

**CAPACITORS, LEADLESS SURFACE MOUNTED,  
TANTALUM, SOLID ELECTROLYTE,  
ENCLOSED ANODE CONNECTION**

**ESCC Generic Specification No. 3012**

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**TABLE OF CONTENTS**

1	INTRODUCTION	8
1.1	SCOPE	8
1.2	APPLICABILITY	8
2	APPLICABLE DOCUMENTS	8
2.1	ESCC SPECIFICATIONS	8
2.2	OTHER (REFERENCE) DOCUMENTS	9
2.3	ORDER OF PRECEDENCE	9
3	TERMS, DEFINITIONS, ABBREVIATIONS, SYMBOLS AND UNITS	9
4	REQUIREMENTS	10
4.1	GENERAL	10
4.1.1	Specifications	10
4.1.2	Conditions and Methods of Test	10
4.1.3	Manufacturer's Responsibility for Performance of Tests and Inspections	10
4.1.4	Inspection Rights	10
4.2	QUALIFICATION AND QUALIFICATION MAINTENANCE REQUIREMENTS ON A MANUFACTURER	10
4.3	DELIVERABLE COMPONENTS	11
4.3.1	ESCC Qualified Components	11
4.3.2	ESCC Components	11
4.3.3	Lot Failure	11
4.4	MARKING	11
4.5	MATERIALS AND FINISHES	11
5	PRODUCTION CONTROL	12
5.1	GENERAL	12
5.2	SPECIAL IN-PROCESS CONTROLS	12
5.2.1	Internal Visual Inspection	12
5.2.2	Dimension Check	12
5.2.3	Weight	12
5.2.4	Documentation	12
6	SCREENING TESTS	12
6.1	GENERAL	12
6.2	FAILURE CRITERIA	13
6.2.1	Environmental and Mechanical Test Failure	13
6.2.2	Parameter Limit Failure	13
6.2.3	Other Failures	13
6.3	FAILED COMPONENTS	13
6.4	LOT FAILURE	13

6.4.1	Lot Failure during 100% Testing	13
6.4.2	Lot Failure during Sample Testing	13
6.5	DOCUMENTATION	13
7	QUALIFICATION, QUALIFICATION MAINTENANCE AND LOT VALIDATION TESTING	14
7.1	QUALIFICATION TESTING	14
7.1.1	General	14
7.1.2	Distribution within the Qualification Test Lot	14
7.2	QUALIFICATION WITHIN A TECHNOLOGY FLOW	15
7.3	QUALIFICATION MAINTENANCE (PERIODIC TESTING)	15
7.4	LOT VALIDATION TESTING	15
7.5	FAILURE CRITERIA	15
7.5.1	Environmental and Mechanical Test Failures	15
7.5.2	Electrical Failures	15
7.5.3	Other Failures	16
7.6	FAILED COMPONENTS	16
7.7	LOT FAILURE	16
7.8	QUALIFICATION, PERIODIC TESTING AND LOT VALIDATION TESTING SAMPLES	16
7.9	DOCUMENTATION	16
8	TEST METHODS AND PROCEDURES	16
8.1	INTERNAL VISUAL INSPECTION	17
8.2	RAPID CHANGE OF TEMPERATURE	17
8.2.1	During Screening Tests (Chart F3)	17
8.2.2	During Qualification, Periodic Testing and Lot Validation Testing (Chart F4)	17
8.3	SURGE CURRENT	18
8.4	ELECTRICAL MEASUREMENTS	19
8.4.1	General	19
8.4.1.1	Capacitance	19
8.4.1.2	DC Leakage Current	19
8.4.1.3	Dissipation Factor	19
8.4.1.4	Equivalent Series Resistance	19
8.4.1.5	Temperature Characteristic	19
8.4.2	Room Temperature Electrical Measurements	20
8.4.3	High and Low Temperatures Electrical Measurements	20
8.4.4	Intermediate and End-Point Electrical Measurements	20
8.5	BURN-IN	20
8.6	SEAL (FINE AND GROSS LEAK)	20
8.7	EXTERNAL VISUAL INSPECTION AND DIMENSION CHECK	20

8.8	MOUNTING	21
8.9	ROBUSTNESS OF TERMINATIONS	21
8.10	CLIMATIC SEQUENCE	21
8.10.1	Initial Measurements	21
8.10.2	Dry Heat	22
8.10.3	Damp Heat (First Cycle)	22
8.10.4	Cold	22
8.10.5	Damp Heat (Remaining Cycles)	22
8.10.6	Final Inspection and Electrical Measurements	22
8.11	VIBRATION	22
8.12	MECHANICAL SHOCK	23
8.13	HIGH AND LOW TEMPERATURE STABILITY	23
8.14	SURGE VOLTAGE	24
8.15	DAMP HEAT, STEADY STATE	24
8.16	OPERATING LIFE	25
8.17	PERMANENCE OF MARKING	26
8.18	SOLDERABILITY	26
9	DATA DOCUMENTATION	26
9.1	GENERAL	26
9.1.1	Qualification and Qualification Maintenance	27
9.1.2	Component Procurement and Delivery	27
9.1.3	Additional Documentation	27
9.1.4	Data Retention/Data Access	27
9.2	COVER SHEET(S)	27
9.3	LIST OF EQUIPMENT USED	27
9.4	LIST OF TEST REFERENCES	27
9.5	SPECIAL IN-PROCESS CONTROLS DATA (CHART F2)	27
9.6	SCREENING TESTS DATA (CHART F3)	27
9.7	QUALIFICATION, PERIODIC TESTING AND LOT VALIDATION TESTING DATA (CHART F4)	28
9.7.1	Qualification Testing	28
9.7.2	Periodic Testing for Qualification Maintenance	28
9.7.3	Lot Validation Testing	28
9.8	FAILED COMPONENTS LIST AND FAILURE ANALYSIS REPORT	28
9.9	CERTIFICATE OF CONFORMITY	28
10	DELIVERY	29
11	PACKAGING AND DISPATCH	29
12	CHARTS	30



12.1	CHART F1 – GENERAL FLOW OF PROCUREMENT	30
12.2	CHART F2 – PRODUCTION CONTROL	31
12.3	CHART F3 – SCREENING TESTS	31
12.4	CHART F4 – QUALIFICATION, PERIODIC TESTING AND LOT VALIDATION TESTING	32

## 1 INTRODUCTION

### 1.1 SCOPE

This specification defines the general requirements for the qualification, qualification maintenance, procurement, and delivery of leadless, surface mounted, solid electrolyte tantalum capacitors with enclosed anode connection, for space applications. This specification contains the appropriate inspection and test schedules and also specifies the data documentation requirements.

### 1.2 APPLICABILITY

This specification is primarily applicable to the granting of qualification approval to components qualified in accordance with one of the following ESCC methods:

- Qualification of Standard Components per ESCC Basic Specification No. [20100](#).
- Technology Flow Qualification per ESCC Basic Specification No. [25400](#).

It is also primarily applicable to the procurement of components so qualified.

This specification may also be applied to the procurement of unqualified components, recommendations for which are given in ESCC Basic Specification No. [23100](#).

