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**CONTACTS, ELECTRICAL, CRIMP
FOR 3401/002 CONNECTORS**

ESCC Detail Specification No. 3401/005

**ISSUE 2
April 2003**



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DOCUMENTATION CHANGE NOTICE

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DCR No.	CHANGE DESCRIPTION
35	Specification upissued to incorporate editorial and technical changes per DCR.

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APPENDICES (Applicable to specific Manufacturers only)

None.

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1. **GENERAL**

1.1 **SCOPE**

This specification details the ratings, physical and electrical characteristics, test and inspection data for Contacts, Electrical, Crimp, Gauge 20 and 22, for 3401/002 Connectors.

These contacts shall be packed separately from the connectors and may be procured either with the connectors or separately.

This specification shall be read in conjunction with:

- ESCC Generic Specification No. 3401, Connectors, Electrical, Non-Filtered, Circular and Rectangular,
- ESCC Detail Specification No. 3401/002, Connectors, Electrical, Rectangular, Removable Crimp Contacts, Based on Type D*MA,

the requirements of which are supplemented herein.

1.2 **TYPE VARIANTS**

The different sizes of contacts specified herein, which are also covered by this specification are scheduled in Table 1(a).

1.3 **MAXIMUM RATINGS**

The maximum ratings, which shall not be exceeded at any time during use or storage, applicable to the contacts specified herein, are scheduled in Table 1(b).

1.4 **PARAMETER DERATING INFORMATION (FIGURE 1)**

Not applicable.

1.5 **PHYSICAL DIMENSIONS**

The physical dimensions of the contacts specified herein are shown in Figure 2.



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TABLE 1(a) - TYPE VARIANTS

VAR- IANT	TYPE	MATING END SIZE	CRIMP BARREL SIZE	RATED CUR- RENT	ACCEPT WIRE	MAX WEIGHT	ENGAGEMENT & SEPARATION		TEST PINS		CONTACT CAPABILITY		CON- TACT RETENT. FORCE MAX	CON- TACT INSERT WITHDR FORCES MAX	PROBE DAMAGE		OVERSIZE PIN EXCL.	
							ENGAG. FORCES N (1)	SEPAR. FORCES N (1)	min.	max.	Drop (3) g	Pick-up (2) g			MO- MENT N.cm	PROBE DIA mm	FORCE MAX	TEST PIN DIA mm
01	Male	20	20	7.5	20 22 24	0.16	-	-	-	-	-	-	18.50	-	-	-	-	-
	Female						3.33	2.22 0.28	1.039 0.990	1.040 0.993	-	226.80 28.35	40	18.50	5.65	1.007	1.033	3.33
02	Male	20	26	3.0	26 28	0.18	-	-	-	-	-	-	18.50	-	-	-	-	-
	Female						3.33	2.22 0.28	1.039 0.990	1.040 0.993	-	226.80 28.35	40	18.50	5.65	1.007	1.033	3.33
03	Male	20	18	7.5	18 20	0.25	-	-	-	-	-	-	18.50	-	-	-	-	-
	Female						3.33	2.22 0.28	1.039 0.990	1.040 0.993	-	226.80 28.35	40	18.50	5.65	1.007	1.033	3.33
04	Male	22	22	5.0	22 24 26	0.08	-	-	-	-	-	-	18.50	-	-	-	-	-
	Female						3.33	2.22 0.20	0.773 0.749	0.775 0.751	-	226.80 19.84	40	18.50	1.30	0.749	0.774	2.43

NOTES

- 1st line, maximum values with maximum diameter test pin;
2nd line, minimum values with minimum diameter test pin.
- With minimum diameter test pin and minimum insertion depth of 4.0mm.
- With maximum diameter test pin and minimum insertion depth of 4.0mm.



