

REV	ECO #	DATE	BY	INIT
AG	9750	02/12/99	ATV	ATV
AH	10700	09/20/99	DKN	ATV
AJ	11066	12/12/99	ATV	ATV
AK	11295	02/24/00	DKN	ATV
AL	12076	08/09/00	DKN	ATV
AM	12470	10/01/00	IMG	ATV
AN	13087	03.20.01	ATV	ATV
AP	13163	04.12.01	AGS	ATV
AR	14009	12.13.01	ATV	ATV
AS	14384	04.11.02	AGS	ATV
AT	14567	05.30.02	DKN	PM
AU	15026	11.07.02	AGS	ATV
AV	16203	10.06.03	ATV	ATV
AW	16276	10.28.03	SLM	DKN
AX	16519	01.20.04	DKN	PM
AY	16753	03.22.04	ATV	DNg
BA	16793	04.05.04	ATV	DNg
BB	17501	10.01.04	JF	DNg
BC	17552	10.15.04	DKN	SMP
BD	17590	10.28.04	JF	DNg
BE	18085	04.13.05	RC	DNg
BF	19150	03.31.06	SLM	DNg
BG	19486	08.14.06	SLM	PM
BH	20252	05.11.07	ATV	ATV
BJ	20704	11/02/07	ATV	ATV
BK	22531	10.14.09	PM	PM
BL	23648	10/04/10	PM	ATV

GENERAL SPECIFICATION GS100


		High Performance Cables & Interconnect Systems LONG BEACH, CALIFORNIA 90815	
TITLE GENERAL SPECIFICATION GS100			
SCALE NONE	SUB-DIRECTORY\FILENAME _GS\GS100.DOC		SHEET 1 OF 8
SIZE A	CAGE CODE 30990	DRAWING NO. GS100	REV. BL

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1.0 Material Usage Table.

COMPONENT(S)	MATERIAL(S)	SPECIFICATION(S)	PROCUREMENT(S)	CURING	FINISH(ES)
BODY					
MACHINED ALUMINUM (6061-T6, 6061-T651)	M34	S14, S22, S23			F7
MACHINED ALUMINUM (6262-T9)	M14	S14			F7
MACHINED ALUMINUM (6061-T651)	M15	S14, S22, S23			F7
MACHINED BeCu	M5	S5	P2		F4
MACHINED BRASS	M4	S4	P3		F4,F9, F11, F12
MACHINED KOVAR	M12	S13			F6
MACHINED SST	M1, M13	S1, S12	P1		F1,F2,F6
MOLDED	M13	S12	P1		F1,F2,F6
CASTING	M1, M13	S11, S12	P1		F1,F2,F6
SOLDER ON	M1	S1	P1		F3
TUBE SEAMLESS SST	M2	S2	P4		
CENTER CONDUCTOR					
FEMALE					
STRAIGHT BeCu	M5	S5	P2		F4
RIGHT ANGLE BeCu	M5	S5	P2		F4
STR PHOSPHOR BRONZE	M37	S21			F3, F4
MALE					
STRAIGHT BECU	M5	S5	P2		F4
STRAIGHT BRASS	M4	S4	P3		F4
STRAIGHT KOVAR	M12	S13			
STRAIGHT MOLYDENUM	M16	S16			
RIGHT ANGLE BECU	M5	S5	P2		F4
CAPTIVATION					
EPOXY	M8			C1,C2,C3	
HYSOL	M29			C6	
CONDUCTIVE EPOXY	M9, M32			C4, C5	
CERAMIC	M25	S17			
GASKET					
EMI	M7	S7			
NON-EMI	M6	S6			
INSULATOR					
BORON NITRIDE	M30				
CRYSTALOR (FR-TPX- T130)	M19				
CRYSTALOR (HBG-30)	M20				
FLUOROLOY H	M24				
GLASS 7052	M22				
GLASS 7070	M23				
PEEK	M21				
NORYL	M36				
REXOLITE	M28				
TEFLON	M3	S3			
TORLON®	M17	S15			
VECTRA® E130i	M33				
ULTEM 1000	M35	S20			
PMP (MBZ230A)	M38				
NUT	M1	S1	P1		F1,F2
RETAINING RING	M5	S5	P2		
SHRINK TUBING	M31	S19			
SOLDER					
LOW TEMP	M10	S9			
HIGH TEMP	M11	S9			
TUBE SEAMLESS SST	M2	S10	P4		
WASHER					
FLAT					
LOCK	M26, M27	S18			F1,F2,F4

