



Project Number: NA		Tracking Code: 0212--0640	
Requested by: W. Ouyang		Date: 3/22/02	Product Rev: See Front Page
Part #: See Front Page	Lot #: 03/18/02	Tech: G.Lewis	Eng: J. Tozier
Part description: 0.8mm, 0.635mm, 0.5mm Quiet & Basic High Speed Products			Qty to test: 210
Test Start: 3/29/02	Test Completed: 6/6/02		

Mating - Unmating Summary Report

PARTS DESCRIPTIONS

TERMINAL SIDE	SOCKET SIDE
BTE-020-01-F-D-A	BSE-020-01-F-D-A
BTE-060-01-F-D-A	BSE-060-01-F-D-A
BTE-120-01-F-D-A	BSE-120-01-F-D-A
REV: Q	REV: D
BTS-025-01-F-D-A	BSS-025-01-F-D-A
BTS-075-01-F-D-A	BSS-075-01-F-D-A
BTS-150-01-F-D-A	BSS-150-01-F-D-A
REV: B	REV: A
BTH-030-01-F-D-A	BSH-030-01-F-D-A
BTH-090-01-F-D-A	BSH-090-01-F-D-A
BTH-150-01-F-D-A	BSH-150-01-F-D-A
REV: K	REV: D
MIT-019-01-F-D-A	MIS-133-01-F-D-A
MIT-076-01-F-D-A	MIS-019-01-F-D-A
MIT-133-01-F-D-A	MIS-076-01-F-D-A
REV: C	REV: C
QTE-020-01-F-D-A	QSE-020-01-F-D-A
QTE-060-01-F-D-A	QSE-060-01-F-D-A
QTE-100-01-F-D-A	QSE-100-01-F-D-A
REV: X	REV: R
QTS-025-01-F-D-A	QSS-025-01-F-D-A
QTS-075-01-F-D-A	QSS-075-01-F-D-A
QTS-125-01-F-D-A	QSS-125-01-F-D-A
REV: A	REV: B
QTH-030-01-F-D-A	QSH-030-01-F-D-A
QTH-090-01-F-D-A	QSH-090-01-F-D-A
QTH-150-01-F-D-A	QSH-150-01-F-D-A
REV: N	REV: F



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CERTIFICATION

All instruments and measuring equipment were calibrated to National Institute for Standards and Technology (NIST) traceable standards according to ISO 10012-1 and ANSI/NCSL 2540-1, as applicable.

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SCOPE

To perform the following tests: Mating - Unmating

APPLICABLE DOCUMENTS

Standards: EIA Publication 364

TEST SAMPLES AND PREPARATION

- 1) All materials were manufactured in accordance with the applicable product specification.
- 2) All test samples were identified and encoded to maintain traceability throughout the test sequences.
- 3) After soldering, the parts to be used for LLCR testing were cleaned according to TLWI-0001:
 - a) Sample test boards are to be ultrasonically cleaned after test lead attachment, preparation and/or soldering using the following process.
 - b) Immerse the sample test boards into the Branson 3510 cleaner which contains Kyzen Ionox HC1 (or equivalent) cleaning solution with the following conditions:
 - i) Temperature: 55° C +/- 5° C
 - ii) Frequency: 40 KHz
 - iii) Immersion Time: 5 to 10 Minutes
 - c) Sample test boards are then slowly removed and placed into the Branson 3510 cleaner which contains deionized water with the following conditions:
 - i) Temperature: 55° C +/- 5° C
 - ii) Frequency: 40 KHz
 - iii) Immersion Time: 5 to 10 Minutes
 - d) Sample test boards are then removed and placed in a beaker, on a hot plate with a magnetic stirrer containing deionized water warmed to 55° C +/- 5° C for 1/2 to 1 minute (Use 55° C as target)
 - e) Upon removal, the sample test boards are then rinsed for 1/2 to 1 minute in room temperature free flowing deionized water.
 - f) After the final rinse, the sample test boards are to be dried in an air-circulating oven for 10 to 15 minutes at 50° C +/- 5° C (Use 50° C as target)
 - g) Sample test boards are then allowed to set and recover to room ambient condition prior to testing.
- 4) Parts not intended for testing LLCR and DWV/IR are visually inspected and cleaned if necessary.
- 5) Any additional preparation will be noted in the individual test procedures.



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ATTRIBUTE DEFINITION

Following is a brief, simplified description of the attribute measured.

