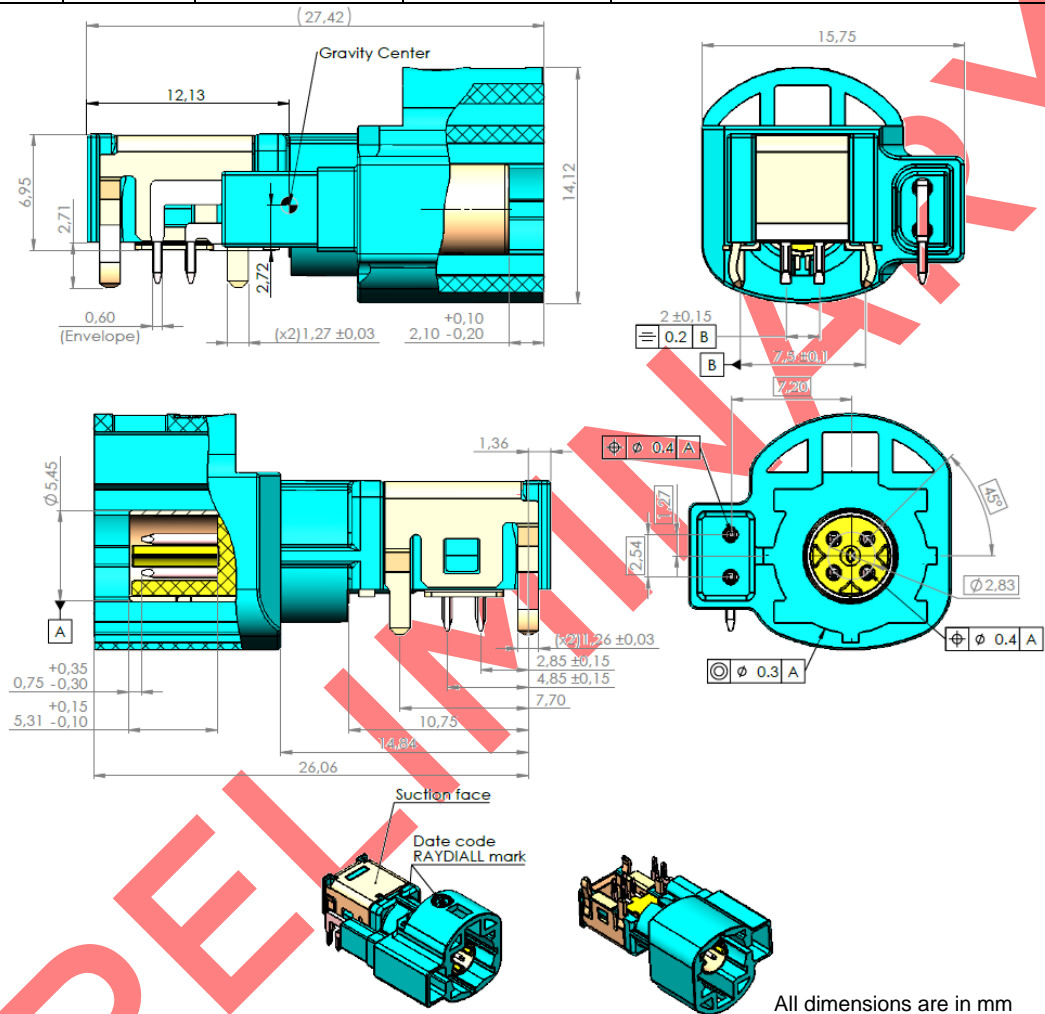


HSD 90° +2  
Process: Reflow

R195.660.\_00

TECHNICAL DATA SHEET

56ate	Product Index	Edited	Approved	Modification
10/09/2018	A	J. MALIK	L. DELION	Creation
23/01/2019	C	D.GABET	M.DUPONT	Layout and reference update



Components	Materials	Plating
Body	Brass	High temp tin over nickel
Center contact	Brass	Gold over nickel interface Tin over nickel (Pcb)
Power contact	Bronze	High temp tin over nickel
Insulator	LCP	Natural color
Cap	Brass	
Housing	Polyamid	See Codings

