



3.5mm/2.92mm/2.40mm/1.85mm Series
Printed Circuit Board Mounted Connectors

1 SCOPE

1.1 Content

This specification covers performance, tests and quality requirements for TE Connectivity (TE) 3.5mm series, 2.92mm series, 2.4mm series, 1.85mm series printed circuit board mounted connectors.

1.2 Qualification

When tests are performed on the subject product line, procedures specified in this Product Specification shall be used. All inspections shall be performed using applicable inspection plan and product drawing.

2 APPLICABLE DOCUMENTS

The following documents form a part of this specification to the extent specified herein. Unless otherwise specified, the latest edition of the document applies. In the event of conflict between the requirements of this specification and the product drawing or customer drawing, the product drawing or customer drawing shall take precedence. In the event of conflict between the requirements of this specification and the referenced documents, this specification shall take precedence.

2.1 TE Connectivity (TE) Documents

- 109-1: General Requirement for Test Specification.
- 109-197: Test Specification (TE Test Specification vs EIA and IEC Test Methods)
- 109 Series: Test Specifications as indicated in Table 1

2.2 Industry Document

- MIL-PRF-39012: Performance Specification for Radio Frequency Coaxial Connectors
- MIL-STD-348: Department of Defense Interface Standard
Radio Frequency Connector Interface for MIL-DTL-3643, MIL-DTL-3650,
MIL-DTL-3655, MIL-DTL-25516, MIL-PRF-31031, MIL-PRF-39012,
MIL-PRF-49142, MIL-PRF-55339, MIL-DTL-83517
- MIL-STD-202H: Test Method Standard Electronic and Electrical Component Parts
- IEC-169-23: Radio-frequency Connector-Part 23: Pin and socket connector for use with
3,5mm rigid precision coaxial lines with inner diameter of outer conductor
3,5 mm (0,1378 in)
- IEC 61169-35: Radio-frequency Connector-Part 35: Sectional specification for 2.92 Series RF
Connectors
- IEC 61169-40: Radio-frequency Connector-Part 40: Sectional specification for 2.4 Series RF
Connectors
- IEC 61169-32: Radio-frequency Connector-Part 32: RF coaxial connectors with inner diameter of
outer conductor 1.85mm (0.072in) with screw coupling – Characteristic impedance
50 ohms (type 1.85)
- IEC-364: Electrical Connector/Socket Test Procedures Including Environmental
Classifications
- 501-160051: Test Report

3 REQUIREMENTS

3.1 Design and Construction

Product shall be of the design, construction, materials and physical dimensions specified on the applicable product drawing.

3.2 Materials

Materials used in the construction of this product shall be as specified on the applicable product drawing.

3.3 Ratings

- Temperature Range: -45°C to +85 °C
- Nominal Impedance: 50 ohms

3.4 Performance and Test Description

Products is designed to meet the electrical, mechanical and environmental performance requirements specified in Table 1(See section 3.5). Unless otherwise specified, all tests shall be performed at ambient environmental conditions Test Specification 109-1.

3.5 Test Requirements and Procedures Summary (Table 1)

Test Description	Requirement	Procedure
Initial examination of product	Meets requirements of product drawing	EIA-364-18. Visual and dimensional (C of C) inspection per product drawing
Final examination of product	Meets visual requirements	EIA-364-18. Visual inspection
ELECTRICAL		
Contact Resistance	Center contact: ≤4 mΩ Outer Contact: ≤2.5 mΩ	EIA-364-23. Subject specimens to 100 milliamperes maximum and 20 millivolts maximum open circuit voltage. See Figure 3.
Insulation Resistance	≥1000 MΩ initial	EIA-364-21/ 500 volts DC, 2 minutes hold. Test between adjacent contacts;
Withstanding Voltage	750V rms	EIA-364-20, Condition I / Requested volts AC (rms) at sea level. One minute hold with no breakdown or flashover.
MECHANICAL		
Durability	500 cycles	EIA-364-9. Mate and unmate specimens for 500 cycles at a maximum rate of 600 cycles per hour.
ENVIRONMENTAL		
Corrosion Test/Salt Spray	5% spray for 96 hours,	MIL-STD-202, METH. 101, COND A

(End of table 1)

3.6 Product Qualification and Requalification Test Sequence (Table 2)

Test or Examination	Test Group (a)	
	1	2
Initial examination of product	1	1
Contact Resistance	2,6	2,6
Insulation Resistance	3	3,7
Withstanding Voltage	4	4,8
Durability	5	
Corrosion Test/Salt Spray		5
Final examination of product	7	9

(End of table 2)

NOTE

- (a) See paragraph 4.1.A.
- (b) Numbers indicate sequence in which tests are performed.

4 QUALITY ASSURANCE PROVISIONS

4.1 Qualification Testing

A. Specimen Selection

Specimens shall be prepared in accordance with applicable Instruction Sheets and shall be selected at random from current production. All test groups shall each consist of a minimum of 2 specimens.

B. Test Sequence

Qualification inspection shall be verified by testing specimens as specified in table 2.

4.2 Requalification Testing

If changes significantly affecting form, fit or function are made to the product or manufacturing process, product assurance shall coordinate requalification testing, consisting of all or part of the original testing sequence as determined by development/product, quality and reliability engineering.

4.3 Acceptance

Acceptance is based on verification that the product meets the requirements of table 1. Failures attributed to equipment, test setup or operator deficiencies shall not disqualify the product. If product failure occurs, corrective action shall be taken and specimens resubmitted for qualification. Testing to confirm corrective action is required before resubmittal.

4.4 Quality Conformance Inspection

The applicable quality inspection plan shall specify the sampling acceptable quality level to be used. Dimensional and functional requirements shall be in accordance with the applicable product drawing and this specification.

Changed list

REV	DATE (DD-MM-YY)	CATEGORY	ADDITIONS, DELETIONS, CHANGES
1	20-Jun-2020	All	Preliminary version