

**TEST REPORT**



**TITLE: PROCESSING TEMPERATURE OF EDGE CARD CONNECTORS WITH R-7 RYTON BODIES**

**TEST REPORT NO.: STR-052  
December 23, 2004**

**APPROVED BY: Marshall Hulbert, Quality Assurance Manager**

**REVISION HISTORY**

DATE	REVISION	DESCRIPTION	ENGR.
12/23/04	A	INITIAL RELEASE	MNH

**CERTIFICATION**

This is to certify that all testing and evaluations that are described herein were designed and executed by certified personnel of Sullins Electronics, San Marcos, Ca.

All equipment and measuring devices used during test and verification were calibrated and traceable to NIST standards.

All data contained, raw and summarized, are the property of Sullins Electronics, no copy of this report, except in full, shall be forwarded to any agency, customer, etc. without the written approval of Sullins Electronics.

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### SCOPE

To determine the use of Ryton R-7 Polyphenylene Sulfide (PPS) as an acceptable insulator material in high temperature (260°C) re-flow soldering application, which are required for lead free soldering.

### APPLICABLE DOCUMENTS

1. Unless otherwise specified, the following documents of issue at the time of testing performed form a part of this report. The specifications of sub-tier specifications and/or standards apply only when specifically referenced in this report.
2. Standards:
  - MIL-C-21097**: Connectors, Electrical, Printed Wiring Board, General Purpose, General Specification For.
  - MIL-STD-1344**: Method 3001.1, Dielectric Withstanding Voltage (DWV)
  - MIL-STD-1344**: Method 3003.1, Insulation Resistance (IR).

### TEST SAMPLES AND PREPARATION

1. The following test samples were used to perform testing and evaluation.  
Description: Edgecard Connector, AMC25DRXH, 25 Position, Serial Number: HSXT.
2. Test samples were dimensionally verified and recorded (see Electrical and dimensional data summary for results)
3. Insertion/Withdraw of specific positions was tested and recorded. (See Insertion/Withdraw data sheets for results)
4. DWV and IR was tested and certified to pass (see see Electrical and dimensional data summary for results)
5. Samples placed over PCB on Aluminum plate to be placed in oven. See Figure 1.
6. Parts stabilized at 150°C for 5 minutes.
7. Parts taken to 260°C for 2 minutes (See figure 3 for Heat profile graph).
8. Steps 2, 3, and 4 repeated (see Electrical and dimensional data summary sheet, and Insertion/Withdraw data sheets for results)

### SAMPLE CODING:

The test samples were coded in the following manner:  
ID # 1, 2, 3, 4, 5, 6

### CONCLUSION

The use of Ryton R-7 PPS is acceptable as an insulator material for use in high temperature reflow soldering applications. As figure 3 shows, the temperature reached in

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the oven during test was 269°C. The connector showed no effects from the temperatures exposed to for the 2 minute duration. Therefore it is the conclusion of Sullins Electronics' Engineering and QA departments that the acceptable Temperature profile this material is as follows:

**Max temperature: 260°C**

**Max Duration: 2 minutes.**

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**FIGURE #1**

**TEST REPORT**

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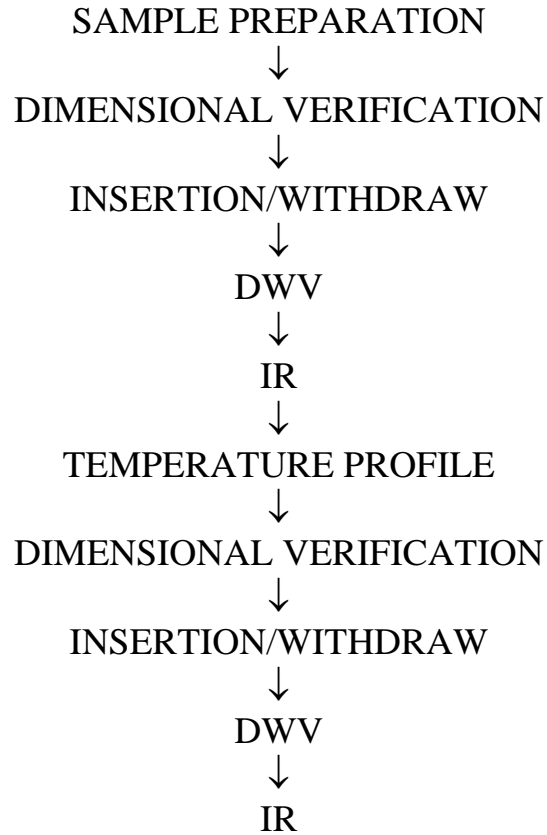
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**FIGURE #2**

