



025 (0.64III) Series Connector

1. SCOPE

1.1. Content

This specification covers the requirements for product performance, test method and quality assurance provisions for the TE Connectivity (TE) 025 (0.64III) Series Connector.

Applicable product description and part numbers are as follow.

Part Number	Part Description
X-2237145-X	8P 1 Row 025 (0.64) Cap SMT (Male)
X-2291172-X	8P 025 (0.64) Cap SMT (Male)
X-2237149-X	8P 025 (0.64) Cap SMT (Male)
X-2291173-X	12P 025 (0.64) Cap SMT (Male)
X-2291174-X	16P 025 (0.64) Cap SMT (Male)
X-2237067-X	24P 025 (0.64) Cap SMT (Male)
X-2237309-X	24P 025 (0.64) Cap SMT (Male)
X-2237138-X	32P 025 (0.64) Cap SMT (Male)
X-2237147-X	8P 1 Row 0.64III Plug Assy (Female)
X-1717103-X	8P 0.64III Plug Assy (Female)
X-1717106-X	12P 0.64III Plug Assy (Female)
X-1746872-X	12P 0.64III Plug Assy Short Body (Female)
X-1717109-X	16P 0.64III Plug Assy (Female)
X-2237049-X	16P 0.64III Plug Assy (Female)
X-2237152-X	16P 0.64III Plug Assy Short Body (Female)
X-1717112-X	24P 0.64III Plug Assy (Female)
X-1717118-X	32P 0.64III Plug Assy (Female)
X-1674311-X	0.64III Receptacle Contact

Note: The model number (part number) is configured with a single digit number with a dash in the list parent number. For more information on the dash with a number for each parent numbers refer to the drawing or catalog for the customer. It should be noted that if the prefix is zero, zero and dash are omitted.

1.2. Qualification

When tests are performed on the subject product line, procedures specified in Figure 1 and 2 shall be used. All inspections shall be performed using the applicable inspection plan and product drawing.

2. APPLICABLE DOCUMENTS

The following documents and forms constitute a part of this specification to the extent specified herein. 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. Unless otherwise indicated, the latest edition of the document applies.

2.1. TE Documents

- 109-1 : Test Specification (General Requirements for Testing)
- 109-201 : Component Heat Resistance to Lead-Free Reflow Soldering
- 114-5329 : Application Specification (Crimping 0.64III Receptacle Contact)
- 108-5931 : Product Specification
- 501-5596 : Qualification Test Report
- 501-166000 : Qualification Test Report

2.2. Industry Document

- JASO D605: Multi-pole Connector for Automobiles
- JASO D7101: Test Methods for Plastic Molded Parts
- JIS C3406: Low Voltage Wires and Cables for Automobiles
- JIS D0203: Method of Moisture, Rain and Spray Test for Automobile Parts
- JIS D0204: Method of High and Low Temperature Test for Automobile Parts
- JIS D1601: Vibration Testing Method for Automobile Parts
- JIS R5210: Portland Cement

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

A. Tab (Male)

Material: Copper Alloy

Finish: Post-Tin

B. Receptacle (Female)

Material: Copper Alloy

Finish: Pre-Tin

C. Housing (Male)

Material: PPS

D. Housing (Female)

Material: PBT

3.3. Ratings

- Voltage Rating: 12V DC
- Temperature Rating: -40 to 105°C
(Ambient temperature + Temperature rise due to energized current)

3.4. Performance Requirements and Test Description

The product is designed to meet the electrical, mechanical and environmental performance requirements specified in Figure 1 and 2. All tests shall be performed in the room temperature, unless otherwise specified.

