

LEOCO CORPORATION		PRODUCTION SPECIFICATION	No.	S-97-2420-9
<div>☆ 2420 SERIES AND 2421 SERIES CONNECTOR ☆</div> <div>This product specification contains the test method ,the general performance and requirements for interconntection system connector with 2420 series socket 2421 series header and 2453 series terminal.</div>				
1. construction and dimensions shall be in accordance with the referenced drawing 产品结构及尺寸依据所提供的图面.				
2. characteristics 特性: current rating 额定电流 :3A AC DC Voltage rating 额定电压: 250V AC DC Applicable wire 适用的线 conductor construction size #22~#28				
3.Elctrical performance 电气性能:				
ITEM 项目	DESCRIPTION 内容	TEST CONDITION 测试条件	REQUIREMENT 需求	
3.1	Contact resistance 接触阻抗	It should be tested in accordance with method EIA-364-23	Initial :20 mΩ max. after environmental test:40 mΩ max	
3.2	Insulation resistance 绝缘阻抗	It should be tested in accordance with method EIA-364-21	Initial :1000 MΩ min After humidity and thermal shock test 500MΩ min	
3.3	Dielectric withstanding Voltage 耐电压	Unmated connector shall be tested in accordance with method EIA-364-20 when the AC 800 v rms for one adjacent contacts.	No evidence of breakdown and flashover	
4. Mechanical Performance 机械性能 :				
ITEM 项目	DESCRIPTION 内容	TEST METHODS&CONDITION 测试方法及条件	REQUIREMENT 需求	
4.1	Crimp tensile strength 铆合张力强度	Pulling load shall be applied between correctly crimped contact and wire at a constant speed . pulling speed: 25mm/minute	AWG #22 : 4.0 kgf min AWG #24 : 2.5 kgf min AWG #26 : 1.5 kgf min AWG #28 : 1.0 kgf min	
4.2	Contact insertion force 接触插入力	The force required to insert a contact Into a housing . inserting speed: 25mm/minute	600 gf max	
4.3	Contact removal force 接触拔出力	Crimped contact mounted in a housing shall be pulled in an alignment at a constant speed of 25mm/minute	1.5 kgf min	
4.4	Post retention force 保持力	The end of a post shall be pushed in a perpendicular to base housing at a constant speed of 25mm/minute.	1.0 kgf min	
4.5	Insertion force 插入力	Housing with contact mating header at a constant speed of 25mm/minute	700 gf max	

LEOCO CORPORATION		PRODUCTION SPECIFICATION	No.	S-97-2420-9
4.6	Withdrawal force 拔出力	Housing with contact mating header, pull out from header at speed 25mm/minute	150 gram min	
4.7	Durability 耐久性	It should be tested in accordance with method EIA-364-09.connector shall be subjected to 100 cycles of insertion and withdrawal.	No defects. Contact resistance shall be 20 mΩ max	
4.8	Vibration 振动性	The connector mated PCB shall be vibrated in accordance with method EIA-364-28 test condition B. there shall be no current discontinuity longer than 1 ms during the test. Frequency:10-55-10 Hz/min Amplitude :1.52mm Period : 2 hours for each direction.	No evidence of loosening of parts or electric discontinuity contact resistance less than twice of initial.	
5.Environmental performance 环境性能:				
ITEM 项目	DESCRIPTION 内容	TEST CONDITION 测试条件	REQUIREMENT 需求	
5.1	Humidity 耐湿性	The unmated connector shall be tested in accordance with method EIA-364-31 test procedure type I condition B. Tem: 40±2℃ Humidity : 90~95% (RH) Period: 96 hours	No damage Contact resistance less than twice of initial. Insulation resistance : paragraph 3-2 dielectric withstanding voltage: to pass paragraph 3-3	
5.2	Salt spray 盐雾测试	Connector shall be tested in accordance with method EIA-364-26 Temperature: 35±2℃ Density : 5% in weight Period: 48 hours	No damage Contact resistance less than twice of initial	
5.3	Solderability 着锡性	Connector termination ends shall be checked for solder ability in accordance with method EIA-364-52 Solder temperature :245±5℃ Immersion period 5±0.5 sec	No damage. Minimum : 95% of immersed area.	
5.4	Resistance to soldering heat 耐高温焊接	Specimen shall be mounted on PCB. Solder temperature:260±5℃ Solder temperature :280±5℃ (High-temperature materials) Immersion period: 5±0.5 sec.	No damage and deformation.	

LEOCO CORPORATION		PRODUCTION SPECIFICATION	No.	S-97-2420-9
5.5	Cold 冷却测试	It should be tested in accordance with method 11233 of CNS temperature :-25±3℃ period : 96 hours	No damage Contact resistance less than twice of initial.	
5.6	Dry heat 加热干燥测试	It should be tested in accordance with method 3634 of CNS temperature :+85±3℃ period : 96 hours	No damage Contact resistance less than twice of initial.	
6. 2420 Series and 2421 Series Mating force and unmating force:				
Unit:Kgf				
Number of Circuits	Mating Force		Unmating Force	
	Initial(max.)		Initial (min.)	
2	3.5		0.4	
3	4.5		0.5	
4	5.5		0.6	
5	6.0		0.7	
6	6.5		0.8	
7	7.5		0.9	
8	7.5		1.0	
9	8.5		1.1	
10	8.5		1.2	
11	10.0		1.3	
12	10.5		1.4	
13	10.5		1.5	
14	11.0		1.6	
15	11.5		1.7	
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