## 2 APPLICABLE DOCUMENTS

The following documents form part of, and shall be read in conjunction with, this specification. The relevant issues shall be those in effect on the date of starting qualification or placing the Purchase Order.

### 2.1 ESCC SPECIFICATIONS

- No. [20100](#), Requirements for the Qualification of Standard Electronic Components for Space Application.
- No. [20400](#), Internal Visual Inspection.
- No. [20500](#), External Visual Inspection.
- No. [20600](#), Preservation, Packaging and Dispatch of ESCC Components.
- No. [21300](#), Terms, Definitions, Abbreviations, Symbols and Units.
- No. [21700](#), General Requirements for the Marking of ESCC Components.
- No. [22600](#), Requirements for the Evaluation of Standard Electronic Components for Space Application.
- No. [22800](#), ESCC Non-Conformance Control System.
- No. [23100](#), Recommendations on the use of the ESCC Specification System for the Evaluation and Procurement of Unqualified Components.
- No. [23500](#), Lead Materials and Finishes for Components for Space Application.
- No. [24600](#), Minimum Quality System Requirements.
- No. [24800](#), Resistance to Solvents of Marking, Materials and Finishes.
- No. [25400](#), Requirements for the Technology Flow Qualification of Electronic Components for Space Application



For qualification and qualification maintenance or procurement of qualified components, with the exception of ESCC Basic Specifications Nos. [20100](#), [21700](#), [22800](#), [24600](#) and [25400](#), where Manufacturers' specifications are equivalent to, or more stringent than, the ESCC Basic Specifications listed above, they may be used in place of the latter, subject to the approval of the ESCC Executive.

Such replacements shall be clearly identified in the applicable Process Identification Document (PID).

For procurement of unqualified components, where Manufacturers' specifications are equivalent to or more stringent than the ESCC Basic Specifications listed above, they may be used in place of the latter subject to the approval of the Orderer.

Such replacements may be listed in an appendix to the appropriate Detail Specification at the request of the Manufacturer or Orderer, subject to the approval of the ESCC Executive.

Unless otherwise stated herein, references within the text of this specification to "the Detail Specification" shall mean the relevant ESCC Detail Specification.

## 2.2 OTHER (REFERENCE) DOCUMENTS

- IEC Publication No. 60068 Part 2, Basic Environmental Testing Procedures.
- IEC Publication No. 60384-1 Part 1, Generic Specification for Fixed Capacitors for Use in Electronic Equipment.
- [MIL-STD-202](#), Test Methods for Electronic and Electrical Component Parts.

## 2.3 ORDER OF PRECEDENCE

For the purpose of interpretation and in case of conflict with regard to documentation, the following order of precedence shall apply:

- (a) ESCC Detail Specification.
- (b) ESCC Generic Specification.
- (c) ESCC Basic Specification.
- (d) Other documents, if referenced herein.

## 3 TERMS, DEFINITIONS, ABBREVIATIONS, SYMBOLS AND UNITS

The terms, definitions, abbreviations, symbols and units specified in ESCC Basic Specification No. [21300](#) shall apply.

## 4 REQUIREMENTS

### 4.1 GENERAL

The requirements for the qualification of a component shall be in accordance with ESCC Basic Specification No. [20100](#).

The requirements for Technology Flow Qualification and the listing of qualified component types shall be in accordance with ESCC Basic Specification No. [25400](#).

The test requirements for procurement of both qualified and unqualified components (see Chart F1) shall comprise:

- Special In-Process Controls.
- Screening Tests.
- Periodic Testing (for qualified components only).
- Lot Validation Testing if stipulated in the Purchase Order.

#### 4.1.1 Specifications

For qualification, qualification maintenance, procurement and delivery of components in conformity with this specification, the applicable specifications listed in Section 2 of this document shall apply in total unless otherwise specified herein or in the Detail Specification.

#### 4.1.2 Conditions and Methods of Test

The conditions and methods of test shall be in accordance with this specification, the ESCC Basic Specifications referenced herein and the Detail Specification.

#### 4.1.3 Manufacturer's Responsibility for Performance of Tests and Inspections

The Manufacturer shall be responsible for the performance of tests and inspections required by the applicable specifications. These tests and inspections shall be performed at the plant of the Manufacturer of the components unless it is agreed by the ESCC Executive (for qualification, qualification maintenance, or procurement of qualified components) or the Orderer (for procurement of unqualified components), to use an approved external facility.

#### 4.1.4 Inspection Rights

The ESCC Executive (for qualification, qualification maintenance, or procurement of qualified components) or the Orderer (for procurement of unqualified components if stipulated in the Purchase Order) reserves the right to monitor any of the tests and inspections scheduled in the applicable specifications.

### 4.2 QUALIFICATION AND QUALIFICATION MAINTENANCE REQUIREMENTS ON A MANUFACTURER

To obtain and maintain the qualification of a component, or family of components, a Manufacturer shall satisfy the requirements of ESCC Basic Specification No. [20100](#).

To obtain and maintain the qualification of a component produced using a qualified Technology Flow, a Manufacturer shall satisfy the requirements of ESCC Basic Specification No. [25400](#).

#### 4.3 DELIVERABLE COMPONENTS

##### 4.3.1 ESCC Qualified Components

Components delivered to this specification shall be processed and inspected in accordance with the relevant Process Identification Document (PID).

##### 4.3.2 ESCC Components

Each component, irrespective of qualification status, identified with an ESCC component number and delivered to this specification shall:

- be traceable to its production lot.
- have satisfactorily completed all the tests required by the relevant issues of the applicable specifications.
- be produced from lots that are considered by the Manufacturer to be capable of passing all applicable tests, and sequences of tests, that are defined in Chart F4. The Manufacturer shall not knowingly supply components that cannot meet this requirement. In the event that, subsequent to delivery and prior to operational use, a component is found to be in a condition such that, demonstrably, it could not have passed these tests at the time of manufacture, this shall be grounds for rejection of the delivered lot.

##### 4.3.3 Lot Failure

Lot failure may occur during, Screening Tests (Chart F3), or Qualification, Periodic Testing and Lot Validation Testing (Chart F4).

Should such failure occur during qualification, qualification maintenance or procurement of qualified components the Manufacturer shall initiate the non-conformance procedure in accordance with ESCC Basic Specification No. [22800](#). The Manufacturer shall notify the Orderer and the ESCC Executive by any appropriate written means, within 5 working days, giving details of the number and mode of failure and the suspected cause. No further testing or analysis shall be performed on the failed components until so instructed by the ESCC Executive.

Should such failure occur during procurement of unqualified components the Manufacturer shall notify the Orderer by any appropriate written means within 5 working days, giving details of the number and mode of failure and the suspected cause. No further testing or analysis shall be performed on the failed components until so instructed by the Orderer. The Orderer shall inform the Manufacturer within 5 working days of receipt of notification what action shall be taken.

#### 4.4 MARKING

All components procured and delivered to this specification shall be marked in accordance with ESCC Basic Specification No. [21700](#).