NOTE: VECTRA® IS A REGISTERED TRADEMARK OF TICONA COMPANY
TORLON® IS A REGISTERED TRADEMARK OF AMOCO COMPANY

2.0 MATERIAL TABLE

CODE(S)	DESCRIPTION(S)
M1	303 STAINLESS STEEL (SST)
M2	304 STAINLESS STEEL (SST)
M3	PTFE (TEFLON)
M4	BRASS ALLOY C360
M5	BERYLLIUM COPPER (BeCu) ALLOY C173; CONDITION H
M6	SILICON RUBBER
M7	CHO-SEAL
M8	No. 1 VARY FLEX TYPE HV (SIGMA PLASTRONICS)
M9	ABLEBOND 16-1 SILVER EPOXY (ABLESTICK LABORATORIES)
M10	SN-63 FLUX WRMA-P3
M11	SN-96 FLUX WRMA-P3
M12	KOVAR
M13	304L STAINLESS STEEL (SST)
M14	ALUMINUM 6262-T9
M15	ALUMINUM 6061-T651
M16	MOLY HCT PHILLIPS ELMET
M17	POLYAMIDE-IMIDE (PAI) TORLON® AMOCO, GRADE 4203L
M18	KEL-F
M19	POLYMETHYLPENTENE (PMP) FR-TPX-T130
M20	POLYMETHYLPENTENE (PMP) HBG-30
M21	POLYETHEREKEYTONE (PEEK)
M22	GLASS 7052
M23	GLASS 7070
M24	FLUOROLOY H
M25	BERYLLIUM OXIDE ¹
M26	410 STAINLESS STEEL (SST)
M27	PHOSPHOR BRONZE, C510 SPRING ROD
M28	REXOLITE
M29	HYSOL EA 9395
M30	BORON NITRIDE GRADE M
M31	HEAT SHRINKABLE INSULATION SLEEVE
M32	ECCOBOND 56C
M33	VECTRA® E130i
M34	ALUMINUM 6061-T6; 6061-T651
M35	ULTEM 1000 (POLYETHERIMIDE)
M36	NORYL
M37	PHOSPHOR BRONZE B-2, C544
M38	POLYMETHYLPENTENE (PMP) RESIN, MBZ230A

NOTE: VECTRA® IS A REGISTERED TRADEMARK OF TICONA COMPANY
TORLON® IS A REGISTERED TRADEMARK OF AMOCO COMPANY
NORYL™ IS A REGISTERED TRADEMARK OF GENERAL ELECTRIC

3.0 EPOXY CURING TABLE

MATERIAL(S)	CODE(S)	DESCRIPTION(S)
M8	C1	SOFTCURE: 8 TO 10 HOURS @ ROOM TEMP. (25°C OR 77°F); FOR NON-OUTGASSING REQUIREMENT
M8	C2	HARDCURE: 3 HOURS @ 150°F; FOR OUTGASSING REQUIREMENT
M8	C3	HARDCURE: 24 HOURS MINIMUM @ ROOM TEMP. (25°C OR 77°F), FOLLOWED BY 2 HOURS BAKE @ 225°F, FOR OUTGASSING REQUIREMENT
M8	C4	HARDCURE: 1/2 HOURS MINIMUM @ ROOM TEMP. (25°C OR 77°F), FOLLOWED BY 2 HOURS BAKE @ 225°F, FOR OUTGASSING REQUIREMENT
M32	C5	1 HOUR @ 65°C (150°F ± 10°F), USING CATALYST # 9
M32	C6	8 HOURS @ 80°C (176°F), USING CATALYST # 11
M9, M29	C7	24 HOURS MINIMUM @ ROOM TEMP. (25°C OR 77°F), FOLLOWED BY MINIMUM OF 1 HOUR @ 65°C (150°F)

¹ ANY COMPONENTS USING THIS MATERIAL MUST BE PURCHASED AS FINISHED PARTS.