MATING/UNMATING:

- 1) Reference document: EIA-364-13, *Mating and Unmating Forces Test Procedure for Electrical Connectors*.
- 2) The full insertion position was to within 0.003" to 0.004" of the plug bottoming out in the receptacle to prevent damage to the system under test.
- 3) One of the mating parts is secured to a floating X-Y table to prevent damage during cycling.
- 4) Mating/Unmating forces were evaluated on the first cycle.
- 5) Number of Samples tested: 5 per series

RESULTS BXX Series (data)

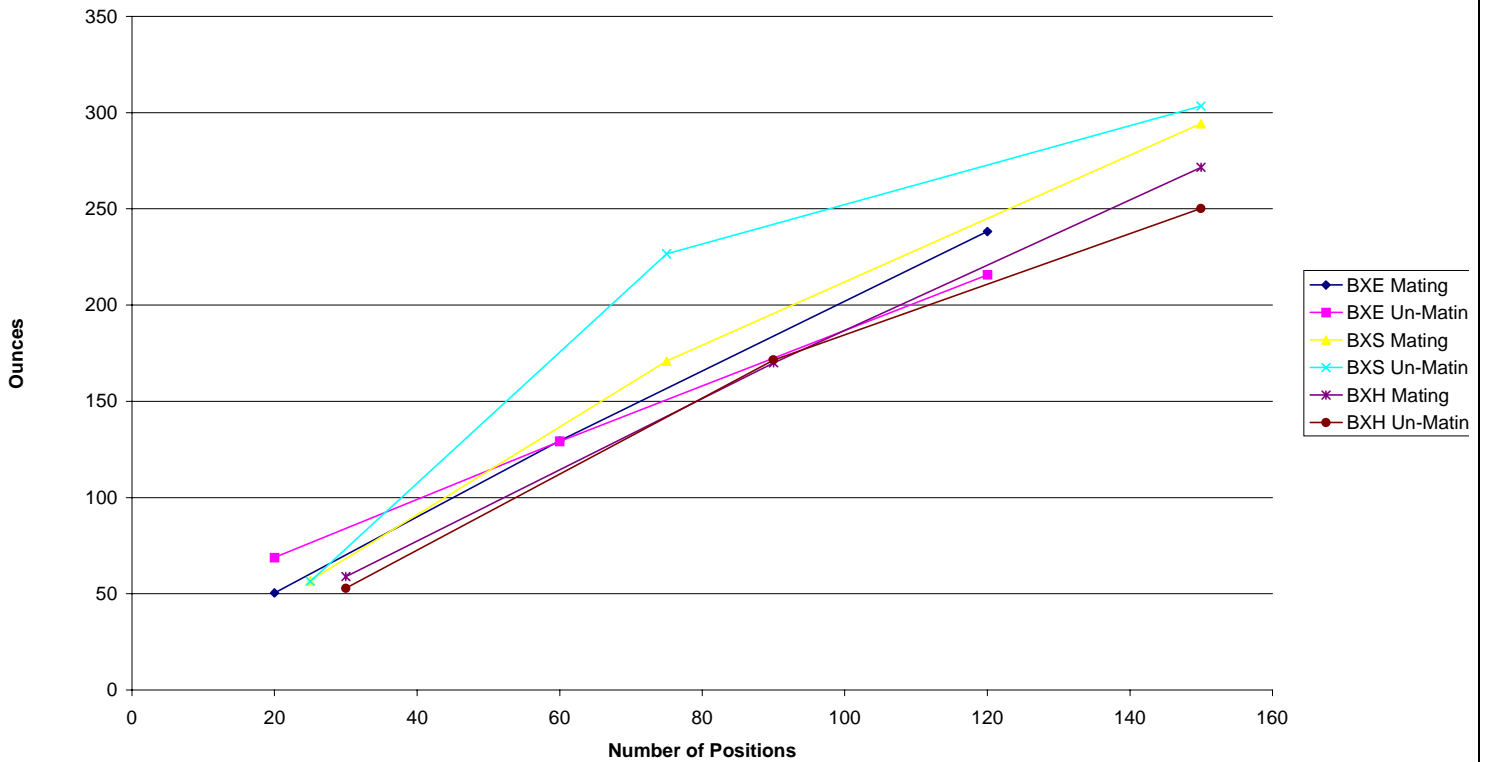
-
- **Mating Forces BXE Series Maximums**
 - BXE 20 Positions 57.1 oz.
 - BXE 60 Positions 133.2 oz.
 - BXE 120 Positions 246.2 oz.
 - **Unmating Forces BXE Series Maximums**
 - BXE 20 Positions 77.4 oz.
 - BXE 60 Positions 142.1 oz.
 - BXE 120 Positions 236.5 oz.
-
- **Mating Forces BXS Series Maximums**
 - BXS 25 Positions 61.0 oz.
 - BXS 75 Positions 179.8 oz.
 - BXS 150 Positions 320.4 3 oz.
 - **Unmating Forces BXS Series Maximums**
 - BXS 25 Positions 59.5 oz.
 - BXS 75 Positions 234.7 oz.
 - BXS 150 Positions 325.0 oz.
-
- **Mating Forces BXH Series Maximums**
 - BXH 30 Positions 65.3 oz.
 - BXH 90 Positions 175.5 oz.
 - BXH 150 Positions 280.0 oz.
 - **Unmating Forces BXH Series Maximums**
 - BXH 30 Positions 66.6 oz.
 - BXH 90 Positions 182.2 oz.
 - BXH 150 Positions 273.6 oz.