#### 4.5 MATERIALS AND FINISHES

Specific requirements for materials and finishes are specified in the Detail Specification. Where a definite material or finish is not specified a material or finish shall be used so as to ensure that the component meets the performance requirements of this specification and the Detail Specification. Acceptance or approval of any constituent material or finish does not guarantee acceptance of the finished product.

All materials and finishes of the components specified in the Detail Specification shall comply with the restrictions on materials specified in ESCC Basic Specification No. [22600](#).

## **5 PRODUCTION CONTROL**

### **5.1 GENERAL**

Unless otherwise specified herein or in the Detail Specification all lots of components used for qualification and qualification maintenance, Lot Validation Testing and for delivery shall be subject to tests and inspections in accordance with Chart F2 in the sequence shown.

Any components which do not meet these requirements shall be removed from the lot and at no future time be resubmitted to the requirements of this specification.

The applicable test requirements are detailed in the paragraphs referenced in Chart F2.

For qualified components the full production control provisions are defined in the PID.

In the case of lot failure, the Manufacturer shall act in accordance with Para. 4.3.3.

### **5.2 SPECIAL IN-PROCESS CONTROLS**

#### **5.2.1 Internal Visual Inspection**

Internal Visual Inspection shall be performed in accordance with Para. 8.1.

#### **5.2.2 Dimension Check**

Dimension Check shall be performed in accordance with Para. 8.7 on 3 samples.

In the event of any failure a 100% Dimension Check shall be performed.

#### **5.2.3 Weight**

The maximum weight of the component specified in the Detail Specification shall be guaranteed but not tested.

#### **5.2.4 Documentation**

Documentation of Special In-Process Controls shall be in accordance with Para. 9.5.

## **6 SCREENING TESTS**

### **6.1 GENERAL**

Unless otherwise specified herein or in the Detail Specification, all lots of components used for qualification and qualification maintenance, Lot Validation Testing, and for delivery, shall be subjected to tests and inspections in accordance with Chart F3 in the sequence shown.

Any components which do not meet these requirements shall be removed from the lot and at no future time be resubmitted to the requirements of this specification.

The applicable test methods and conditions are specified in the paragraphs referenced in Chart F3.

## 6.2 FAILURE CRITERIA

### 6.2.1 Environmental and Mechanical Test Failure

The following shall be counted as component failures:

- Components which fail during tests for which the pass/fail criteria are inherent in the test method, e.g. Surge Current, Seal, External Visual Inspection.

### 6.2.2 Parameter Limit Failure

A component shall be counted as a limit failure if one or more parameters exceed the limits shown in Room Temperature Electrical Measurements or High and Low Temperatures Electrical Measurements in the Detail Specification.

Any component which exhibits a limit failure prior to the submission to Burn-in shall be rejected and not counted when determining lot rejection.

### 6.2.3 Other Failures

A component shall be counted as a failure in any of the following cases:

- Visual failure.
- Mechanical failure.
- Handling failure.
- Lost component.

## 6.3 FAILED COMPONENTS

A component shall be considered as a failed component if it exhibits one or more of the failure modes described in Para. 6.2.

## 6.4 LOT FAILURE

In the case of lot failure, the Manufacturer shall act in accordance with Para. 4.3.3.

### 6.4.1 Lot Failure during 100% Testing

If the number of components failed on the basis of the failure criteria specified in Para. 6.2.2 exceeds 5% (rounded upwards to the nearest whole number) of the components submitted to Burn-in of Chart F3, the lot shall be considered as failed.

If a lot is composed of groups of components of one family defined in one ESCC Detail Specification, but separately identifiable for any reason, then the lot failure criteria shall apply separately to each identifiable group.

### 6.4.2 Lot Failure during Sample Testing

A lot shall be considered as failed if the number of allowable failures during sample testing as specified herein or in the Detail Specification, is exceeded.

Unless otherwise specified, if a lot failure occurs, a 100% testing may be performed but the cumulative percent defective shall not exceed that specified in Para. 6.4.1.

## 6.5 DOCUMENTATION

Documentation of Screening Tests shall be in accordance with Para. 9.6.

## 7 QUALIFICATION, QUALIFICATION MAINTENANCE AND LOT VALIDATION TESTING

The requirements of this paragraph are applicable to the tests performed on components or test structures as part of qualification or qualification maintenance in accordance with either ESCC Basic Specification No. 20100 or 25400 as applicable. They are also applicable to Lot Validation Testing as part of the procurement of qualified or unqualified components.

All components shall be serialised prior to the tests and inspections.

### 7.1 QUALIFICATION TESTING

#### 7.1.1 General

Qualification testing shall be in accordance with the requirements specified in Chart F4. The tests of Chart F4 shall be performed on the specified sample, chosen at random from components which have successfully passed the tests in Chart F3. This sample constitutes the Qualification Test Lot.

The Qualification Test Lot is divided into subgroups of tests and all components assigned to a subgroup shall be subjected to all of the tests in that subgroup, in the sequence shown. The applicable test requirements are detailed in the paragraphs referenced in Chart F4.

The conditions governing qualification testing are specified in ESCC Basic Specification No. 20100.

#### 7.1.2 Distribution within the Qualification Test Lot

Where a Detail Specification covers a range, or series of components that are considered similar, then the Qualification Test Lot shall be comprised of test vehicles so selected that they adequately represent all of the various mechanical, structural and electrical peculiarities of that range or series.

In addition, the Qualification Test Lot test vehicles shall be selected in accordance with the following provisions:

- Components with the maximum and minimum DC rated voltage proposed for qualification shall be selected and for these voltages, the maximum and minimum case sizes. If there are more than 4 sizes an intermediate size shall also be selected.
- For each voltage/case size combination selected, the maximum capacitance and tightest tolerance shall be selected.

The specified sample in Chart F4 shall be distributed equally between the test vehicles.

Where more than 4 test vehicles are selected, the minimum quantity of components in Chart F4 per test vehicle shall be as follows:

- Subgroup 1A: 3 components
- Subgroup 1B: 3 components
- Subgroup 1C: 3 components
- Subgroup 2A: 15 components
- Subgroup 3: 3 components

The Qualification Test Lot test vehicles may be specified by, but in any case shall be agreed with, the ESCC Executive, prior to the commencement of qualification testing and the justification for the selection shall be declared in the qualification test report.

## 7.2 QUALIFICATION WITHIN A TECHNOLOGY FLOW

The qualification of a component produced using a qualified Technology Flow shall be in accordance with ESCC Basic Specification No. [25400](#).

## 7.3 QUALIFICATION MAINTENANCE (PERIODIC TESTING)

Qualification is maintained through Periodic Testing and, unless otherwise specified, the test requirements of Para. 7.1 shall apply.

The samples to be subjected to Periodic Testing shall be so selected that they adequately represent all of the various mechanical, structural and electrical peculiarities of the specified range or series. The sample selection may be specified by, but in any case shall be agreed with, the ESCC Executive, prior to the commencement of Periodic Testing.

For each subgroup the sample size and the period between successive subgroup testing shall be as specified in Chart F4. The conditions governing qualification maintenance are specified in ESCC Basic Specification No. [20100](#).