4.0 MATERIAL SPECIFICATION TABLE

CODE(S)	UNS NO.	SAE-AMS	ASTM	FED. SPEC.	MIL. SPEC.	FORM(S)
S1			A-582			ST. STL. FREE MACHINE BAR
S2		5370				STEEL CASTINGS, INVESTMENT, CORROSION AND HEAT RESISTANT
S3			D-1710 D-1457			TYPE 1, GRADE 1, CLASS B POLYTETRAFLUOROETHYLENE (PTFE) ROD OR MOLDING
S4	C36000	4610	B-16			FREE-CUTTING BRASS ROD, BAR, AND SHAPES FOR USE IN SCREW MACHINES.
S5	C17300		B-196			COPPER BERYLLIUM ALLOY ROD AND BAR; CONDITION H
S6				A-A-59588		RUBBER, SILICONE; GASKET
S7					MIL-G-83528 TYPE B	
S8						NOT ASSIGNED
S9				QQ-S-571		
S10		5567			MIL-T-8504	ST. STL. SEAMLESS OR WELDED TUBE
S11			A-743 A-744		MIL-S-81591 TYPE 1C303	ST. STL. FOR CASTINGS, IRON-CHROMIUM, IRON-CHROMIUM-NICKEL, AND NICKEL-BASE CORROSION-RESISTANT
S12	S30403	5511				STAINLESS AND HEAT-RESISTING CHROMIUM-NICKEL STEEL PLATE, SHEET STRIP AND BAR
S13	K94610		F-15			IRON, NICKEL-COBALT SEALING ALLOY (KOVAR)
S14		QQ-A-225/8	B-211			ALUMINUM COLD DRAWN ROD
S15		3670	D-5204		P-46179	TORLON®
S16			B-387			TYPE 361 WIRE OR ROD MODIFIED TO HCT
S17						THERMALOX 995 CERAMICS ²
S18			B-139	QQ-B-750		ROD COMPOSITION A
S19		DTL-23053				HEAT SHRINKABLE INSULATION SLEEVES
S20			D-5205			ULTEM 1000 (POLYETHERIMIDE)
S21		4520	B-103			PHOSPHOR BRONZE B-2
S22		QQ-A-200	B-221			ALUMINUM EXTRUDED ROD
S23		QQ-A-250	B209			ALUMINUM FLAT SHEET

5.0 PROCUREMENT/PROCESS TABLE

CODE(S)	DESCRIPTION(S)	USEABLE WITH SPECIFICATION CODE(S)
P1	CONDITION A (ANNEALED)	S1, S12
P2	TEMPER TD04 (Formerly H) H04	S5 S4 (ASTM B-16 ONLY)
P3	H02	S4 (ASTM B-16 ONLY)
P4	ANNEALED AND DESCALED	S10
P5	HEAT TREAT 2HR @ 675°F/685°F TO CONDITION TH04 PER SAE-AMS-H-7199	S5
P6	HEAT TREAT 2HR @ 600°F ± 5°F TO CONDITION TH04 PER SAE-AMS-H-7199	S5
P7	HEAT TREAT 1.5HR @ 525°F ± 5°F TO CONDITION TH04 PER SAE-AMS-H-7199	S5
P8	HEAT TREAT 2HR @ 600°F/625°F TO CONDITION HT PER SAE-AMS-H-7199	S5