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Test Start: 3/29/02		Test Completed: 6/6/02			

RESULTS BXX Series (graphs)

Trends
BXX Series



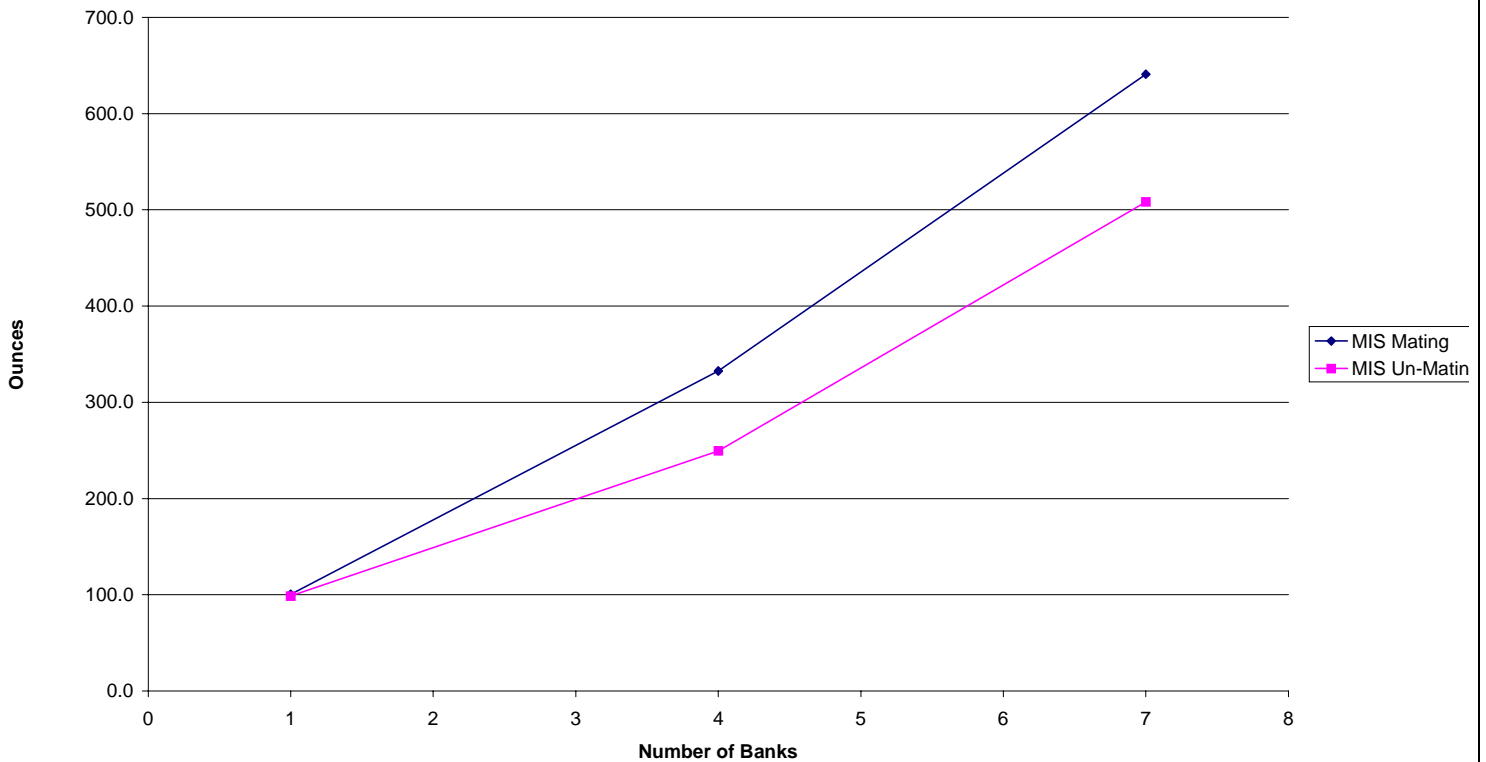


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RESULTS MIS Series (data)

- **Mating Forces MIS Series Maximums**
 - MIS 1 Bank----- 115.2 oz.
 - MIS 4 Bank----- 360.5 oz.
 - MIS 7 Bank----- 694.6 oz.
- **Unmating Forces MIS Series Maximums**
 - MIS 1 Bank----- 109.3 oz.
 - MIS 4 Bank----- 293.3 oz.
 - MIS 7Bank ----- 541.1 oz.

Trends
MIX Series





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RESULTS QXX Series (data)

- **Mating Forces QXE Series Maximums**
 - QXE 1 Bank -----60.0 oz.
 - QXE 3 Bank -----163.8 oz.
 - QXE 5 Bank -----287.2 oz.

