



The product described in this document has not been fully tested to ensure conformance to the requirements outlined below. Therefore, TE Connectivity (TE) makes no representation or warranty, express or implied, that the product will comply with these requirements. Further, TE may change these requirements based on the results of additional testing and evaluation. Contact TE Engineering for further details.

**025 SLD 3P**

**1. SCOPE**

1.1. Content

This specification covers the requirements for product performance, test methods and quality assurance provisions of 025 SLD 3P

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 has not been completed. The Qualification Test Report number will be issued upon successful qualification testing.

**2. APPLICABLE DOCUMENTS AND FORMS**

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

2.1. TE Documents

- 109-1: General Requirements for Test specifications.
- 936531: Customer Drawing (025 SLD HDR ASSY)
- 936527: Customer Drawing (025 SLD 3P PLUG ASSY)
- 936685: Customer Drawing (025 SLD 3P COVER HSG)

**3. REQUIREMENTS**

3.1. Design and Construction

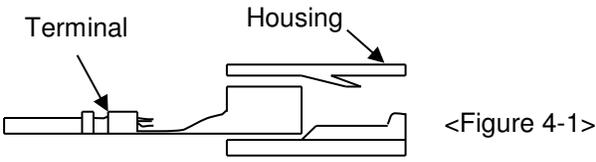
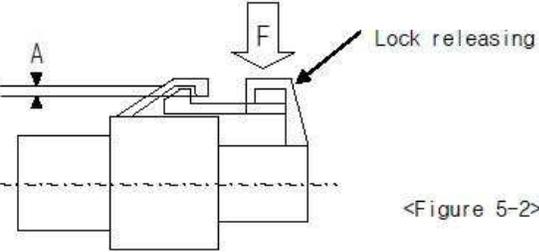
Product shall be of the design, construction, materials and physical dimensions specified on the applicable product drawing.

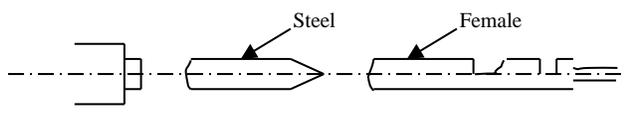
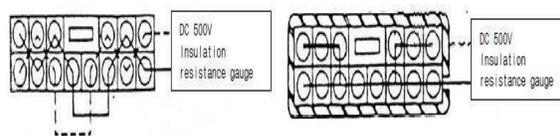
3.2. Ratings

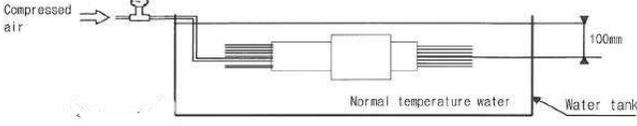
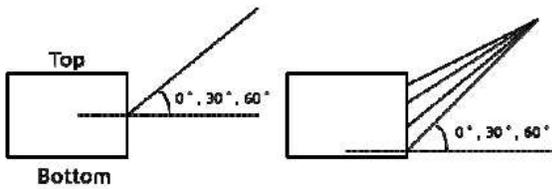
Voltage	Temperature	Humidity
12V DC	25±5°C	60±20%

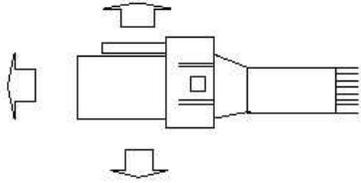
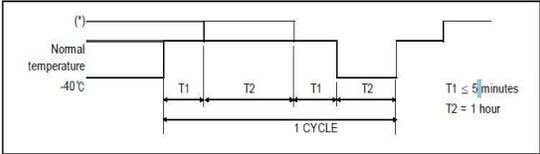
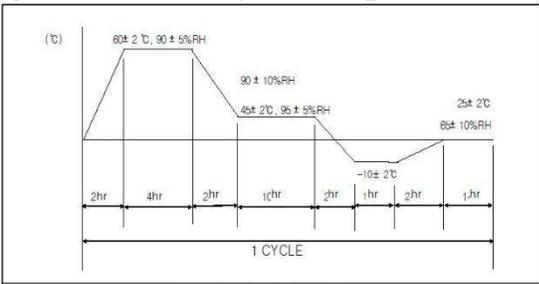
### 3.3. Test Requirements and Procedures Summary

Unless otherwise specified, all tests shall be performed at ambient environmental conditions.

