

**NOTES:**

**1- MATERIAL:**

HOUSING: LCP GLASS FILLED UL 94V0, COLOUR: BLACK  
 TERMINAL: COPPER ALLOY PLATED WITH:  
 BASE FINISH: NICKEL  
 CONTACT SURFACE FINISH:  
 GOLD  
 OR  
 GOLD FLASH OVER PALLADIUM NICKEL.  
 EXCEEDS PRODUCT REQUIREMENTS BASED ON PS-95501

SOLDER PEGS: COPPER ALLOY PLATED WITH TIN.

2- JACK FOR MATING WITH IEC 60603-7 & TIA-1096-A PLUGS (MOLEX 90075 SERIES).

3- PRODUCT SPECIFICATION: MOLEX PS-95501

4- POLYIMIDE ADHESIVE TAPE FOR PICK & PLACE SURFACE. THICKNESS: 125 µm

5- PACKAGING SPECIFICATION: MOLEX PK-85502. (BLISTER PACKAGING).

6- COPLANARITY OF SIGNAL LEADS: 0.10

7- SEE DIMENSIONS IN CHART ON SHEET 2.

8- P.C. BOARD THICKNESS: 1.57

9- MANUFACTURING I.D. CAN BE EITHER MG, MXF OR MXI.

10- APPLICATION SPEC: AS-85513-001

LAST INSPECTION NUMBER: 14

CHANGED PROD SPEC EC NO: IPG2013-0771 DRWN:DBYRNES 2012/11/23 CHKD: APPR:STGRIFFIN 2012/12/13	DESCRIPTION REV	QUALITY SYMBOLS	GENERAL TOLERANCES (UNLESS SPECIFIED)		DIMENSION STYLE MM ONLY		SCALE 5:1	DESIGN UNITS METRIC	THIRD ANGLE PROJECTION	
		▽=0	mm	INCH	DRAWN BY DB	DATE 2006/06/12	TITLE R/A LOW PROFILE P.C.JACK SMT; 4,6 & 8 CKTS WITH THROUGH HOLE SOLDER PEGS			
		∠=0	4 PLACES ± --- ± ---	3 PLACES ± --- ± ---	CHECKED BY EOMAHONY	DATE 2006/06/15	MOLEX MOLEX INCORPORATED			
			2 PLACES ± 0.25 ± ---	1 PLACE ± 0.35 ± ---	APPROVED BY EOMAHONY	DATE 2006/06/15	MATERIAL NO. SEE CHART SHT 2	DOCUMENT NO. SD-85502-103	SHEET NO. 1 OF 2	
			ANGULAR ± 2 °		DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS					
					THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INCORPORATED AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION					



# PRODUCT SPECIFICATION

## RIGHT ANGLE HIGH SPEED CAT 5E MODULAR JACK

### 1.0 SCOPE

This specification covers the performance requirements of the Molex High Speed Cat 5e Right Angle Low Profile Modular Telephone Jacks. Where applicable, tests are in accordance with IEC 60603-7-2.

### 2.0 PRODUCT DESCRIPTION

#### 2.1 PRODUCT NAME.

85503-\*\*\*\* High Speed Modular Jack Right Angle Low Profile.

#### 2.2 DIMENSIONS, MATERIALS, PLATINGS AND MARKINGS

CONTACT FINISH: GOLD

Post Plate 0.00127mm-0.00152mm Gold in contact area.

0.00190mm Min pure Tin in Tail area, both over 0.00127mm Min Nickel overall.

**OR,**

PALLADIUM NICKEL WITH GOLD FLASH:

Post plate 0.00005mm Min Gold Flash over 0.00060mm Min Palladium Nickel in contact area,

0.00190mm Min pure Tin in tail area, both over 0.00127mm Min Nickel overall.

### 3.0 APPLICABLE DOCUMENTS AND SPECIFICATIONS

See the appropriate Sales Drawings and the other sections of this Specification for the necessary referenced Documents and Specifications.

