements and EIA-364-17B, method A (without electrical load), condition 4 (105°C±2°C). Exposure consisted of 21 days. No electrical monitoring was performed during the exposure.

**MFG (Corrosion Resistance) -** Corrosion resistance was tested by exposure to mixed flowing gas in accordance with EIA-364-65B, Class IIA. This test consisted of target environments of 27 to 32°C and near 70% relative humidity with four corrosive gases. Gases included chlorine (Cl<sub>2</sub>), nitric oxide (NO<sub>2</sub>), hydrogen sulfide (H<sub>2</sub>S), and sulfur dioxide (SO<sub>2</sub>) in nominal concentrations of 10, 200, 10, and 100 ppb, respectively. The exposure was specified to be a total of 20 days. Samples were exposed in mated conditions for the treatment.

**Vibration-**The mated test samples were subjected to vibration in accordance with GS-12-149U sec.8.6.and EIA-364-28F, Condition III with test duration of 4 hours per axis. The samples were mounted on rigid support fixtures to remove inertial effects of PWBs. Vibration was limited to a peak acceleration of 15 G (acceleration of gravity) at frequencies of 10Hz to 2000Hz. The samples were subjected to vibration along each of three axes for 12 \*20-minute cycles totaling four hours in ambient condition. The samples were monitoring during the exposure for all signal contacts. The samples were fixtured as shown in Figure 4. On each connector, all signal contacts were monitored on a series circuit.

**Mechanical Shock-**The Mated connectors were subjected to mechanical shock in accordance with GS-12-149U sec.8.7.and EIA-364-27C, Condition A [1/2 sine, 50G (±2.5) acceleration, 11ms duration], Three shock pulses were applied in two directions along each of three axes. The samples were fixtured as shown in Figure 4. Discontinuity monitoring for signal contacts was performed during exposure. On each connector, all signal contacts were monitored on a series circuit.



**Figure 4 PwrBlade Sample Fixturing for Shock and Vibration testing**

**Durability-** Durability cycling of the connectors was performed in accordance with EIA-364-09C and GS-12-149U Sec.8.8. The test samples were axially aligned to accomplish the mating and unmating function allowing for self-centering movement. Mating and unmating of the connectors proceeded automatically with a crosshead speed set at 5 in/min. The durability cycling consisted of 200 cycles of mating and unmating samples.

**Solderability-** Solderability exposure and evaluation was performed in accordance with IPC/ECA J-STD-002C and GS-12-149U Sec.8.9. The samples were exposed to four hours of steam age and evaluated for solder coverage.

**TEST RESULTS**

Table 5 through 13 given a summary of the results from testing for Groups 1, 2, 4, 5, 7, 9, 10, 12 & 13.

**Table 5 Summary of Test Result, Group 1**

Step	Test	Requirement	Step Description	Results	Comment
1	Examination of product	No detrimental condition	Initial	No detriment	Pass
2	Mating/un-mating force	Mating: ≤22.5kgf Un-mating: ≥6.06kgf	Initial	Mating: ≤10.64kgf Un-mating: ≥8.09kgf	Pass
3	LLCR	≤20mΩ	Initial LLCR	≤ 17.3mΩ	Pass
4	Phase I (thermal shock)	No damage	Thermal shock	No damage	Pass
5	LLCR	≤20mΩ	After thermal shock	≤ 17.9mΩ	Pass
6	Phase II (Humidity )	No damage	Humidity	No damage	Pass
7	LLCR	≤20mΩ	After humidity	≤ 16.9mΩ	Pass
8	Mating/un-mating force	Mating: ≤22.5kgf Un-mating: ≥6.06kgf	After humidity	Mating: ≤ 9.29kgf Un-mating: ≥ 7.06kgf	Pass
9	Durability	No damage	Durability	No damage	Pass
10	Mating/un-mating force	Mating: ≤22.5kgf Un-mating: ≥6.06kgf	After durability	Mating: ≤ 10.88kgf Un-mating: ≥ 8.45kgf	Pass
11	LLCR	≤20mΩ	After durability	≤ 17.4mΩ	Pass
12	Phase III (High Temp life )	No damage	High temp life	No damage	Pass
13	LLCR	≤20mΩ	Final (After high temp life)	≤ 17.7mΩ	Pass
14	Mating/un-mating force	Mating: ≤22.5kgf Un-mating: ≥6.06kgf	Final (After high temp life)	Mating: ≤ 9.06kgf Un-mating: ≥ 8.48kgf	Pass
15	Examination of product	No detrimental condition	Final	No degradation	Pass