**TEST PLAN FLOW CHART**



TEST REPORT

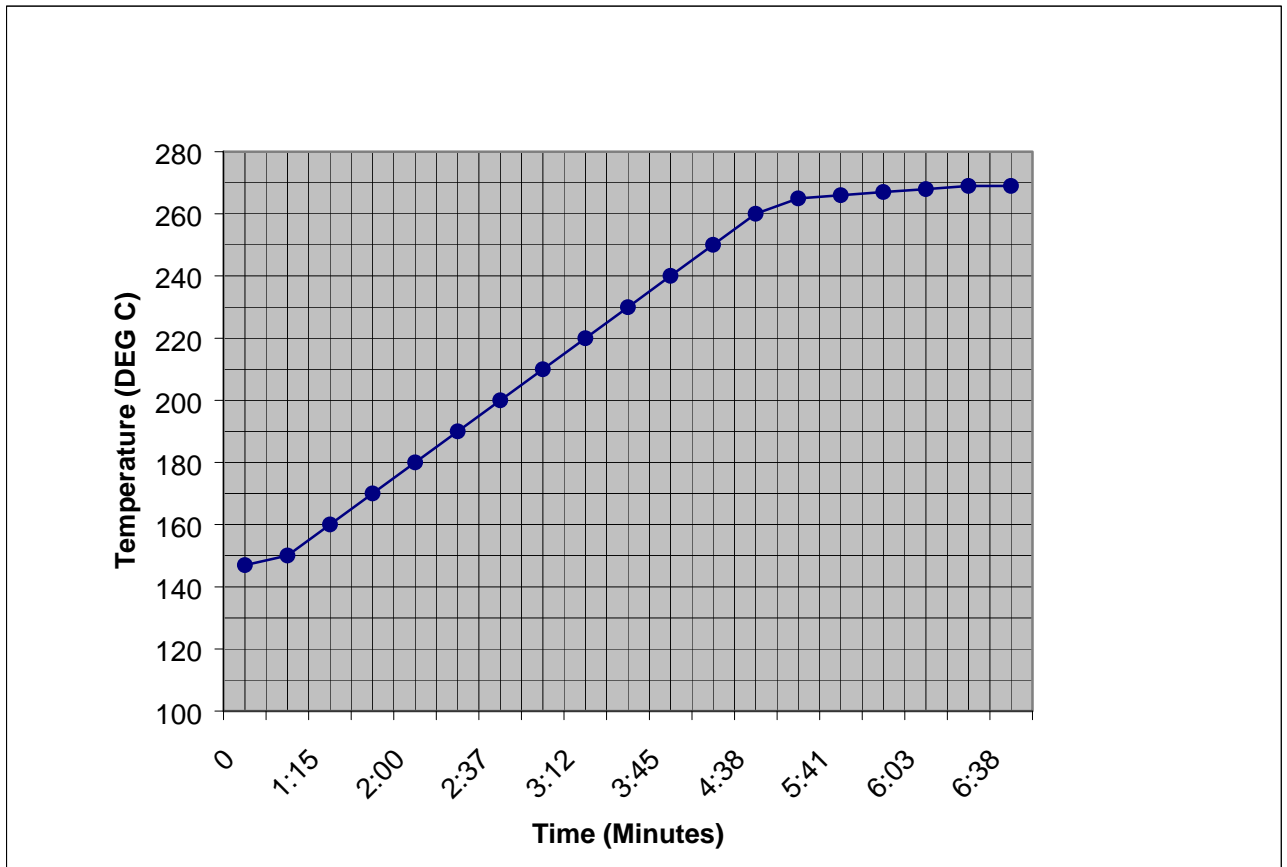
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FIGURE #4  
HEAT/TIME PROFILE



