SPECIFICATION

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SPEC. NO.: PS-50281-XXXXX **REVISION:** G

PRODUCT NAME: 1.25mm PITCH WTB CONNECTOR SMT R/A TYPE

PRODUCT NO: 50281,50282,50283,50284,50285,50380, 88267,51288
88467,51378 Series

PREPARED:	CHECKED:	APPROVED:
SHI,YANAN	**BRAVE**	**BRAVE**
DATE: **2018/08/14**	DATE: **2018/08/14**	DATE: **2018/08/14**

1 REVISION HISTORY

Rev.	ECN #	Revision Description	Prepared	Date
O	ECN-0910018	NEW SPEC	JASON	2009/1/5
A	ECN-0906177	SALT SPRAY ADD 30U" GOLD TEST TIME	JASON	2009/6/25
B	ECN-0909088	ADD HAND SOLDERING	JASON	2009/9/15
B1	ECN-1103110	ADD CRIMPING	GAVIN	2011/03/23
C	ECN-1401172	ADD WORKING VOLTAGE	XUFEI	2014/01/09
D	ECN-1509133	ADD 51288 SERIES	XUBIN	2015/9/10
E	ECN-1603117	ADD 88467 SERIES	JUGG	2016/2/4
F	ECN-1802099	ADD51378 SERIES	Huang,Shun Sen	2018/02/08
L	ECN-1808261	UPDATE Salt Spray	SHIYANAN	2018/08/14

2 SCOPE

This specification covers performance, tests and quality requirements for 1.25mm pitch WTB connector.These connectors are this Product Spec. refer to Aces's P/N: 50281,50282,50283,50284,50285,50380, 88267,51288 ,88467,51378 Series

3 APPLICABLE DOCUMENTS

EIA-364: ELECTRONICS INDUSTRIES ASSOCIATION

4 REQUIREMENTS

4.1 Design and Construction

4.1.1 Product shall be of design, construction and physical dimensions specified on applicable product drawing.
4.1.2 All materials conform to R.o.H.S. and the standard depends on TQ-WI-140101.

4.2 Materials and Finish

4.2.1 Contact: High performance copper alloy.
Finish: (a) Contact Area: Refer to the drawing.
(b) Under plate: Refer to the drawing.
(c) Solder area: Refer to the drawing.
4.2.2 Housing: Thermoplastic or Thermoplastic High Temp., UL94V-0
4.2.3 Fitting Nail: Copper Alloy,
Finish: Refer to the drawing.

4.3 Ratings

4.3.1 Working voltage less than 36 volts (per pin)
4.3.2 Voltage: 200 Volts AC (per pin)
4.3.3 Current: AWG#28: 1.0 Amperes (per pin)
AWG#30: 1.0 Amperes (per pin)
AWG#32: 0.8 Amperes (per pin)
AWG#34: 0.5 Amperes (per pin)
4.3.4 Operating Temperature : -40℃ to +85℃

5 Performance

5.1. Test Requirements and Procedures Summary

Item	Requirement	Standard
Examination of Product	Product shall meet requirements of applicable product drawing and specification.	Visual, dimensional and functional per applicable quality inspection plan.
ELECTRICAL		
Item	**Requirement**	**Standard**
Low Level Contact Resistance	55 m Ω Max.(initial)per contact △R 20 m Ω Max.	Mate connectors, measure by dry circuit, 20mV Max., 100mA Max. (EIA-364-23)
Insulation Resistance	100 M Ω Min.	Unmated connectors, apply 500 V DC between adjacent terminals. (EIA-364-21)
Dielectric Withstanding Voltage	No discharge, flashover or breakdown. Current leakage: 1 mA max.	300V AC Min. at sea level for 1 minute. Test between adjacent contacts of unmated connectors. (EIA-364-20)
Temperature Rise	30℃ Max. Change allowed	Mate connector: measure the temperature rise at rated current until temperature stable. The ambient condition is still air at 25℃ (EIA-364-70,METHOD1,CONDITION1)
MECHANICAL		
Item	**Requirement**	**Standard**
Durability	50 cycles.	The sample should be mounted in the tester and fully mated and unmated the number of cycles specified at the rate of 25.4 ± 3mm/min.
Mating / Unmating Forces	Please see Item 8	Operation Speed： 25.4 ± 3 mm/minute.. Measure the force required to mate/unmate connector. (EIA-364-13)
Contact Retention Force (Board Side)	0.50 Kgf Min.	Operation Speed： 25.4 ± 3 mm/minute. Measure the contact retention force with tester.
Fitting Nail /Housing Retention Force	0.25 Kgf MIN.	Apply axial pull out force at the speed rate of 25.4 ± 3 mm/minute. On the fitting nail assembled in the housing.