TEST DESCRIPTION	REQUIREMENT	PROCEDURE
Appearance	No crack, damage, distortion are permitted	Using sense of sight and touch.
CONN engage and disengage force	Max 15 kgf and less	Measure force by inserting and disengaging the connector with terminal assembled at constant 100 mm/min speed. However, remove lock part when measuring disengage force.
Reverse insertion between housings	It shall not be incorrectly inserted by applying force of 20kgf.	Insert the housing with terminal by pushing it in reverse direction with applying 20kgf.
Reverse insertion between terminal and housing	5kgf or more	Crimp cable of maximum size on terminal and then insert it into housing by end of insulation barrel in the reserve direction.
Engage force between terminal and housing	1.5kgf or less	As shown in the following figure 4-1, measure the weight while inserting terminal into fixed housing at 50mm/min speed. 
Strength of HSG lock	8kgf or more	Combine housing only, fix the one side of housing in completely locked condition, and extend the other side in axial direction and 30 angle direction at a constant speed of 50mm/min. Then measure weight when lock structure is disengaged or destroyed.
HSG lock releasing force	Max 6kgf	Apply force (F) to lock releasing part, and measure weight on the point of A=0. However, cut connector and then perform test at the section in order to secure visibility. 
Terminal retention force	5kg or more	Fix the housing after inserting crimped terminals. Extend one line of cable in axial direction at a speed of 50mm/min at a position 50~100mm away from crimped part, and measure weight when terminal is disengaged from the housing.

Terminal engage and disengage force (kgf)	Engage	0.1~0.5kgf	As shown in figure 4-3, engage and disengage male terminal or steel gauge into or from female terminal at 100 mm/min speed. 												
	Disengage	0.1~0.5kgf													
Crimp strength (kgf)	1.25SQ: Min 17.0kgf or more		Fix the crimped terminal, and draw the cable at a position 50~100 mm away from crimped part in axial direction at 100 mm/min speed. Then measure the weight when cable is cut or disengaged from the crimped part												
Voltage Drop	Max 10mV/A		Measure the circuit voltage drop (V) by sending voltage and current described in the table 5-1 with terminal combined on the connector. Then calculate a voltage drop (VD) in terminal by subtracting cable resistance (L) from the circuit voltage drop (V). 1)HARNESS versus UNIT:VD =V(L3+L4 ) <table border="1" data-bbox="812 871 1421 1008"> <thead> <tr> <th>Application</th> <th>Open voltage</th> <th>Short circuit current</th> <th>Division</th> </tr> </thead> <tbody> <tr> <td>Signal circuit</td> <td>20 ± 5 mV</td> <td>10 mA</td> <td>ECU, Sensor</td> </tr> <tr> <td>Power circuit</td> <td>13 V</td> <td>1 A</td> <td>Other than the above</td> </tr> </tbody> </table> <Table5-1>	Application	Open voltage	Short circuit current	Division	Signal circuit	20 ± 5 mV	10 mA	ECU, Sensor	Power circuit	13 V	1 A	Other than the above
Application	Open voltage	Short circuit current	Division												
Signal circuit	20 ± 5 mV	10 mA	ECU, Sensor												
Power circuit	13 V	1 A	Other than the above												
Insulation resistance	Min 250 MΩ		Measure resistance between neighbor terminals (figure 5-6), and between terminal and housing surface (figure 5-7) with DC 500V insulation resistance gauge with connector combined.  <Figure 5-6: Between neighboring terminals>    <Figure 5-7: Between neighboring terminal and housing surface>												
Leakage Current	1 μA or less		Measure it by applying DC 14V between neighboring terminals (figure 5-6).												
High voltage test	No allowed Insulation breakdown		Measured by applying test potential of 1000 V AC between the adjacent contact between the contact and housing.												
Temperature rise	Max 30 °C		Apply basic current ( I = I <sub>o</sub> *K ) of clause to the connector with electrodes in series in the room free from wind (normal temperature). And measure a temperature of crimped part after reaching saturation temperature. Then calculate a temperature of crimped part by subtracting ambient temperature from the temperature.												