- **Unmating Forces QXE Series Maximums**
 - QXE 1 Bank -----64.2 oz.
 - QXE 3 Bank -----169.3 oz.
 - QXE 5 Bank -----302.1 oz.

-
- **Mating Forces QXS Series Maximums**
 - QXS 1 Bank -----60.6 oz.
 - QXS 3 Bank -----213.4 oz.
 - QXS 5 Bank -----339.2 oz.

 - **Unmating Forces QXS Series Maximums**
 - QXS 1 Bank -----62.7 oz.
 - QXS 3 Bank -----187.4 oz.
 - QXS 5 Bank -----264.3 oz.

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- **Mating Forces QXH Series Maximums**
 - QXH 1 Bank-----72.0 oz.
 - QXH 3 Bank-----232.6 oz.
 - QXH 5 Bank-----434.6 oz.

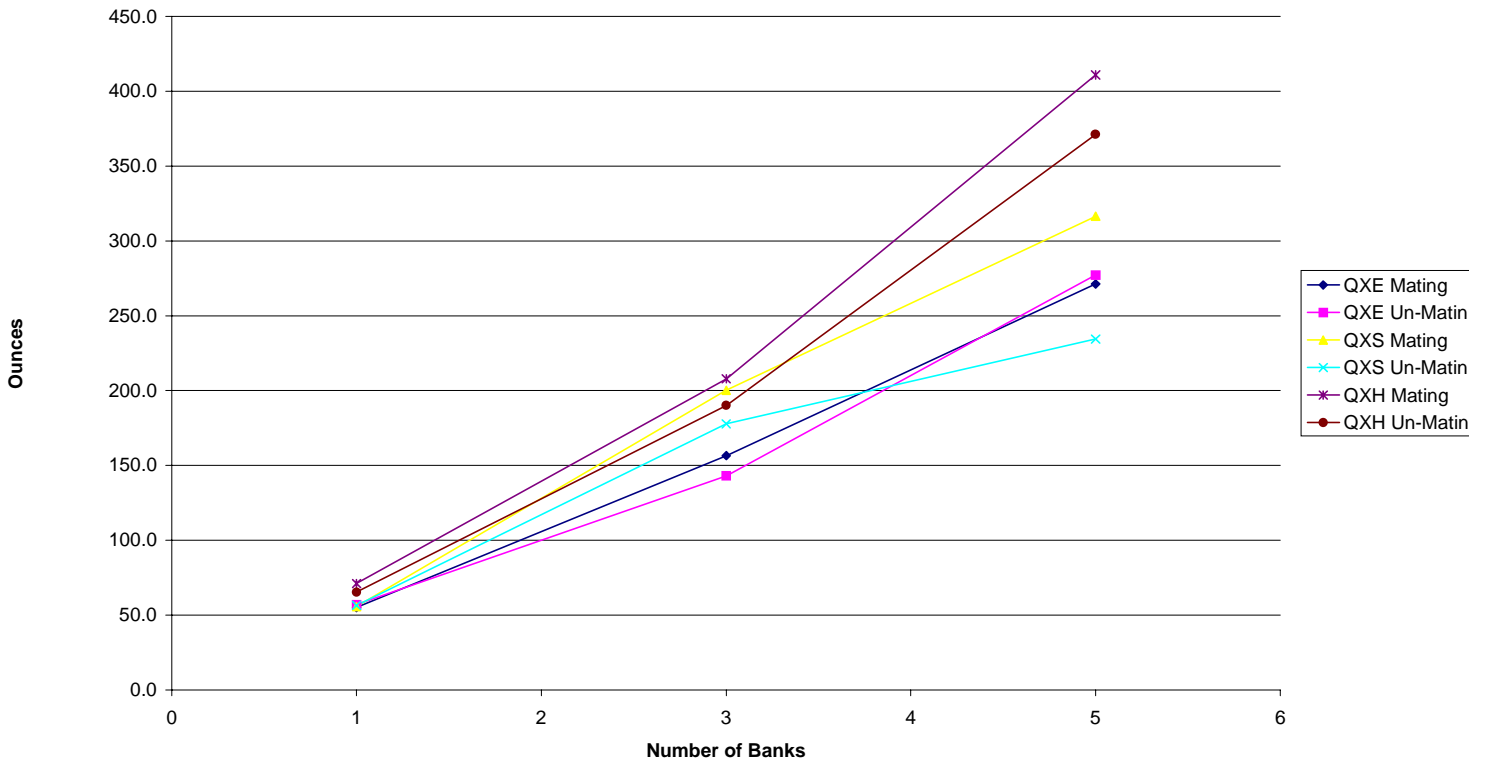
 - **Unmating Forces QXH Series Maximums**
 - QXH 1 Bank-----74.9 oz.
 - QXH 3 Bank-----213.3 oz.
 - QXH 5 Bank-----396.2 oz.