Qualification of a component, produced using a qualified Technology Flow, is maintained by the maintenance of the Technology Flow Qualification itself in accordance with ESCC Basic Specification No. [25400](#).

## 7.4 LOT VALIDATION TESTING

For procurement of qualified components, Lot Validation Testing is not required and shall only be performed if specifically stipulated in the Purchase Order.

For procurement of unqualified components the need for Lot Validation Testing shall be determined by the Orderer (ref. ESCC Basic Specification No. [23100](#)).

When Lot Validation Testing is required, it shall consist of the performance of one or more of the tests or subgroup test sequences of Chart F4. The testing to be performed and the sample size shall be as stipulated in the Purchase Order.

When procurement of more than one component type is involved from a family, range or series, the selection of representative samples shall also be stipulated in the Purchase Order.

## 7.5 FAILURE CRITERIA

The following criteria shall apply to Qualification, Periodic Testing and Lot Validation Testing.

### 7.5.1 Environmental and Mechanical Test Failures

The following shall be counted as component failures:

- Components which fail during tests for which the pass/fail criteria are inherent in the test method, e.g. Robustness of Terminations, Solderability, etc.

### 7.5.2 Electrical Failures

The following shall be counted as component failures:

Components which fail one or more of the applicable limits at each of the relevant data points specified for environmental, mechanical and endurance testing in Intermediate and End-Point Electrical Measurements in the Detail Specification.



### 7.5.3 Other Failures

A component shall be counted as a failure in any of the following cases:

- Visual failure.
- Mechanical failure.
- Handling failure.
- Lost component.

### 7.6 FAILED COMPONENTS

A component shall be considered as failed if it exhibits one or more of the failure modes detailed in Para. 7.5.

When requested by the ESCC Executive (for qualification, qualification maintenance or procurement of qualified components) or the Orderer (for procurement of qualified or unqualified components), failure analysis of failed components shall be performed under the responsibility of the Manufacturer and the results provided.

Failed components shall be retained at the Manufacturer's plant until the final disposition has been agreed and certified.

### 7.7 LOT FAILURE

For Qualification Testing and Periodic Testing, the lot shall be considered as failed if one component in any subgroup of Chart F4 is a failed component based on the criteria specified in Para. 7.5.

For procurement, the lot shall be considered as failed if one component in any test specified for Lot Validation Testing is a failed component based on the criteria specified in Para. 7.5.

In the case of lot failure, the Manufacturer shall act in accordance with Para. 4.3.3.

### 7.8 QUALIFICATION, PERIODIC TESTING AND LOT VALIDATION TESTING SAMPLES

All tests of Chart F4 are considered to be destructive and therefore components so tested shall not form part of the delivery lot.

### 7.9 DOCUMENTATION

Documentation of Qualification, Periodic Testing and Lot Validation Testing shall be in accordance with Para. 9.7.

## 8 TEST METHODS AND PROCEDURES

If a Manufacturer elects to eliminate or modify a test method or procedure, the Manufacturer is still responsible for delivering components that meet all of the performance, quality and reliability requirements defined in this specification and the Detail Specification.

For a qualified component, documentation supporting the change shall be approved by the ESCC Executive and retained by the Manufacturer. It shall be copied, when requested, to the ESCC Executive. The change shall be specified in an appendix to the Detail Specification and in the PID.

For an unqualified component the change shall be approved by the Orderer. The change may be specified in an appendix to the Detail Specification at the request of the Manufacturer or Orderer, subject to the approval of the ESCC Executive.



## 8.1 INTERNAL VISUAL INSPECTION

ESCC Basic Specification No. [20400](#).

## 8.2 RAPID CHANGE OF TEMPERATURE

### 8.2.1 During Screening Tests (Chart F3)

Components shall be subjected to Test Na of IEC Publication No. 60068-2-14.

Unless otherwise specified, the following details shall apply:

- Test Conditions:
  - (a) Components shall be conditioned for 15 minutes at  $T_{amb} = +22 \pm 3^{\circ}\text{C}$  prior to the first cycle.
  - (b) Low temperature: minimum operating temperature rating as specified in the Detail Specification.
  - (c) High temperature: maximum operating temperature rating as specified in the Detail Specification.
  - (d) Number of cycles: 5
  - (e) Exposure time (each cycle, each temperature): 30 minutes
  - (f) Transition time: 1 minute

### 8.2.2 During Qualification, Periodic Testing and Lot Validation Testing (Chart F4)

Components shall be subjected to Test Na of IEC Publication No. 60068-2-14.

Unless otherwise specified, the following details shall apply:

- Test Conditions:
  - (a) Components shall be conditioned for 15 minutes at  $T_{amb} = +22 \pm 3^{\circ}\text{C}$  prior to the first cycle.
  - (b) Low temperature: minimum storage temperature rating as specified in the Detail Specification.
  - (c) High temperature: maximum storage temperature rating as specified in the Detail Specification.
  - (d) Number of cycles: 5
  - (e) Exposure time (each cycle, each temperature): 30 minutes
  - (f) Transition time: 1 minute

- Data Points:

Prior to the test, Capacitance shall be measured as specified in Intermediate and End-Point Electrical Measurements in the Detail Specification.

On completion of testing, the components shall be subjected to standard atmospheric conditions for recovery for 4 hours minimum.

After recovery, the components shall be visually examined and there shall be no evidence of corrosion, mechanical damage or obliteration of marking. Capacitance, Capacitance Change, Dissipation Factor and Equivalent Series Resistance (when specified in the Detail Specification) shall be measured as specified in Intermediate and End-Point Electrical Measurements in the Detail Specification. Capacitance Change shall be related to the initial measurements.

### 8.3 SURGE CURRENT

Components shall be subjected to a surge current test immediately after Rapid Change of Temperature during Screening Tests (Chart F3).

Unless otherwise specified, the following details shall apply:

- Test Conditions:
  - (a) Test temperature:  $T_{amb} = +22 \pm 3^{\circ}\text{C}$
  - (b) Test procedure: each component shall be submitted to 5 charge/discharge surge current cycles of at least 0.5s per charge and 0.5s per discharge, at DC rated voltage. The test circuit shall comply with the following:
    - The test shall be performed on individual components.
    - The power supply used for charging the energy storage capacitor bank shall be capable of supplying a regulated DC voltage, variable from 0 to 100V minimum at 10A minimum.
    - The energy storage capacitor bank placed across the DC power supply shall be continually charged. It shall consist of very low ESR aluminium electrolytic capacitors, connected in parallel, having a capacitance of 20000 $\mu\text{F}$  minimum.
    - The energy storage capacitor bank shall provide, across the component under test, a peak surge current value equal to the test voltage divided per ESR of the component under test plus total circuit resistance. This requirement shall be verified for each test line.
    - For calibration purposes, the voltage across a 47 $\mu\text{F}$   $\pm 10\%$  35V capacitor shall be monitored and shall demonstrate that the peak voltage across the capacitor during charging is DC rated voltage  $\pm 5\%$  and that 90% of DC rated voltage is achieved within the first 100 $\mu\text{s}$ . This requirement shall be verified for each test line.
    - A 30A mercury relay or equivalent shall be used to switch the component under test to the energy storage capacitor bank for charge and into a short-circuit of not more than 0.2 $\Omega$  maximum for discharge.
    - A fuse shall be placed in series with each component under test. Each fuse shall have a rating of not less than 1A and not more than 5A.
    - The total resistance of all wiring between the energy storage capacitor bank and the capacitor under test, including the mercury relay, the ESR of the energy storage capacitor bank and the fuse, shall not exceed 0.5 $\Omega$  maximum.
- Data Points:

During the test, the fuse for each component under test shall be monitored. The component under test shall be considered a failure if the fuse blows during the test.