6.0 FINISH TABLE (MIL-DTL-45204)

CODE(S)	FINISH(ES)	DESCRIPTION(S)
K1	PASSIVATE	303 & 410 STAINLESS STEEL, PER AMS-QQ-P-35, TYPE II 304, 316 & 321 STAINLESS STEEL, PER AMS-QQ-P-35, TYPE IV
K2	PLATE	SULFAMATE NICKEL PER SAE-AMS-QQ-N-290, CLASS 1, .000015/.000100 THICK. GOLD PER MIL-DTL-45204, TYPE II, GRADE C, (.000010/.000030 THICK)
K3	PLATE	SULFAMATE NICKEL PER SAE-AMS-QQ-N-290, CLASS 1, .000050/.000150 THICK. GOLD PER MIL-DTL-45204, TYPE II, GRADE C, (.000010/.000030 THICK)
K4	PLATE	COPPER STRIKE. VIBRATORY SULFAMATE NICKEL PER SAE-AMS-QQ-N-290, CLASS 1, .000050/.000110 THICK . GOLD STRIKE TYPE I. VIBRATORY GOLD PER MIL-DTL-45204, TYPE II, GRADE C OR D, CLASS 1 (.000050/.000090 THICK) ³
K5	PLATE	COPPER STRIKE. VIBRATORY SULFAMATE NICKEL PER SAE-AMS-QQ-N-290, CLASS 1, .000050/.000110 THICK. GOLD STRIKE TYPE III. VIBRATORY GOLD PER MIL-DTL-45204, TYPE II, GRADE C OR D, CLASS 1 (.000050/.000090 THICK) ³
K6	PLATE	SULFAMATE NICKEL PER SAE-AMS-QQ-N-290, CLASS 1, .000050/.000150 THICK. GOLD PER MIL-DTL-45204, TYPE II, GRADE C, CLASS 1 (.000050/.000150 THICK) ³
K7		(INTENTIONALLY LEFT BLANK)
K8	PLATE	WOODS NICKEL STRIKE ⁴ ELECTROLESS NICKEL PER ASTM B 656 OR MIL-C-26074, .000050/.000100 THICK. GOLD PER MIL-DTL-45204, TYPE III, GRADE A, CLASS 1, .000050/.000090 THICK.
K9	PLATE	ALBALOY, .000050~ .000100 THICKNESS.
K10	PLATE	SULFAMATE NICKEL PER SAE-AMS-QQ-N-290, CLASS 1, .000015/.000100 THICK GOLD PER MIL-DTL-45204, TYPE II, GRADE C OR D, CLASS 00 (.000020/.000050 THICK)
K11		(INTENTIONALLY LEFT BLANK)
K12	PLATE	COPPER PLATE PER AMS 2418, .000050/.000100 THICK GOLD PLATE PER MIL-DTL-45204, TYPE II, GRADE C OR D, CLASS 1, (.000050/.000090 THICK)
K13	PLATE (Special for BeCu)	COPPER STRIKE. BRIGHT NICKEL PLATE PER SAE-AMS-QQ-N-290, CLASS 1, .000050/.000100 THICK. GOLD PLATE PER MIL-DTL-45204, TYPE II, GRADE C, .000010/.000030 THICK
K14	PLATE (Special for 303 SST.)	BRIGHT NICKEL PLATE PER SAE-AMS-QQ-N-290, CLASS 1, .000050/.000100 THICK. GOLD PLATE PER MIL-DTL-45204, TYPE II, GRADE C, .000010/.000030 THICK
K15	PLATE	SULFAMATE NICKEL PLATE PER SAE-AMS-QQ-N-290, CLASS 1, .000050/.000100 THICK. GOLD PLATE PER MIL-DTL-45204, TYPE II, GRADE C, .000050/.000090 THICK.
K16	PLATE	SULFAMATE NICKEL PER SAE-AMS-QQ-N-290, CLASS 1, .000050/.000150 THICK. GOLD PER MIL-DTL-45204, TYPE II, GRADE C, (.000020/.000040 THICK)
K17	PLATE	SULFAMATE NICKEL PER SAE-AMS-QQ-N-290, CLASS 1, .000050/.000150 THICK. GOLD PER MIL-DTL-45204, TYPE III, GRADE A, CLASS 2 (.000100/.000150 THICK) ⁷

³ UNLESS OTHERWISE STATED ON DRAWING. GOLD PLATING IS NOT REQUIRED ON THE INSIDE SURFACE OF THE SOCKET CONTACT (FEMALE), FROM THE BOTTOM OF THE SLOTS THE BASE OF THE INSIDE DIAMETER. THIS AREA IS TO BE FREE OF PLATING SALTS AND CONTAMINATION.

⁴ WOODS NICKEL STRIKE IS ONLY APPLICABLE FOR STAINLESS STEEL MATERIAL.

⁷ RECOMMENDED FOR WIRE BONDING APPLICATIONS.