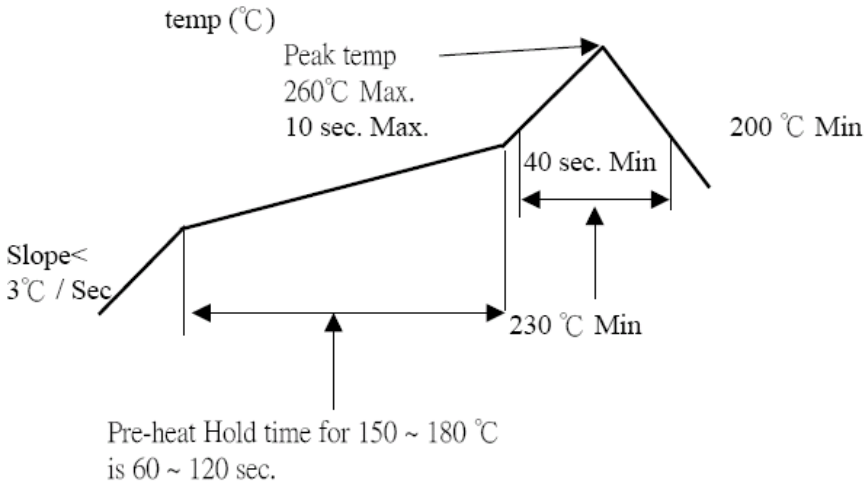
Crimping Terminal / Housing Retention Force (Cable Side)	0.50Kgf MIN.	Apply axial pull out force at the speed rate of 25.4 ± 3 mm/minute. On the terminal assembled in the housing.
Crimping Pull Out Force	AWG#28:1.0Kgf Min. AWG#30: 0.8Kgf Min. AWG#32: 0.5Kgf Min. AWG#34: 0.3Kgf Min.	Operation Speed： 25.4 ± 3 mm/minute. Fix the crimped terminal, apply axial pull out force on the wire.
Vibration	1 μs Max.	The electrical load condition shall be 100 mA maximum for all contacts. Subject to a simple harmonic motion having amplitude of 0.76mm (1.52mm maximum total excursion) in frequency between the limits of 10 and 55 Hz. The entire frequency range, from 10 to 55 Hz and return to 10 Hz, shall be traversed in approximately 1 minute. This motion shall be applied for 2 hours in each of three mutually perpendicular directions. (EIA-364-28 Condition I)
Shock (Mechanical)	1 μs Max.	Subject mated connectors to 50 G's (peak value) half-sine shock pulses of 11 milliseconds duration. Three shocks in each direction shall be applied along the three mutually perpendicular axes of the test specimen (18 shocks). The electrical load condition shall be 100mA maximum for all contacts. (EIA-364-27, test condition A)
ENVIRONMENTAL		
Item	**Requirement**	**Standard**
Resistance to **Reflow** Soldering Heat (Board Side)	See Product Qualification and Test Sequence Group 10 **(Lead Free)**	Pre Heat：150℃~180℃, 60~120sec. Heat：230℃ Min., 40sec Min. Peak Temp.：260℃Max, 10sec Max.
Thermal Shock	See Product Qualification and Test Sequence Group 4	Mate module and subject to follow condition for 5 cycles. 1 cycles: -55 +0/-3 ℃, 30 minutes +85 +3/-0 ℃, 30 minutes (EIA-364-32, test condition I)
Humidity	See Product Qualification and Test Sequence Group 4	Mated Connector 40℃, 90~95% RH, 96 hours. (EIA-364-31,Condition A, Method II)