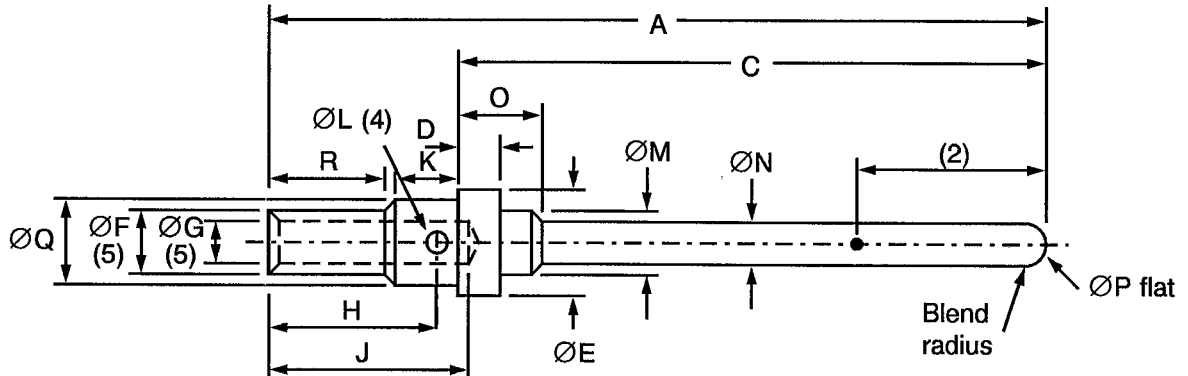
TABLE 1(b) - MAXIMUM RATINGS

No.	CHARACTERISTICS	SYMBOL	MAXIMUM RATING		UNIT
			MIN.	MAX.	
1	Rated Current	I_{CR}	-	See Table 1(a)	A
2	Operating Temperature Range	T_{op}	-55	+125	°C
3	Storage Temperature Range	T_{stg}	-65	+125	°C

FIGURE 1 - PARAMETER DERATING INFORMATION

Not applicable

FIGURE 2 - PHYSICAL DIMENSIONS
VARIANTS 01 AND 03 - MALE CONTACTS

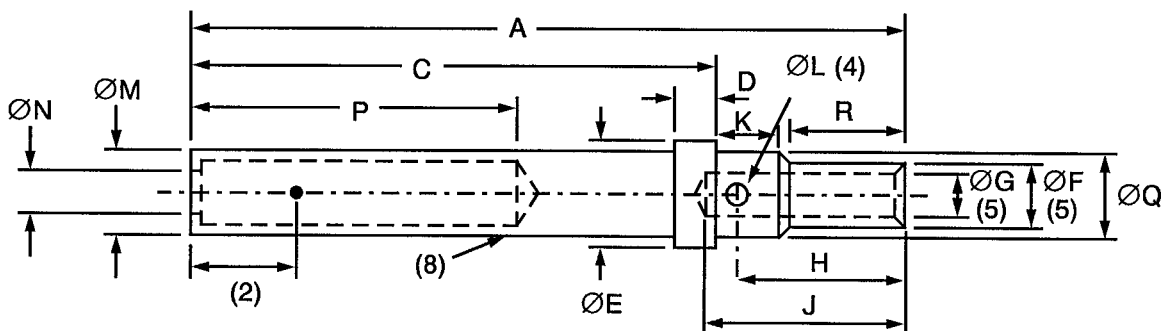


	A	<u>C</u>	D	<u>ØE</u>	ØF	<u>ØG</u> (6)	H	J	K	ØL (7)	ØM	<u>ØN</u>	<u>O</u>	ØP	<u>ØQ</u>	R
Min.	-	9.80	0.72	2.08	1.65	1.09	3.40	3.80	1.01	0.60	1.78	0.99	1.65	-	1.70	2.40
Max.	14.14	10.0	0.86	2.16	1.73	1.17	3.68	4.70	1.25	0.80	1.85	1.04	1.75	0.30	1.80	-

NOTES

- All dimensions are in millimetres.
- Measurement point for plating thickness: 4.0 ± 1.0 .
- Underlined dimensions, in table, are critical to ensure intermateability and interchangeability.
- Inspection hole may be $\varnothing L$ square and shall only penetrate one wall of the crimp barrel.
- $\varnothing F$ and $\varnothing G$ to be concentric within 0.04.
- $\varnothing G$ of Variant 03 shall be 0.59 minimum, 0.66 maximum.
- $\varnothing L$ of Variant 03 shall be 0.45 minimum, 0.55 maximum.

