

审核	说明	日期
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序号	名称	数量	零件图号	对应端子号	材质	颜色/镀层
⑥	基座	1	CK3.5-327A-06	—	PPA	??
⑤	5号插片	1	CK3.5-327A-05	5	H62 t=0.25	Ag
④	4号插片	1	CK3.5-327A-04	4	Qsn6.5-0.1	Ag
③	3号插片	1	CK3.5-327A-03	3	QSn6.5-0.1	Ag
②	2号插片	1	CK3.5-327A-02	2	QSn6.5-0.1	Ag
①	1号插片	1	CK3.5-327A-01	1	QSn6.5-0.1	Ag

外形图		设计		日期		名称	
角度 ±2°	±2°	设计	黄彬	日期	2020-8-13	3.5耳插	
L > 10	±0.3	审核	张伟	日期	2020-8-13	料号: HX PJ-327A-Y	
6 < L	±0.2	批准	罗小春	日期	2020-8-13	版本: A	
≤ 10	±0.1	图号		质量	0.3659	A4	
单	比例	比例	5:1	页码	1/1	版本: A	
单位: mm	10	11	12	13	14	15	16

**深圳市韩下电子有限公司**



深圳市韩下电子有限公司

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## 承 认 书

### SPECIFICATION FOR APPROVAL

客 户 Customer:

\_\_\_\_\_

产品名称 Project:

耳机座

\_\_\_\_\_

规格型号 Part No:

HX PJ-327A-Y

\_\_\_\_\_

#### 贵公司承认印 Approval signatures

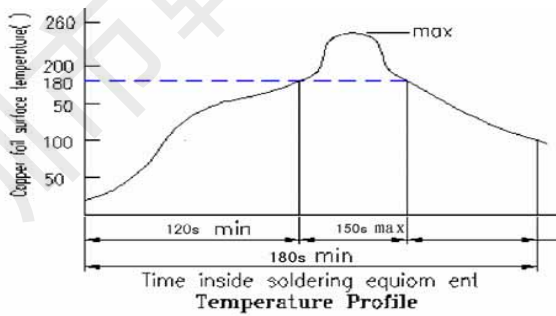
料 号/Part No.	签 章/Signatures

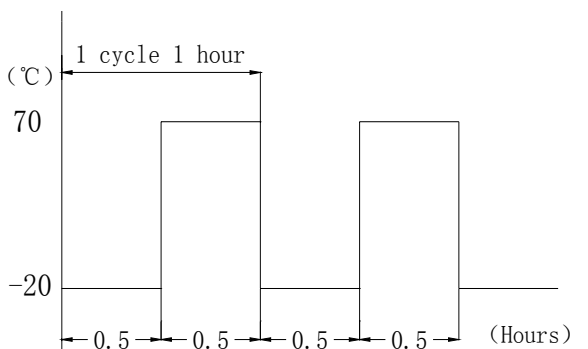
日期 Date:

拟制/Drawn	黄彬	
审核/Check	张伟	
批准/Approved	罗小春	



<b>DESCRIPTION</b> 名称: PHONE JACK MODEL NO.: HX PJ-327A-Y			
RATING (额定值): DC 30V 0.5 A			
<b>PRACTICAL TEMPERATURE RANGE</b> 使用温度范围	-30~70° C 在-30° C~+70° C 温度内使用		
<b>STANDARD ATMOSPHERIC CONDITIONS</b> 测试标准状况	UNLESS OTHERWISE SPECIFIED THE STANDARD RANGE OF ATMOSPHERIC CONDITIONS FOR MAKING MEASUREMENTS AND TESTS ARE AS FOLLOWS: (1) BETWEEN BODY AND CONDUCTOR: 5° C TO 35° C (2) BETWEEN CONDUCTORS NOT TO BE CONTACT: 45% TO 85% (3) PRESSURE: 86Kpa TO 106Kpa 在没有指定的情况下测试温度、湿度、气压如下: (1) 温度为 5° C~35° C (2) 湿度为 45%~85% (3) 气压为 86 Kpa~106Kpa		
<b>MECHANICAL (机械性能)</b>			
<b>ITEM 项目</b>	<b>TEST CONDITIONS 测试条件</b>	<b>PERFORMANCE 规格</b>	
1	<b>CONNECTION FORCE</b> 插入力度	MEASUREMENT SHALL BE MADE AFTER CONNECTING AND DISCONNECTING USING STANDARD PLUG GAUGE 3 TIMES. 依据标准的 PLUG GAUGE 做第 3 次拔插后测定	3 ~ 20N
	<b>DISCONNECTION FORCE</b> 拔出力度	MEASUREMENT SHALL BE MADE AFTER CONNECTING AND DISCONNECTING USING STANDARD PLUG GAUGE 3 TIMES. 依据标准的 PLUG GAUGE 做第 3 次拔插后测定	3 ~ 20N
2	<b>TERMINAL STRENGTH</b> 端子强度	A STATIC LOAD OF 0.1N/m(1kgf/cm) SHALL BE APPLIED TO THE TIP OF THE TERMINAL FOR 1 MIN IN ANY DIRECTION 向排脚先端的任意一个方向加 1 分钟 0.1N/m(1kgf/cm)的力度.	THERE SHALL BE NO DAMAGE TO THE TERMINAL SUCH AS CRACKS, LOOSENESS OR PLAY ELECTRICAL, AND MECHANICAL CHARACTERISTICS SHALL BE SATISFIED 在排脚中没有裂开、松动等异常, 满足于机械、电气性能
<b>ELECTRICAL (电气性能)</b>			
<b>ITEM 项目</b>	<b>TEST CONDITIONS 测试条件</b>	<b>PERFORMANCE 规格</b>	
3.1	<b>CONTACT RESISTANCE</b> 接触电阻	MEASURED AT SMALL CURRENT (100m A OR LESS) 1000Hz 在微小电流 (100 m A) 以下测试	$\leq 30m \Omega$
3.2	<b>INSULATION RESISTANCE</b> 绝缘电阻	APPLY A VOLTAGE OF 500V DC FOR 1 MIN TO FOLLOWING PORTIONS AFTER WHICH MEASUREMENT SHALL BE MADE: (1) BETWEEN BODY AND CONDUCTOR (2) BETWEEN CONDUCTORS NOT TO BE CONTACT (3) BETWEEN CONDUCTORS NOT TO BE WHEN PLUG IS INSERTED DC 500V 1 MIN 输入 500V DC 电压 1 分钟, 按以下接触方法测试: (1) 插座体与排脚之间 (2) 不接触的排脚之间 (3) 插头插入时不接触排脚之间	$\geq 100M \Omega$