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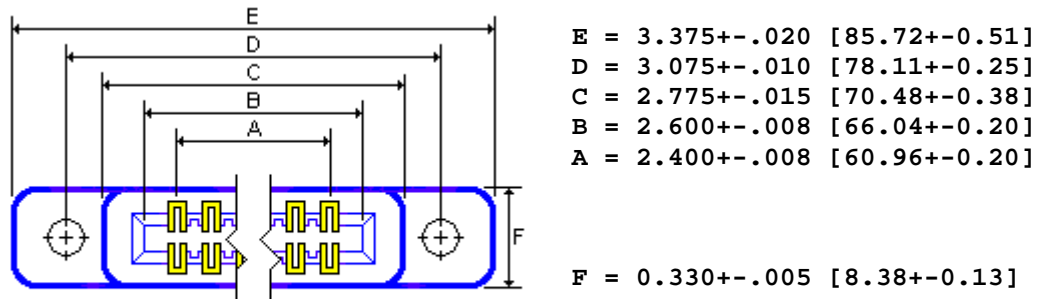
APPROVED BY: Marshall Hulbert, Quality Assurance Manager

FIGURE #4

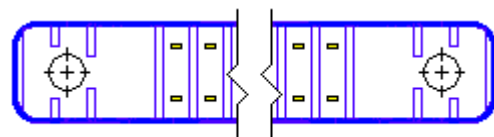
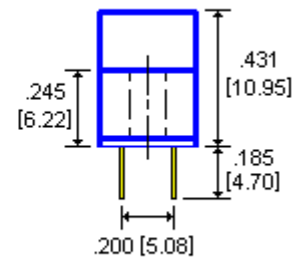
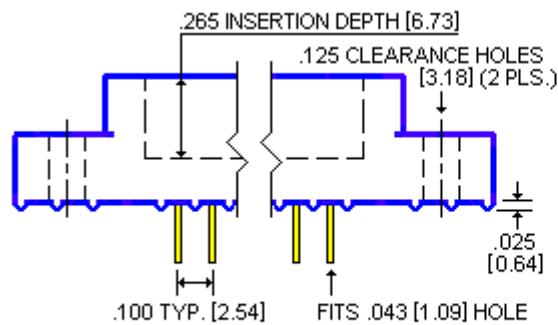
Connector Specification

**SULLINS ELECTRONICS CORP**

SAN MARCOS, CA 760-744-0125 FAX 760-744-6081



FULL BELLOWS BIFURCATED CONTACTS



CONTACT MARKING:

B 1 2 ... 24 25 B  
A 1 2 ... 24 25 A

- 1.0 SPECIFICATIONS FOR A DUAL 25/50 POSITION EDGE CARD CONNECTOR
- 2.0 INSULATION MATERIAL: RYTON
- 3.0 CONTACT MATERIAL: BERYLLIUM COPPER CA170 AM
- 4.0 TEMPERATURE: TO 150 DEGREES C CONTINUOUS
- 5.0 PLATING: .000030" GOLD ON CONTACT SURFACE, .000010" GOLD ON TAILS
- 6.0 VOLTAGE RATING: 600 VDC MINIMUM AT SEA LEVEL
- 7.0 UL FLAMMABILITY RATING: 94V-0
- 8.0 CURRENT RATING: 3 AMPERES

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9.0 VOLTAGE DROP: 30 MILLIVOLTS AT RATED CURRENT