HSD 90° +2  
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TECHNICAL DATA SHEET

**Interface** Product compatible to AK (German OEM Working Group) interface

**Application** This terminal has been qualified according to AUDI Specification

**Electrical characteristics**

Impedance	100 $\Omega$
Frequency	0-2 GHz
VSWR	17 dB up to 1 Ghz Maxi
Voltage rating	100 Veff Maxi
Dielectric withstanding Voltage	250 Veff maxi
Insulation resistance	5000 M $\Omega$
RF leakage	$\geq$ 75 dB
Test voltage	250 V rms
Skew	Not relevant because of the short electrical length of the receptacle compared to the length of the cable assembly
Nearend crosstalk	< 30 dB
Fearend crosstalk	< 35 dB
Signal contact resistance	10 m $\Omega$ (but not relevant because the contact is not elastic)
Outer contact resistance	25 m $\Omega$ (but not relevant because the contact is not elastic)
Power current	1.5 A DC
RoHs compliant	
EMC screening must be assured by chassis compartment	
Control box manufacturer is responsible for EMC screening	

**Mechanical characteristics**

Center contact retention, axial force, mating end	10 N mini
Center contact retention, axial force, opposite end	10 N mini
Housing retention	200 N
Mating cycles	$\geq$ 25

**Environmental**

Operating temperature	-40 / +105°C
Hermetic seal	
Panel leakage	

**Component weight** 4.81 g

HSD 90° +2  
Process: Reflow

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TECHNICAL DATA SHEET

**Codings**

To obtain the complete part number, please fill in the blank "\_" with the coding letter

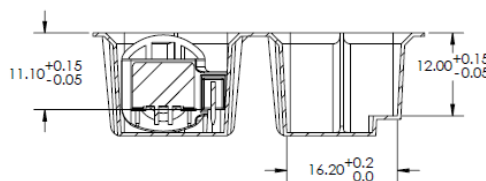
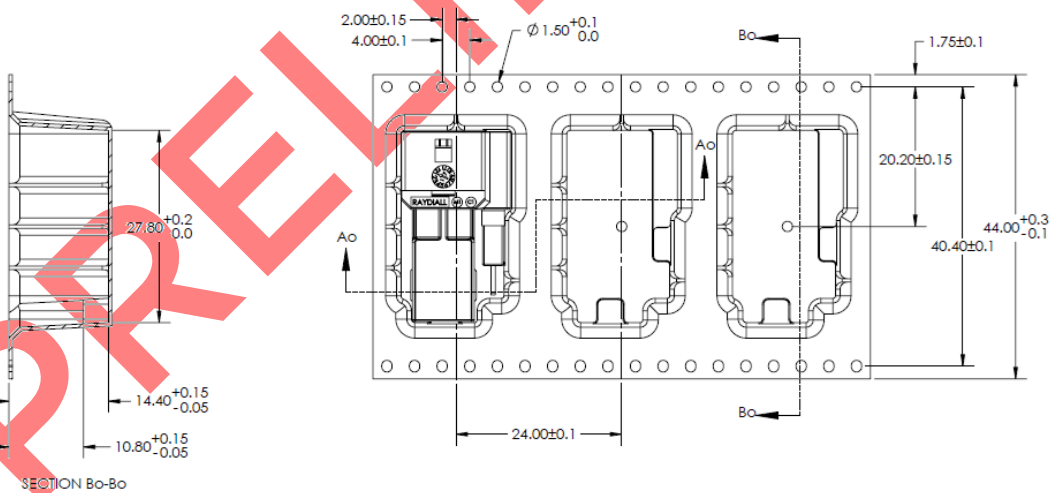
	<b>A</b>	<b>B</b>	<b>C</b>	<b>D</b>	<b>E</b>	<b>F</b>	<b>Z</b>
	Black RAL 9005	White RAL 9001	Blue RAL 5005	Bordeaux RAL 4004	Green RAL 6002	Brown RAL 8011	Waterblue RAL 5021
12h Coding							
	Grey RAL 7031	Violet RAL 4003	Beige RAL 1001	Curry RAL 1027	Yellow Green RAL 6018	Pastel Orange RAL 2003	Light Green RAL 6027
6H Coding							

