
HE Insert Series

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1. SCOPE

1.1. Content

This specification covers the performance, tests and quality standards for the contact inserts of heavy duty connector series **HE-006/HE-010/HE-016/HE-024/HE-032/HE-048**. The contact inserts are available for positions number 6/10/16/24/32/48.

The termination conductor-contact insert is affected via:

- 1). A crimped connection contact which is fitted into the contact insert. The contact insert is designed for conductors of 0.14mm² up to 4.0mm².
- 2). Or a screw-type clamping connection contact which is integrated into the contact insert. The contact insert is designed for conductors 0.5mm² up to 2.5mm².
- 3). Or a screwless-type clamping (spring clamping) connection contact which is integrated into the contact insert. The contact insert is designed for conductors 0.5 mm² up to 2.5mm².
- 4). Or a screwless-type clamping (double spring clamping) connection contact which is integrated into the contact insert. The contact insert is designed for conductors 0.5mm² up to 2.5mm².

1.2. Qualifications

When tests are performed, the following specified specifications and standards shall be used. All inspections shall be performed using the applicable inspection plan and product drawing.

2. APPLICABLE DOCUMENTS

The following documents form part of this specification to the extent specified herein. In the case of a conflict between the requirements of this specification and the product drawing or of conflicts between the requirements of this specification and the referenced documents, this specification shall take precedence.

2.1. TE Connectivity Documents

A. Customer drawing and name : HE insert series

2.2. Other Documents

- EN 61984: Connectors - Safety requirements and tests
- IEC 60068: Environmental testing
- IEC 60512: Connectors for electronic equipment -Test and measurements
- IEC 60529: Degrees of Protection Provided by Enclosures (IP Code)
- IEC 60664-1: Insulation coordination for equipment within low-voltage systems (Part 1)
- EN 61373: Railway application - Rolling stock equipment - Shock and vibration test
- ISO 6988: Metallic and other non-organic coatings - Sulfur dioxide test with general condensation of moisture

3.5.3	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
3.5.4	Pull out force of terminations	See 6.6 of EN 61984	See 6.6 of EN 61984
	^a 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.
	^a 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
	^a 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
3.5.5	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
3.5.6	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
3.5.7	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
3.5.8	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)
3.5.9	Shock	No damage likely to impair function No discontinuities greater than $t > 1\mu s$	Acceleration:50m/s ² Duration:30ms Total 18 shocks(three positive and three negative in each of the three orthogonal axes) Per EN 61373

Electrical				
3.5.10	Contact Resistance	Initial	Max.5mΩ	Test current: 1A Measure points ^b 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	
3.5.11	Temperature Rise Test	The sum of the ambient temperature and the temperature rise (ΔT) 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
3.5.12	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
3.5.13	Insulation Resistance	Not less than 400 MΩ		Test voltage 1000V DC Time:60s IEC 60512-3-1 Test 3a Method B

Environmental				
3.5.14	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)
3.5.15	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)
3.5.16	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
3.5.17	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)

3.5.18	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>
3.5.19	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>^a test items are for themselves separate tests and are performed on new specimens. ^b measuring point: at the conductors as close as possible to the termination, if this is not possible, the conductor resistance shall be recalculated.</p>			

Number of Specimen as below table 1:

Table 1 - Number of Specimen		
Test	Description	Numbers & consist of
Group A	Mechanical Test	3 pairs of connectors
Group B	Service life Test	3 pairs of connectors
Group C	Thermal Test, Mated	3 pairs of connectors
Group D	Climatic Test, Mated	3 pairs of connectors
Group E	Degree of protection Test	3 pairs of connectors
Group F	Temperature Cycle Test	3 pairs of connectors
Group G	Vibration and Shock Test	3 pairs of connectors (together Hood & Housing)
<p>Note: For connector family of the same design and comparable size, test may be made only on that member of the family which represents the worse case for that test.</p>		

3.6. Test Sequences

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 ^a						
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) ^a test items are for themselves separate tests and are performed on new specimens.

4. QUALITY ASSURANCE PROVISIONS

4.1. Qualification Testing

A. Specimen Selection

Specimens shall be prepared in accordance with product drawing and shall be selected at random from current production.

B. Test Sequence

The samples shall be prepared in accordance with product drawings. They shall be selected at random from current production.

4.2. Requalification Testing

If changes significantly affecting form, fit or functions are made to the product or manufacturing process, product assurance shall coordinate requalification testing, consisting of all or part of the original testing sequence as determined by development/product, quality and reliability engineering.

4.3. Acceptance

Acceptance is based on verification that the product meets the requirements of paragraph 3.5. Failures attributed to equipment, test setup or operator deficiencies shall not disqualify the product. If product failure occurs, corrective action shall be taken and specimens resubmitted for qualification. Testing to confirm corrective action is required before re-submittal.

4.4. Quality Conformance Inspection

The applicable quality inspection plan shall specify the sampling acceptable quality level to be used. Dimensional and functional requirements shall be in accordance with the applicable product drawing and this specification. Bulk wire resistance shall be subtracted from resistance readings.