**Table 6 Summary of Test Result, Group 2**

Step	Test	Requirement	Step Description	Results	Comment
1	Examination of product	No detrimental condition	Initial	No detriment	Pass
2	Mating/ un-mating force	Mating: $\leq 22.5\text{kgf}$ Un-mating: $\geq 6.06\text{kgf}$	Initial	Mating: $\leq 11.14\text{kgf}$ Un-mating: $\geq 8.15\text{kgf}$	Pass
3	LLCR	$\leq 20\text{m}\Omega$	Initial	$\leq 18.5\text{m}\Omega$	Pass
4	Durability	No damage	Durability	No damage	Pass
5	LLCR	$\leq 20\text{m}\Omega$	After durability	$\leq 17.3\text{m}\Omega$	Pass
6	MFG	No damage	20 days MFG	No damage	Pass
7	LLCR	$\leq 20\text{m}\Omega$	After 20d MFG	$\leq 17.7\text{m}\Omega$	Pass
8	Mating/ un-mating force	Mating: $\leq 22.5\text{kgf}$ Un-mating: $\geq 6.06\text{kgf}$	Final (After MFG)	Mating: $\leq 10.26\text{kgf}$ Un-mating: $\geq 6.9\text{kgf}$	Pass
9	Examination of product	No detrimental condition	Final	No degradation	Pass

**Table 7 Summary of Test Result, Group 4**

Step	Test	Requirement	Step Description	Results	Comment
1	Examination of product	No detrimental condition	Initial	No detriment	Pass
2	LLCR	$\leq 20\text{m}\Omega$	Initial	$\leq 17.2\text{m}\Omega$	Pass
3	Vibration	No discontinuities >10ns	Vibration	No discontinuities >10ns	Pass
4	LLCR	$\leq 20\text{m}\Omega$	After Vibration	$\leq 19.0\text{m}\Omega$	Pass
5	Mechanical shock	No discontinuities >10ns	Mechanical shock	No discontinuities >10ns	Pass
6	LLCR	$\leq 20\text{m}\Omega$	Final (After shock)	$\leq 19.9\text{m}\Omega$	Pass
7	Examination of product	No detrimental condition	Final	No degradation	Pass

**Table 8 Summary of Test Result, Group 5**

Step	Test	Requirement	Step Description	Results	Comment
1	Examination of product	No detrimental condition	Initial	No detriment	Pass
2	IR	$\geq 500\text{M}\Omega$	Initial IR	$\geq 35,600\text{M}\Omega$	Pass
3	DWV	No arcing, leakage current $\leq 1\text{mA}$	Initial DWV	No arcing, leakage current $< 1\text{mA}$	Pass
4	Thermal shock	No damage	Thermal shock	No damage	Pass
5	Humidity, Steady State	No damage	Humidity, Steady State	No damage	Pass
6	IR	$\geq 500\text{M}\Omega$	Final IR (After Humidity)	$\geq 927,000\text{M}\Omega$	Pass
7	DWV	No arcing, leakage current $\leq 1\text{mA}$	Final DWV (After Humidity)	No arcing, leakage current $< 1\text{mA}$	Pass
8	Examination of product	No detrimental condition	Final	No degradation	Pass

**Table 9 Summary of Test Result, Group 7**

Step	Test	Requirement	Step Description	Results	Comment
1	Examination of product	No detrimental condition	Initial	No detriment	Pass
2	LLCR	$\leq 20\text{m}\Omega$	Initial LLCR	$\leq 17.4\text{m}\Omega$	Pass
3	Durability	No damage	Durability	No damage	Pass
4	High temp life	No damage	High temp life	No damage	Pass
5	LLCR	$\leq 20\text{m}\Omega$	Final LLCR (After High Temp)	$\leq 16.7\text{m}\Omega$	Pass
6	Examination of product	No detrimental condition	Final	No degradation	Pass