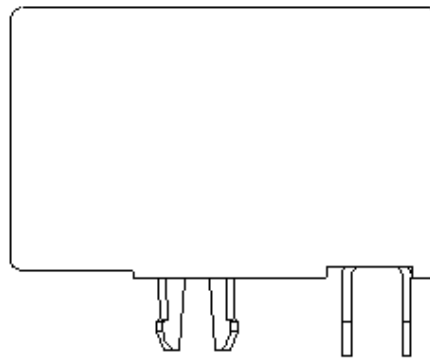
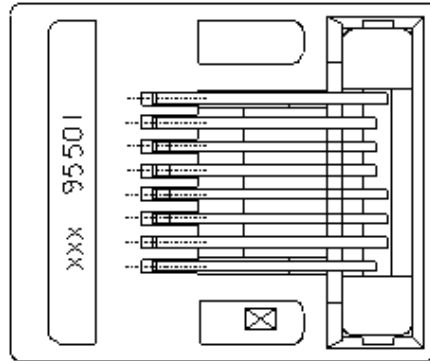
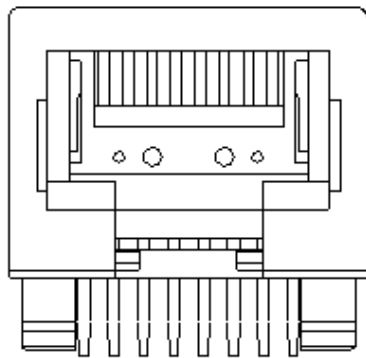
IEC 60603-7-2

TIA-1096-A

REVISION: <b>D</b>	ECR/ECN INFORMATION: EC No: <b>IPG2013-0856</b> DATE: <b>2012 / Feb / 21</b>	TITLE: <b>RIGHT ANGLE HIGH SPEED CAT 5E LOW PROFILE MODULAR JACKS PRODUCT SPECIFICATION.</b>	SHEET No. <b>1 of 12</b>
DOCUMENT NUMBER: <b>PS-85503-001</b>	CREATED / REVISED BY: <b>D.Byrnes</b>	CHECKED BY: <b>A.Higgins</b>	APPROVED BY: <b>S.Griffin</b>



# PRODUCT SPECIFICATION



## 4.0 RATINGS

### 4.1 VOLTAGE

125 Volts d.c.

### 4.2 CURRENT

1.5 Amps max

### 4.3 TEMPERATURE

Operating: - 40° C to + 85° C

Non operating: - 40° C to + 85° C

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# PRODUCT SPECIFICATION

## 5.0 TEST SCHEDULES

The following tests specify the characteristics to be checked and the requirements to be fulfilled.

For a complete test sequence, a minimum of 62 specimens are needed. This equals 6 groups of 10, and 1 group of 2. The group of 2 is for transmission testing, group EP.

All connectors in each group shall undergo the following tests as described in the sequence given, required alteration of the sequence of tests or adding of new tests to verify additional connector characteristics.

**All the test group specimens shall be subjected to the preliminary group P tests in the following sequence.**

Test group P

TEST PHASE	TITLE	SEVERITY	REQUIREMENTS
P 1	GENERAL EXAMINATION PER IEC 60512-1-1, Test 1a	Visual examination	There shall be no defects that would impair normal operation
P2	N/A		
P 3	CONTACT RESISTANCE IEC 60512-2-1, Test 2a	Mated connectors:  (Measurement points per section 7.0)	Initial 20 mΩ maximum
P 4	INSULATION RESISTANCE IEC 60512-3-1, Test 3a, Method a.	Test voltage 100 Vd.c. Method A mated connectors	500 MΩ Minimum
P 5	VOLTAGE PROOF IEC 60512-4-1, Test 4a, Method a.	Contact/contact Method A Mated Connector	1000 V d.c. or a.c. peak

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# PRODUCT SPECIFICATION

Test group AP

TEST PHASE	TITLE	SEVERITY	REQUIREMENTS
AP 1	INSERTION AND WITHDRAWAL FORCES PER IEC 60512-13-2, Test 13b	Connector locking device depressed.	Insertion force 20 N max, Withdrawal force 20 N max.
AP 2	EFFECTIVENESS OF CONNECTOR COUPLING DEVICE.  PER IEC 60512-15-6, Test 15f	Rate of load application 44,5 N/S Max	50N for 60s ± 5s
AP 3	RAPID CHANGE OF TEMPERATURE  PER IEC 60512-11-4	-40°C to 70°C Mated connectors 25 cycles t = 30 min recovery time 2 h	
AP 4	INSULATION RESISTANCE  IEC 60512-3-1, Test 3a, Method a.	Test voltage 100 v ±15 v d.c. method a mated connectors	PER P4
AP 5	CONTACT RESISTANCE  IEC 60512-2-1, Test 2a	PER P3	20 mΩ maximum change from initial
AP 6	VOLTAGE PROOF  IEC 60512-4-1, Test 4a, Method a.	PER P5	PER P5
AP 7	VISUAL EXAMINATION	PER P1	PER P1
AP 8	CYCLIC DAMP HEAT  PER IEC 60068-2-38	21 cycles low temperature 25°C high temperature 65°C cold subcycle -10°C humidity 93 % Half of the samples in mated state Half of the samples in unmated state	
AP 9	CONTACT RESISTANCE  IEC 60512-2-1, Test 2a	PER P3	20 mΩ maximum change from initial for signal contacts. Input to output resistance 100 mΩ max for screen.