Sealing test	After endurance		Put the combined connector in water as shown in the figure 5-9 and supply 10Kpa(0.1kg/cm <sup>2</sup> ) to connector for 30 seconds. Then increase it by 10Kpa(0.1kg/cm <sup>2</sup> ) until 200Kpa(2kg/cm <sup>2</sup> ) is reached and maximum value shall be specified in the test report for reference. (Use a wire of which the pressure does not leak at the end)										
	1kgf/ cm <sup>2</sup>		  										
Twisting Test - Connector Engage and Disengage Endurance Test	Appearance	No crack, damage, distortion are permitted	Apply 8kgf force on the end part of combined connector 10 times each in the (front, rear, left, right) directions perpendicular to axial direction.  Make combine connectors engage and disengage at 100mm/min. Perform it 50 times.  (Do not use locking device)										
	Max 20mV/A												
Overcurrent cycle test	Appearance	No crack, damage distortion are permitted											
	Voltage Drop	Max 20mV/A	Condition A										
			Condition B										
	Temp rise	Max 40	Condition A										
Condition B													
			Engage and disengage connector with terminal assembled 10 times with hands, and apply the following current 1000 cycles for the connector with electrodes in series at 60 °C of ambient temperature.										
			<table border="1"> <tr> <td rowspan="2">Current application condition A</td> <td>Applied current</td> <td>2 times of basic current</td> </tr> <tr> <td>Current application time</td> <td>1 minute - ON, 9 minutes - OFF</td> </tr> <tr> <td rowspan="2">Current application condition B</td> <td>Applied current</td> <td>5 times of basic current</td> </tr> <tr> <td>Current application time</td> <td>10 seconds - ON, 590 seconds - OFF</td> </tr> </table>	Current application condition A	Applied current	2 times of basic current	Current application time	1 minute - ON, 9 minutes - OFF	Current application condition B	Applied current	5 times of basic current	Current application time	10 seconds - ON, 590 seconds - OFF
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Cold temperature test	Appearance	No crack, damage, distortion are permitted											
	Insulation Resistance	Sealed CONN'R : Min 100 MΩ	Between terminals housing surface										
			Engage and disengage connector with terminal assembled 10 times with hands, and leave it in temperature chamber of -40°C for 120 hours. Make connector engaged and disengaged 5 times immediately, and drop it onto the concrete surface from 1m height 3 times in the direction of figure 6-1. (Voltage drop & Temperature rise test perform at normal temperature) :										

	Current Leakage	Max 100 $\mu$ A		 <p>&lt;Figure 6-1&gt;</p>				
	Sealing	Min 0.5kgf/cm <sup>2</sup>						
Cold and hot temperature shock test	Appearance	No crack, damage, distortion are permitted		<p>Engage and disengage Connector with terminal assembled 10 times with hands, this repeats 200 CYCLE by below test condition. (Sealed : 120°C, Non-Sealed : 80°C)</p> 				
	Voltage Drop	Max 20mV/A						
	Sealing	Min 0.5kgf/cm <sup>2</sup>						
High temperature test	Appearance	No crack, damage, distortion are permitted		<p>Engage and disengage connector with terminal assembled 10 times with hands, and leave it in combined state at the temperature chamber of the table 6-1 for 300 hours. Then pick it out and leave it until it returns to normal temperature.</p> <table border="1" data-bbox="786 890 1343 1005"> <tr> <td>High Temperature</td> <td>Connector Using Part</td> </tr> <tr> <td>120°C</td> <td>Waterproof Connector</td> </tr> </table>	High Temperature	Connector Using Part	120°C	Waterproof Connector
	High Temperature	Connector Using Part						
	120°C	Waterproof Connector						
Voltage Drop	Max 20mV/A							
Sealing	Min 0.5kgf/cm <sup>2</sup>							
Temperature Humidity Test	Appearance	No crack, damage, distortion are permitted		<p>Engage and disengage connector with terminal assembled 10 times with hands, and leave it at 25°C ambient temperature and 65% relative humidity for 25 hours. And perform 5 cycles of the method specified in figure 6-3</p>  <p>&lt; Figure 6-3 : Test pattern &gt;</p>				
	Voltage Drop	Max 20mV/A						
	Insulation Resistance	Min 100M $\Omega$	Between terminals		Max 100 $\mu$ A			
			housing surface					
Current Leakage	Max 100 $\mu$ A							
Dust Test	Appearance	No crack, damage, distortion are permitted		<p>Engage and disengage connector with terminal assembled 10 times with hands, and diffuse 1.5kg Portland cement(JIS R5210) with fan (or others) for 10 seconds per 15 minutes while maintaining 150mm distance from wall in the closed container of 900~1200mm length, width and height, with connector combined. After 1 hour, measure it.</p>				
	Voltage Drop	Max 20mV/A						
	Sealing	Min 0.5kgf/cm <sup>2</sup>						
Waterproof Test	Appearance	No crack, damage, distortion are permitted		<p>Make combined connectors engaged and disengaged 10 times k hands, and leave it in combined state at 120 °C ambient tempera for 40 minutes and then spray water of normal temperature for 2 minutes according to S2 of JIS D0203. Repeat 48 cycles of this. * JIS D0203 S2 condition: attach specimen at 400mm distance from the waterproof pipe with water spray hole or</p>				
	Insulation Resistance	Min	Between terminals					