10.0 INSULATION RESISTANCE: 5,000 MEGA OHMS

11.0 IDENTIFICATION: PART TO BE MARKED WITH PART NUMBER AND DATE  
CODE

12.0 BOARD THICKNESS ACCOMMODATED: .054 INCH TO .070 INCH

13.0 INSERTION FORCE: 16 OZ MAX PER CONTACT PAIR USING .062 INCH  
BLADE

14.0 WITHDRAWAL FORCE: 1 OZ MIN PER CONTACT PAIR USING .054 INCH  
BLADE

15.0 SPECIFICATIONS SUBJECT TO CHANGE WITHOUT NOTICE

16.0 TOLERANCE:  $\pm .010$  INCH UNLESS OTHERWISE NOTED

17.0 NOT DRAWN TO SCALE

**SULLINS PART NUMBER: AMC25DRXH**

**DATE: 12-23-04**



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**DIMENSIONAL AND ELECTRICAL DATA SUMMARY**

**Sullins Electronics  
Dimensional Analysis Record**

<b>Part Number:</b>	<b>AMC25DRXH</b>	<b>Part ID Number:</b>	<b>1</b>
<b>Drawing Number:</b>	<b>WEB SPEC.</b>	<b>Inspector:</b>	<b>DALAVONG</b>
<b>Lot Number:</b>	<b>HSXT</b>		
<b>Date:</b>	<b>12-14-04</b>	<b>PRE-REFLOW</b>	<b>POST-REFLOW</b>
<b>Dimension</b>	<b>Tolerance</b>	<b>Actual</b>	<b>Actual</b>
<b>(A) 2.400</b>	<b>±.008</b>	<b>2.400</b>	<b>2.402</b>
<b>(B) 2.600</b>	<b>±.008</b>	<b>2.603</b>	<b>2.600</b>
<b>(C) 2.775</b>	<b>±.015</b>	<b>2.784</b>	<b>2.781</b>
<b>(D) 3.075</b>	<b>±.010</b>	<b>3.079</b>	<b>3.076</b>
<b>(E) 3.375</b>	<b>±.020</b>	<b>3.384</b>	<b>3.380</b>
<b>(F) .330</b>	<b>±.005</b>	<b>.327/.328</b>	<b>.327/.328</b>
<b>.245</b>	<b>±.005</b>	<b>.244</b>	<b>.244</b>
<b>.431</b>	<b>±.005</b>	<b>.428</b>	<b>.428</b>
<b>.185</b>	<b>±.020</b>	<b>.189</b>	<b>.190</b>
<b>.100 PIN SPCG.</b>	<b>±.005</b>	<b>.099</b>	<b>.099</b>
<b>DWV=600 VDC</b>	<b>PASS</b>		
<b>IR=5,000 MEGA OHMS</b>	<b>PASS</b>	<b>&gt;10G Ohms</b>	

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Dimensional Analysis Record**

<b>Part Number:</b>	<b>AMC25DRXH</b>	<b>Part ID Number:</b>	<b>2</b>
<b>Drawing Number:</b>	<b>WEB SPEC.</b>	<b>Inspector:</b>	<b>DALAVONG</b>
<b>Lot Number:</b>	<b>HSXT</b>		
<b>Date:</b>	<b>12-14-04</b>	<b>PRE-REFLOW</b>	<b>POST-REFLOW</b>
<b>Dimension</b>	<b>Tolerance</b>	<b>Actual</b>	<b>Actual</b>
<b>(A) 2.400</b>	<b>±.008</b>	<b>2.404</b>	<b>2.404</b>
<b>(B) 2.600</b>	<b>±.008</b>	<b>2.602</b>	<b>2.600</b>
<b>(C) 2.775</b>	<b>±.015</b>	<b>2.785</b>	<b>2.783</b>
<b>(D) 3.075</b>	<b>±.010</b>	<b>3.080</b>	<b>3.076</b>
<b>(E) 3.375</b>	<b>±.020</b>	<b>3.381</b>	<b>3.381</b>
<b>(F) .330</b>	<b>±.005</b>	<b>.327/.328</b>	<b>.327/.328</b>
<b>.245</b>	<b>±.005</b>	<b>.244</b>	<b>.244</b>
<b>.431</b>	<b>±.005</b>	<b>.428</b>	<b>.428</b>
<b>.185</b>	<b>±.020</b>	<b>.189</b>	<b>.192</b>
<b>.100 PIN SPCG.</b>	<b>±.005</b>	<b>.100</b>	<b>.100</b>
<b>DWV=600 VDC</b>	<b>PASS</b>		
<b>IR=5,000 MEGA OHMS</b>	<b>PASS</b>	<b>&gt;10G Ohms</b>	