3.5. Test Requirements and Procedures Summary

Item No	Test Description	Requirement	Procedure
3.5.1	Confirmation of Product	Meet requirements of product drawing and TE Specification 114-5329	Visually, dimensionally and functionally inspected per applicable quality inspection plan
ELECTRICAL			
3.5.2	Termination Resistance (Low Level)	8 m Ω Max (Initial) 16 m Ω Max (Final)	Subject mated contacts assembled in housing to 20mV Max open circuit at 10mA Figure 3
3.5.3	Termination Resistance (Specified Current)	8 m Ω Max (Initial) 16 m Ω Max (Final)	Subject mated contacts assembled in housing to 12V Max open circuit at 1A Figure 3
3.5.4	Dielectric Withstanding Voltage	No creeping discharge or flashover shall occur	Impressed voltage 1kVAC for 1 min on mated connector Figure 4
3.5.5	Insulation Resistance	100 M Ω Min (Initial) 100 M Ω Min (Final)	Impressed voltage 500VDC on mated connector Figure 4
3.5.6	Current Leakage	3mA Max	Impressed voltage 14VDC Figure 5
3.5.7	Temperature Rise	60°C Max	Measure temperature rising at wire crimped by applied current to all positions Figure 9
3.5.8	Over Current Loading	No ignition is allowed during the test	Apply the current to only one position Applied Current Figure 8
MECHANICAL			
3.5.9	Vibration (High Frequency)	No electrical discontinuity greater than 1 μ sec shall occur. Satisfy requirements of test item on the "3.6 sequence"	Vibration Frequency: 20→200→20Hz/3min Acceleration: 44.1m/s ² Vibration Direction: X, Y, Z Duration: 3hrs each Mounting Figure 6
3.5.10	Shock	No electrical discontinuity greater than 1 μ sec shall occur	Acceleration: 980m/s ² Waveform: Half sine wave Duration: 6msec Velocity Number of Drops: 6 drops each direction of X, -X, Y, -Y, Z, and -Z axes, total 18 drops Mounting Figure 6

Figure 1 (Cont.)

Item No	Test Description	Requirement	Procedure
MECHANICAL			
3.5.11	Connector Mating Force	70N Max	Operation Speed: 100mm/min Measure the force required to mate connectors
3.5.12	Connector Unmating Force	70N Max	Operation Speed: 100mm/min Measure the force required to unmate connectors (without housing lock)
3.5.13	Connector Locking Strength	100N Min	Operation Speed: 100mm/min Apply an axial pull off load to one of the mated housing, measure locking strength
3.5.14	Contact Insertion Force	10N Max per contact	Measure the force required to insert contact into housing
3.5.15	Contact Retention Force (Latch Only)	30N Min	Operation Speed: 100mm/min Apply an axial pull-off load to crimped wire
3.5.16	Contact Retention Force (Secondary Lock)	100N Min	Operation Speed: 100mm/min Measure contact retention force with secondary lock set in
3.5.17	Resistance to "Kojiri"	Satisfy requirements of test item on the "3.6 sequence"	Repeat mating-unmating by hand in up-down and right-left directions for 10 cycles
3.5.18	Solderability (Reflow Soldering)	Fillet shall be formed around the contact	Test connector on PCB (FR4, Thickness 1.6mm) <Sn-Ag-Cu Solder Paste> Pre-Heat: 180±10°C, 60~120sec Soldering: 217°C, 40±5sec Peak Temperature: 235°C, 10sec Temperature measured at contact / peg
3.5.19	Handling Ergonomics	No abnormalities allowed in manual mating/unmating handling	Manually operated
3.5.20	Retention Force of Tab	20N Min	Measure the retention force between housing and tab contact Operation speed: 100mm/min
3.5.21	Resistance to Soldering Heat	No cracks, deformation, discoloration that are problematic in function shall appear.	TEC-109-201 Test Method B, Condition B Solder Temperature: 260°C 20~40sec within 5°C of peak

Figure 1 (Cont.)

Item No	Test Description	Requirement	Procedure
ENVIRONMENTAL			
3.5.22	Thermal Shock	Satisfy requirements of test item on the "3.6 sequence"	Mated connector -40°C/30min, 100°C/30min Making this a cycle, repeat 1000 cycles Monitor resistance-variation at closed circuit current of 10mA during the test
3.5.23	Humidity (Steady State)	Satisfy requirements of test item on the "3.6 sequence" Current Leakage: 3mA Max	Mated connector 90~95% R.H., 60±5°C, 96hrs, 14V applied Monitor current leakage during the test
3.5.24	Industrial Gas (SO ₂)	Satisfy requirements of test item on the "3.6 sequence"	Unmated connector SO ₂ Gas: 25ppm, 75% R.H. 25°C, 96hrs
3.5.25	Temperature Life (Heat Aging)	Satisfy requirements of test item on the "3.6 sequence"	Mated connector 120°C, 120hrs
3.5.26	Resistance to Cold	Satisfy requirements of test item on the "3.6 sequence"	Mated connector -40°C, 120hrs
3.5.27	Humidity Temperature Cycling	Satisfy requirements of test item on the "3.6 sequence"	Mated connector Condition Figure 7 Making this condition a cycle Repeat 10 cycles Monitor resistance variation at closed circuit current of 10mA during the test
3.5.28	Dust Bombardment	Satisfy requirements of test item on the "3.6 sequence"	Mated connector Subject JIS R 5210 cement blow of 1.5kg per 10sec in 15min intervals for 8 cycles with mating/unmating per 2 cycles
3.5.29	Compound Environment Resistance	Satisfy requirements of test item on the "3.6 sequence" No electrical discontinuity greater than 1µsec shall occur	Temperature: 80°C Vibration Frequency: 20→200→20Hz/3min (Log) Acceleration: 44.1m/s ² Vibration Direction: X, Y, Z Duration: 300hrs Test Current Figure 10 Mounting Figure 6 Monitor resistance variation and after this test check if instant cutoff occurs for an hour on "Vibration (High Frequency)"
3.5.30	Condensation	Satisfy requirements of test item on the "3.6 sequence"	0°C/10min, 80°C/90~95%/30min Making this a cycle, repeat 48 cycles Monitor current leakage during the test