**Table 10 Summary of Test Result, Group 9**

Step	Test	Requirement	Step Description	Results	Comment
1	Examination of product	No detrimental condition	Initial	No detriment	Pass
2	Current Rating	All signal: $\geq 1A$ One signal: $\geq 3A$	Current Rating	All signal: $\geq 1.71A$ One signal: $\geq 6.64A$	Pass
3	Examination of product	No detrimental condition	Final	No degradation	Pass

**Table 11 Summary of Test Result, Group 10**

Step	Test	Requirement	Step Description	Results	Comment
1	Examination of product	No detrimental condition	Initial	No detriment	Pass
2	Solderability	Wet solder coverage $\geq 95\%$	Solderability	Wet solder coverage $> 95\%$	Pass
3	Examination of product	No detrimental condition	Final	No degradation	Pass

**Table 12 Summary of Test Result, Group 12**

Step	Test	Requirement	Step Description	Results	Comment
1	Examination of product	No detrimental condition	Initial	No detriment	Pass
2	Contact insertion/retention	$\geq 3lb$	Contact insertion/retention	$\geq 3.54lb$	Pass
3	Examination of product	No detrimental condition	Final	N/A	N/A

**\*\*After contact retention force testing, some contacts have been pulled out. The visual examination is not applicable herein.**

**Table 13 Summary of Test Result, Group 13**

Step	Test	Requirement	Step Description	Results	Comment
1	Examination of product	No detrimental condition	Initial	No detriment	Pass
2	Individual pin insertion	≤6lb	1 <sup>st</sup> Insertion	≤4.269lb	Pass
3	LLCR	≤1mΩ	1 <sup>st</sup> LLCR	≤0.205mΩ	Pass
4	Individual pin retention	≥1.5lb	1 <sup>st</sup> Retention	≥1.996lb	Pass
5	Individual pin insertion	≤6lb	2 <sup>nd</sup> Insertion	≤3.778lb	Pass
6	LLCR	≤1mΩ	2 <sup>nd</sup> LLCR	≤0.206mΩ	Pass
7	Individual pin retention	≥1.5lb	2 <sup>nd</sup> Retention	≥1.67lb	Pass
8	Individual pin insertion	≤6lb	3 <sup>rd</sup> Insertion	≤3.626lb	Pass
9	LLCR	≤1mΩ	3 <sup>rd</sup> LLCR	≤0.231mΩ	Pass
10	Individual pin retention	≥1.5lb	3 <sup>rd</sup> Retention	≥1.703lb	Pass
11	PCB Hole Deformation Radius	<0.0015'' avg. <0.002'' individual	PCB Hole Deformation Radius	0.000727'' avg. ≤0.00188'' individual	Pass
12	PCB Hole Damage	>0.0003'' Cu thickness & No damage	PCB Hole Damage	≥0.00092'' Cu thickness & No damage	Pass
13	Examination of product	No detrimental condition	Final	No degradation	Pass

Statistical summaries of LLCR results are further summarized in the Appendix A.

Statistical summaries of mating/ Un-mating force results are further summarized in the Appendix B.

Statistical summaries of Group 9 Current Rating results are further summarized in the Appendix C.

Statistical summaries of Group 13 EON LLCR results are further summarized in the Appendix D.

Statistical summaries of Group 13 Individual pin insertion/retention force results are further summarized in the Appendix E.