VARIANTS 02 AND 04 - FEMALE CONTACTS



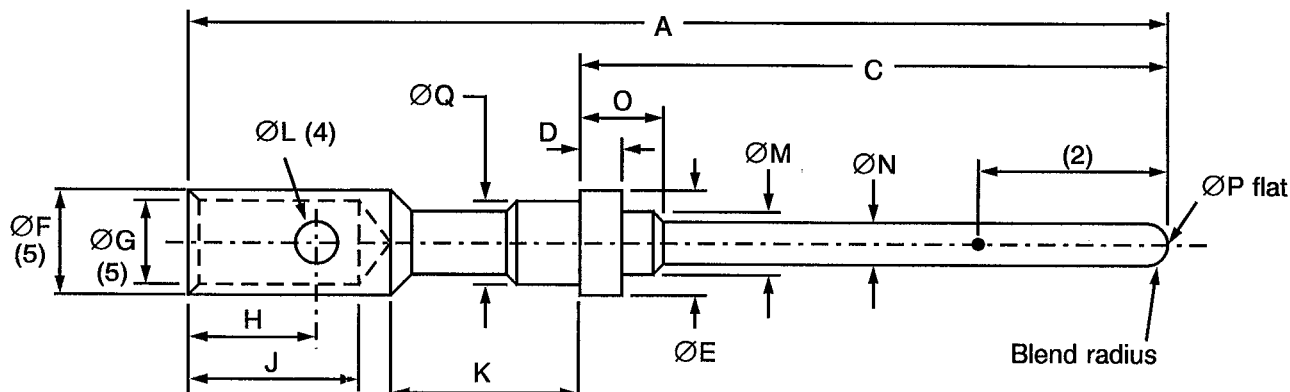
	A	<u>C</u>	D	<u>ØE</u>	ØF	<u>ØG</u> (6)	H	J	K	ØL	ØM	<u>ØN</u>	<u>P</u>	<u>ØQ</u>	R
Min.	-	9.45	0.72	2.08	1.65	1.09	3.40	3.80	1.01	0.60	1.70	1.07	7.0	1.70	2.40
Max.	13.80	9.65	0.86	2.16	1.73	1.17	3.68	4.70	1.25	0.80	1.85	1.14	-	1.80	-

NOTES

- All dimensions are in millimetres.
- Measurement point for plating thickness: 2.0 ± 1.0 .
- Underlined dimensions, in table, are critical to ensure intermateability and interchangeability.
- Inspection hole may be $\varnothing L$ square and shall only penetrate one wall of the crimp barrel.
- $\varnothing F$ and $\varnothing G$ to be concentric within 0.04.
- $\varnothing G$ of Variant 04 shall be 0.59 minimum, 0.66 maximum.
- $\varnothing L$ of Variant 04 shall be 0.45 minimum, 0.55 maximum.
- The mechanical pressure member shall be shrouded. Sleeve, if used, shall conform to the applicable requirements.

FIGURE 2 - PHYSICAL DIMENSIONS (CONTINUED)