After the final cycle, DC Leakage Current shall be measured as specified in Room Temperature Electrical Measurements in the Detail Specifications.

## 8.4 ELECTRICAL MEASUREMENTS

### 8.4.1 General

Unless otherwise specified in the Detail Specification, the following electrical measurements and methods apply.

#### 8.4.1.1 *Capacitance*

The following details shall apply:

- Test Frequency: 100  $\pm$ 5Hz or 120  $\pm$ 5Hz
- Test Voltage: The maximum DC bias shall be 2.2V for all AC measurements. The magnitude of the AC voltage shall be  $\leq$  0.5Vrms.
- Required Accuracy: within 2% of the specified limit, whether this is given as an absolute value or as a change of capacitance.

#### 8.4.1.2 *DC Leakage Current*

The following details shall apply:

- Test Voltage: DC rated voltage  $\pm$ 2% applied by a regulated power supply through a 1000 $\Omega$  series resistor (to limit charging current), for a maximum electrification period of 5 minutes.
- Required Accuracy: within 0.02 $\mu$ A.

#### 8.4.1.3 *Dissipation Factor*

The following details shall apply:

- Test Frequency: 100  $\pm$ 5Hz or 120  $\pm$ 5Hz
- Required Accuracy: within  $\pm$ 2% of the measured dissipation factor

#### 8.4.1.4 *Equivalent Series Resistance*

The following details shall apply:

- Test Frequency: 100  $\pm$ 5kHz or 500  $\pm$ 5kHz
- Test Voltage: The maximum DC bias shall be 2.2V for all AC measurements. The magnitude of the AC voltage shall be  $\leq$  0.5Vrms.
- Required Accuracy: within  $\pm$ 5% of the reading or  $\pm$ 3m $\Omega$ , whichever is greater.

#### 8.4.1.5 *Temperature Characteristic*

Temperature Characteristic shall be measured as follows:

Unless otherwise specified, components shall be maintained at each of the following temperature steps in turn until both chamber temperature and capacitance have fully stabilised:

- (a)  $T_{amb} = +22 \pm 3^{\circ}\text{C}$ ; no voltage applied (reference point).
- (b) Minimum Operating Temperature rating (+3 -0) $^{\circ}\text{C}$ , as specified in the Detail Specification; no voltage applied.
- (c) Rated Temperature  $\pm 3^{\circ}\text{C}$ , as specified in the Detail Specification; no voltage applied.
- (d) Upper Category Temperature (+0 -3) $^{\circ}\text{C}$ , as specified in the Detail Specification; no voltage applied.

- Data Points:  
At each step, after stabilisation, Capacitance and chamber temperature shall be measured. Temperature measurement shall be accurate to within 0.5°C. The capacitance change over temperature at each step, referred to the capacitance at the reference point, shall meet the Temperature Characteristic limits specified in High and Low Temperatures Electrical Measurements in the Detail Specification.

Measurements performed during Screening Tests (Chart F3) shall be on a go-no-go basis. Measurements performed during Qualification, Periodic Testing and Lot Validation Testing (Chart F4) shall be recorded against serial number.

#### 8.4.2 Room Temperature Electrical Measurements

Room Temperature Electrical Measurements shall be performed as specified in the Detail Specification.

#### 8.4.3 High and Low Temperatures Electrical Measurements

High and Low Temperatures Electrical Measurements shall be performed as specified in the Detail Specification. Unless otherwise specified, measurements shall be performed on a sample of 5 components from each manufacturing lot with 0 failures allowed. In the event of any failure a 100% inspection may be performed.

#### 8.4.4 Intermediate and End-Point Electrical Measurements

At each of the relevant data points, Intermediate and End-Point Electrical Measurements shall be performed as specified in the Detail Specification. All values obtained shall be recorded against serial numbers and the parameter drift calculated if specified.

#### 8.5 BURN-IN

Components shall be subjected to an endurance test in accordance with IEC Publication No. 60384-1 clause 4.23.

Unless otherwise specified, the following details shall apply:

- Test Conditions:
  - (a) Duration: 168 hours minimum.
  - (b) Temperature: Rated Temperature  $\pm 3^{\circ}\text{C}$ , as specified in the Detail Specification.
  - (c) Applied Voltage: DC Rated Voltage as specified in the Detail Specification.

#### 8.6 SEAL (FINE AND GROSS LEAK)

Components shall be subjected to a seal (fine and gross leak) test in accordance with [MIL-STD-202, Test Method 112](#).

Unless otherwise specified, the following details shall apply:

- Test Conditions:
  - (a) Fine leak: Test Condition C, Procedure III, maximum leak rate =  $1 \times 10^{-8}$  atm.cm<sup>3</sup>/s.
  - (b) Gross leak: Test Condition A, B or D

#### 8.7 EXTERNAL VISUAL INSPECTION AND DIMENSION CHECK

External Visual Inspection shall be performed in accordance with ESCC Basic Specification Nos. [20400](#) and [20500](#).

Dimension Check shall be performed in accordance with ESCC Basic Specification No. [20500](#).

## 8.8 MOUNTING

Components shall be mounted on a suitable substrate in accordance with IEC Publication No. 60384-1, Clause 4.33.

Unless otherwise specified, the following details shall apply:

- **Data Points:**

When specified in the Detail Specification, prior to the test, Capacitance shall be measured as specified in Intermediate and End-Point Electrical Measurements in the Detail Specification.

After mounting, components shall be visually examined and there shall be no evidence of damage. Terminations and substrate shall be inspected for good wetting.

Capacitance, Capacitance Change (when specified in the Detail Specification), DC Leakage Current, Dissipation Factor and Equivalent Series Resistance (when specified in the Detail Specification) shall be measured as specified in Intermediate and End-Point Electrical Measurements in the Detail Specification. Capacitance Change shall be related to the initial measurements.

## 8.9 ROBUSTNESS OF TERMINATIONS

Components mounted in accordance with Para. 8.8 shall be subjected to a shear (adhesion) test in accordance with IEC Publication No. 60384-1, clause 4.34.

Unless otherwise specified, the following details shall apply:

- **Test Conditions:**

A force of 5N shall be applied normal to the line joining the terminations and in a plane parallel to the substrate. The force shall be applied progressively (without any shock) and then maintained for a period of  $10 \pm 1$ s.

- **Data Points:**

Prior to the test, Capacitance shall be measured as specified in Intermediate and End-Point Electrical Measurements in the Detail Specification.