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Dimensional Analysis Record**

<b>Part Number:</b>	<b>AMC25DRXH</b>	<b>Part ID Number:</b>	<b>3</b>
<b>Drawing Number:</b>	<b>WEB SPEC.</b>	<b>Inspector:</b>	<b>DALAVONG</b>
<b>Lot Number:</b>	<b>HSXT</b>		
<b>Date:</b>	<b>12-14-04</b>	<b>PRE-REFLOW</b>	<b>POST-REFLOW</b>
<b>Dimension</b>	<b>Tolerance</b>	<b>Actual</b>	<b>Actual</b>
<b>(A) 2.400</b>	<b>±.008</b>	<b>2.401</b>	<b>2.403</b>
<b>(B) 2.600</b>	<b>±.008</b>	<b>2.602</b>	<b>2.600</b>
<b>(C) 2.775</b>	<b>±.015</b>	<b>2.784</b>	<b>2.781</b>
<b>(D) 3.075</b>	<b>±.010</b>	<b>3.078</b>	<b>3.076</b>
<b>(E) 3.375</b>	<b>±.020</b>	<b>3.382</b>	<b>3.381</b>
<b>(F) .330</b>	<b>±.005</b>	<b>.327/.328</b>	<b>.327/.328</b>
<b>.245</b>	<b>±.005</b>	<b>.244</b>	<b>.243</b>
<b>.431</b>	<b>±.005</b>	<b>.428</b>	<b>.428</b>
<b>.185</b>	<b>±.020</b>	<b>.189</b>	<b>.189</b>
<b>.100 PIN SPCG.</b>	<b>±.005</b>	<b>.099</b>	<b>.100</b>
<b>DWV=600 VDC</b>	<b>PASS</b>		
<b>IR=5,000 MEGA OHMS</b>	<b>PASS</b>	<b>&gt;10G Ohms</b>	

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Dimensional Analysis Record**

<b>Part Number:</b>	<b>AMC25DRXH</b>	<b>Part ID Number:</b>	<b>4</b>
<b>Drawing Number:</b>	<b>WEB SPEC.</b>	<b>Inspector:</b>	<b>DALAVONG</b>
<b>Lot Number:</b>	<b>HSXT</b>		
<b>Date:</b>	<b>12-14-04</b>	<b>PRE-REFLOW</b>	<b>POST-REFLOW</b>
<b>Dimension</b>	<b>Tolerance</b>	<b>Actual</b>	<b>Actual</b>
<b>(A) 2.400</b>	<b>±.008</b>	<b>2.404</b>	<b>2.403</b>
<b>(B) 2.600</b>	<b>±.008</b>	<b>2.603</b>	<b>2.600</b>
<b>(C) 2.775</b>	<b>±.015</b>	<b>2.784</b>	<b>2.780</b>
<b>(D) 3.075</b>	<b>±.010</b>	<b>3.079</b>	<b>3.076</b>
<b>(E) 3.375</b>	<b>±.020</b>	<b>3.381</b>	<b>3.380</b>
<b>(F) .330</b>	<b>±.005</b>	<b>.327/.329</b>	<b>.327/.328</b>
<b>.245</b>	<b>±.005</b>	<b>.245</b>	<b>.244</b>
<b>.431</b>	<b>±.005</b>	<b>.428</b>	<b>.428</b>
<b>.185</b>	<b>±.020</b>	<b>.190</b>	<b>.190</b>
<b>.100 PIN SPCG.</b>	<b>±.005</b>	<b>.101</b>	<b>.100</b>
<b>DWV=600 VDC</b>	<b>PASS</b>		
<b>IR=5,000 MEGA OHMS</b>	<b>PASS</b>	<b>&gt;10G Ohms</b>	