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# PRODUCT SPECIFICATION

Test group AP(continued).

TEST PHASE	TITLE	SEVERITY	REQUIREMENTS
AP 10	INSERTION AND WITHDRAWAL FORCES PER IEC 60512-13-2, Test 13b	PER AP1	PER AP1
AP 11	EFFECTIVENESS OF CONNECTOR COUPLING PER IEC 60512-15-6, Test 15f	PER AP2	PER AP2
AP 12	VISUAL EXAMINATION	PER P1	PER P1
AP 13	SOLDERABILITY	Solder Bath 260+0/-5°C Immersion Time 2,0 +/- 0.5s	The Dipped surface shall be covered with a smooth and bright solder coating. Some imperfections are acceptable but NOT concentrated in the same area.
AP 14	RESISTANCE TO SOLDERING HEAT	For recommended Reflow Profile (See Section 6.0)	Appearance: No Damage.
AP 15	VOLTAGE PROOF IEC 60512-4-1, Test 4a, Method a.	PER P5	PER P5

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# PRODUCT SPECIFICATION

Test group BP

TEST PHASE	TITLE	SEVERITY	REQUIREMENTS
BP 1		N/A	
BP 2	MECHANICAL OPERATIONS PER IEC 60512-9-1, Test 9a	Mate connectors 1,250 cycles, at a maximum rate of 10mm/s maximum. Rest 1s (when mated and when unmated) Locking device inoperative.	
BP 3	FLOWING MIXED GAS CORROSION PER IEC 60512-11-7, Test 11g	Method 1, 4 days Half of the samples in mated state Half of the samples in unmated state	
BP 4	CONTACT RESISTANCE IEC 60512-2-1, Test 2a	PER P3	20 mΩ maximum change from initial
BP 5	MECHANICAL OPERATIONS PER IEC 60512-9-1, Test 9a	Mate connectors 1,250 cycles, at a maximum rate of 10mm/s maximum. Rest 5s (when unmated) locking device inoperative.	
BP 6	CONTACT RESISTANCE IEC 60512-2-1, Test 2a	PER P3	20 mΩ maximum change from initial.
BP 7	INSULATION RESISTANCE IEC 60512-3-1, Test 3a, Method a.	Test voltage 100 v ±15 v d.c. method a mated connectors	PER P4
BP 8	VOLTAGE PROOF IEC 60512-4-1, Test 4a, Method a.	PER P5	PER P5
BP 9	VISUAL EXAMINATION	PER P1	PER P1

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# PRODUCT SPECIFICATION

Test group CP

TEST PHASE	TITLE	SEVERITY	REQUIREMENTS
CP 1	VIBRATION  PER IEC 60512-6-4, Test 6d (See Section 7.0)	$f = 10 \text{ Hz to } 500 \text{ Hz}$ , Amplitude: 0.35 mm Accel 50m/s <sup>2</sup> 10 sweeps / axis measurement points per section 7.0  (For arrangement, See IEC 60603-7, 7.3)	Discontinuities 10 $\mu$ s maximum.
CP 2	CONTACT RESISTANCE  No disturbance of the free connector to fixed connector electrical connections, between vibration test and contact resistance measurement  IEC 60512-2-1, Test 2a	PER P3	20 m $\Omega$ maximum change from initial.
CP 3	INSULATION RESISTANCE  IEC 60512-3-1, Test 3a, Method a.	PER P4	PER P4
CP 4	VISUAL EXAMINATION	PER P1	PER P1

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# PRODUCT SPECIFICATION

Test group DP

TEST PHASE	TITLE	SEVERITY	REQUIREMENTS
DP 1	ELECTRICAL LOAD AND TEMPERATURE PER IEC 60512-9-2, Test 9b	500 h 70° C Recovery period 2 h	0.8A 5 connectors, no current 5 connectors
DP 2	INSULATION RESISTANCE IEC 60512-3-1, Test 3a, Method a.	PER P4	PER P4
DP 3	VOLTAGE PROOF IEC 60512-4-1, Test 4a, Method a.	PER P5	PER P5
DP 4	VISUAL EXAMINATION	PER P1	PER P1
DP 5	CONTACT RESISTANCE IEC 60512-2-1, Test 2a	PER P3	20 mΩ maximum change from initial.
DP 6	MECHANICAL GAUGING PER IEC 60603-7-3, Annex L	Both, free and fixed Connector	Passing go / no go test
DP 7	GAUGING CONTINUITY PER IEC 60603-7-3, Annex A	All signal contacts and screen/specimens	10 μs maximum