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RESULTS QXX Series (graphs)

Trends
QXX Series





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Test Start: 3/29/02				Test Completed: 6/6/02											

DATA SUMMARY

MATING/UNMATING:

BXE Series

	20 Position				60 Position				120 Position			
	Mating		Ummating		Mating		Ummating		Mating		Ummating	
	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs
Minimum	48.3	3.0	59.0	3.7	123.0	7.7	118.7	7.4	224.3	14.0	190.4	11.9
Maximum	57.1	3.6	77.4	4.8	133.3	8.3	142.1	8.9	246.2	15.4	236.5	14.8
Average	50.4	3.2	68.8	4.3	129.5	8.1	129.1	8.1	238.2	14.9	215.7	13.5

BXS Series

	25 Position				75 Position				150 Position			
	Mating		Ummating		Mating		Ummating		Mating		Ummating	
	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs
Minimum	53.0	3.3	53.0	3.3	161.1	10.1	214.7	13.4	271.2	17.0	279.8	17.5
Maximum	61.0	3.8	59.5	3.7	179.8	11.2	234.7	14.7	320.5	20.0	325.0	20.3
Average	56.8	3.5	56.4	3.5	170.8	10.7	226.6	14.2	294.3	18.4	303.4	19.0

BXH Series

	30 Position				90 Position				150 Position			
	Mating		Ummating		Mating		Ummating		Mating		Ummating	
	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs
Minimum	49.4	3.1	44.3	2.8	166.9	10.4	141.6	8.9	260.5	16.3	221.3	13.8
Maximum	65.3	4.1	66.6	4.2	175.5	11.0	182.2	11.4	280.0	17.5	273.6	17.1
Average	58.9	3.7	52.8	3.3	170.0	10.6	171.5	10.7	271.6	17.0	250.2	15.6



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Test Start: 3/29/02		Test Completed: 6/6/02					

DATA SUMMARY continued

MATING/UNMATING:

MIS Series

	One Bank				Four Bank				Seven Bank			
	Mating		Ummating		Mating		Ummating		Mating		Ummating	
	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs
Minimum	81.0	5.1	85.9	5.4	303.2	19.0	203.2	12.7	579.7	36.2	457.1	28.6
Maximum	115.2	7.2	109.3	6.8	360.5	22.5	293.3	18.3	694.6	43.4	541.1	33.8
Average	100.3	6.3	98.7	6.2	332.5	20.8	249.5	15.6	641.0	40.1	508.3	31.8