Temperature Life	See Product Qualification and Test Sequence Group 5	Subject mated connectors to temperature life at 85℃ for 96 hours. (EIA-364-17, Test condition A)
Salt Spray (Only For Gold Plating)	See Product Qualification and Test Sequence Group 6	Subject mated/unmated connectors to 5% salt-solution concentration, 35℃ (I) Gold flash for 8 hours (II) Gold plating 3 u" for 48 hours. (II) Gold plating 5 u"(Min) for 96 hours. (EIA-364-26)
Solder ability (Board Side)	Tin plating: Solder able area shall have minimum of 95% solder coverage. Gold plating: Solder able area shall have minimum of 75% solder coverage	And then into solder bath, Temperature at 245 ±5℃, for 4-5 sec. (EIA-364-52)
Hand Soldering Temperature Resistance (Board Side)	Appearance: No damage	T≧350℃, 3sec at least.

Note. Flowing Mixed Gas shell be conduct by customer request.

6 INFRARED REFLOW CONDITION

TEMPERATURE CONDITION GRAPH
(TEMPERATURE ON BOARD PATTERN SIDE)



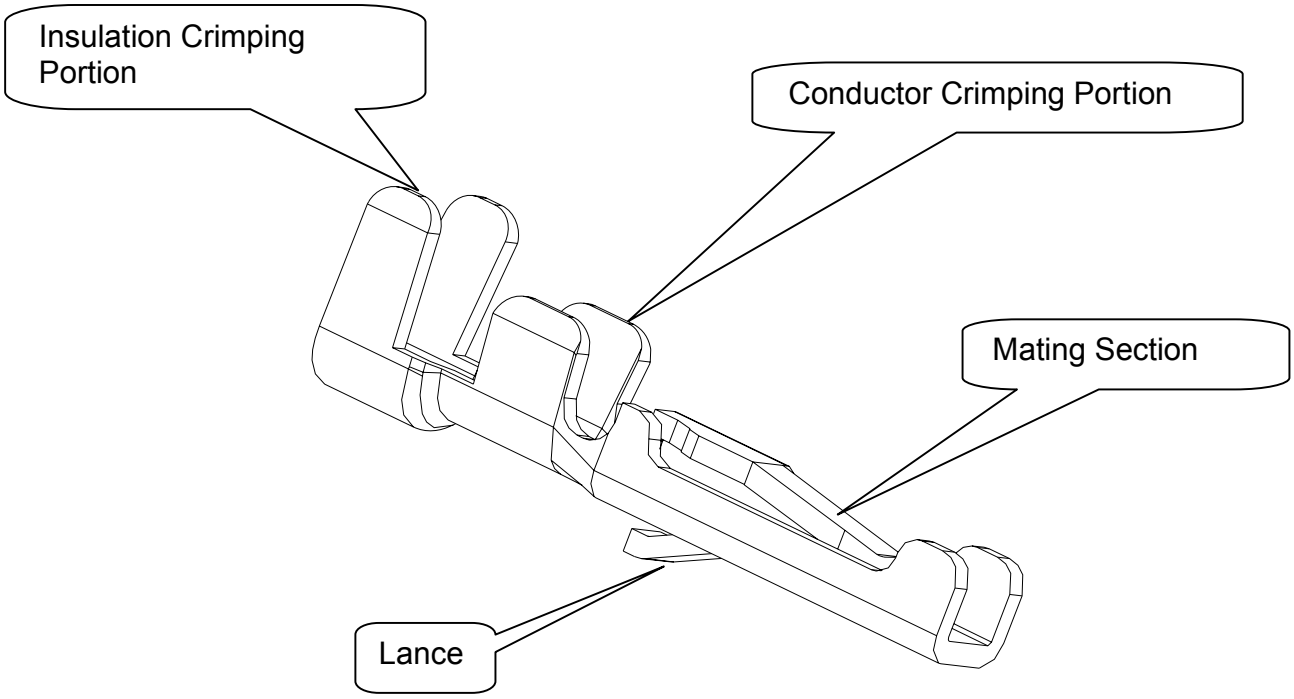
7 PRODUCT QUALIFICATION AND TEST SEQUENCE