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# PRODUCT SPECIFICATION

## Test group EP

TEST PHASE	TITLE	SEVERITY	REQUIREMENTS
EP 1	INSERTION LOSS IEC 60512-27-1, Test a	All pairs, one direction.	$\leq 0,04x \sqrt{f}$ dB from 1 MHz to 100MHz
EP 2	NEXT IEC 60512-27-3, Test c	All pairs, both directions, (pair to pair)	All Pairs: $\geq 83 - 20\log(f)$ dB from 1 MHz to 100 MHz
EP 3	RETURN LOSS IEC 60512-27-2, Test b	All pairs, both directions	All Pairs: $\geq 60 - 20\log(f)$ dB from 1 MHz to 100 MHz
EP 4	FEXT IEC 60512-27-4, Test d	All pairs, both directions, (pair to pair)	All Pairs: $\geq 75, 1 - 20\log(f)$ dB from 1 MHz to 100 MHz
EP 5	TRANSVERSE CONVERSION LOSS IEC 60512-27-6, Test f		All Pairs: $\geq 68 - 20\log(f)$ dB from 1 MHz to 100 MHz
EP 6	TRANSVERSE CONVERSION TRANSFER LOSS IEC 60512-27-7, Test g		All Pairs: $\geq 68 - 20\log(f)$ dB from 1 MHz to 100 MHz
EP 7	INPUT TO OUTPUT RESISTANCE PER IEC 60512-2-1, Test 2a	Mate Connectors	Mated Connectors Cable termination to Cable Termination All types: 200 m $\Omega$ maximum.
EP 8	RESISTANCE UNBALANCE IEC 60512-2-1, Test 2a PER IEC 60603-7-3	Millivolt level method	Unbalance resistance = 50 m $\Omega$ maximum.

## Test group FP

TEST PHASE	TITLE	SEVERITY	REQUIREMENTS
FP 1	SURGE TEST PER IEC 60512, Test no. ITU_T K.20	Mated connectors, Table 2a /2b, Basic test level Tests 2.1.1a, 2.1.1b, 2.1.3, 2.2.1a and 2.3.1A	Test 2.1 & 2.2: Acceptance criteria A per ITU-T K.44, clause 9, Test 2.3: Acceptance criteria B PER ITU-T K.44, CLAUSE 9,
FP 2	INSULATION RESISTANCE IEC 60512-3-1, Test 3a, Method a.	Test voltage 100 v $\pm$ 15 v d.c. method a mated connectors	PER P4
FP 3	VISUAL EXAMINATION	PER P1	PER P1

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<b>PS-85503-001</b>	<b>D.Byrnes</b>	<b>A.Higgins</b>	<b>S.Griffin</b>



# PRODUCT SPECIFICATION

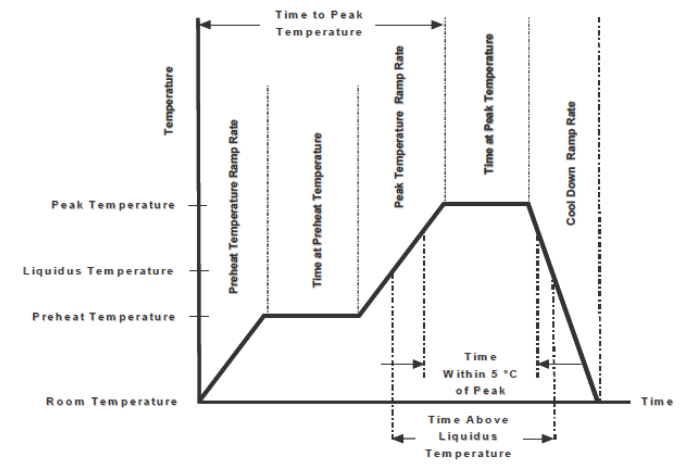
Test group AZ

TEST PHASE	TITLE	SEVERITY	REQUIREMENTS
AZ1	HIGH TEMPERATURE (DRY HEAT)  PER IEC 60068-2-2, Test 9b	Mate connectors; expose to: 96 hours at 85 ± 2°C	Use Molex plug 500602-0819
AZ 2	CONTACT RESISTANCE  IEC 60512-2-1, Test 2a	PER P3	20 mΩ maximum change from initial for signal contacts. Input to output resistance 100 mΩ max for screen.