7.0 FINISH TABLE (ASTM B-488)

CODE(S)	FINISH(ES) TYPE	DESCRIPTION(S)
F1	PASSIVATE	303 & 410 STAINLESS STEEL, PER ASTM A 967, NITRIC 1 304, 316 & 321 STAINLESS STEEL, PER ASTM A 967, NITRIC 2
F2	PLATE	SULFAMATE NICKEL PER SAE-AMS-QQ-N-290, CLASS 1, .000015/.000100 THICK. GOLD PER ASTM B 488, TYPE II, CODE C, CLASS 0.25 (.000010/.000030 THICK)
F3	PLATE	SULFAMATE NICKEL PER SAE-AMS-QQ-N-290, CLASS 1, .000050/.000150 THICK. GOLD PER ASTM B 488, TYPE II, CODE C, CLASS 0.25 (.000010/.000030 THICK)
F4	PLATE	COPPER STRIKE. VIBRATORY SULFAMATE NICKEL PER SAE-AMS-QQ-N-290, CLASS 1, .000050/.000110 THICK. GOLD STRIKE TYPE I. VIBRATORY GOLD PER ASTM B 488, TYPE II, CODE C OR D, CLASS 1.25 (.000050/.000090 THICK) ⁵
F5	PLATE	COPPER STRIKE. VIBRATORY SULFAMATE NICKEL PER SAE-AMS-QQ-N-290, CLASS 1, .000050/.000110 THICK. GOLD STRIKE TYPE III. VIBRATORY GOLD PER ASTM B 488, TYPE II, CODE C OR D, CLASS 1.25 (.000050/.000090 THICK) ⁵
F6	PLATE	SULFAMATE NICKEL PER SAE-AMS-QQ-N-290, CLASS 1, .000050/.000150 THICK. GOLD PER ASTM B 488, TYPE II, CODE C, CLASS 1.25 (.000050/.000150 THICK) ⁵
F7	PLATE	SULFAMATE NICKEL PER AMS-QQ-N-290, CLASS 1, .000050/.000100 THICK
F8	PLATE	WOODS NICKEL STRIKE ⁶ ELECTROLESS NICKEL PER ASTM B 656 OR MIL-C-26074, .000050/.000100 THICK. GOLD PER ASTM B 488, TYPE III, GRADE A, .000050/.000090 THICK.
F9	PLATE	ALBALOY, .000050~.000100 THICKNESS.
F10	PLATE	SULFAMATE NICKEL PER SAE-AMS-QQ-N-290, CLASS 1, .000015/.000100 THICK GOLD PER ASTM B-488, TYPE II, CODE C OR D, CLASS 0.50 (.000020/.000050 THICK)
F11	PLATE	SILVER PLATE PER QQ-S-365D, GRADE A, .000050/.000100 THICK POST-TREATMENT WITH TARNISH PREVENTATIVE FOR ELECTRONIC APPLICATIONS.
F12	PLATE	COPPER PLATE PER AMS 2418, .000050/.000100 THICK GOLD PLATE PER ASTM B-488, TYPE II, CODE C OR D, CLASS 1.25 (.000050/.000090 THICK)
F13	PLATE (Special for BeCu)	COPPER STRIKE. BRIGHT NICKEL PLATE PER SAE-AMS-QQ-N-290, CLASS 1, .000050/.000100 THICK. GOLD PLATE PER ASTM B 488, TYPE II, CODE C, .000010/.000030 THICK
F14	PLATE (Special for 303 SST.)	BRIGHT NICKEL PLATE PER SAE-AMS-QQ-N-290, CLASS 1, .000050/.000100 THICK. GOLD PLATE PER ASTM B 488, TYPE II, CODE C, .000010/.000030 THICK
F15	PLATE	SULFAMATE NICKEL PLATE PER SAE-AMS-QQ-N-290, CLASS 1, .000050/.000100 THICK. GOLD PLATE PER ASTM B-488, TYPE II, CODE C, .000050/.000090 THICK.
F16	PLATE	SULFAMATE NICKEL PER SAE-AMS-QQ-N-290, CLASS 1, .000050/.000150 THICK. GOLD PER ASTM B 488, TYPE II, CODE C, CLASS 0.50 (.000020/.000040 THICK)
F17	PLATE	SULFAMATE NICKEL PER SAE-AMS-QQ-N-290, CLASS 1, .000050/.000150 THICK. GOLD PER ASTM B 488, TYPE III, CODE A, CLASS 2.5 (.000100/.000150 THICK) ⁷
F18	PLATE	ALBALOY, .000200 MIN. THICKNESS
F19	PASSIVATE	PASSIVATE PER SAE-AMS 2700, METHOD 1, TYPE 2 FOR 303SST AND 410SST
F20	PASSIVATE	PASSIVATE PER SAE-AMS 2700, METHOD 1, TYPE 4 FOR 304SST AND 316SST

⁵ UNLESS OTHERWISE STATED ON DRAWING. GOLD PLATING IS NOT REQUIRED ON THE INSIDE SURFACE OF THE SOCKET CONTACT (FEMALE), FROM THE BOTTOM OF THE SLOTS THE BASE OF THE INSIDE DIAMETER. THIS AREA IS TO BE FREE OF PLATING SALTS AND CONTAMINATION.