**REVISION RECORD**

Revision Level	Affected Pages	Description	Revision Date
A	All	Original Release	08-May-2012



**Appendix A. Statistical Summary of Measured LLCR (Unit: m $\Omega$ )**

Table A1. Statistical Summary of LLCR, Group 1

Sample Count=252	Min	Max	Average	Stdev
Initial	5.7	17.3	11.3	3.5
After Thermal Shock	6.1	17.9	11.6	3.4
After Humidity	5.7	16.9	11.5	3.3
After Durability	5.7	17.4	11.5	3.4
After High temp life	6.1	17.7	12.0	3.4

Table A2. Statistical Summary of LLCR, Group 2

Sample Count=252	Min	Max	Average	Stdev
Initial	6.3	18.5	11.6	3.4
After Durability	5.9	17.3	11.2	3.4
After 20days MFG test	5.9	17.7	11.5	3.4

Table A3. Statistical Summary of LLCR, Group 4

Sample Count=252	Min	Max	Average	Stdev
Initial	6.1	17.2	11.6	3.3
After vibration test	5.4	19.0	11.6	3.5
After shock test	5.3	19.9	11.7	3.5

Table A4. Statistical Summary of LLCR, Group 7

Sample Count=252	Min	Max	Average	Stdev
Initial	6.3	17.4	11.5	3.3
After High temp life	5.7	16.7	11.6	3.4

**Appendix B. Statistical Summary of Measured Mating/ Unmating Force (Unit: N)**

Table B1. Statistical Summary of Mating/ un-mating force, Group 1

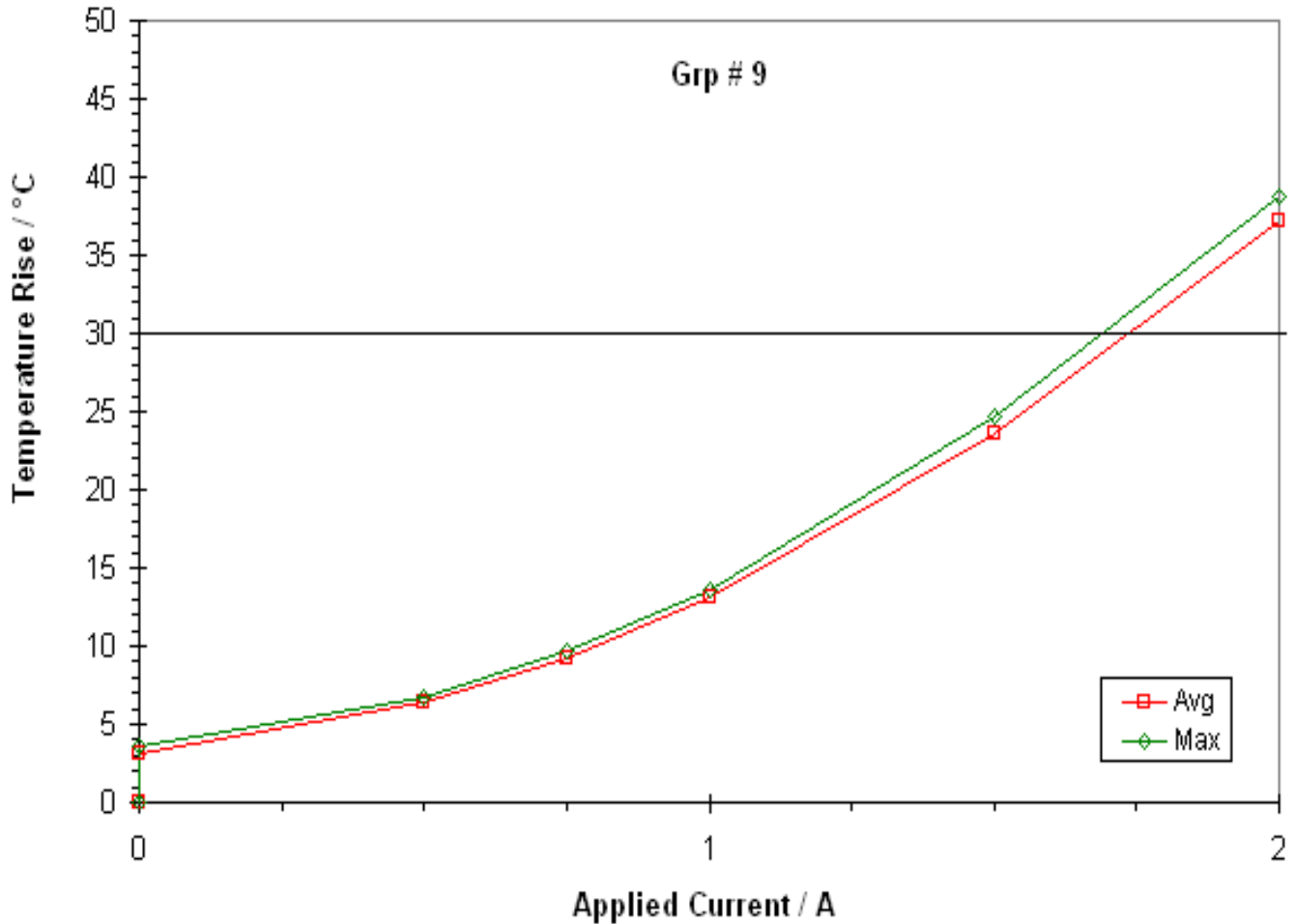
Sample Count=3		Min	Max	Average	Stdev
Initial	Mating force	9.70	10.64	10.11	0.48
	un-Mating force	8.09	10.00	9.07	0.96
After Humidity	Mating force	8.14	9.29	8.77	0.58
	un-Mating force	7.06	7.76	7.39	0.35
After Durability	Mating force	9.50	10.88	10.09	0.71
	un-Mating force	8.45	10.20	9.12	0.94
After High temp life	Mating force	8.74	9.06	8.90	0.16
	un-Mating force	8.48	8.56	8.53	0.04

