

## HE series insert

### 1. INTRODUCTION

#### 1.1 Purpose

This document provides the qualification summary of TE Connectivity HE series insert of HDC connector.

#### 1.2 Scope

This specification covers the electrical, mechanical, and environmental performance of HE-024 inserts. Testing was performed at the TE Shanghai Electrical Components Test Laboratory.

#### 1.3 Conclusion

Based on the test results, all meet the requirements according to TE Connectivity Design Objectives 108-137044.

#### 1.4 Product Description

Name	Remarks
HE-024-M	Screw termination
HE-024-F	Screw termination
HE-024-MS	Spring termination
HE-024-FS	Spring termination
HE-024-MC	Crimp termination
HE-024-FC	Crimp termination

#### 1.5 Qualification Test Sequence

Test or Examination	Test Group						
	A	B	C	D	E	F	G
	Test Sequence						
Visual and dimensional examination	1,6	1,5	1,3	1,11	1,3	1,8	1,6
Durability of marking	2						
Polarization and coding (If application)	3						
Pull out force of terminations	7 <sup>a</sup>						
Only for Crimped connections							
Only for Screw less-type clamping units							
Only for Screw-type clamping units							
Contact retention force in insert	4						
Mechanical strength impact	5						

Mechanical Operation (Durability)		3					
Vibration, Random							3
Shock							4
Contact Resistance		2,4		2,8		2,5	2,5
Temperature Rise Test			2				
Dielectric Voltage Withstand Test				3,9		6	
Insulation Resistance				4,10		7	
Cold				5			
Dry Heat				6			
Damp Heat, cyclic						4	
Rapid Change of temperature (Temperature Cycle)						3	
Corrosion (Alternative)				7			
Protection against electric shock					2		

**\* Notes:**

- 1) Numbers indicate the sequence in which the tests are performed.
- 2) <sup>a</sup> test items are for themselves separate tests and are performed on new specimens.

**2. TEST PROCEDURE**

<b>General</b>			
No.	Test Items	Requirements	Condition according to
2.1	Visual and dimensional examination	Meets requirements of product drawing	Visual and dimensional examination IEC 60512-1-1/-2, Test 1a and 1b 6.2 of EN 61984

<b>Mechanical</b>			
2.2	Durability of marking	Marking shall be still readable according to 6.2 of EN61984 (If marking made by impression, molding, pressing or engraving or the like are not subjected to this test)	Test piston: Size 1 Wet test with liquid: water Duration: 10 cycles Force:5N IEC 60068-2-70 Test Xb (7.3.2 of EN61984)
2.3	Polarisation and coding	For multi-pole connector, require provision against incorrect mating according to 6.3 & 6.9.1 of EN 61984 No damage likely to impair function	For unenclosed connector (internal connections) 20N For enclosed connector (external connections) 1.5 x Mating force, but not higher than 80Ns Test 13e of IEC 60512-13-5