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Test Start: 3/29/02		Test Completed: 6/6/02					

DATA SUMMARY continued

MATING/UNMATING:

QXE Series

	One Bank				Three Bank				Five Bank			
	Mating		Ummating		Mating		Ummating		Mating		Ummating	
	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs
Minimum	52.2	3.3	53.3	3.3	151.4	9.5	117.0	7.3	259.7	16.2	261.1	16.3
Maximum	60.0	3.8	64.2	4.0	163.8	10.2	169.3	10.6	287.2	18.0	302.1	18.9
Average	55.0	3.4	57.0	3.6	156.6	9.8	143.1	8.9	271.3	17.0	277.3	17.3

QXS Series

	One Bank				ThreeBank				Five Bank			
	Mating		Ummating		Mating		Ummating		Mating		Ummating	
	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs
Minimum	51.8	3.2	48.3	3.0	179.8	11.2	157.9	9.9	301.8	18.9	201.4	12.6
Maximum	60.6	3.8	62.7	3.9	213.4	13.3	187.4	11.7	339.2	21.2	264.3	16.5
Average	55.6	3.5	56.4	3.5	200.2	12.5	177.7	11.1	316.5	19.8	234.4	14.7

QXH Series

	One Bank				Three Bank				Five Bank			
	Mating		Ummating		Mating		Ummating		Mating		Ummating	
	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs
Minimum	69.6	4.4	57.1	3.6	193.6	12.1	169.4	10.6	395.0	24.7	347.0	21.7
Maximum	72.0	4.5	74.9	4.7	232.6	14.5	213.3	13.3	434.6	27.2	396.2	24.8
Average	71.1	4.4	65.2	4.1	207.8	13.0	190.1	11.9	410.9	25.7	371.2	23.2



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DATA

MATING/UNMATING:

BXE Series

Test Date:	5/29/2002	5/29/2002	5/29/2002									
Operator:	GL	GL	GL									
Temperature (C):	25	25	25									
Humidity (RH):	39%	39%	39%									
Equipment Code Number	59	59	59									
Load Cell Code Number	60	60	60									
Readout Code Number												
Contact Description												
Contact Used In:	BSE/BTE	BSE/BTE	BSE/BTE									
Contact Mates With:												
	20 Position				60 Position				120 Position			
	Mating		Ummating		Mating		Ummating		Mating		Ummating	
Sample#	<u>Oz</u>	<u>Lbs</u>	<u>Oz</u>	<u>Lbs</u>	<u>Oz</u>	<u>Lbs</u>	<u>Oz</u>	<u>Lbs</u>	<u>Oz</u>	<u>Lbs</u>	<u>Oz</u>	<u>Lbs</u>
1	48.5	3.0	65.4	4.1	131.5	8.2	118.7	7.4	224.3	14.0	204.3	12.8
2	48.8	3.1	70.4	4.4	130.2	8.1	124.8	7.8	243.5	15.2	190.4	11.9
3	57.1	3.6	77.4	4.8	129.4	8.1	129.3	8.1	245.6	15.4	233.6	14.6
4	49.3	3.1	59.0	3.7	133.3	8.3	142.1	8.9	231.4	14.5	213.8	13.4
5	48.3	3.0	71.7	4.5	123.0	7.7	130.7	8.2	246.2	15.4	236.5	14.8



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DATA continued

MATING/UNMATING:

BXS Series

Test Date:	5/29/2002	5/29/2002	5/29/2002
Operator:	GL	GL	GL
Temperature (C):	25	25	25
Humidity (RH):	37%	37%	37%
Equipment Code Number	59	59	59
Load Cell Code Number	60	60	60
Readout Code Number			
Contact Description			
Contact Used In:	BSS/BTS	BSS/BTS	BSS/BTS
Contact Mates With:			

Sample#	25 Position				75 Position				150 Position			
	Mating		Ummating		Mating		Ummating		Mating		Ummating	
	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs
1	53.0	3.3	55.8	3.5	179.8	11.2	232.0	14.5	320.5	20.0	324.2	20.3
2	61.0	3.8	58.1	3.6	171.8	10.7	234.7	14.7	271.2	17.0	289.6	18.1
3	56.0	3.5	53.0	3.3	177.3	11.1	225.3	14.1	287.7	18.0	279.8	17.5
4	56.8	3.6	55.5	3.5	161.1	10.1	226.2	14.1	289.3	18.1	298.6	18.7
5	57.1	3.6	59.5	3.7	164.0	10.3	214.7	13.4	302.9	18.9	325.0	20.3