Figure 1 (end)

3.6. Product Qualification and Requalification Test Sequence

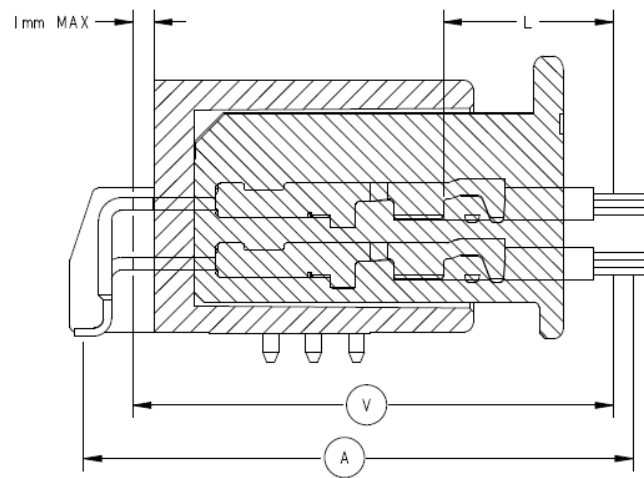
Test or Examination	Test Group															
	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16
	Test Sequence (a)															
3.5.1 Confirmation of Product	1	1,5	1,6	1,4	1,5	1,5	1,6	1,5	1,6	1,4	1,5	1,6	1,7	1,4	1,3	1,3
3.5.2 Termination Resistance (Low Level)	2	2,6	2,7		2,6	2,6	2,7	2,6	2,7		2,6	2,7	2,8			
3.5.3 Termination Resistance (Specified Current)	3	3,7	3,8		3,7	3,7	3,8	3,7	3,8		3,7	3,8	3,9			
3.5.4 Dielectric Withstanding Voltage	7						10				9					
3.5.5 Insulation Resistance	6						9				8			5		
3.5.6 Current Leakage							5							3		
3.5.7 Temperature Rise	4								4,9				4,10			
3.5.8 Over Current Loading		4														
3.5.9 Vibration (High Frequency)			5										6			
3.5.10 Shock				3												
3.5.11 Connector Mating Force	8															
3.5.12 Connector Unmating Force	9															
3.5.13 Connector Locking Strength	10					9	11		11	5	11					
3.5.14 Contact Insertion Force	11															
3.5.15 Contact Retention Force (Latch Lock)	12															
3.5.16 Contact Retention Force (Secondary Lock)	13					10	12		12	6	12					
3.5.17 Resistance to "Kojiri"					4											
3.5.18 Solderability (Reflow Soldering)																2
3.5.19 Handling Ergonomics	5					8			10	3	10					
3.5.20 Retention Force of Tab	14														4	
3.5.21 Resistance to Soldering Heat															2	
3.5.22 Thermal Shock						4										
3.5.23 Humidity (Steady State)							4									
3.5.24 Industrial SO ₂ Gas								4								
3.5.25 Temperature Life (Heat Aging)			4	2					5			4				
3.5.26 Resistance to Cold										2						
3.5.27 Humidity Temperature Cycling											4					
3.5.28 Dust Bombardment												5				
3.5.29 Compound Environment Resistance													5			
3.5.30 Condensation														2		

Figure 2



NOTE

(a) Numbers indicate sequence in which tests are performed.