	Pull out force of terminations	See 6.6 of EN 61984	See 6.6 of EN 61984
2.4	<sup>a</sup> Only for crimp contact connection	The conductor shall not slip out of crimp barrel and pull out force as specified in Table 1 of IEC 60352-2	Visual tests on the crimp barrel and tensile strength test of the crimp connection as specified in IEC 60352-2.
	<sup>a</sup> Only for screw less-type clamping (spring or double spring clamp) contact connection	The conductor of the smallest and largest cross-sectional area shall not slip out of the clamping unit, and pull out force as specified in Table 3 IEC 60999-1 or IEC 60999-2	Mechanical tests on the conductor connection as specified in 9.3~9.5 of IEC 60999-1 or IEC 60999-2 or IEC 60352-7
	<sup>a</sup> Only for screw-type clamping contact connection	The conductor of the smallest and largest cross-sectional area shall not slip out of the clamping unit, and pull out force as specified in Table 3, and torque force as specified in Table 4 IEC 60999-1 or IEC 60999-2	Mechanical tests on the conductor connection as specified in 9.3~9.6 of IEC 60999-1 or IEC 60999-2
2.5	Contact retention force in insert	Test load shall be three times the specified insertion force (mating) of one contact, whichever is less. The minimum test load shall not be less than 20 N. 6.18.2 of EN 61984	Test load applied in axial direction, test speed:20mm/min, permissible shift contacts of 1.0mm, Test 15a of IEC 60512-15-1
2.6	Mechanical strength impact	Connector and internal insulation shall no damage to impair normal use. A reduction of clearance and creepage distance is not allowed. 6.18.1& 6.18.3 of EN 61984	Dropping height: - 750mm for specimens of mass ≤250g - 500mm for specimens of mass > 250g Dropping cycles:8 positions in 45° step, one cycles per position IEC 60512-7-2 Test 7b
2.7	Mechanical Operation (Durability)	500 operation cycles without load No damage likely to impair normal use 6.14.1 of EN 61984	Shall be engaged and disengaged by means of A) a device simulating normal operating conditions at the speed of approximately 50mm/min B) manual mating/un-mating 300 Max. cycle per hour IEC 60512-9-1 Test 9a 7.3.9 of EN 61984
2.8	Vibration, Random	No damage likely to impair function No discontinuities greater than $t > 1\mu s$	Frequency:5~150Hz Per EN 61373, Category 1, Class B (IEC60068-2-6 Test Fc)
2.9	Shock	No damage likely to impair function No discontinuities greater than $t > 1\mu s$	Acceleration:50m/s <sup>2</sup> Duration:30ms Total 18 shocks(three positive and three negative in each of the three orthogonal axes) Per EN 61373

Electrical				
2.10	Contact Resistance	Initial	Max.5mΩ	Test current: 1A Measure points <sup>b</sup> at the end of the termination. Max three contacts per specimen plus protective earthing, if any IEC 60512-2-2 Test 2b
		Final	The change of contact resistance shall be no more than 50 % of the reference value or ≤5 mΩ. The higher value is permissible.	
2.11	Temperature Rise Test	The sum of the ambient temperature and the temperature rise ( $\Delta T$ ) of a connector shall not exceed the upper limiting temperature 6.16 of EN 61984		Length of test cable see table 7 of 7.3.8 of EN 61984 Carry its rated current Upper limiting temperature:125°C (Table 5b) IEC 60512-5-1 Test 5a
2.12	Dielectric Voltage Withstand Test	No flashover or breakdown of voltage 6.13 of EN 61984		Impulse test voltage according to Table 8, applied three impulses of each polarity and interval of at least 1s between impulses. 7.3.12 of EN 61984
2.13	Insulation Resistance	Not less than 400 MΩ		Test voltage 1000V DC Time:60s IEC 60512-3-1 Test 3a Method B

Environmental				
2.14	Cold	No damage likely to impair function 6.6.3;6.8;6;15;6.18.3 of EN 61984		Subject mated specimen to -40°C Duration time:16h, Test Ab Per IEC 60512-11-10 Test 11j (IEC 60068-2-1)
2.15	Dry Heat	No damage likely to impair function 6.6.3;6.8;6;15;6.18.3 of EN 61984		Subject mated specimen to +125°C Duration time:168h Test Bb Per IEC 60512-11-9 Test 11i (IEC 60068-2-2)
2.16	Damp Heat, cyclic	No damage likely to impair function		Subject mated specimen to Min ambient temperature: 25°C Max ambient temperature: 45°C Number of cycles:21 Variant 1 IEC 60512-11-12 Test 11m
2.17	Rapid Change of temperature (Temperature Cycle)	No damage likely to impair function		Subject mated specimen to Ta=-40±2°C to Tb=+125±2°C, duration t1: 1h each extreme, 100 cycles IEC 60512-11-4 Test 11d (IEC 60068-2-14 Test Na)