Test or Examination	Test Group										
	1	2	3	4	5	6	7	8	9	10	11
	Test Sequence										
Examination of Product				1、7	1、6	1、4				1	1
Low Level Contact Resistance		1、5	1、4	2、10	2、9	2、5				3	
Insulation Resistance				3、9	3、8						
Dielectric Withstanding Voltage				4、8	4、7						
Temperature Rise	1										
Mating / Unmating Force		2、4									
Durability		3									
Contact Retention Force (Board Side)									3		
Vibration			2								
Shock (Mechanical)			3								
Thermal Shock				5							
Humidity				6							
Temperature Life					5						
Salt Spray(Only For Gold Plating)						3					
Solder ability							1				
Crimping Pull Out Force								1			
Crimping Terminal / Housing Retention Force (Cable Side)									1		
Fitting Nail /Housing Retention Force									2		
Resistance to Soldering Heat (Board Side)										2	
Hand Soldering Temperature Resistance (Board Side)											2
Sample Size	2	4	4	4	4	4	2	4	4	4	4

8 MATING / UNMATING FORCE

NO. Of Ckt.	Mating Force (Max.)	Un-Mating Force (Min.)
2	1.50Kgf [14.7N]	0.10Kgf [0.98N]
3	1.75Kgf [17.15N]	0.15Kgf [1.47N]
4	2.00Kgf [19.6N]	0.20Kgf [1.96N]
5	2.25Kgf [22.06N]	0.25Kgf [2.45N]
6	2.50Kgf [24.51N]	0.30Kgf [2.94N]
7	2.75Kgf [26.97N]	0.35Kgf [3.43N]
8	3.00Kgf [29.41N]	0.40Kgf [3.92N]
9	3.25Kgf [31.86N]	0.45Kgf [4.41N]
10	3.50Kgf [34.31N]	0.50Kgf [4.90N]
11	3.75Kgf [36.76N]	0.55Kgf [5.39N]
12	4.00Kgf [39.22N]	0.60Kgf [5.88N]
13	4.25Kgf [41.67N]	0.65Kgf [6.37N]
14	4.50Kgf [44.12N]	0.70Kgf [6.86N]
15	4.75Kgf [46.57N]	0.75Kgf [7.35N]
18	5.50Kgf [53.92N]	0.90Kgf [8.82N]
20	6.00Kgf [58.82N]	1.00Kgf [9.80N]
25	7.25Kgf [71.08N]	1.25Kgf [12.25N]
30	8.50Kgf [83.33N]	1.50Kgf [14.70N]

9 ANATOMY OF CRIMPING TERMINAL



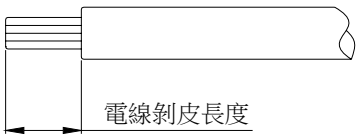
The crimping contact drawing is for reference only. May not be the same with this P/N.

10 APPLICABLE WIRES:

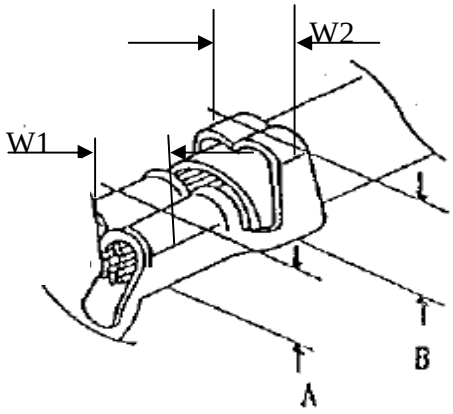
AWG Size:AWG#28 UL1571 Insulation OD: Φ0.80mm
AWG#30 UL3302 Insulation OD: Φ0.60mm
AWG#32 UL10064Insulation OD: Φ0.50mm
AWG#34 UL10064Insulation OD: Φ0.32mm

11 CRIMPING CONDITION

鉚線條件表 CRIMPING CONDITION							
Part Number	Wire Specification			Crimp Height (mm)		Crimp Width (mm)	
	UL Style (REF.)	AWG Size	Insulation OD(mm)	Conductor A	Insulation B	Conductor W1	Insulation W2
88267	UL1571	28	0.80	0.51~0.56	1.00~1.05	0.79~0.84	0.95MAX
	UL3302	30	0.60	0.50~0.55	0.90~0.95	0.80~0.85	0.95MAX
	UL10064	32	0.50	0.48~0.53	0.85~0.90	0.80~0.85	0.95MAX
88467	UL10064	34	0.32	0.35~0.70	0.70~0.80	0.90~0.95	0.95MAX