		100 M $\Omega$	housing surface	water discharge hole, and rotate waterproof pipe 23 times per minute around the axis.	
	Current Leakage	Max 100 $\mu$ A			
	Sealing	Min 0.5kgf/cm <sup>2</sup>			
Oil and liquid test	Appearance	No crack, damage, distortion are permitted		Engage and disengage connector with terminal assembled 10 times with hands, and perform test each sample with connector combined. A. Immerse connector in combined state for 2 hours in mixed oil of 50 $\pm$ 2 $^{\circ}$ C ENG oil (SAE10W) or equivalent oil and B. Immerse connector in combined state for 1 hour in car gasoline (JIS K2202) at normal temperature, and then pick it out. C. Immerse connector in combined state for 1 hour in brake liquid (pure product) at normal temperature, and then pick it out. D. Immerse connector in combined state for 1 hour in 100% washer liquid (pure product) at normal temperature, and then pick it out. E. Immerse connector in combined state for 1 hour in 50% LLC (Long life coolant) at normal temperature, and then pick it out.	
	Voltage Drop	Max 20mV/A			
	Sealing	Min 0.5kgf/ cm <sup>2</sup>			
Ozone Test	Appearance	No crack, damage, distortion are permitted		Engage and disengage Connector with terminal assembled 10 times with hands, and samples keep at 40 $^{\circ}$ C and 50 $\pm$ 5pphm Ozone for 100hour. Then pick connector out of chamber and dry it for 2hours or more	
	Voltage Drop	Max 20mV/A			
	Sealing	Min 0.5kgf/ cm <sup>2</sup>			
Salt Water Test	Appearance	No crack, damage, distortion are permitted		Engage and disengage connector with terminal assembled 10 times with hands, and put it in 35 $^{\circ}$ C temperature regulation chamber, spray 5% salty water for 24 hours according to JIS Z2371, and, maintain room temperature without spray for 1 hour, Then repeat this four times. Then pick connector out of chamber and dry it at room temperature for 2 hours or more.	
	Voltage Drop	Max 20mV/A			
	Insulation Resistance	Min 100 M $\Omega$	Between terminals		housing surface
			housing surface		
Current Leakage	Max 100 $\mu$ A				
Sulfur (SO <sub>2</sub> ) gas test	Appearance	No crack, damage, distortion are permitted		Engage and disengage connector with terminal assembled 10 times with hands, and expose it in combined state to sulfur gas of 40 $\pm$ 3 $^{\circ}$ C, density 10ppm, humidity 90~95%, for 24 hours. Then pick connector out of chamber and dry it for 2 hours or more.	
	Voltage Drop	Max 20mV/A			
Complex environment endurance test	Appearance	No crack, damage, distortion are permitted		Engage and disengage connector with terminal assembled 10 times with hands, and leave it in combined state in the temperature chamber of 120 $^{\circ}$ C or 80 $^{\circ}$ C (follows table 7) for 48 hours.	