Table B2. Statistical Summary of Mating/ un-mating force, Group 2

Sample Count=3		Min	Max	Average	Stdev
Initial	Mating force	9.74	11.14	10.41	0.70
	un-Mating force	8.15	9.63	9.13	0.85
After 20d MFG	Mating force	8.39	10.26	9.13	0.99
	un-Mating force	6.90	7.27	7.14	0.21

**Appendix C. Statistical Summary of Measured Current Rating- Group 9 (Unit: °C)**

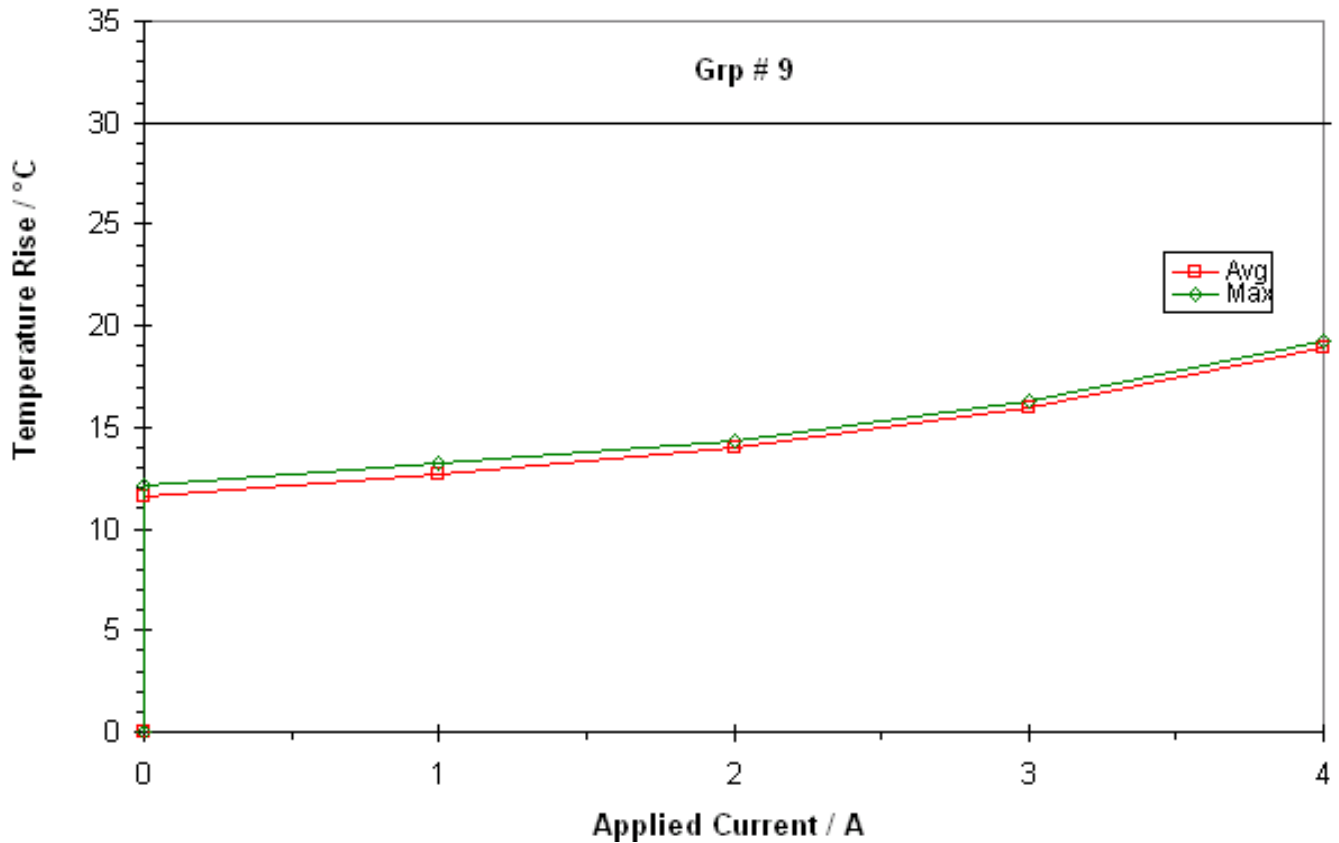
The 20 power contacts were energized at 30ADC, and all signal contacts were powered in series for current rating testing simultaneously						
Amp	0	0.5	0.75	1	1.5	2
1# HdrA11	3.128	6.445	9.293	13.250	23.862	37.924
1# HdrA10	3.120	6.358	9.234	13.049	23.469	37.249
1# RecA11	2.725	6.030	8.934	12.837	23.498	37.610
1# RecA10	3.122	6.515	9.374	13.208	23.654	37.492
2# HdrA11	2.907	5.969	9.133	13.149	24.002	37.663
2# HdrA10	3.325	6.423	9.528	13.552	24.689	38.761
2# RecA11	2.925	5.952	8.965	12.901	23.375	36.806
2# RecA10	3.166	6.217	9.088	12.847	22.777	34.469
3# HdrA10	3.360	6.275	9.118	12.954	23.223	36.668
3# RecA10	3.415	6.493	9.378	13.289	23.702	36.923
3# HdrA11	3.541	6.626	9.432	13.185	23.190	36.194
3# RecA11	3.602	6.688	9.650	13.614	24.462	38.566



Temperature rise of sample # 2 Hdr A10 reached 30°C when applied 1.71A Current.

The 20 power contacts were energized in series at 30ADC, and only signal contacts D1 was powered for current rating testing simultaneously

Amp	0	1	2	3	4
1# Hdr D1	12.17	13.182	14.337	16.285	19.012
1# Rec D1	11.852	12.93	14.015	15.85	18.488
2# Hdr D1	11.631	12.901	14.039	16.177	19.292
2# Rec D1	11.762	13.102	14.243	16.179	19.143
3# Hdr D1	11.376	12.475	13.915	15.962	19.094
3# Rec D1	10.848	11.809	13.271	15.231	18.232



Temperature rise of sample # 2 Hdr D1 reached 30°C when applied 6.64A Current.