⁶ WOODS NICKEL STRIKE IS ONLY APPLICABLE FOR STAINLESS STEEL MATERIAL.

⁷ RECOMMENDED FOR WIRE BONDING APPLICATIONS.

8.0 AMS 2418 COPPER PLATING SPECIFICATIONS:

DESIGNATION(S)	THICKNESS (INCH)	COMMENTS
AMS 2418	.0005 ~ .0007	DESIGNATED PLATING THICKNESS OF AMS 2418.
	.0001 (APPROX.)	COPPER FLASH
	.0007 ~ .0020	PERMISSIBLE FOR PREVENTING CARBURIZING
OTHER PLATING THICKNESS MAY BE SPECIFIED BY AMS 2418 AND A SUFFIX NUMBER DESIGNATING THE MINIMUM THICKNESS IN TEN THOUSANDTHS (.0001) OF AN INCH. A TOLERANCE OF +.0002 INCH WILL BE ALLOWED. THUS . . .		
AMS 2418-1	DESIGNATES A THICKNESS OF .0001 ~ .0003	
AMS 2418-3	DESIGNATES A THICKNESS OF .0003 ~ .0005	
AMS 2418-6	DESIGNATES A THICKNESS OF .0006 ~ .0008	

9.0 AMS-QQ-N-290 NICKEL PLATING SPECIFICATIONS:

CLASS(S) GRADE(S)	THICKNESS	COMMENTS
CLASS 1	-----	FOR CORROSION PROTECTION
CLASS 2	-----	ENGINEERING PLATING APPLICATION
GRADE A	.0016"	
GRADE B	.0012"	
GRADE C	.0010"	
GRADE D	.0008"	
GRADE E	.0006"	
GRADE F	.0004"	
GRADE G	.0002"	

10.0 ASTM B 488 & MIL-DTL-45204 GOLD PLATING SPECIFICATIONS:

ASTM B-488		MIL-DTL-45204		COMMENT(S)
TYPE	PURITY	TYPE	PURITY	
TYPE III	99.9% GOLD MIN.	TYPE III	99.9% GOLD MIN.	(CODE A OR GRADE A ONLY)
TYPE I	99.7% GOLD MIN.	TYPE I	99.7% GOLD MIN.	(CODE A, B, C OR GRADE A, B, C)
TYPE II	99.0% GOLD MIN.	TYPE II	99.0% GOLD MIN.	(CODE B, C, D OR GRADE A, B, C)
CODE	KNOOP	GRADE	KNOOP	
CODE A	90 KNOOP MAX.	GRADE A	90 KNOOP MAX.	
CODE B	91-129 KNOOP.	GRADE B	91-129 KNOOP.	
CODE C	130-200 KNOOP.	GRADE C	130-200 KNOOP.	
CODE D	201 KNOOP MIN.	GRADE D	201 KNOOP MIN.	
CLASS	THICKNESS	CLASS	THICKNESS	
CLASS 0.25	.000010" MIN. (.25 μM)	CLASS 00	.000020" MIN.	
CLASS 0.50	.000020" MIN. (.50 μM)	CLASS 0	.000030" MIN.	
CLASS 0.75	.000030" MIN. (.75 μM)	CLASS 1	.000050" MIN.	
CLASS 1.0	.000040" MIN. (1.0 μM)	CLASS 2	.000100" MIN.	
CLASS 1.25	.000050" MIN. (1.25 μM)	CLASS 3	.000200" MIN.	
CLASS 2.5	.000100" MIN. (2.5 μM)	CLASS 4	.000300" MIN.	
CLASS 5.0	.000200" MIN. (5.0 μM)	CLASS 5	.000500" MIN.	
		CLASS 6	.001500" MIN.	