VARIANT 05 - MALE CONTACT

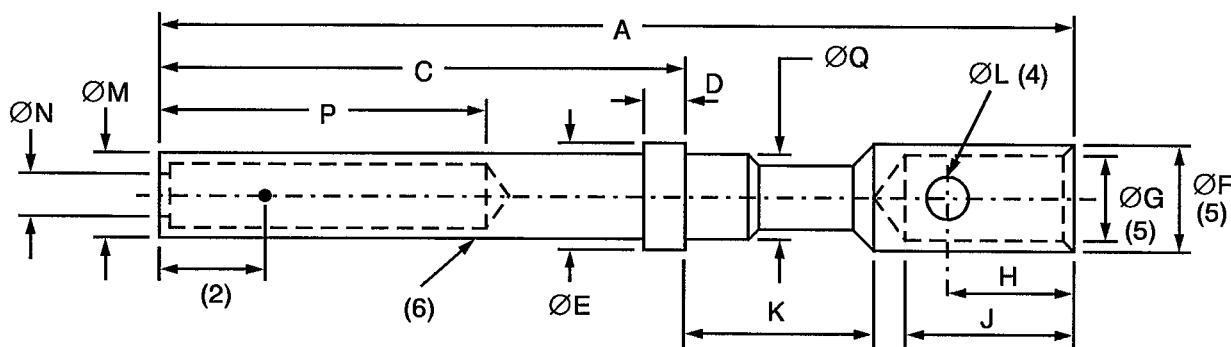


	A	<u>C</u>	D	<u>ØE</u>	ØF	<u>ØG</u>	H	J	K	ØL	ØM	<u>ØN</u>	<u>O</u>	ØP	<u>ØQ</u>
Min.	-	9.80	0.72	2.08	2.09	1.65	3.80	4.32	6.15	0.60	1.78	0.99	1.65	-	1.70
Max.	21.13	10.0	0.86	2.16	2.18	1.74	4.00	4.70	6.45	0.80	1.85	1.04	1.75	0.30	1.80

NOTES

1. All dimensions are in millimetres.
2. Measurement point for plating thickness: 4.0 ± 1.0 .
3. Underlined dimensions, in table, are critical to ensure intermateability and interchangeability.
4. Inspection hole may be $\varnothing L$ square and shall only penetrate one wall of the crimp barrel.
5. $\varnothing F$ and $\varnothing G$ to be concentric within 0.04.

VARIANT 06 - FEMALE CONTACT

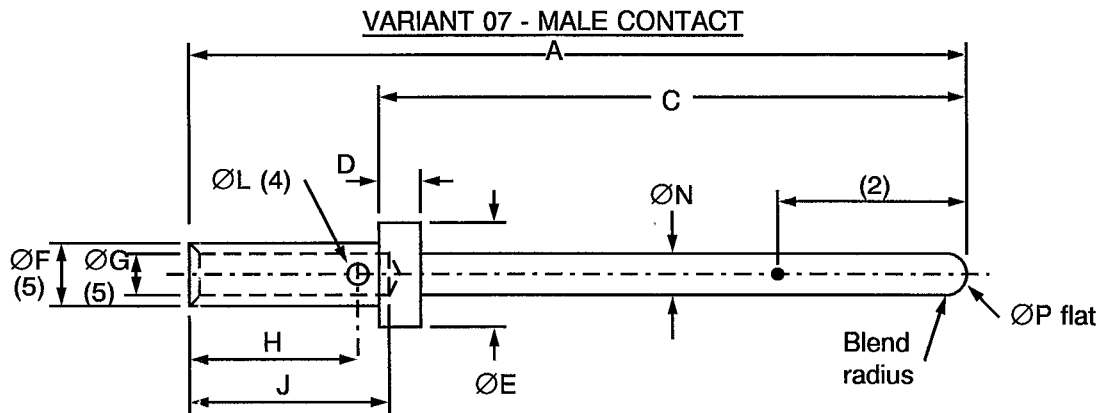


	A	<u>C</u>	D	<u>ØE</u>	ØF	<u>ØG</u>	H	J	K	ØL	ØM	<u>ØN</u>	<u>P</u>	<u>ØQ</u>
Min.	-	9.45	0.72	2.08	2.09	1.65	3.80	4.32	6.15	0.60	1.70	1.07	7.0	1.70
Max.	20.80	9.65	0.86	2.16	2.18	1.74	4.00	4.70	6.45	0.80	1.85	1.14	-	1.80

NOTES

1. All dimensions are in millimetres.
2. Measurement point for plating thickness: 2.0 ± 1.0 .
3. Underlined dimensions, in table, are critical to ensure intermateability and interchangeability.
4. Inspection hole may be $\varnothing L$ square and shall only penetrate one wall of the crimp barrel.
5. $\varnothing F$ and $\varnothing G$ to be concentric within 0.04.
6. The mechanical pressure member shall be shrouded. sleeve, if used, shall conform to the applicable requirements.