2.18	Corrosion (Alternative)	No damage likely to impair function Per 6.21 of EN 61984	<p>Test 1: Flowing mixed gas corrosion according to test 11g, method 1 or method 4 (Table 1) Duration time: 4days (96h) IEC 60512-11-7 Test 11g 7.3.14 of EN 61984</p> <p>Alternative: Test 2: Sulphur dioxide test with general condensation of moisture according to EN ISO 6988 Duration time:24h (1 test cycle) 7.3.14 of EN 61984</p>
2.19	Protection against electric shock	No live parts shall be accessible by test finger, 6.4.2.2 or 6.4.2.3 of EN 61984	<p>Unenclosed connector: Test finger or 50mm sphere pressed with 20N against the surface as specified by the manufacture Mated specimen and socket connector (if application) 7.3.6.1 of EN 61984</p>
<p><sup>a</sup> test items are for themselves separate tests and are performed on new specimens. <sup>b</sup> measuring point: at the conductors as close as possible to the termination, if this is not possible, the conductor resistance shall be recalculated.</p>			

3. SUMMARY OF TEST RESULTS:

Examination of product – all test group

Test Group	Test Item	Test Result	Requirement	Judgment
Group A	Visual and dimensional examination	No physical damage	Meets requirements of product drawing	Passed
	Durability of marking	Marking readable (Laser marking)	Marking shall be readable	passed
	Polarisation and coding	No physical damage	require provision against incorrect mating	passed
	Contact retention force in insert	No axial displacement likely to impair normal operation	Axial displacement <1.0mm when test speed: 20mm/min, min 50N force for each pin or socket	passed
	Mechanical strength impact	No physical damage	No damage likely to impair function	passed
	Visual and dimensional examination	No physical damage	Meets requirements of product drawing	Passed
	Pull out force of terminations	For crimp contact connection	0.14mm <sup>2</sup> contact: 27.71N 4.0mm <sup>2</sup> contact: 337.37N	0.14mm <sup>2</sup> : 18N Min 4.0mm <sup>2</sup> : 310N Min
For screw less type clamping (spring clamp) contact connection		0.5mm <sup>2</sup> contact: 20N 2.5mm <sup>2</sup> contact: 92.96N	0.5mm <sup>2</sup> : 20N Min 2.5mm <sup>2</sup> : 50N Min	Passed
For screw-type clamping contact connection		0.5mm <sup>2</sup> contact: 34N 2.5mm <sup>2</sup> contact: 435.68N	0.5mm <sup>2</sup> : 20N Min 2.5mm <sup>2</sup> : 50N Min	Passed
Group B	Visual and dimensional examination	No physical damage	Meets requirements of product drawing	Passed
	Contact Resistance	HE-024-MC&FC 2.23mΩ Max. HE-024-MS&FS 1.85 mΩ Max. HE-024-M&F 4.16 mΩ Max.	Max.5mΩ	passed
	Mechanical Operation (Durability)	No physical damage	After 500 operation cycles, No damage likely to impair normal use	passed
	Contact Resistance	HE-024-MC&FC 4.59mΩ Max. HE-024-MS&FS 3.28 mΩ Max. HE-024-M&F 6.52 mΩ Max.	The change of contact resistance shall be no more than 50 % of the reference value or ≤5 mΩ. The higher value is permissible	passed
	Visual and dimensional examination	No physical damage	Meets requirements of product drawing	Passed
Group C	Visual and dimensional examination	No physical damage	Meets requirements of product drawing	Passed
	Temperature Rise Test	HE-024-MC&FC 70.58°C HE-024-MS&FS 84.33°C HE-024-M&F 49.58°C	The sum of the ambient temperature and the temperature rise ≤125°C	passed