**Appendix D. Statistical Summary of Group 13 Measured EON LLCR (Unit: m  $\Omega$ )**

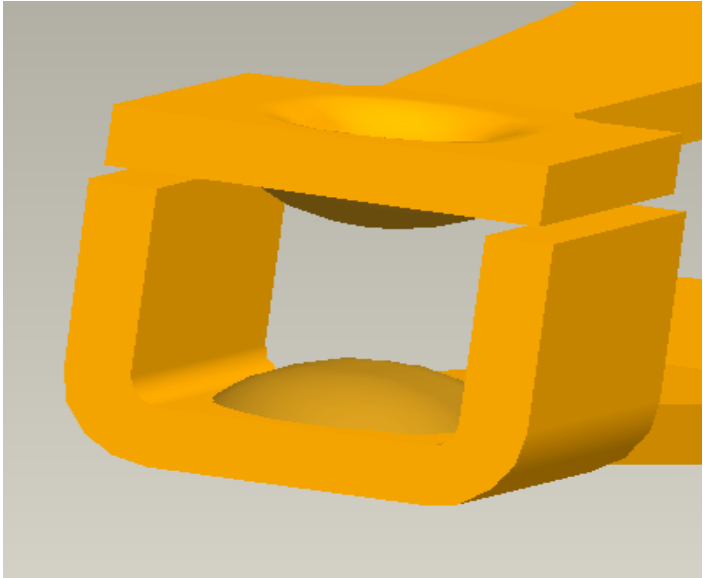
Sample Count=22		Min	Max	Average	Stdev
Min PTH	1 <sup>st</sup> LLCR	0.103	0.137	0.117	0.012
	2 <sup>nd</sup> LLCR	0.113	0.151	0.128	0.011
	3 <sup>rd</sup> LLCR	0.128	0.167	0.148	0.012
Max PTH	1 <sup>st</sup> LLCR	0.155	0.205	0.174	0.017
	2 <sup>nd</sup> LLCR	0.137	0.206	0.170	0.020
	3 <sup>rd</sup> LLCR	0.145	0.231	0.185	0.024

**Appendix E Statistical Summary of Group 13 Measured Individual pin insertion/retention force (Unit: lb)**

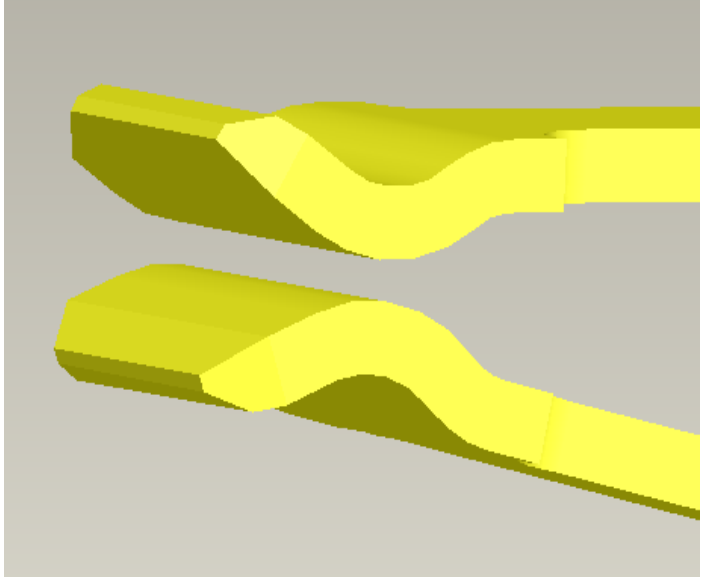
Sample Count=22			Min PTH				Max PTH			
			Min	Max	Average	Stdev	Min	Max	Average	Stdev
For LLCR	Insertion force	1 <sup>st</sup> time	3.584	4.269	3.765	0.200	2.132	3.118	2.632	0.373
		2 <sup>nd</sup> time	3.170	3.778	3.419	0.200	2.054	3.032	2.331	0.274
		3 <sup>rd</sup> time	3.025	3.626	3.413	0.194	1.793	2.606	2.124	0.255
	Retention force	1 <sup>st</sup> time	2.115	3.336	2.785	0.369	1.996	2.690	2.260	0.198
		2 <sup>nd</sup> time	2.658	3.448	3.167	0.255	1.670	2.349	2.060	0.258
		3 <sup>rd</sup> time	2.964	4.296	3.723	0.350	1.703	2.133	1.874	0.146