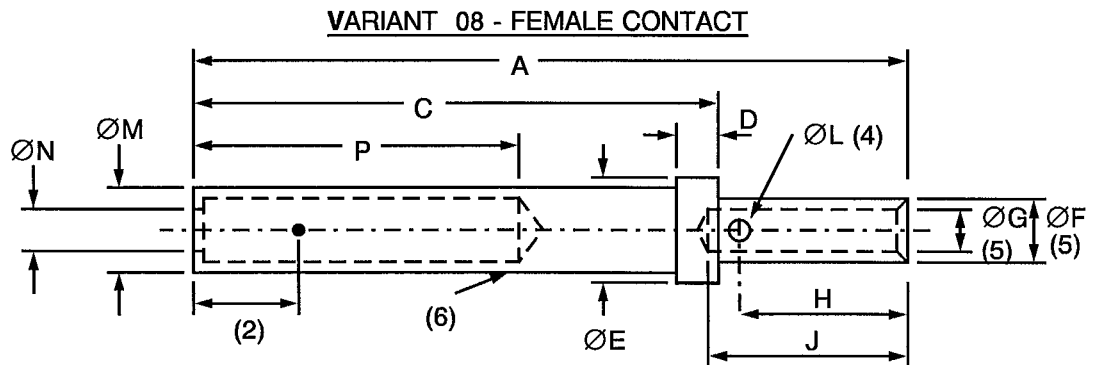
FIGURE 2 - PHYSICAL DIMENSIONS (CONTINUED)



	<u>A</u>	<u>C</u>	<u>D</u>	<u>ØE</u>	ØF	ØG	H	J	ØL	ØN	ØP
Min.	-	7.49	0.74	1.52	1.17	0.85	3.09	3.58	0.46	0.75	-
Max.	13.64	7.62	0.84	1.57	1.22	0.90	3.27	3.99	0.56	0.77	0.20

NOTES


1. All dimensions are in millimetres.
2. Measurement point for plating thickness: 4.0 ± 1.0 .
3. Underlined dimensions, in table, are critical to ensure intermateability and interchangeability.
4. Inspection hole may be ØL square and shall only penetrate one wall of the crimp barrel.
5. ØF and ØG to be concentric within 0.04.



	<u>A</u>	<u>C</u>	<u>D</u>	<u>ØE</u>	ØF	ØG	H	J	ØL	ØM	ØN	<u>P</u>
Min.	-	7.08	0.74	1.52	1.17	0.85	3.09	3.58	0.46	-	0.78	4.22
Max.	13.41	7.34	0.84	1.57	1.22	0.90	3.27	3.99	0.56	1.57	-	-

NOTES

1. All dimensions are in millimetres.
2. Measurement point for plating thickness: 2.0 ± 1.0 .
3. Underlined dimensions, in table, are critical to ensure intermateability and interchangeability.
4. Inspection hole may be ØL square and shall only penetrate one wall of the crimp barrel.
5. ØF and ØG to be concentric within 0.04.
6. The mechanical pressure member shall be shrouded. Sleeve, if used, shall conform to the applicable requirements.

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2. APPLICABLE DOCUMENTS

The following documents form part of this specification and shall be read in conjunction with it:-

- (a) ESCC Generic Specification No. 3401, Connectors, Electrical, Non-Filtered, Circular and Rectangular.
- (b) ESCC Detail Specification No. 3401/002, Connectors, Electrical, Rectangular, Removable Crimp Contacts, Based on Type D*MA.
- (c) MIL-G-45204, Gold Plating, Electro-deposited.
- (d) MIL-C-14450, Copper Plating, Electro-deposited.

3. TERMS, DEFINITIONS, ABBREVIATIONS, SYMBOLS AND UNITS

For the purpose of this specification, the terms, definitions, abbreviations, symbols and units specified in ESCC Basic Specification No. 21300 shall apply.

