



ENGINEERING DEPT.	PRODUCT SPECIFICATION For CI15 Series Connector System	SPEC.NO.: SPCI033E
		PAGE: 1/5

1. SCOPE:

This specification contains the test requirement of subject connectors when tested under the condition and procedure with terminals crimped on the specified maximum size wire

2. APPLICABLE STANDARDS:

- MIL - STD - 202 Methods for test of connectors for electronic equipment
- MIL - STD - 1344 Test methods for electrical connectors
- J-STD-020 Resistance to soldering Temperature for through hole Mounted Devices
- SS-00254 Test methods for electronic components ,LEAD-FREE soldering Part design standards

3. APPLICABLE SERIES NO: CI15 Series

4. SHAPE, CONSTRUCTION AND DIMENSIONS

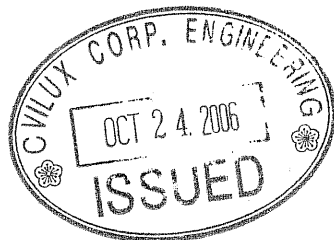
See attached drawings

5. MATERIALS

See attached drawings

6. ACCOMMODATED P.C.BOARD

- 6.1 Thickness: 0.6 mm (.024") ~ 1.2 mm (.047"),1.6mm(.063")
- 6.2 P.C. Board Layout: See attached drawings



REVIEWED : Alp APPROVED : Pavin VERIFIED : Hank



ENGINEERING DEPT.	PRODUCT SPECIFICATION For CI15 Series Connector System	SPEC.NO.: SPCI033E
		PAGE: 2/5

7. ELECTRICAL PERFORMANCE:

	ITEM	TEST CONDITION	REQUIREMENT
7.1	Rated current and voltage		1.0A AC/DC(AWG#26) 50V AC/DC (r.m.s.)
7.2	Contact resistance	Dry circuit of DC 20 mV max. , 100 mA max.	Less than 20 mΩ(Initial)
7.3	Dielectric strength	When applied AC 500 V 1 minute between adjacent terminal	No change
7.4	Insulation resistance	When applied DC 500 V between adjacent terminal or ground	More than 500 MΩ

8. MECHANICAL PERFORMANCE:

	ITEM	TEST CONDITION	REQUIREMENT
8.1	Wire size	Specified wire size	Accepts AWG#26~#32
8.2	Terminal crimp Tensile strength	When crimped AWG#26 size wire When crimped AWG#28 size wire When crimped AWG#30 size wire When crimped AWG#32 size wire	More than 2.0 Kgf More than 1.3 Kgf More than 0.8 Kgf More than 0.6 Kgf
8.3	Single contact insertion force	Measure force to insertion using 0.50 mm square pin at speed 25± 3 mm per minute	700 gram max.
8.4	Single contact withdrawal force	Measure force to withdrawal using 0.50 mm square pin at speed 25± 3 mm per minute	100 gram min.
8.5	Terminal insertion force	Insertion speed 25± 3 mm per minute into housing	Less than 500 gram
8.6	Contact retaining force in insulator	Retention speed 25± 3 mm per minute from housing	More than 0.7 Kgf
8.7	Durability	Connector shall be subjected to 100 cycles of insertion and withdrawal	Contact resistance: Less than twice of initial
8.8	Pin retention force	Push pin from insulator base at speed 25± 3 mm per minute	More than 1.0 Kgf

9. ENVIRONMENTAL PERFORMANCE:

	ITEM	TEST CONDITION	REQUIREMENT
9.1	Temperature rise	Then carried the rated current	30°C max.