	Visual and dimensional examination	No physical damage	Meets requirements of product drawing	Passed
Group D	Visual and dimensional examination	No physical damage	Meets requirements of product drawing	Passed
	Contact Resistance	HE-024-MC&FC 2.14mΩ Max. HE-024-MS&FS 4.64 mΩ Max. HE-024-M&F 1.73 mΩ Max.	Max.5mΩ	passed
	Dielectric Voltage Withstand Test	No breakdown or flashover	No breakdown or flashover	passed
	Insulation Resistance	HE-024-MC&FC >0.31x10 <sup>11</sup> Ω HE-024-MS&FS >2.42x10 <sup>11</sup> Ω HE-024-M&F >1.0x10 <sup>11</sup> Ω	Not less than 400MΩ	passed
	Cold	No physical damage	No damage likely to impair function	passed
	Dry Heat	No physical damage	No damage likely to impair function	passed
	Corrosion	No physical damage	No damage likely to impair function	passed
	Contact Resistance	HE-024-MC&FC 4.61mΩ Max. HE-024-MS&FS 9.64 mΩ Max. HE-024-M&F 2.56 mΩ Max.	The change of contact resistance shall be no more than 50 % of the reference value or ≤5 mΩ. The higher value is permissible	passed
	Dielectric Voltage Withstand Test	No breakdown or flashover	No breakdown or flashover	passed
	Insulation Resistance	HE-024-MC&FC >2.46x10 <sup>11</sup> Ω HE-024-MS&FS >1.24x10 <sup>11</sup> Ω HE-024-M&F >1.24x10 <sup>11</sup> Ω	Not less than 400MΩ	passed
Group E	Visual and dimensional examination	No physical damage	Meets requirements of product drawing	Passed
	Protection against electric shock	No live parts was accessible.	No live part shall be accessible	passed
	Visual and dimensional examination	No physical damage	Meets requirements of product drawing	Passed
Group F	Visual and dimensional examination	No physical damage	Meets requirements of product drawing	Passed
	Contact Resistance	HE-024-MC&FC 3.18mΩ Max. HE-024-MS&FS 4.53 mΩ Max. HE-024-M&F 1.14 mΩ Max.	Max.5mΩ	passed
	Rapid Change of temperature (Temperature Cycle)	No physical damage	No damage likely to impair function	passed
	Damp Heat, cyclic	No physical damage	No damage likely to impair function	passed
	Contact Resistance	HE-024-MC&FC 4.16mΩ Max. HE-024-MS&FS 3.30 mΩ Max. HE-024-M&F 0.65 mΩ Max.	The change of contact resistance shall be no more than 50 % of the reference value or ≤5 mΩ. The higher value is permissible	passed

	Dielectric Voltage Withstand Test	No breakdown or flashover	No breakdown or flashover	passed
	Insulation Resistance	HE-024-MC&FC >1.13x10 <sup>11</sup> Ω HE-024-MS&FS >6.1x10 <sup>11</sup> Ω HE-024-M&F >2.53x10 <sup>11</sup> Ω	Not less than 400MΩ	passed
	Visual and dimensional examination	No physical damage	Meets requirements of product drawing	Passed
Group G	Visual and dimensional examination	No physical damage	Meets requirements of product drawing	Passed
	Contact Resistance	HE-024-MC&FC 2.38mΩ Max. HE-024-MS&FS 4.48mΩ Max. HE-024-M&F 1.24mΩ Max.	Max.5mΩ	passed
	Vibration, Random	No physical damage; No electrical discontinuity greater than 1 μs	No damage likely to impair function; No discontinuities greater than t>1μs	passed
	Shock	No physical damage; No electrical discontinuity greater than 1 μs	No damage likely to impair function; No discontinuities greater than t>1μs	passed
	Contact Resistance	HE-024-MC&FC 3.83mΩ Max. HE-024-MS&FS 9.78mΩ Max. HE-024-M&F 1.67mΩ Max.	The change of contact resistance shall be no more than 50 % of the reference value or ≤5 mΩ. The higher value is permissible	passed
	Visual and dimensional examination	No physical damage	Meets requirements of product drawing	Passed