4. REQUIREMENTS

4.1 GENERAL

The complete requirements for procurement of the contacts specified herein are stated in this specification and ESCC Generic Specification No. 3401. Deviations from the Generic Specification, applicable to this Detail Specification only, are listed in Para. 4.2.

Deviations from the applicable Generic Specification and this Detail Specification, formally agreed with specific Manufacturers on the basis that the alternative requirements are equivalent to the ESCC requirements and do not affect the components' reliability, are listed in the appendices attached to this specification.

4.2 DEVIATIONS FROM GENERIC SPECIFICATION

4.2.1 Deviations from Special In-process Controls

None.

4.2.2 Deviations from Final Production Tests (Chart II)

None.

4.2.3 Deviations from Burn-in and Electrical Measurements (Chart III)

Not applicable.

4.2.4 Deviations from Qualification Tests (Chart IV)

- (a) Para. 9.31, Solderability: Not applicable.

4.2.5 Deviations from Lot Acceptance Tests (Chart V)

- (a) Para. 9.31, Solderability: Not applicable.



4.3 MECHANICAL REQUIREMENTS

4.3.1 Dimension Check

The dimensions of the contacts specified herein shall be verified in accordance with the requirements set out in Para. 9.6 of ESCC Generic Specification No. 3401 and shall conform to those shown in Figure 2 of this specification. Only the underlined dimensions shall be checked during procurement.

4.3.2 Weight

The maximum weight of the contacts specified herein shall be as specified in Table 1(a).

4.3.3 Contact Capability

For the purpose of this test, the pick-up and drop weights shall be as specified in Table 1(a).

4.3.4 Contact Retention (in insert)

The contact retention force shall be as specified in Table 1(a).

4.3.5 Mating and Unmating Forces

As specified in ESCC Detail Specification No. 3401/002.

4.3.6 Insert Retention (In Shell)

As specified in ESCC Detail Specification No. 3401/002.

4.3.7 Jackscrew Retention

As specified in ESCC Detail Specification No. 3401/002.

4.3.8 Contact Insertion and Withdrawal Forces

The contact insertion and withdrawal forces shall be as specified in Table 1(a).

4.3.9 Engagement and Separation Forces

The diameter of the test pin and the engagement and separation forces of the female contacts shall be as specified in Table 1(a).

4.3.10 Oversize Pin Exclusion

The diameter of the test pin and the force applied to it shall be as specified in Table 1(a).

4.3.11 Probe Damage

The probe diameter and the moment at the end of the probe shall be as specified in Table 1(a).

4.3.12 Solderability

Not applicable.

4.4 MATERIALS AND FINISHES

The materials and finishes shall be as specified herein. Where a definite material is not specified, a material which will enable the connectors specified herein to meet the performance requirements of this specification shall be used. Acceptance or approval of any constituent material does not guarantee acceptance of the finished product.

4.4.1 Shells

As specified in ESCC Detail Specification No. 3401/002.

4.4.2 Inserts

As specified in ESCC Detail Specification No. 3401/002.

4.4.3 Contacts

The contact body shall be made of copper alloy with an underplate of 1.0µm minimum of copper to MIL-C-14450, gold plated with 1.27µm of gold, Type 2 Grade C of MIL-G-45204.

The female contact spring element shall be made of copper alloy with an underplate of 1.0µm minimum of nickel or copper to MIL-C-14450, gold plated with 1.27µm minimum of gold, Type 2 Grade C of MIL-G-45204.

4.4.4 Contact Retaining Clip

As specified in ESCC Detail Specification No. 3401/002.

4.4.5 Guiding and Locking Devices

As specified in ESCC Detail Specification No. 3401/002.

4.4.6 Magnetism Level

As specified in ESCC Detail Specification No. 3401/002.