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Dimensional Analysis Record**

<b>Part Number:</b>	<b>AMC25DRXH</b>	<b>Part ID Number:</b>	<b>5</b>
<b>Drawing Number:</b>	<b>WEB SPEC.</b>	<b>Inspector:</b>	<b>DALAVONG</b>
<b>Lot Number:</b>	<b>HSXT</b>		
<b>Date:</b>	<b>12-14-04</b>	<b>PRE-REFLOW</b>	<b>POST-REFLOW</b>
<b>Dimension</b>	<b>Tolerance</b>	<b>Actual</b>	<b>Actual</b>
<b>(A) 2.400</b>	<b>±.008</b>	<b>2.403</b>	<b>2.402</b>
<b>(B) 2.600</b>	<b>±.008</b>	<b>2.603</b>	<b>2.601</b>
<b>(C) 2.775</b>	<b>±.015</b>	<b>2.783</b>	<b>2.781</b>
<b>(D) 3.075</b>	<b>±.010</b>	<b>3.078</b>	<b>3.075</b>
<b>(E) 3.375</b>	<b>±.020</b>	<b>3.381</b>	<b>3.381</b>
<b>(F) .330</b>	<b>±.005</b>	<b>.327/.328</b>	<b>.327/.328</b>
<b>.245</b>	<b>±.005</b>	<b>.244</b>	<b>.243</b>
<b>.431</b>	<b>±.005</b>	<b>.428</b>	<b>.428</b>
<b>.185</b>	<b>±.020</b>	<b>.190</b>	<b>.190</b>
<b>.100 PIN SPCG.</b>	<b>±.005</b>	<b>.099</b>	<b>.099</b>
<b>DWV=600 VDC</b>	<b>PASS</b>		
<b>IR=5,000 MEGA OHMS</b>	<b>PASS</b>	<b>&gt;10G Ohms</b>	

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<b>Part Number:</b>	<b>AMC25DRXH</b>	<b>Part ID Number:</b>	<b>6</b>
<b>Drawing Number:</b>	<b>WEB SPEC.</b>	<b>Inspector:</b>	<b>DALAVONG</b>
<b>Lot Number:</b>	<b>HSXT</b>		
<b>Date:</b>	<b>12-14-04</b>	<b>PRE-REFLOW</b>	<b>POST-REFLOW</b>
<b>Dimension</b>	<b>Tolerance</b>	<b>Actual</b>	<b>Actual</b>
<b>(A) 2.400</b>	<b>±.008</b>	<b>2.404</b>	<b>2.403</b>
<b>(B) 2.600</b>	<b>±.008</b>	<b>2.603</b>	<b>2.600</b>
<b>(C) 2.775</b>	<b>±.015</b>	<b>2.783</b>	<b>2.783</b>
<b>(D) 3.075</b>	<b>±.010</b>	<b>3.078</b>	<b>3.078</b>
<b>(E) 3.375</b>	<b>±.020</b>	<b>3.382</b>	<b>3.383</b>
<b>(F) .330</b>	<b>±.005</b>	<b>.327/.329</b>	<b>.327/.328</b>
<b>.245</b>	<b>±.005</b>	<b>.245</b>	<b>.244</b>
<b>.431</b>	<b>±.005</b>	<b>.428</b>	<b>.428</b>
<b>.185</b>	<b>±.020</b>	<b>.190</b>	<b>.190</b>
<b>.100 PIN SPCG.</b>	<b>±.005</b>	<b>.100</b>	<b>.100</b>
<b>DWV=600 VDC</b>	<b>PASS</b>		
<b>IR=5,000 MEGA OHMS</b>	<b>PASS</b>	<b>&gt;10G Ohms</b>	

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**INSERTION/WITHDRAW FORCES DATA SUMMARY**