On completion of testing, components shall be visually examined and there shall be no evidence of damage, cracking, lifting or dry solder joints.

Capacitance and Capacitance Change shall be measured as specified in Intermediate and End-Point Electrical Measurements in the Detail Specification. Capacitance Change shall be related to the initial measurements.

## 8.10 CLIMATIC SEQUENCE

Components shall be subjected to Climatic Sequence as follows unless otherwise specified.

### 8.10.1 Initial Measurements

Capacitance shall be measured as specified in Intermediate and End-Point Electrical Measurements in the Detail Specification.

#### 8.10.2 Dry Heat

The components shall be subjected to Test Bb of IEC Publication No. 60068-2-2 at the maximum storage temperature rating as specified in the Detail Specification for 2 hours.

While still at the specified high temperature and at the end of the period of high temperature, the DC leakage current shall be measured as specified in Intermediate and End-Point Electrical Measurements in the Detail Specification

On completion of testing, the components shall be subjected to standard atmospheric conditions for recovery, for not less than 1 hour before being subjected to Damp Heat (First Cycle).

#### 8.10.3 Damp Heat (First Cycle)

The components shall be subjected to Test Db, Severity a (+40°C), Variant 2, of IEC Publication No. 60068-2-30, for one cycle of 24 hours.

On completion of testing, the components shall be subjected to standard atmospheric conditions for recovery, for 1 to 2 hours before being subjected to Cold.

#### 8.10.4 Cold

The components shall be subjected to Test Ab of IEC Publication No. 60068-2-1 at the minimum storage temperature rating as specified in the Detail Specification for 2 hours.

On completion of testing, the components shall be subjected to standard atmospheric conditions for recovery, for 1 to 2 hours before being subjected to Damp Heat (Remaining Cycles).

#### 8.10.5 Damp Heat (Remaining Cycles)

The components shall be subjected to Test Db, Severity b (+55°C), Variant 2, of IEC Publication No. 60068-2-30 for 5 cycles of 24 hours.

On completion of testing, the components shall be removed from the chamber and subjected to standard atmospheric conditions for recovery for 1 to 24 hours, prior to final inspection and electrical measurements.

#### 8.10.6 Final Inspection and Electrical Measurements

Components shall be visually inspected in accordance with ESCC Basic Specification No. [20500](#). Capacitance, Capacitance Change, DC Leakage Current, Dissipation Factor and Equivalent Series Resistance (when specified in the Detail Specification) shall be measured as specified in Intermediate and End-Point Electrical Measurements in the Detail Specification. Capacitance Change shall be related to the initial measurements.

#### 8.11 VIBRATION

Components mounted in accordance with Para. 8.8 shall be subjected to Test Fc of IEC Publication No. 60068-2-6.

Unless otherwise specified, the following details shall apply:

- Test Conditions:
  - (a) Frequency Range: 10Hz to 2000Hz
  - (b) Amplitude: 3mm (peak-to-peak) or 200m/s<sup>2</sup> whichever is the less severe.
  - (c) Number of sweep cycles: 12 in each of three mutually perpendicular axes chosen so that faults are likely to be revealed.
  - (d) Sweep cycle duration: 20 minutes (test total: 12 hours approximately)

- **Data Points:**  
During the last sweep cycle in each axis, an electrical measurement shall be made to determine intermittent operation, intermittent contacts of  $\geq 0.5\text{ms}$ , arcing, or open or short circuit.  
  
On completion of testing, the components shall be visually examined and there shall be no evidence of damage.

#### 8.12 MECHANICAL SHOCK

Components mounted in accordance with Para. 8.8 shall be subjected to Test Ea of IEC Publication No. 60068-2-27.

Unless otherwise specified, the following details shall apply:

- **Test Conditions:**
  - (a) Pulse shape: half-sine.
  - (b) Peak acceleration:  $500\text{m/s}^2$ .
  - (c) Pulse duration: 11ms.
  - (d) Shock application: 3 in each direction of the three mutually perpendicular axes (18 total).
- **Data Points:**  
On completion of testing, the components shall be visually examined and there shall be no evidence of damage.

#### 8.13 HIGH AND LOW TEMPERATURE STABILITY

Unless otherwise specified, electrical measurements for High and Low Temperature Stability shall be performed as specified in Intermediate and End-Point Electrical Measurements in the Detail Specification, at the following temperature steps:

<u>Step</u>	<u>Temperature (Note 1)</u>
-------------	-----------------------------

- |    |   |
|----|---|
| 1: | $T_{\text{amb}} = +22 \pm 3^\circ\text{C}$  |
| 2: | Minimum operating temperature rating (+3 -0) $^\circ\text{C}$ , as specified in the Detail Specification (see note 2) |
| 3: | $T_{\text{amb}} = +22 \pm 3^\circ\text{C}$  |
| 4: | Rated Temperature $\pm 3^\circ\text{C}$ , as specified in the Detail Specification                                    |
| 5: | Upper Category Temperature (+0 -3) $^\circ\text{C}$ , as specified in the Detail Specification                        |
| 6: | $T_{\text{amb}} = +22 \pm 3^\circ\text{C}$  |

**NOTE:**

1. The components shall be stabilised at each temperature prior to measurements; thermal stability will have been reached when no further change in capacitance is observed between 2 successive measurements taken at 15 minute intervals.
2. DC Leakage Current at minimum operating temperature is not required to be measured.



#### 8.14 SURGE VOLTAGE

Components shall be subjected to a surge voltage test.

Unless otherwise specified, the following details shall apply:

- Test Conditions:
  - (a) Test temperature: Rated Temperature  $\pm 3^{\circ}\text{C}$ , as specified in the Detail Specification.
  - (b) Test procedure: each component shall be submitted to 1000 charge/discharge cycles of 30s per charge and 30s per discharge, at the applicable DC surge voltage as specified in the Detail Specification. Voltage application shall be through a  $33\Omega \pm 5\%$  resistor. Discharge shall be made using a suitable short circuit, through the  $33\Omega$  charging resistor or equivalent.
- Data Points:

On completion of testing, and after thermal stabilisation at standard atmospheric conditions, Capacitance, DC Leakage Current, Dissipation Factor and Equivalent Series Resistance (when specified in the Detail Specification) shall be measured as specified in Intermediate and End-Point Electrical Measurements in the Detail Specification.

#### 8.15 DAMP HEAT, STEADY STATE

Components shall be subjected to Test Cab of IEC Publication No. 60068-2-78.

Unless otherwise specified, the following details shall apply:

- Test Conditions:
  - (a) Temperature:  $+40 \pm 2^{\circ}\text{C}$ .
  - (b) Relative humidity:  $93 \pm 3\%$ .
  - (c) Duration: 56 days.
- Data Points:

Prior to the test, Capacitance shall be measured as specified in Intermediate and End-Point Electrical Measurements in the Detail Specification.

On completion of testing, and after a recovery period of 1 to 2 hours, the components shall be visually examined and there shall be no evidence of damage.