4.5 MARKING

4.5.1 General

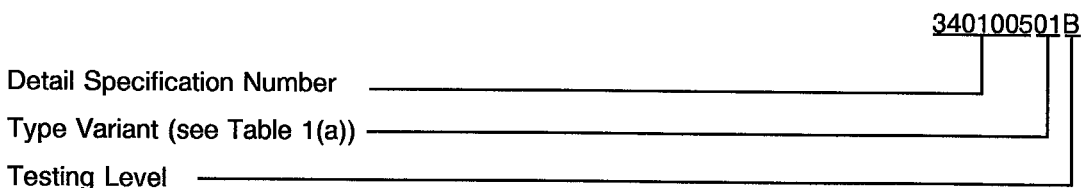
The marking of all components delivered to this specification shall be in accordance with the requirements of ESCC Basic Specification No. 21700 and the following subparagraphs.

These components being too small to accommodate the marking as specified hereafter, the full marking information shall accompany each lot of components in its primary package. Such marking shall comprise:-

- (a) The ESCC Component Number.
- (b) Traceability information.

4.5.2 The ESCC Component Number

The ESCC component number shall be constituted and marked as follows:-



4.5.3 Traceability Information

Traceability information shall be marked in accordance with ESCC Basic Specification No. 21700.



4.6 ELECTRICAL MEASUREMENTS

4.6.1 Electrical Measurements at Room Temperature

The parameters to be measured in respect of electrical characteristics are scheduled in Table 2. Unless otherwise specified these measurements shall be performed at $T_{amb} = +22 \pm 3$ °C.

4.6.2 Electrical Measurements at High and Low Temperatures (Table 3)

Not applicable.

4.6.3 Circuit for Electrical Measurements (Figure 4)

Not applicable.

4.7 BURN-IN AND ELECTRICAL MEASUREMENTS (TABLES 4 AND 5)

Not applicable.

4.8 ENVIRONMENTAL AND ENDURANCE TESTS

4.8.1 Measurements and Inspections on Completion of Environmental Tests

The parameters to be measured and inspections to be performed on completion of environmental testing are scheduled in Table 6. Unless otherwise specified, these measurements shall be performed at $T_{amb} = +22 \pm 3$ °C.

4.8.2 Measurements and Inspections at Intermediate Points during Endurance Tests

Not applicable.

4.8.3 Measurements and Inspections on Completion of Endurance Tests

The parameters to be measured and inspections to be performed on completion of endurance tests shall be those specified in Table 6. Unless otherwise specified, these measurements shall be performed at $T_{amb} = +22 \pm 3$ °C.

4.8.4 Conditions for Operating Life Test (Part of Endurance Testing)

Not applicable.

4.8.5 Electrical Circuits for Operating Life Test

Not applicable.

4.8.6 Conditions for High Temperature Storage Test (Part of Endurance Testing)

The requirements for the high temperature storage test are specified in Section 9 of ESCC Generic Specification No. 3401. The conditions for high temperature storage testing shall be the maximum storage temperature specified in Table 1(b) of this specification.

TABLE 2 - ELECTRICAL MEASUREMENTS AT ROOM TEMPERATURE

No.	CHARACTERISTICS	SYMBOL	SPEC. AND/OR TEST METHOD	TEST CONDITION	VARIANTS	LIMITS		UNIT
						MIN.	MAX.	
1	Contact Resistance (Low Level Current)	Rcl	ESCC No. 3401 Para 9.1.1.3	Para 9.1.1.3	All	-	6.0	mΩ
2	Contact Resistance (Rated Current)	Rcr	ESCC No. 3401 Para 9.1.1.3	Para 9.1.1.3	01,02,05,06 03,04 07,08	-	5.0	mΩ
				7.5A		-	5.0	mΩ
				3.0A		-	5.0	mΩ
				5.0A		-	5.0	mΩ