## 6.0 SOLDERING CONDITIONS. RECOMMENDED

### REFLOW SOLDERING SIMULATION PEAK PROFILE REFLOW AT 260 °C

DESCRIPTION	REQUIREMENT
Solder Type	None
Solder Flux Type	None
Paste Flux Type	None
Average Ramp Rate	3 °C/second maximum
Preheat Temperature	150 °C minimum; 200 °C maximum
Preheat Time	60 to 180 seconds
Ramp to Peak	3 °C/second maximum
Time over Liquidus (217 °C)	60 to 150 seconds
Peak Temperature	260 °C +0/-5 °C
Time within 5 °C of peak	20 to 40 seconds
Ramp – Cool Down	6 °C/second maximum
Time 25 °C to Peak	8 minutes maximum



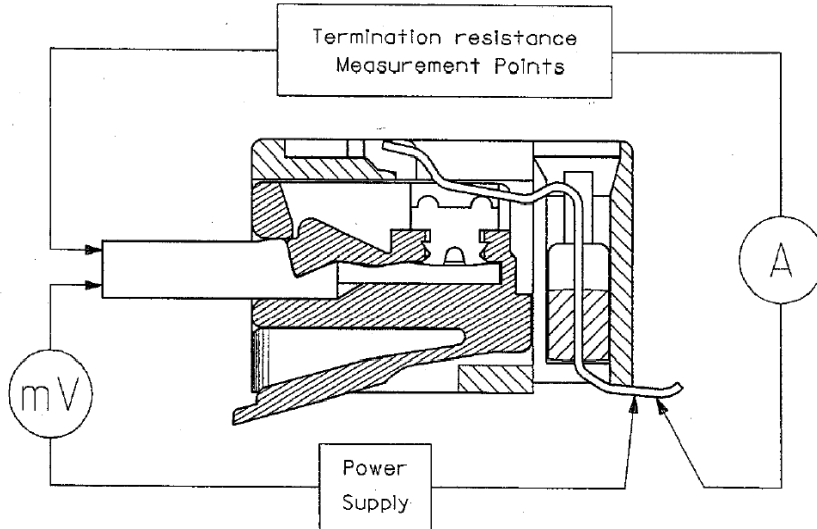
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# PRODUCT SPECIFICATION

## 7.0 GAUGES AND FIXTURES

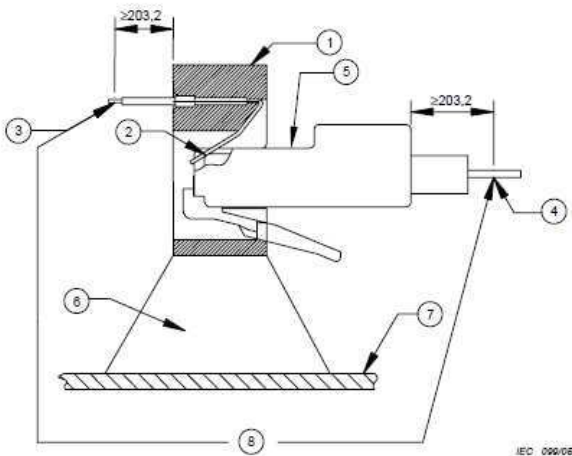
### Termination Resistance Measurement Points



System resistance equals millivolt drop (mV) divided by test current (A)  
 (Conductor resistance will be deducted from measurement.)

## VIBRATION

### Arrangement for vibration test (test phase CP1)



### Key

- 1 Fixed connector vibration feature.
- 2 Contact point.
- 3 Point A: secure to the non-vibrating member.
- 4 Point C: secure to the non-vibrating member.
- 5 Free connector.
- 6 Fixed connector rigidly fixed to the mounting plate.
- 7 Mounting plate.
- 8 Contact resistance measurement point.

Arrangement for vibration test  
 FROM IEC-60603-7

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# PRODUCT SPECIFICATION

## 8.0 PACKAGING

Parts shall be packaged to protect against damage during handling, transit and storage.

## 9.0 QUALITY ASSURANCE PROVISIONS

The applicable Molex inspection plan specifies the sampling acceptable quality level to be used. Dimensional and functional requirements shall be in accordance with applicable product drawings and this specification.

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