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DATA continued

MATING/UNMATING:

BXH Series

Test Date:	6/6/2002		6/6/2002		6/6/2002	
Operator:	GL		GL		GL	
Temperature (C):	25		25		25	
Humidity (RH):	38%		38%		38%	
Equipment Code Number	59		59		59	
Load Cell Code Number	60		60		60	
Readout Code Number						
Contact Description						
Contact Used In:	BSH/BTH		BSH/BTH		BSH/BTH	

Sample#	30 Position				90 Position				150 Position			
	Mating		Ummating		Mating		Ummating		Mating		Ummating	
	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs
1	65.3	4.1	46.1	2.9	167.4	10.5	182.2	11.4	277.4	17.3	221.3	13.8
2	64.6	4.0	66.6	4.2	175.5	11.0	141.6	8.9	270.7	16.9	258.2	16.1
3	49.4	3.1	56.5	3.5	166.9	10.4	174.4	10.9	269.6	16.9	272.0	17.0
4	59.5	3.7	44.3	2.8	169.4	10.6	178.9	11.2	280.0	17.5	273.6	17.1
5	55.7	3.5	50.4	3.2	170.6	10.7	180.2	11.3	260.5	16.3	225.9	14.1



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DATA continued

MATING/UNMATING:

MIS Series

Test Date:	5/30/2002	5/30/2002	5/30/2002
Operator:	GL	GL	GL
Temperature (C):	21	21	21
Humidity (RH):	48%	48%	48%
Equipment Code Number	59	59	59
Load Cell Code Number	60	60	60
Readout Code Number			
Contact Description			
Contact Used In:	MIS/MIT	MIS/MIT	MIS/MIT
Contact Mates With:			

Sample#	One Bank				Four Bank				Seven Bank			
	Mating		Ummating		Mating		Ummating		Mating		Ummating	
	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs
1	81.0	5.1	85.9	5.4	332.0	20.8	293.3	18.3	598.2	37.4	457.1	28.6
2	100.8	6.3	109.3	6.8	337.1	21.1	231.4	14.5	677.8	42.4	535.2	33.5
3	115.2	7.2	91.0	5.7	303.2	19.0	203.2	12.7	654.7	40.9	510.4	31.9
4	102.1	6.4	107.4	6.7	360.5	22.5	276.5	17.3	694.6	43.4	541.1	33.8
5	102.4	6.4	99.7	6.2	329.8	20.6	243.4	15.2	579.7	36.2	497.6	31.1



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Part #: See Front Page	Lot #: 03/18/02	Tech: G.Lewis	Eng: J. Tozier
Part description: 0.8mm, 0.635mm, 0.5mm Quiet & Basic High Speed Products			Qty to test: 210
Test Start: 3/29/02	Test Completed: 6/6/02		

DATA continued

MATING/UNMATING:

QXE Series

Test Date:	6/3/2002	6/3/2002	6/3/2002
Operator:	GL	GL	GL
Temperature (C):	21	21	21
Humidity (RH):	51%	51%	51%
Equipment Code Number	59	59	59
Load Cell Code Number	60	60	60
Readout Code Number			
Contact Description			
Contact Used In:	QSE/QTE	QSE/QTE	QSE/QTE

Sample#	One Bank				Three Bank				Five Bank			
	Mating		Ummating		Mating		Ummating		Mating		Ummating	
	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs
1	58.2	3.6	56.3	3.5	Lbs	Oz	Lbs	8.0	Lbs	Oz	Lbs	16.3
2	60.0	3.8	64.2	4.0	Lbs	Oz	Lbs	7.3	Lbs	Oz	Lbs	18.9
3	52.3	3.3	53.3	3.3	Lbs	Oz	Lbs	9.4	Lbs	Oz	Lbs	17.2
4	52.2	3.3	56.0	3.5	Lbs	Oz	Lbs	9.4	Lbs	Oz	Lbs	16.9
5	52.2	3.3	55.0	3.4	Lbs	Oz	Lbs	10.6	Lbs	Oz	Lbs	17.4