ENGINEERING DEPT.	PRODUCT SPECIFICATION For CI15 Series Connector System	SPEC.NO.: SPCI033E
		PAGE: 3/5

9. ENVIRONMENTAL PERFORMANCE:

	ITEM	TEST CONDITION	REQUIREMENT
9.2	Vibration	1.5 mm 10-55-10 HZ / minute each 2 hours for X , Y and Z directions	Appearance: No damage Discontinuity: 1 micro second max.
9.3	Heat aging	85 ± 2 °C , 96 hours	No damage
9.4	Humidity	40 ± 2 °C , 90-95% RH , 96 hours measurement must be taken within 30 min. after tested	Appearance: No damage Contact resistance: Less than twice of initial Dielectric strength: To pass para 7-3
9.5	Temperature cycling	One cycle consists of : (1)-55 ⁺⁰ ₋₃ °C , 30 min. (2)Room temp. 10-15 min. (3) 85 ⁺³ ₋₀ °C , 30 min. (4)Room temp. 10-15 min.	Appearance: No damage Contact resistance: Less than twice of initial
9.6	Salt spray	Temperature: 35 ± 3 °C Solution: 5 ± 1% Spray time: 48 ± 4 hours Measurement must be taken after water rinse	Appearance: No damage Contact resistance: Less than twice of initial
9.7	Resistance to soldering heat	Tin-Lead Process: Soldering time: 5 ± 0.5 second Soldering pot: 240 ± 5 °C Lead-Free Process Soldering time: 5 ± 0.5 second Soldering pot: 260 ± 5 °C SMT Type Tin-Lead Process: Refer Reflow temperature profile(12.1) SMT Type Lead-Free Process: Soldering time: 20 second Max. Soldering pot: 250~260 °C Refer Reflow temperature profile(12.2)	No damage



ENGINEERING DEPT.	PRODUCT SPECIFICATION For CI15 Series Connector System	SPEC.NO.: SPCI033E
		PAGE: 4/5

	ITEM	TEST CONDITION	REQUIREMENT
9.8	Solder ability	Tin-Lead Process: Soldering time: 5 ± 0.5 second Soldering pot: $230 \pm 5^{\circ}\text{C}$ Lead-Free Process: Soldering time: 3 ± 0.5 second Soldering pot: $245 \pm 5^{\circ}\text{C}$	Minimum: 90% of immersed area

10. AMBIENT TEMPERATURE RANGE: -25 to $+85^{\circ}\text{C}$

11. Mating and Unmating Force:

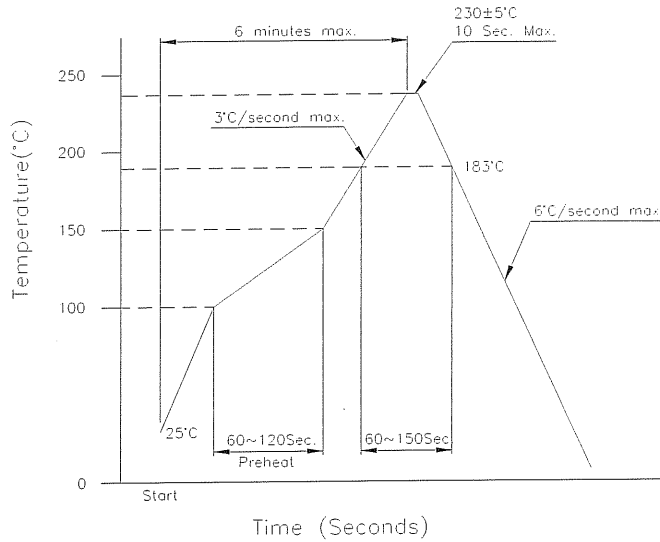
PIN No.	Mating(kgf max.)	Unmating(kgf min.)
2	2.5	0.5
3	3.0	0.6
4	3.5	0.7
5	4.0	0.8
6	4.5	0.9
7	5.0	1.0
8	5.5	1.1
9	5.0	1.2
10	6.5	1.3
11	7.0	1.4
12	7.5	1.5
13	8.0	1.6
14	8.5	1.7
15	9.0	1.8



ENGINEERING DEPT.	PRODUCT SPECIFICATION For CI15 Series Connector System	SPEC.NO.: SPCI033E
		PAGE: 5/5

12. Recommended IR Reflow Temperature Profile:

12.1 Using Typical Solder Paste



12.2 Using Lead-Free Solder Paste