Capacitance, Capacitance Change, DC Leakage Current, Dissipation Factor and Equivalent Series Resistance (when specified in the Detail Specification) shall be measured as specified in Intermediate and End-Point Electrical Measurements in the Detail Specification. Capacitance Change shall be related to the initial measurements.



## 8.16 OPERATING LIFE

Components shall be subjected to an endurance test in accordance with IEC Publication No. 60384-1 clause 4.23.

Unless otherwise specified, the following details shall apply:

(a) Applicable to Qualification Testing, and to Periodic Testing for renewal of qualification after lapse

Test Conditions:

- Duration: 2000  $\pm$ 48 hours.
- Test Temperatures (samples divided between the 2 test temperatures; see Chart F4):
  - T1: Rated Temperature  $\pm$ 3°C, as specified in the Detail Specification.
  - T2: Upper Category Temperature (+0 -3)°C, as specified in the Detail Specification.
- Operating conditions:
  - For T1 samples: DC Rated Voltage as specified in the Detail Specification.
  - For T2 samples: DC Category Voltage as specified in the Detail Specification.

Voltage shall be applied gradually (but charging time shall not exceed 5 minutes), either by a slow build-up of the voltage or through a resistor which shall be shorted out within 5 minutes. The voltage shall be applied continuously except for measurement periods. The impedance of the voltage source, as seen from the terminals of each component shall not exceed 3 $\Omega$ . Storage batteries or an electronic power supply, capable of supplying at least 1A when a component is shorted, shall be used.

(b) Applicable to Periodic Testing for extension of qualification

Test Conditions:

- Duration: 1000  $\pm$ 48 hours.
- Test Temperature (T1 only): Rated Temperature  $\pm$ 3°C, as specified in the Detail Specification.
- Operating conditions: DC Rated Voltage as specified in the Detail Specification. Voltage shall be applied gradually (but charging time shall not exceed 5 minutes), either by a slow build-up of the voltage or through a resistor which shall be shorted out within 5 minutes. The voltage shall be applied continuously except for measurement periods. The impedance of the voltage source, as seen from the terminals of each component shall not exceed 3 $\Omega$ . Storage batteries or an electronic power supply, capable of supplying at least 1A when a component is shorted, shall be used.

- Data Points:

Prior to the test, Capacitance shall be measured (initial measurements) as specified in Intermediate and End-Point Electrical Measurements in the Detail Specification.

During testing, after 250  $\pm$ 48 hours and after 1000  $\pm$ 48 hours (when a 2000 hour test is being performed), DC Leakage Current shall be measured at the applicable high temperature, as specified in Intermediate and End-Point Electrical Measurements in the Detail Specification.

On completion of testing, (1000 or 2000 hours), and after a recovery period of 1 to 2 hours, the components shall be visually examined and there shall be no evidence of damage.

Capacitance, Capacitance Change, DC Leakage Current, Dissipation Factor and Equivalent Series Resistance (when specified in the Detail Specification) shall be measured as specified in Intermediate and End-Point Electrical Measurements in the Detail Specification. Capacitance Change shall be related to the initial measurements.

8.17 PERMANENCE OF MARKING  
ESCC Basic Specification No. 24800.

8.18 SOLDERABILITY  
The components shall be subjected to Test Ta of IEC Publication No. 60068-2-20.

Unless otherwise specified, the following details shall apply:

- Test Conditions:
  - (a) Ageing method: 4 hours at  $T_{amb} = +155^{\circ}\text{C}$  (dry aged)
  - (b) Test method: 1 (solder bath at  $+235^{\circ}\text{C}$ )
  - (c) Immersion depth: fully immersed
  - (d) Immersion duration:  $4 \pm 1\text{s}$
- Final Inspection:

On completion of testing, the components shall be visually examined and there shall be no evidence of damage. At least 75% of the terminations shall be covered by a smooth solder covering. The remaining 25% may contain small pin-holes or rough spots but these shall not be concentrated in one area.

## 9 DATA DOCUMENTATION

### 9.1 GENERAL

For the qualification, qualification maintenance and procurement for each lot a data documentation package shall exist in a printed or electronic form.

This package shall be compiled from:

- (a) Cover sheet (or sheets).
- (b) List of equipment (testing and measuring).
- (c) List of test references.
- (d) Special In-Process Controls data (Chart F2),
- (e) Screening Tests data (Chart F3).
- (f) Qualification, Periodic Testing and Lot Validation Testing (when applicable) data (Chart F4).
- (g) Failed components list and failure analysis report (when applicable).
- (h) Certificate of Conformity.

Items (a) to (h) inclusive shall be grouped, preferably as sub-packages and, for identification purposes, each page shall include the following information:

- ESCC Component Number.
- Manufacturer's name.
- Lot identification.
- Date of establishment of the document.
- Page number.

Whenever possible, documentation should preferably be available in electronic format suitable for reading using a compatible PC. The format supplied shall be legible, durable and indexed. The preferred storage medium is CD-ROM and the preferred file format is PDF.

9.1.1 Qualification and Qualification Maintenance

In the case of qualification or qualification maintenance, the items listed in Para. 9.1(a) to (h) are required.

9.1.2 Component Procurement and Delivery

For all deliveries of components procured to this specification, the following documentation shall be supplied:

- (a) Cover sheet (if all of the information is not included on the Certificate of Conformity).
- (b) Certificate of Conformity.

9.1.3 Additional Documentation

The Manufacturer shall deliver additional documentation containing data and reports to the Orderer, if stipulated in the Purchase Order.

9.1.4 Data Retention/Data Access

If not delivered, all data shall be retained by the Manufacturer for a minimum of 5 years during which time it shall be available for review, if requested, by the Orderer or the ESCC Executive (for qualified components).

9.2 COVER SHEET(S)

The cover sheet(s) of the data documentation package shall include as a minimum:

- (a) Reference to the Detail Specification, including issue and date.
- (b) Reference to the applicable ESCC Generic Specification, including issue and date.
- (c) ESCC Component Number and the Manufacturer's part type number.
- (d) Lot identification.
- (e) Number of the Purchase Order.
- (f) Information relative to any additions to this specification and/or the Detail Specification.
- (g) Manufacturer's name and address.
- (h) Location of the manufacturing plant.
- (i) Signature on behalf of Manufacturer.
- (j) Total number of pages of the data package.

9.3 LIST OF EQUIPMENT USED

A list of equipment used for tests and measurements shall be prepared. Where applicable, this list shall contain inventory number, Manufacturer's type number, serial number, etc. This list shall indicate for which tests such equipment was used.

9.4 LIST OF TEST REFERENCES

This list shall include all Manufacturer's references or codes which are necessary to correlate the test data provided with the applicable tests specified in the tables of the Detail Specification.

9.5 SPECIAL IN-PROCESS CONTROLS DATA (CHART F2)

A test result summary shall be compiled showing the total number of components submitted to, and the total number rejected after each of the tests.

9.6 SCREENING TESTS DATA (CHART F3)

A test result summary shall be compiled showing the total number of components submitted to and the total number rejected after each of the tests.