# PwrBlade Receptacle Signal Contact design change

Old Hertz Design



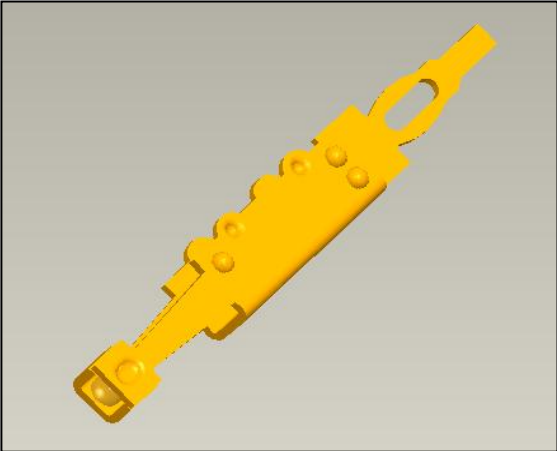
New Opposing Beams Design



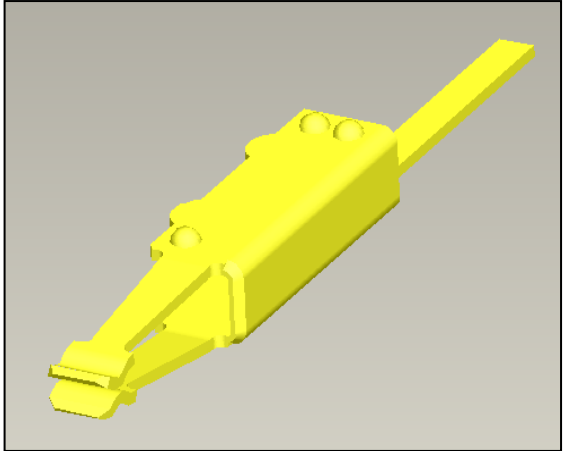
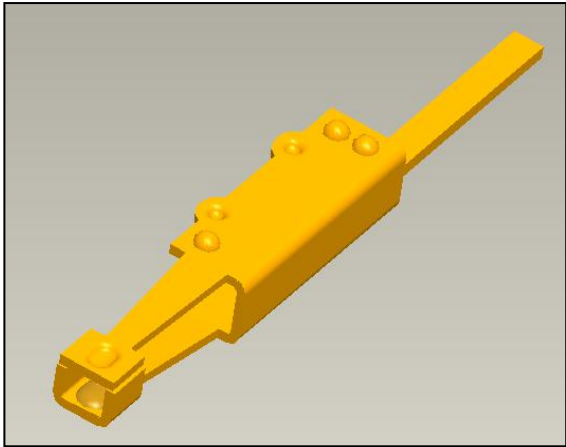
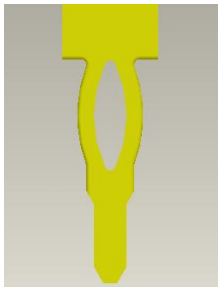
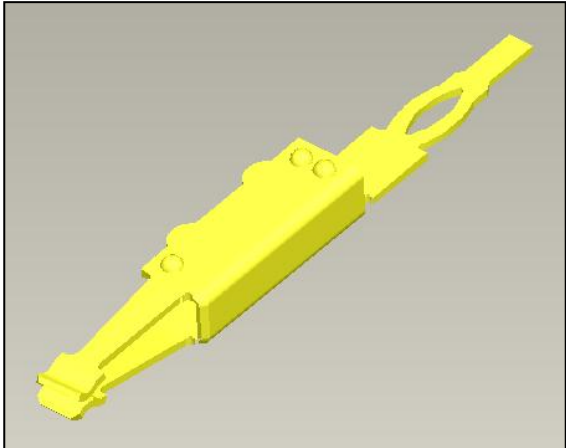
***Changing the contact functional design of signal contacts in the receptacle connectors from the Hertz design into new Opposing beams design with the purpose to better insure that the connectors mate optimally based on better positioning of the contacts***

# PwrBlade Receptacle Signal Contact Design change

Vtl Rec. Old Press Fit and STB



Vtl Rec. New Press fit and STB



RA Rec. Old Press Fit and STB

RA Rec. New Press fit and STB