**Packaging coding 12H**

4 plastic reels inside 1 cardboard box

**Primary packaging: plastic reel**

- Dimensions : Ø 380 x 44.4mm
- Number of connectors per reel: 270
- Carrier tape description:
  - 44mm width, 24mm pitch.
  - Material: thermoplastic static dissipative. Cover tape material: Thermoplastic antistatic



HSD 90° +2  
Process: Reflow

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TECHNICAL DATA SHEET

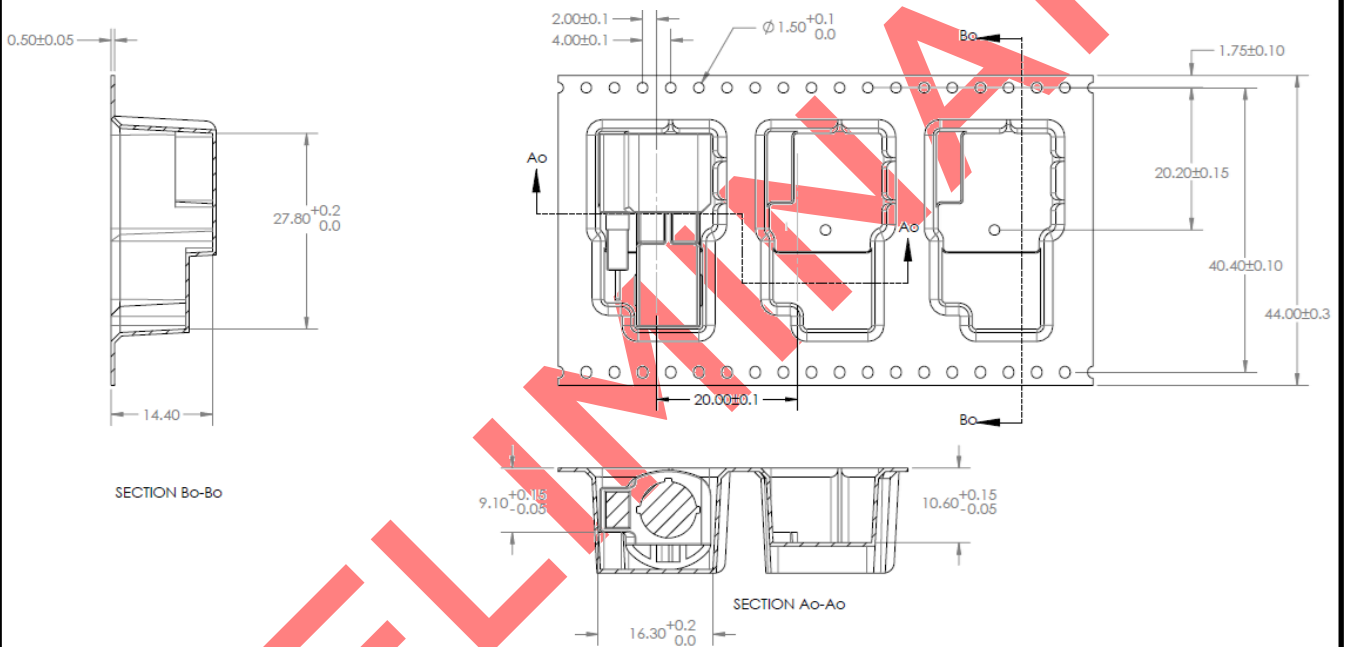
**Packaging coding 6h**

4 plastic reels inside 1 cardboard box

**Primary packaging: plastic reel**

- Dimensions :  $\varnothing$  380 x 44.4mm
- Number of connectors per reel: 270
- Carrier tape description:
  - 44mm width, 24mm pitch.