Strip length



Note:

1、W1為芯線導體鉚壓後之寬度(Conductor Crimping Width)：W1值如上表

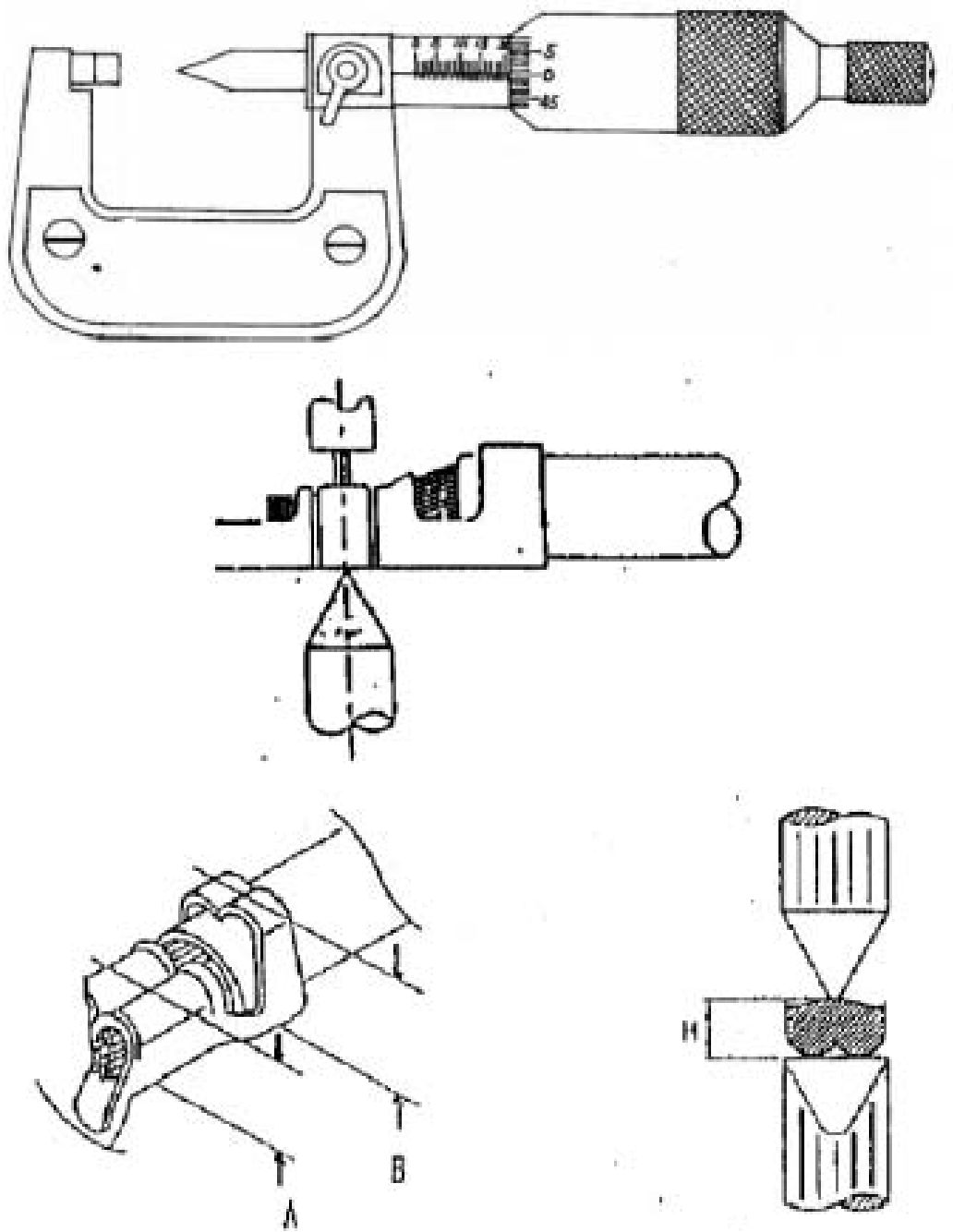
2、W2為電線外被部分鉚壓後之寬度(Insulation Crimping Width)：W2值如上表