Deduct resistance of wire "L"

Figure 3

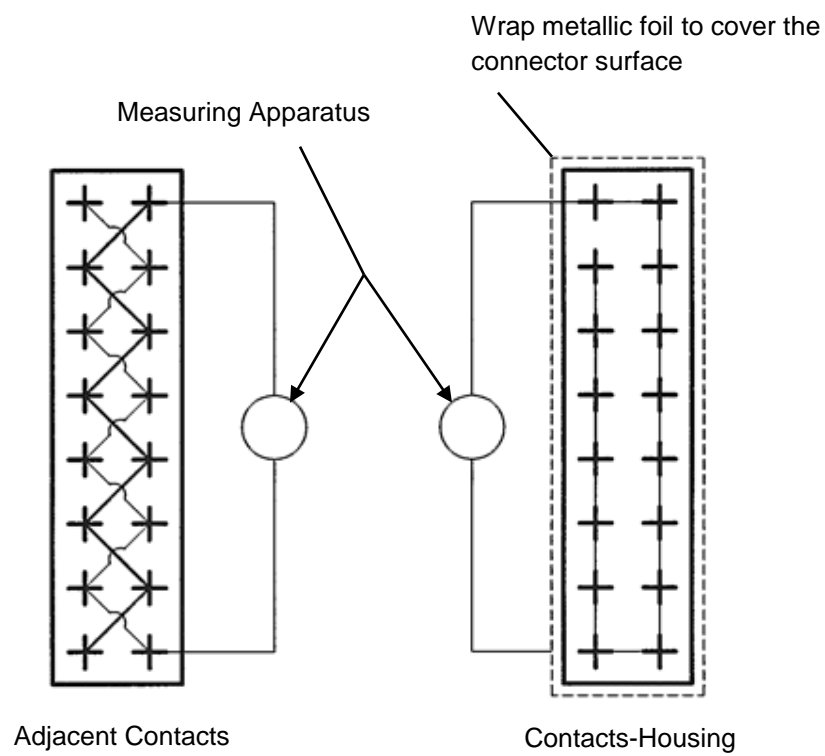


Figure 4

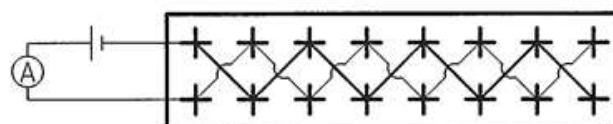


Figure 5

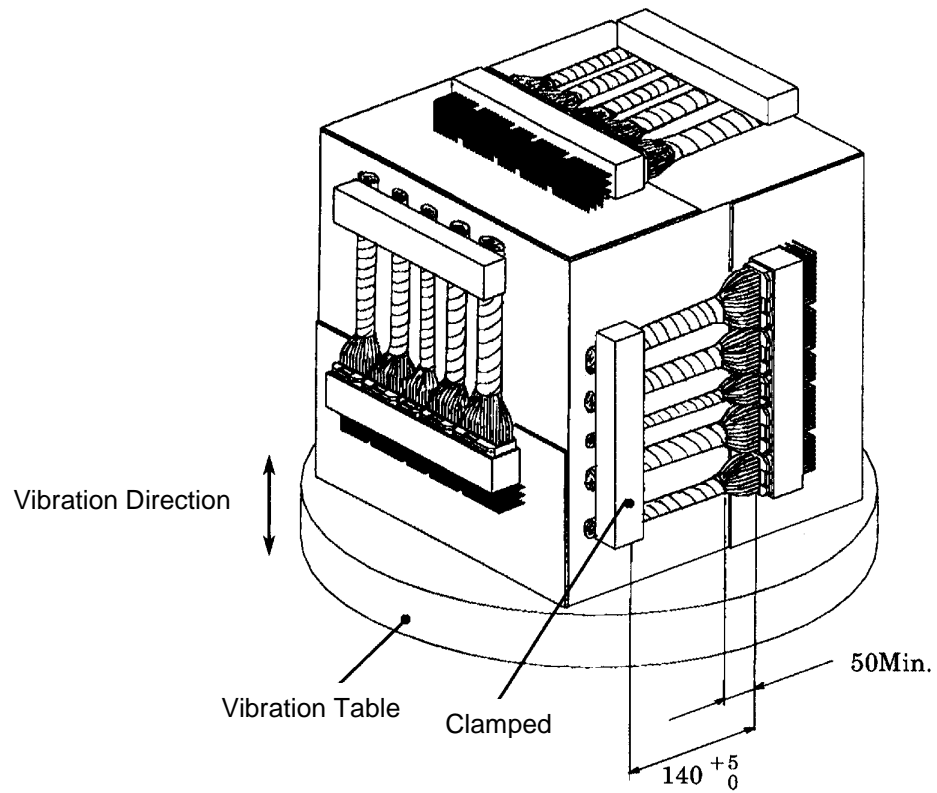


Figure 6

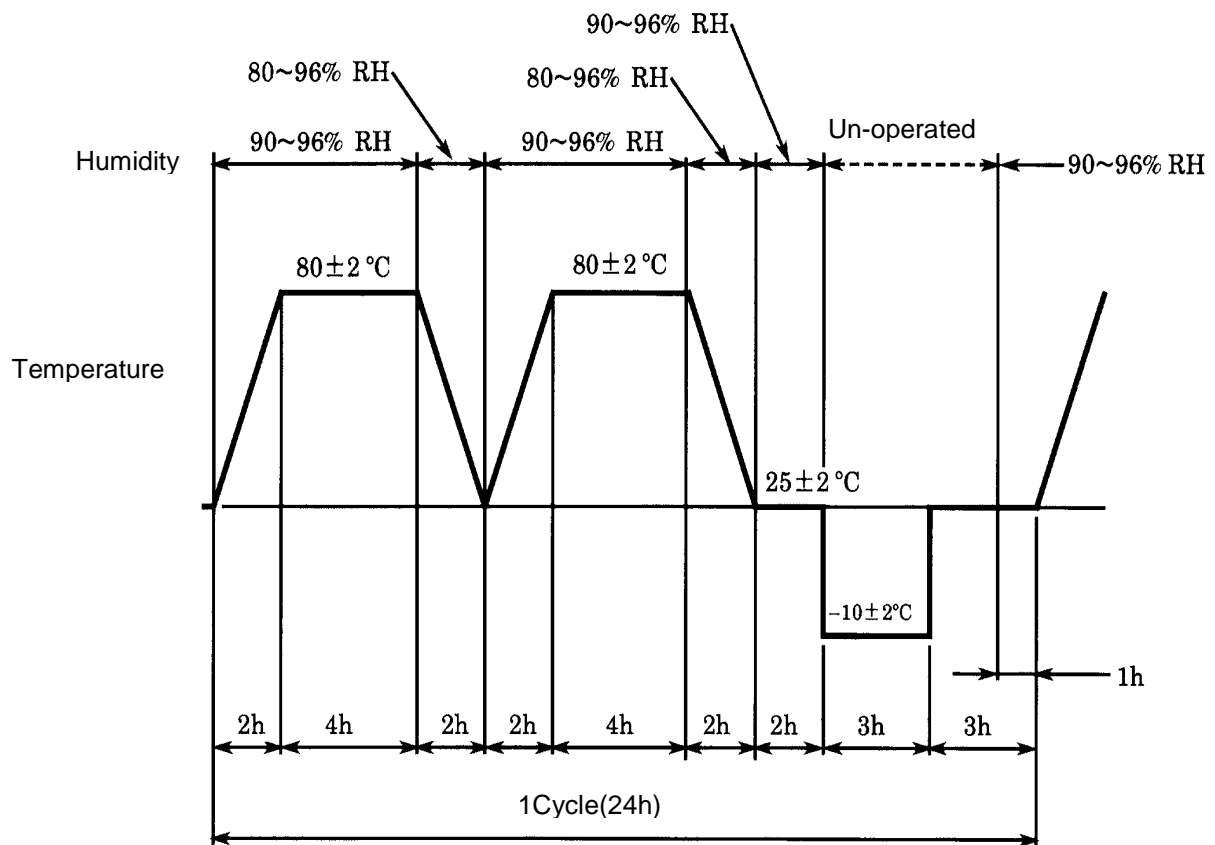


Figure 7

Wire Size (mm ²)	Test Current (A)	Duration
0.5	16.5	60 min
	20.2	200 sec
	22.5	5 sec
	30	1 sec

Figure 8

Kind of Connectors	Wire Size (mm ²)	Test Current (A)	Temperature Rise
8 POS	0.5	6.05	60°C Max
12 POS	0.5	5.5	
16 POS	0.5	4.4	
24 POS	0.5	3.3	
32 POS	0.5	2.2	

Figure 9

Kind of Connectors	Wire Size (mm ²)	Test Current (A)	Test Time
8 POS	0.5	3.3	45min ON, 15min OFF 300 cycles
12 POS	0.5	3	
16 POS	0.5	2.4	
24 POS	0.5	1.8	
32 POS	0.5	1.2	

Figure 10