Material: thermoplastic static dissipative. Cover tape material: Thermoplastic antistatic

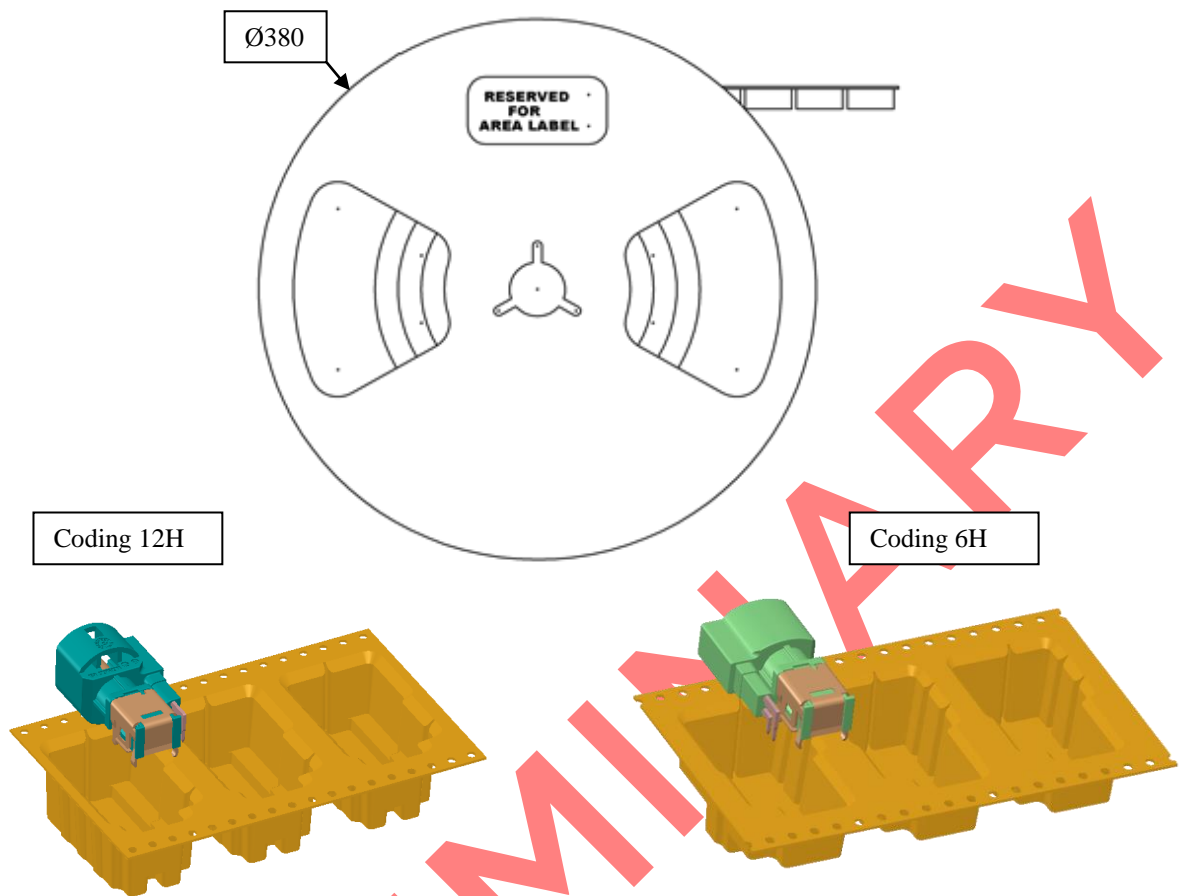


HSD 90° +2  
Process: Reflow

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AUTOMOTIVE

R195.660.\_00

TECHNICAL DATA SHEET



**Secondary packaging: Cardboard box**

- Outside dimensions: 400 x 400 x 260 mm
- Number of reels per cardboard box: 4
- Number of connectors per cardboard box: 1080
- Weight: 8.49 kg



(Picture is not contractual)

**Third Packaging: Pallet**

- PALLET Europe 1200 x 800mm
- Height: < 1450 mm
- 30 cardboard by pallet
- 32 400 receptacles by complete pallet

**Packaging**

The product must be used as soon as it is removed from the cells.