PART ID NUMBER: 1		LOT # HSXT	All units are Oz's	
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PRE REFLOW

POST REFLOW

PART NUMBER	INSERTION	WITHDRAW	INSERTION	WITHDRAW
AMC25DRXH				
<b>POSITION</b>				
1	12.5	7	12.5	7.5
2	13	7	12.5	7.5
12	12.5	7.5	11.5	7
13	12.5	7.13	11.5	7.5
14	12	7	11.5	7.5
24	12.5	7.5	12	8
25	12.5	7.5	12	8

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<b>PART ID NUMBER: 2</b>		LOT # HSXT	All units are Oz's	
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**PRE REFLOW**

**POST REFLOW**

<b>PART NUMBER</b>	<b>INSERTION</b>	<b>WITHDRAW</b>	<b>INSERTION</b>	<b>WITHDRAW</b>
<b>AMC25DRXH</b>				
<b>POSITION</b>				
<b>1</b>	<b>14.5</b>	<b>8</b>	<b>13</b>	<b>8</b>
<b>2</b>	<b>14</b>	<b>8</b>	<b>13</b>	<b>8</b>
<b>12</b>	<b>13.5</b>	<b>7.5</b>	<b>11.5</b>	<b>7</b>
<b>13</b>	<b>13.5</b>	<b>7.5</b>	<b>12</b>	<b>7</b>
<b>14</b>	<b>14</b>	<b>8</b>	<b>12</b>	<b>8</b>
<b>24</b>	<b>13.5</b>	<b>8</b>	<b>13</b>	<b>7</b>
<b>25</b>	<b>13</b>	<b>8</b>	<b>13</b>	<b>7</b>



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<b>PART ID NUMBER: 3</b>		LOT # HSXT	All units are Oz's	
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**PRE REFLOW**

**POST REFLOW**

<b>PART NUMBER</b>	<b>INSERTION</b>	<b>WITHDRAW</b>	<b>INSERTION</b>	<b>WITHDRAW</b>
<b>AMC25DRXH</b>				
<b>POSITION</b>				
<b>1</b>	<b>14</b>	<b>9</b>	<b>14</b>	<b>8.5</b>
<b>2</b>	<b>14</b>	<b>8</b>	<b>13</b>	<b>8</b>
<b>12</b>	<b>14</b>	<b>8</b>	<b>12.5</b>	<b>7.5</b>
<b>13</b>	<b>14</b>	<b>9</b>	<b>13</b>	<b>8.5</b>
<b>14</b>	<b>14</b>	<b>8</b>	<b>12.5</b>	<b>7.5</b>
<b>24</b>	<b>14</b>	<b>8</b>	<b>14</b>	<b>9.5</b>
<b>25</b>	<b>14</b>	<b>8</b>	<b>14</b>	<b>10</b>

**TEST REPORT**



**TITLE: PROCESSING TEMPERATURE OF EDGE CARD CONNECTORS WITH R-7 RYTON BODIES**

**TEST REPORT NO.: STR-052  
December 23, 2004**

**APPROVED BY: Marshall Hulbert, Quality Assurance Manager**

<b>PART ID NUMBER: 4</b>		LOT # HSXT	All units are Oz's	
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**PRE REFLOW**

**POST REFLOW**

<b>PART NUMBER</b>	<b>INSERTION</b>	<b>WITHDRAW</b>	<b>INSERTION</b>	<b>WITHDRAW</b>
<b>AMC25DRXH</b>				
<b>POSITION</b>				
<b>1</b>	<b>14</b>	<b>8</b>	<b>15.5</b>	<b>11</b>
<b>2</b>	<b>14.5</b>	<b>9</b>	<b>14</b>	<b>9</b>
<b>12</b>	<b>14</b>	<b>9</b>	<b>12</b>	<b>8.5</b>
<b>13</b>	<b>13</b>	<b>9</b>	<b>12</b>	<b>7</b>
<b>14</b>	<b>14</b>	<b>8.5</b>	<b>13</b>	<b>9</b>
<b>24</b>	<b>15</b>	<b>10</b>	<b>15</b>	<b>10</b>
<b>25</b>	<b>13.5</b>	<b>10</b>	<b>14.5</b>	<b>10</b>