3.3	<p>DIELECTRIC STRENGTH 耐电压</p>	<p>AC 500V ims(50~60Hz)FOR 1 MIN TRIP CURRENT:0.5mA (1) BETWEEN BODY AND CONDUCTOR (2) BETWEEN CONDUCTORS NOT TO BE CONTACT (3) BETWEEN CONDUCTORS NOT TO BE WHEN PLUG</p> <p>输入 AC 500V (50Hz) /min 电压 1 分钟感度电流为 0.5mA, 按以下接触方法测试: (1) 插座体与排脚之间 (2) 不接触的排脚之间 (3) 插头插入时不接触排脚之间</p>	<p>WITHOUT DAMAGE TO PARTS ARCING OR BREAKDOWN ETC 没有绝缘破坏等异常</p>
URABILITY (耐久性)			
ITEM 项目		TEST CONDITIONS 测试条件	PERFORMANCE 规格
4.1	<p>SOLDERABILITY TEST 可焊性试验</p>	<p>THE TOP OF THE TERMINALS SHALL BE DIPPED 1mm IN THE SOLDER BATH OF 240±5°C FOR 3±0.5 SECONDS 端子顶部被浸入锡池中 1mm 深,温度为 240±5°C,时间为 3±0.5 秒</p>	<p>(1) SOLDER WETTING TIME SHALL BE 3 SEC OR LESS 焊接时间应少于 3 秒 (2) THE AREA OF SOLDERING SHOULD BE OVER 75% 焊接面积应有 75% 以上</p>
4.2	<p>RESISTANCE TO SOLDERING HEAT TEST 耐焊性试验</p>	<p>REFLOW SOLDERING CONDITIONS: PREHEAT:TEMPERATURE ON THE COPPER FOIL SURFACE SHOULD REACH 180 .120S AFTER THE P.C.B ENTERED INTO THE SOLDERING EQUIPMENT. TALLEST TEMPERATURE:TEMPERATURE ON THE COPPER FOIL SURFACE SHOULD REACH THE PEAK TEMPERATURE OF 260±5 WITH IN 20 SECONDS. 过回流焊条件: 预热:电镀层表面的温度应达到180℃, 120s 后电路板进入回 流焊设备。最高温度:电镀层表面温度最高为 260±5℃且 停留不超过 20秒。</p>  <p style="text-align: center;">Temperature Profile</p>	<p>WITHOUT DEFOR MATION OF CASE OR EXCESSIVE LOOSENESS OF TEMINALS ELECTRICAL CHARACTERISTICS SHALL BE SATISFIED 本体无变形, 满足于机械、电气性能</p>
4.2	<p>RESISTANCE TO SOLDERING HEAT TEST 耐焊性试验</p>	<p>SOLDERING IRON METHOD: BIT TEMPERATURE 330±5°C APPLICATION TIME OF SOLDERING IRON3±0.5 SEC HOWEVER EXCESSIVE PRESSURE SHALL NOT BE APPLIED TO THE TERMINAL 手焊接的时候温度需控制在 330±5℃ , 时间为 3±0.5 秒, 但不能在排脚上施加异常压力。</p>	<p>WITHOUT DEFORMATION OF CASE OR EXCESSIVE LOOSENESS OF TEMINALS ELECTRICAL CHARACTERISTICS SHALL BE SATISFIED 本体无变形, 满足于机械、电气性能</p>