Do not leave the product in the open air.



**Solder procedure**

- 1 - Deposit solder paste "Sn95.5Ag3.8Cu0.7" on mounting zone by screen printing application. We recommend a low Residue Solid Flux. We advise a thickness of 0.2 millimeters min. (0,008 inch min.). The holes must be totally filled with cream Verify that the edges of the zone are clean.
- 2 - Placement of the receptacle on the mounting zone with an automatic machine of "pick and place" type. Video camera is preferred to check the positioning of the component. Adhesive agents are forbidden on the receptacle.
- 3 - Soldering by reflow process. The typical profile to use is given below.
- 4 - Clean printed circuit boards.
- 5 - Check of solder joints and position of the component by visual inspection

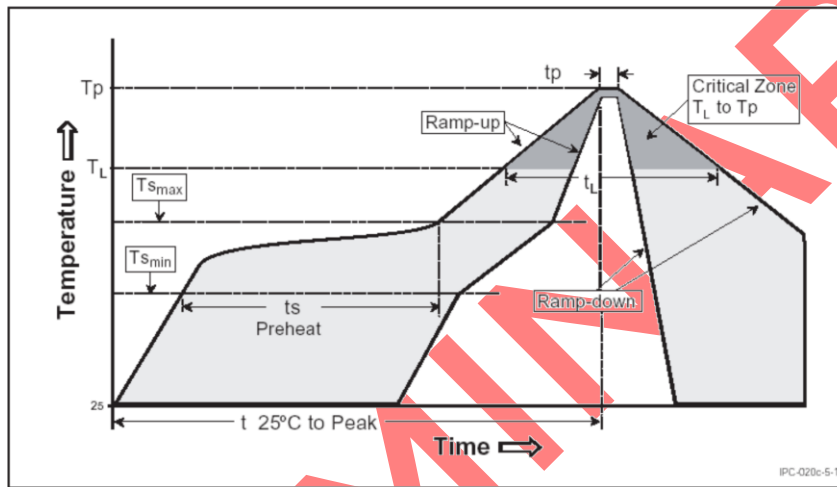


Table 4-2 Pb free process – Package classification reflow temperatures

Package Thickness	Volume mm <sup>3</sup> <350	Volume mm <sup>3</sup> 350 – 2000	Volume mm <sup>3</sup> >2000
< 1,6mm	260 + 0°C*	260 + 0°C*	260 + 0°C*
>1,6mm / <2,5mm	260 + 0°C*	250 + 0°C*	245 + 0°C*
>2,5mm	260 + 0°C*	245 + 0°C*	245 + 0°C*

\*Tolerance: The device manufacturer/supplier shall assure process compatibility up to and including the stated classification temperature (this means Peak reflow temperature +0°C. For example 260°C+0°C at the rated MSL level

Profile Feature	Sn-Pb Eutectic assembly	Pb-Free Assembly
Average Ramp-up Rate (TS <sub>max</sub> to T <sub>p</sub> )	3°C/second max.	3°C/second max.
Preheat		
- Temperature min (TS <sub>min</sub> )	100°C	150°C
- Temperature max (TS <sub>max</sub> )	150°C	200°C
- Time (TS <sub>min</sub> to TS <sub>max</sub> )	60-120 seconds	60-180 seconds
Time maintained above :		
- Temperature (T <sub>L</sub> )	183°C	217°C
- Time (t <sub>L</sub> )	60-150 seconds	60-150 seconds
Peak/Classification Temperature (T <sub>p</sub> )	See Table 4.1	See Table 4.2
Time within 5°C of actual Peak Temperature (t <sub>p</sub> )	10-30 seconds	20-40 seconds
Ramp-down rate	6°C/second max	6°C/second max
Time 25°C to Peak Temperature	6 minutes max	8 minutes max

**Note :** All temperatures refer to topside of the package, measured on the package body surface

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