**TEST REPORT**



**TITLE: PROCESSING TEMPERATURE OF EDGE CARD CONNECTORS WITH R-7 RYTON BODIES**

**TEST REPORT NO.: STR-052  
December 23, 2004**

**APPROVED BY: Marshall Hulbert, Quality Assurance Manager**

<b>PART ID NUMBER: 5</b>		LOT # HSXT	All units are Oz's	
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**PRE REFLOW**

**POST REFLOW**

<b>PART NUMBER</b>	<b>INSERTION</b>	<b>WITHDRAW</b>	<b>INSERTION</b>	<b>WITHDRAW</b>
<b>AMC25DRXH</b>				
<b>POSITION</b>				
<b>1</b>	<b>14</b>	<b>8</b>	<b>13.5</b>	<b>9</b>
<b>2</b>	<b>14</b>	<b>9</b>	<b>13.5</b>	<b>9</b>
<b>12</b>	<b>14.5</b>	<b>9</b>	<b>13</b>	<b>8</b>
<b>13</b>	<b>14</b>	<b>10</b>	<b>13.5</b>	<b>9</b>
<b>14</b>	<b>13</b>	<b>8</b>	<b>13</b>	<b>8</b>
<b>24</b>	<b>14</b>	<b>9.5</b>	<b>14</b>	<b>9</b>
<b>25</b>	<b>14</b>	<b>9</b>	<b>14</b>	<b>9</b>

**TEST REPORT**



**TITLE: PROCESSING TEMPERATURE OF EDGE CARD CONNECTORS WITH R-7 RYTON BODIES**

**TEST REPORT NO.: STR-052  
December 23, 2004**

**APPROVED BY: Marshall Hulbert, Quality Assurance Manager**

<b>PART ID NUMBER: 6</b>		LOT # HSXT	All units are Oz's	
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**PRE REFLOW**

**POST REFLOW**

<b>PART NUMBER</b>	<b>INSERTION</b>	<b>WITHDRAW</b>	<b>INSERTION</b>	<b>WITHDRAW</b>
<b>AMC25DRXH</b>				
<b>POSITION</b>				
<b>1</b>	<b>14</b>	<b>10</b>	<b>15</b>	<b>12</b>
<b>2</b>	<b>14</b>	<b>10</b>	<b>16</b>	<b>12</b>
<b>12</b>	<b>14</b>	<b>9</b>	<b>14</b>	<b>10</b>
<b>13</b>	<b>15</b>	<b>10</b>	<b>14</b>	<b>10</b>
<b>14</b>	<b>14</b>	<b>10</b>	<b>13.5</b>	<b>9</b>
<b>24</b>	<b>14</b>	<b>10</b>	<b>15</b>	<b>11</b>
<b>25</b>	<b>14.5</b>	<b>10</b>	<b>15.5</b>	<b>11.5</b>

**TEST REPORT**



**TITLE: PROCESSING TEMPERATURE OF EDGE CARD CONNECTORS WITH R-7 RYTON BODIES**

**TEST REPORT NO.:  
STR-052  
December 23, 2004**

**APPROVED BY: Marshall Hulbert, Quality Assurance Manager**

**EQUIPMENT LIST**

<b>Next cal</b>	<b>Last Cal</b>	<b>Equipment Name</b>	<b>Manufacturer</b>	<b>Model #</b>	<b>Serial #</b>
		FURNACE	BARNSTEAD	FB1315M	
06/01/05	06/01/04	VISION SYSTEM	QC SOLUTIONS	SMB44	QC230
08/19/05	08/19/04	CALIPER	STARRETT	721	
08/19/05	08/19/04	AC/DC DWV TESTER W/ IR	ASSOCIATED RESEARCH	3670	9330578
10/25/05	10/25/04	FORCE TESTER	CHATILLON	DPF-16	