	Crimp Tensile Strength	1.25SQ Min 17kgf	<p>And then perform the following vibration test. Then measure instant short circuit according to the method of clause 4.16 for 4 hours for X, Y, Z each.</p> <p>1) Sine wave test</p> <table border="1"> <thead> <tr> <th>Division</th> <th>Condition</th> </tr> </thead> <tbody> <tr> <td>Ambient temperature/humidity</td> <td>120°C</td> </tr> <tr> <td>Applied current</td> <td>Basic current (Connector electrodes in series.)</td> </tr> <tr> <td>Current application cycle</td> <td>120 CYCLE (45 minutes-ON, 15 minutes-OFF)</td> </tr> <tr> <td>Vibration acceleration</td> <td>4.4g</td> </tr> <tr> <td>Frequency</td> <td>20Hz ~ 200Hz (sweep time: 3 minutes or less)</td> </tr> <tr> <td>Vibration time</td> <td>40 hours for X, Y, Z each</td> </tr> <tr> <td>Connector attaching method</td> <td>Test mode A, B, C</td> </tr> </tbody> </table>	Division	Condition	Ambient temperature/humidity	120°C	Applied current	Basic current (Connector electrodes in series.)	Current application cycle	120 CYCLE (45 minutes-ON, 15 minutes-OFF)	Vibration acceleration	4.4g	Frequency	20Hz ~ 200Hz (sweep time: 3 minutes or less)	Vibration time	40 hours for X, Y, Z each	Connector attaching method	Test mode A, B, C										
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	Temperature Rise	Max 40°C																											
	Instant short circuit	Max 10 $\mu$ s																											
	Sealing	Min 0.5kgf/cm <sup>2</sup>	<p>2) Random wave test</p> <table border="1"> <thead> <tr> <th>Division</th> <th>Condition</th> </tr> </thead> <tbody> <tr> <td>Ambient temperature/humidity</td> <td>Refer to figure 4-8, 90~95%</td> </tr> <tr> <td>Applied current</td> <td>Basic current (Connector electrodes in series.)</td> </tr> <tr> <td>Current application cycle</td> <td>24 CYCLE (45 minutes-ON, 15 minutes-OFF)</td> </tr> <tr> <td>Vibration acceleration</td> <td>Follow figure 6-8</td> </tr> <tr> <td>Frequency</td> <td>20Hz ~ 200Hz (sweep time: 3 minutes or less)</td> </tr> <tr> <td>Vibration time</td> <td>8 hours for X, Y, Z each</td> </tr> <tr> <td>Connector attaching method</td> <td>Test mode D, E, F</td> </tr> </tbody> </table> <table border="1"> <thead> <tr> <th>Breakpoint (Hz)</th> <th>Magnitude (G<sup>2</sup>/Hz)</th> </tr> </thead> <tbody> <tr> <td>60.0</td> <td>0.00100</td> </tr> <tr> <td>200.0</td> <td>1.50000</td> </tr> <tr> <td>210.0</td> <td>0.10000</td> </tr> <tr> <td>1000.0</td> <td>0.10000</td> </tr> </tbody> </table>	Division	Condition	Ambient temperature/humidity	Refer to figure 4-8, 90~95%	Applied current	Basic current (Connector electrodes in series.)	Current application cycle	24 CYCLE (45 minutes-ON, 15 minutes-OFF)	Vibration acceleration	Follow figure 6-8	Frequency	20Hz ~ 200Hz (sweep time: 3 minutes or less)	Vibration time	8 hours for X, Y, Z each	Connector attaching method	Test mode D, E, F	Breakpoint (Hz)	Magnitude (G <sup>2</sup> /Hz)	60.0	0.00100	200.0	1.50000	210.0	0.10000	1000.0	0.10000
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3.4. Applied Part No List

TE Part no	Description
936531-2	025 SLD 3P HDR ASSY
936527-2/3	025 SLD 3P PLUG ASSY

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1-936527-2	025 SLD 3P PLUG ASSY
936685-2	025 SLD 3P COVER HSG