Project Number: NA		Tracking Code: 0212--0640			
Requested by: W. Ouyang		Date: 3/22/02		Product Rev: See Front Page	
Part #: See Front Page		Lot #: 03/18/02	Tech: G.Lewis		Eng: J. Tozier
Part description: 0.8mm, 0.635mm, 0.5mm Quiet & Basic High Speed Products				Qty to test: 210	
Test Start: 3/29/02		Test Completed: 6/6/02			

DATA continued

MATING/UNMATING:

QXS Series

Test Date:	5/31/2002	5/31/2002	5/31/2002
Operator:	GL	GL	GL
Temperature (C):	21	21	21
Humidity (RH):	45%	45%	45%
Equipment Code Number	59	59	59
Load Cell Code Number	60	60	60
Readout Code Number			
Contact Description			
Contact Used In:	QSS/QTS	QSS/QTS	QSS/QTS

Sample#	One Bank				Three Bank				Five Bank			
	Mating		Ummating		Mating		Ummating		Mating		Ummating	
	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs
1	57.8	3.6	57.8	3.6	210.6	13.2	187.4	11.7	319.8	20.0	255.5	16.0
2	54.1	3.4	48.3	3.0	197.4	12.3	182.1	11.4	301.8	18.9	243.5	15.2
3	60.6	3.8	62.7	3.9	199.8	12.5	178.7	11.2	306.1	19.1	201.4	12.6
4	53.8	3.4	57.0	3.6	179.8	11.2	157.9	9.9	339.2	21.2	264.3	16.5
5	51.8	3.2	56.5	3.5	213.4	13.3	182.6	11.4	315.5	19.7	207.4	13.0



Project Number: NA		Tracking Code: 0212--0640	
Requested by: W. Ouyang		Date: 3/22/02	Product Rev: See Front Page
Part #: See Front Page	Lot #: 03/18/02	Tech: G.Lewis	Eng: J. Tozier
Part description: 0.8mm, 0.635mm, 0.5mm Quiet & Basic High Speed Products			Qty to test: 210
Test Start: 3/29/02	Test Completed: 6/6/02		

DATA continued

MATING/UNMATING:

QXH Series

Test Date:	5/31/2002	5/31/2002	5/31/2002
Operator:	GL	GL	GL
Temperature (C):	25	25	25
Humidity (RH):	36%	36%	36%
Equipment Code Number	59	59	59
Load Cell Code Number	60	60	60
Readout Code Number			
Contact Description			
Contact Used In:	QSH/QTH	QSH/QTH	QSH/QTH

Sample#	One Bank				Three Bank				Five Bank			
	Mating		Ummating		Mating		Ummating		Mating		Ummating	
	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs	Oz	Lbs
1	71.8	4.5	57.1	3.6	198.6	12.4	206.1	12.9	408.8	25.6	382.9	23.9
2	72.0	4.5	63.4	4.0	208.2	13.0	186.1	11.6	409.0	25.6	374.6	23.4
3	70.4	4.4	66.9	4.2	206.2	12.9	213.3	13.3	407.2	25.5	347.0	21.7
4	71.8	4.5	64.0	4.0	232.6	14.5	175.5	11.0	395.0	24.7	355.4	22.2
5	69.6	4.4	74.9	4.7	193.6	12.1	169.4	10.6	434.6	27.2	396.2	24.8



Project Number: NA		Tracking Code: 0212--0640	
Requested by: W. Ouyang		Date: 3/22/02	Product Rev: See Front Page
Part #: See Front Page	Lot #: 03/18/02	Tech: G.Lewis	Eng: J. Tozier
Part description: 0.8mm, 0.635mm, 0.5mm Quiet & Basic High Speed Products			Qty to test: 210
Test Start: 3/29/02	Test Completed: 6/6/02		

EQUIPMENT AND CALIBRATION SCHEDULES

Equipment #: 59

Description: Dillon Quantrol TC2 Test Stand

Manufacturer: Dillon Quantrol

Model: TC2

Serial #: 02-1033-03

Accuracy: Speed Accuracy: +/- 5% of indicated speed; Displacement: +/- 5 micrometers.

... Last Cal: 03/21/02, Next Cal: 03/21/03

Equipment #: 60

Description: 2500 N Load Cell for Dillon Quantrol

Manufacturer: Dillon Quantrol

Model: icell

Serial #: 01-0132-01

Accuracy: .10% of capacity

... Last Cal: 3/21/02, Next Cal: 3/21/03