TABLES 3, 4 AND 5

Not applicable



TABLE 6 - MEASUREMENTS AND INSPECTIONS ON COMPLETION OF ENVIRONMENTAL AND ENDURANCE TESTS

NO.	ESCC GENERIC NO. 3401		MEASUREMENTS AND INSPECTIONS		SYMBOL	LIMITS		UNIT
	ENVIRONMENTAL AND ENDURANCE TESTS (1)	TEST METHOD AND CONDITIONS	IDENTIFICATION	CONDITIONS		MIN	MAX	
01	Wiring	Para. 9.10 & Table 1(a) of this spec.	Low Level Contact Resistance	Table 2 Item 1	Rcl	Table 2 Item 1		
02	Vibration	Para. 9.11	ESCC 3401/002					
03	Shock or Bump	Para. 9.12	ESCC 3401/002					
04	Climatic Sequence	Para. 9.13	ESCC 3401/002					
05	Seal Test	Para. 9.9	ESCC 3401/002					
06	Plating Thickness	Para. 9.14	Thickness	-	-	Para. 4.4.3 of this spec		
07	Joint Strength	Para. 9.15	ESCC 3401 Para 9.15					
08	Rapid Change of Temperature	Para. 9.16	ESCC 3401/002					
09	Contact Retention (in insert)	Para. 9.17 & Para. 4.3.4 of this spec.	Contact Displacement		-	ESCC 3401 Para. 9.17		
10	Endurance	Para. 9.18	Initial Low Level Contact Resist	Table 2 Item 1	Rcl	Record Values		mΩ
			Final Low Level Contact Resistance Drift	Table 2 Item 1	ΔRcl	-	3.0	
11	Permanence of Marking	Para. 9.19	As applicable					
12	Mating/Unmating Forces	Para. 9.20	ESCC 3401/002					
13	High Temperature Storage	Para. 9.21	Initial Low Level Contact Resist	Table 2 Item 1	Rcl	Record Values		mΩ
			Final Low Level Contact Resistance Drift	Table 2 Item 1	ΔRcl	-	3.0	
			Rated Current Contact Resistance	Table 2 Item 2	Rcr	Table 2 Item 2		
			Contact Retention (in insert)	Para. 4.3.4 of this spec.	-	ESCC 3401 Para. 9.17		
14	Corrosion	Para. 9.22	Visual Examination					

NOTES

1. The tests in this table refer to either Chart IV or V and shall be used as applicable.

TABLE 6 - MEASUREMENTS AND INSPECTIONS ON COMPLETION OF ENVIRONMENTAL AND ENDURANCE TESTS (CONTINUED)

NO.	ESCC GENERIC NO. 3401		MEASUREMENTS AND INSPECTIONS		SYMBOL	LIMITS		UNIT
	ENVIRONMENTAL AND ENDURANCE TESTS (1)	TEST METHOD AND CONDITIONS	IDENTIFICATION	CONDITIONS		MIN	MAX	
15	Insert Retention (in shell)	Para. 9.23 & Para. 4.3.6 of this spec.	ESCC 3401/002					
16	Jackscrew Retention	Para. 9.24 & Para. 4.3.7 of this spec.	ESCC 3401/002					
17	High Temperature Measurements	Para. 9.25	ESCC 3401/002					
18	Overload Test	Para. 9.26	Rated Current Contact Resistance	Table 2 Item 2	Rcr	Table 2 Item 2		
19	Maintenance Aging	Para. 9.27	Visual Examination Contact Retention Contact Insertion & Withdrawal Forces	- Para. 4.3.4 of this spec. Para. 4.3.8 of this spec.	- - -	ESCC 3401 Para. 9.17 Para. 4.3.8		
20	Engage/Separation Forces	Para. 9.28 & Para. 4.3.9 of this spec.	Force		-	Para. 4.3.9		
21	Oversize Pin Exclusion	Para. 9.29 & Para. 4.3.10 of this spec.			-	ESCC 3401 Para. 9.29		
22	Probe Damage	Para. 9.30 & Para. 4.3.11 of this spec.	Contact Separation Force	Para. 4.3.9 of this spec.	-	Para. 4.3.9		
23	Solderability	Para. 9.31 & Para. 4.3.12 of this spec.	Not applicable					

NOTES

1. The tests in this table refer to either Chart IV or V and shall be used as applicable.