3、A為芯線導體鉚壓後之高度(Conductor Crimping height)：A值如上表(參考值）

4、B為電線外被鉚壓後之高度(Insulation Crimping height)：B值如上表(參考值）

5、電線剝皮長度(Strip length)：1.5~1.9mm(參考值)

12 CRIMPING HEIGHT MEASUREMENT

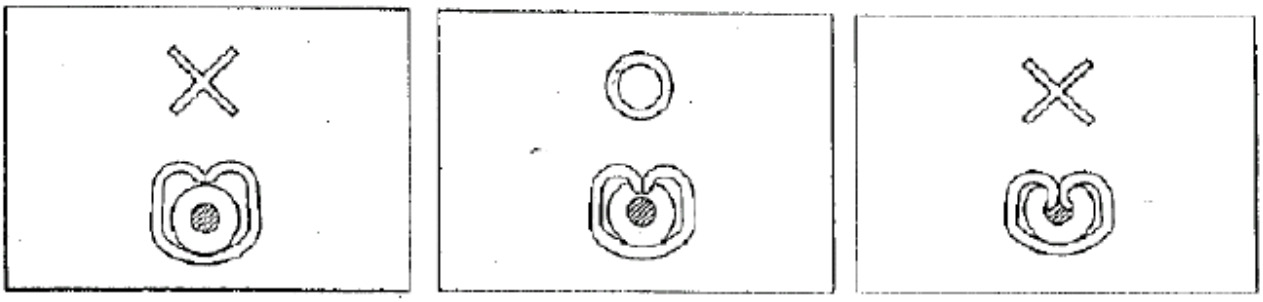


13 PULL FORCE OF CRIMPING SECTION MEASUREMENT

Before test samples, please measure crimp height and do not crimp insulation.

