
SFP Connector and Cage Assemblies

1. SCOPE**1.1. Content**

This specification covers performance, tests and quality requirements for the TE Connectivity (TE) Stacked Small Form-factor Pluggable (SFP) Connector and Cage Assemblies.

1.2. Qualification

When tests are performed on the subject product line, procedures specified in Figure 1 shall be used. All inspections shall be performed using the applicable inspection plan and product drawing.

1.3. Qualification Test Results

Successful qualification testing on the subject product line was completed on 26Aug03. Additional testing was completed on 14Aug09. The Qualification Test Report number for this testing is 501-560. This documentation is on file at and available from Engineering Practices and Standards (EPS).

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, the product 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 Documents

- 114-13103: Application Specification (Stacked Small Form-Factor Pluggable (SFP) Connector and Cage Assembly)
- 501-560: Qualification Test Report (SFP Connector and Cage Assemblies)

2.2. Industry Standard

EIA-364: Electrical Connector/Socket Test Procedures Including Environmental Classifications

2.3. Reference Document

109-197: AMP Test Specifications vs EIA and IEC Test Methods

3. REQUIREMENTS**3.1. Design and Construction**

Product shall be of the design, construction 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

- Voltage: 120 volts AC
- Current: Signal application only
- Temperature: -55 to 105°C

3.4. Performance and Test Description

Product is designed to meet the electrical, mechanical and environmental performance requirements specified in Figure 1. Unless otherwise specified, all tests shall be performed at ambient environmental conditions.

3.5. Test Requirements and Procedures Summary

Test Description	Requirement	Procedure
Initial examination of product.	Meets requirements of product drawing and Application Specification 114-13103.	EIA-364-18. Visual and dimensional © of C) inspection per product drawing.
Final examination of product.	Meets visual requirements.	EIA-364-18. Visual inspection.
ELECTRICAL		
Low Level Contact Resistance (LLCR).	ΔR 10 milliohms maximum for shield and signal contacts.	EIA-364-23. Subject mated specimens to 100 milliamperes maximum and 20 millivolts maximum open circuit voltage.
Insulation resistance.	1×10^9 ohms minimum.	EIA-364-21. 300 volts DC. Test between adjacent contacts of unmated and unmounted specimens.
Withstanding voltage.	One minute hold with no breakdown or flashover.	EIA-364-20, Condition I. 300 volts AC at sea level. Test between adjacent contacts of unmated and unmounted specimens.
MECHANICAL		
Random vibration.	No discontinuities of 1 microsecond or longer duration. See Note.	EIA-364-28, Test Condition VII, Condition D. Subject mated specimens to 3.10 G's rms between 20-500 Hz. Fifteen minutes in each of 3 mutually perpendicular planes.

Figure 1 (continued)

Test Description	Requirement	Procedure
Mechanical shock.	No discontinuities of 1 microsecond or longer duration. See Note.	EIA-364-27, Method H. Subject mated specimens to 30 G's half-sine shock pulses of 11 milliseconds duration. Three shocks in each direction applied along 3 mutually perpendicular planes, 18 total shocks.
Durability.	See Note.	EIA-364-9. Mate and unmate specimens for 100 cycles at a maximum rate of 500 cycles per hour with cage latch operable.
Transceiver insertion force.	40 N [8.99 lbf] maximum.	EIA-364-13. Measure force necessary to mate specimens at a maximum rate of 12.7 mm [.5 in] per minute with cage latch operable.
Transceiver extraction force.	11.5 N [2.59 lbf] maximum.	EIA-364-13. Measure force necessary to unmate specimens at a maximum rate of 12.7 mm [.5 in] per minute with cage latch inoperable.
Cable pull.	100 N [22.481 lbf] minimum without displacement of cage assembly or connector from printed circuit board.	Load cabled module into cage/connector assembly applied to printed circuit board with attached bezel. Apply axial load at a maximum rate of 12.7 mm [.5 in], rotate cable 45 degrees toward printed circuit board, and then rotate 360 degrees with the load still applied.
Press- fit insertion force.	44.5 N [10 lbf] maximum per compliant pin.	Measure force necessary to press cage/connector onto printed circuit board into proper seating location at a maximum rate of 12.7 mm [.5 in] per minute.
Press-fit extraction force.	445 N [100 lbf] minimum for 2X4 cage assembly. 222 N [50 lbf] minimum for connector assembly.	Measure force necessary to extract cage/connector assembly from printed circuit board at a maximum rate of 12.7 mm [.5 in] per minute.
Cage latch strength/module retention.	180 N [40.5 lbf] minimum.	Apply specified axial load to engaged module at a maximum rate of 6.35 mm [.25 in] per minute and hold for 1 minute to verify module retention and cage latch strength.

Figure 1 (continued)

Test Description	Requirement	Procedure
ENVIRONMENTAL		
Thermal shock.	See Note.	EIA-364-32, Test Condition VII. Subject mated specimens to 5 cycles between -55 and 105° with 30 minute dwells at temperature extremes and 1 minute transition between temperatures. C.
Humidity/temperature cycling.	See Note.	EIA-364-31, Method III. Subject mated specimens to 10 cycles (10 days) between 25 and 65°C at 80 to 100% RH.
Temperature life.	See Note.	EIA-364-17, Method A, Test Condition 4. Subject mated specimens to 105°C for 300 hours.
Mixed flowing gas.	See Note.	EIA-364-65, Class IIA (4 gas). Subject mated specimens to environmental Class IIA for 20 days.

NOTE

Shall meet visual requirements, show no physical damage, and meet requirements of additional tests as specified in the Product Qualification and Requalification Test Sequence shown in Figure 2.

Figure 1 (end)

3.6. Product Qualification and Requalification Test Sequence

Test or Examination	Test Group (a)				
	1	2	3	4	5
	Test Sequence (b)				
Initial examination of product	1	1	1	1	1
LLCR		3,5,8	3,5,7	2,4,6	
Insulation resistance					2,6
Withstanding voltage					3,7
Random vibration		6			
Mechanical shock		7			
Durability		4			
Transceiver insertion force		2			
Transceiver extraction force		9			
Cable pull	2				
Press-fit insertion force			2		
Press-fit extraction force			8		
Cage latch strength	3				
Thermal shock					4
Humidity/temperature cycling			6		5
Temperature life			4(c)	3(c)	
Mixed flowing gas				5	
Final examination of product	4	10	9	7	8

NOTE

- (a) See paragraph 4.1.A.
(b) Numbers indicate sequence in which tests are performed.
(c) Precondition specimens with 10 durability cycles.

Figure 2

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. Each test group shall consist of 4 specimens.

B. Test Sequence

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