4.3	<p>HUMIDITY TEST 潮湿试验</p>	<p>THE JACK SHALL BE STORED AT A TEMPERATURE OF <math>40 \pm 2^{\circ}\text{C}</math> AND A HUMIDITY OF 90% TO 96% FOR 96 Hr, THEN THE JACK SHALL BE MAINTAINED AT STANDARD ATMOSPHERIC CONDITION FOR 1 Hr FOR OTHER PROCEDURES</p> <p>放置 <math>40 \pm 2^{\circ}\text{C}</math> 的相应湿度为 90~96% Hr 环境中 96 小时后, 再将样板放在正常环境中 1 小时后进行测试</p>	<p>THERE SHALL BE NO DAMAGE ON APPEARANCE.</p> <p>MECHANICAL AND ELECTRICAL CHARACTERISTICS SHALL BE SATISFIED</p> <p>外观无异常, 满足于机械、电气性能。</p>
4.4	<p>HEAT TEST 耐热试验</p>	<p>THE JACK SHALL BE STORED AT A TEMPERATURE OF <math>70 \pm 2^{\circ}\text{C}</math> FOR 96 HOURS, AND THEN IT SHALL BE SUBJECTED TO THE CONTROLLED RECOVERY MBASURBM</p> <p>放置在温度 <math>70 \pm 2^{\circ}\text{C}</math> 中测试 96 小时后, 再放置正常室温中 1 小时来测定</p>	
4.5	<p>COLD TEST 耐寒试验</p>	<p>THE JACK SHALL BE STORED AT A TEMPERATURE OF <math>-25 \pm 3^{\circ}\text{C}</math> FOR 96 HOURS AND THEN IT SHALL BE SUBJECTED TO THE CONTROLLED RECOVERY CONDITIONS FOR 1 HOUR AFTER WHICH</p> <p>放置在温度 <math>-25 \pm 3^{\circ}\text{C}</math> 中 96 小时后, 再放置常温常湿中 1 小时来测定</p>	<p>THERE SHALL BE NO DAMAGE ON APPEARANCE</p> <p>MECHANICAL AND ELECTRICAL CHARACTERISTICS SHALL BE SATISFIED</p> <p>外观无异常, 满足于机械、电气性能</p>
4.6	<p>LIFE TEST 寿命试验</p>	<p>AT RATING CONDITION (NON-INDUCTIVE LOAD) CONNECTION AND DISCONNECTION SHALL BE MADE 5000 CYCLES AT A SPEED 10 TO 20 CYCLES / MIN</p> <p>以定格状态(无诱导负荷)在 1 分钟内以 10~20 次的速度进行 5000 次插入、拔出</p>	<p>1. CONTACT RESISTANCE SHALL BE <math>\leq 0.1 \Omega</math></p> <p>2. DISCONNECTION FORCE SHALL BE 3 TO 20N</p> <p>3. MECHANICAL AND ELECTRICAL CHARACTERISTICS SHALL BE SATISFIED</p> <p>(1) 接触电阻 <math>\leq 0.1 \Omega</math></p> <p>(2) 拔出力是 3~20N</p> <p>(3) 其它: 满足于机械、电气性能</p>
4.7	<p>COLD&amp;HEAT SHOCK TEST 冷热冲击测试</p>	<p>THE JACK SHALL BE SUBJECTED TO 5 CYCLES OF THE FOLLOWING CONDITIONS SHOWN IN THE FIGURE, AND THEN SHALL RETURNED AND ALLOWED TO REMAIN IN ROOM AMBIENT CONDITION FOR 30 MINUTES</p> <p>将插座以下列条件作 5 个循环, 然后放回室内环境 30 分钟 TEMP (<math>^{\circ}\text{C}</math>)</p>  <p>The graph shows a square wave temperature profile. The y-axis is temperature in degrees Celsius, with marks at 70 and -20. The x-axis is time in hours, with marks at 0.5. A horizontal line at 70°C is labeled '1 cycle 1 hour'. The profile consists of a 0.5-hour dwell at 70°C, a 0.5-hour transition to -20°C, a 0.5-hour dwell at -20°C, and a 0.5-hour transition back to 70°C. This sequence repeats for 5 cycles.</p>	<p>THERE SHALL BE NO DEFORMATION OR CRACKS IN MOLDED PART.</p> <p>INSERTION &amp; EXTRACTION FORCE: 3 TO 20N</p> <p>CONTACT RESISTANCE: MAX. <math>30 \text{ m}\Omega</math></p> <p>INSULATION RESISTANCE: MIN. <math>100 \text{ M}\Omega</math></p> <p>DIELECTRIC WITHSTANDING VOLTAGE: 500VAC/MIN (BETWEEN TERMINALS)</p> <p>产品不能变形与破裂</p> <p>插拔力: 3N 至 20N</p> <p>接触电阻: 最大 <math>30 \text{ m}\Omega</math></p> <p>绝缘电阻: 最小 <math>100 \text{ M}\Omega</math></p> <p>绝缘耐压: 最小 500VAC (端子之间)</p>

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