Pull Force of Crimp Section Measurement

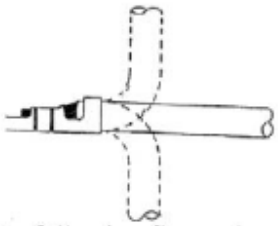
14 STANDARD INSULATION CRIMPING



Not enough crimp | Good | Crimp too much

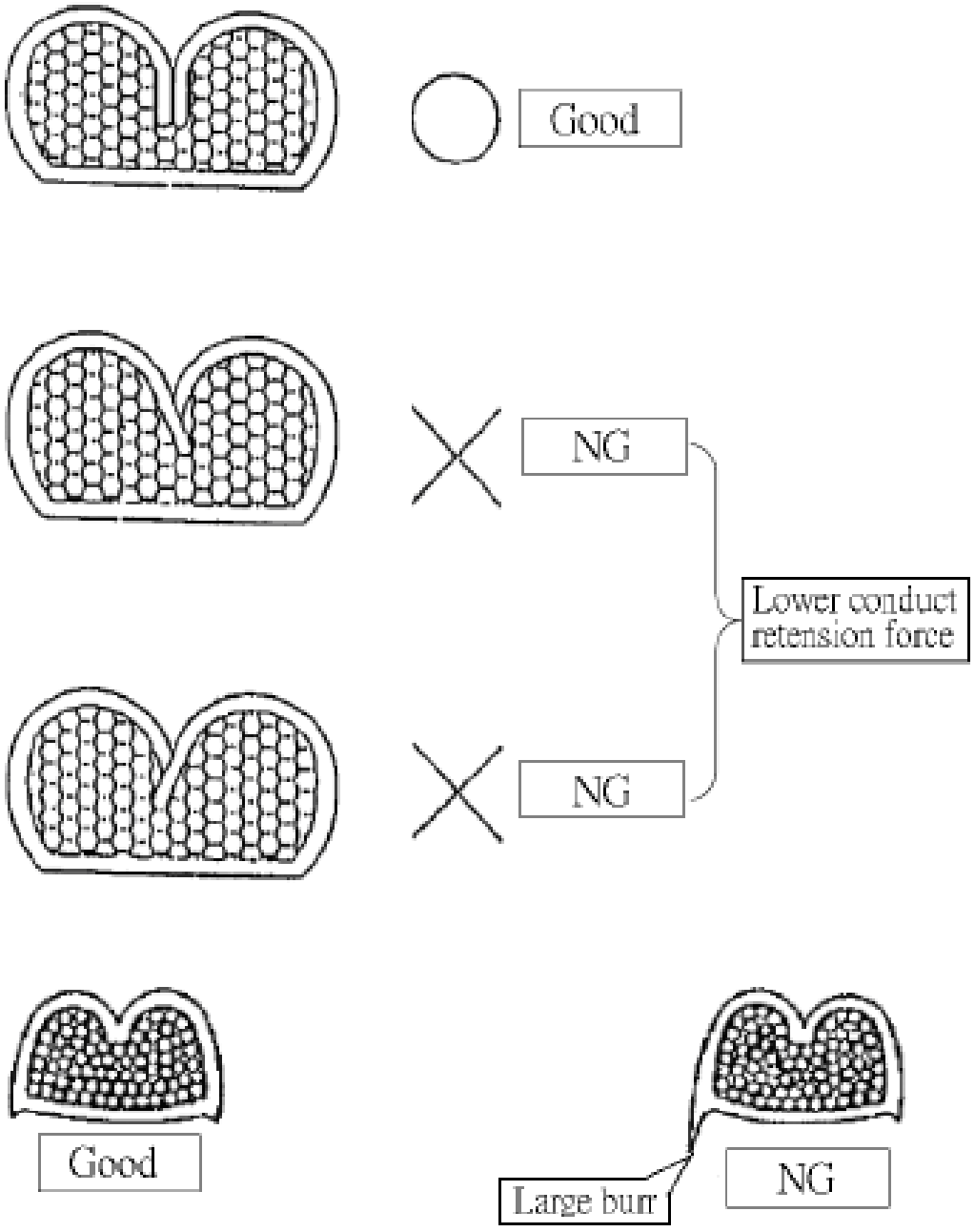
Good | NG

Insulation Crimp Condition

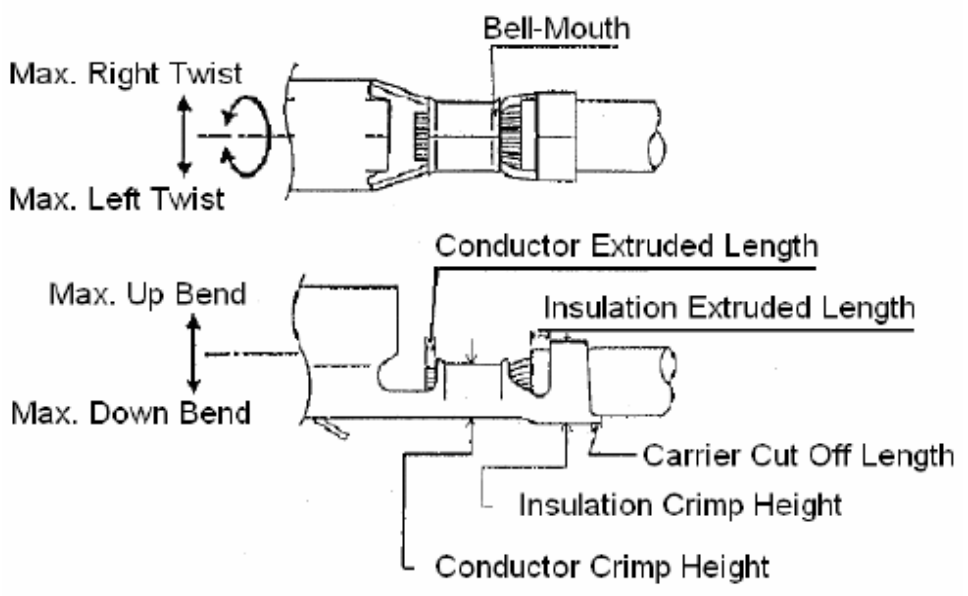


As following figure shown. It is no problem if wire bent up down 90 degrees 1 cycle and insulation position still in ideal position.

15 CONDUCTORS CRIMPING CONDITION


Good
NG
NG
Lower conduct retension force
Good
Large burr
NG

16 CRIMPING REQUIREMENT



Item	Range(Ref.)
Max. Up Bend	6°
Max. Down Bend	6°
Max. Left Twist	5°
Max. Right Twist	5°
Bell-Mouth Length	0~0.3mm
Carrier Cut Off Length	0~0.2mm
Conductor Extruded Length	0.1~0.3mm