## 9.7 QUALIFICATION, PERIODIC TESTING AND LOT VALIDATION TESTING DATA (CHART F4)

### 9.7.1 Qualification Testing

A test result summary shall be compiled showing the components submitted to, and the number rejected after each test in each subgroup. Component serial numbers for each subgroup shall be identified. For each test requiring electrical measurements the results shall be recorded against component serial number. Where a drift value is specified during a test the drift calculation shall be recorded against component serial number.

### 9.7.2 Periodic Testing for Qualification Maintenance

A test result summary shall be compiled showing the components submitted to and the number rejected after each test in each subgroup. Component serial numbers for each subgroup shall be identified. For each test requiring electrical measurements the results shall be recorded against component serial number. Where a drift value is specified during a test the drift calculation shall be recorded against component serial number.

In addition to the full test data a report shall be compiled for each subgroup of Chart F4 to act as the most recent Periodic Testing summary. These reports shall include a list of all tests performed in each subgroup, the ESCC Component Numbers and quantities of components tested, a statement confirming all the results were satisfactory, the date the tests were performed and a reference to the full test data.

### 9.7.3 Lot Validation Testing

A test result summary shall be compiled showing the components submitted to and the number rejected after each test in each subgroup (as applicable). Component serial numbers for each subgroup shall be identified. For each test requiring electrical measurements the results shall be recorded against component serial number. Where a drift value is specified during a test the drift calculation shall be recorded against component serial number.

## 9.8 FAILED COMPONENTS LIST AND FAILURE ANALYSIS REPORT

The failed components list and failure analysis report shall provide full details of:

- (a) The reference and description of the test or measurement performed as defined in this specification and/or the Detail Specification during Special In-Process Controls, Screening Tests, and Qualification, Periodic Testing and Lot Validation Testing.
- (b) Traceability information including serial number (if applicable) of the failed component.
- (c) The failed parameter and the failure mode of the component.
- (d) Detailed failure analysis (if requested by the ESCC Executive or Orderer).

## 9.9 CERTIFICATE OF CONFORMITY

A Certificate of Conformity shall be established in accordance with the requirements of ESCC Basic Specification Nos. [20100](#) or [25400](#).

**10**     **DELIVERY**

For procurement, for each order, the items forming the delivery are:

- (a) The delivery lot.
- (b) The components used for Lot Validation Testing (as applicable), but not forming part of the delivery lot, if stipulated in the Purchase Order.
- (c) The relevant documentation in accordance with the requirements of Paras. 9.1.2 and 9.1.3.

In the case of a component for which a valid qualification is in force, all data of all components submitted to Lot Validation Testing shall also be copied, when requested, to the ESCC Executive.

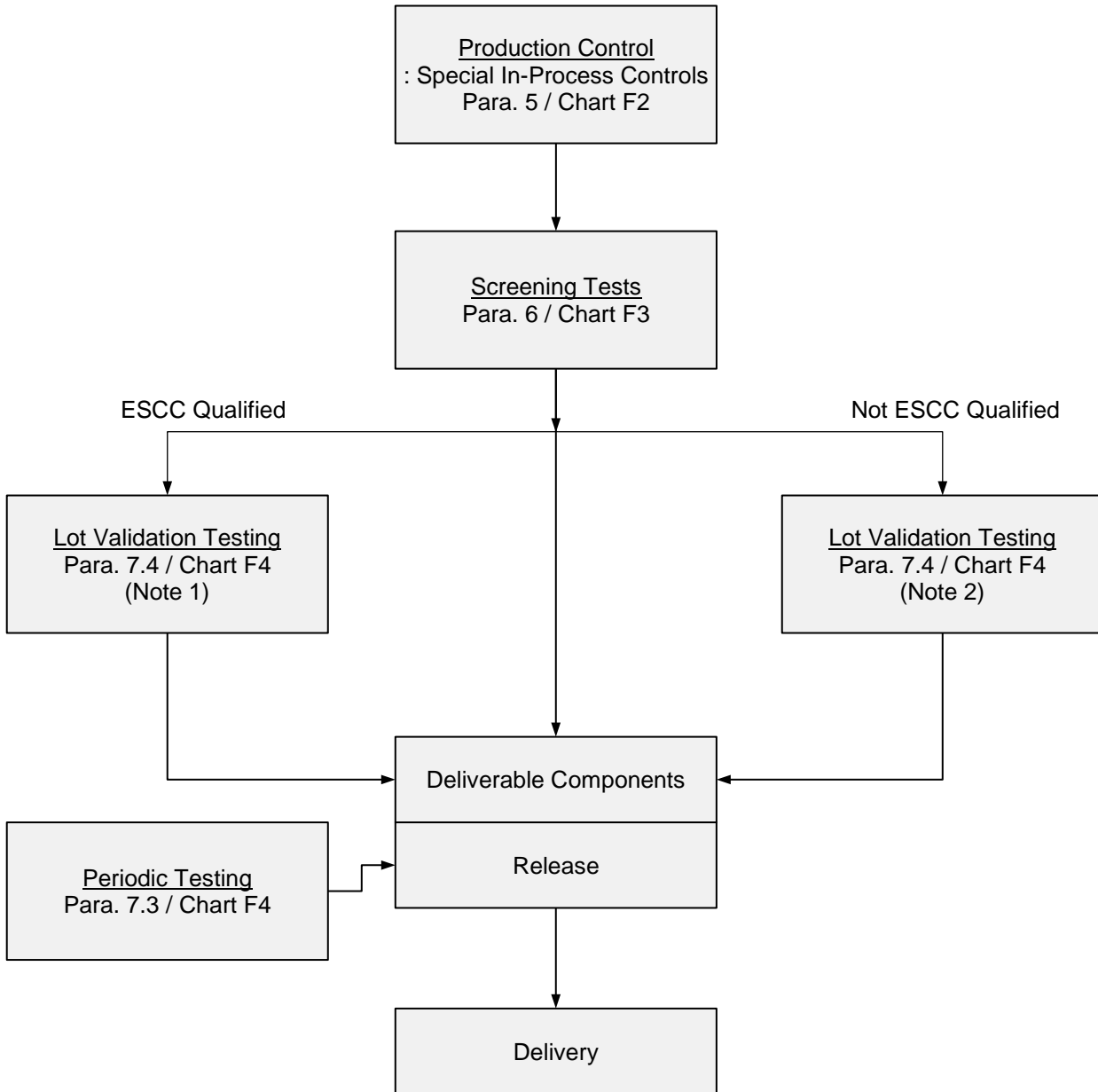
For qualification or qualification maintenance, the disposition of the Qualification Test Lot and its related documentation shall be as specified in ESCC Basic Specification No. [20100](#) or [25400](#) and the relevant paragraphs of Section 9 of this specification.

**11**     **PACKAGING AND DISPATCH**

The packaging and dispatch of components to this specification shall be in accordance with the requirements of ESCC Basic Specification No. [20600](#).

**12 CHARTS**

**12.1 CHART F1 – GENERAL FLOW OF PROCUREMENT**



**NOTES:**

1. Lot Validation Testing is not required for qualified components unless specifically stipulated in the Purchase Order.
2. For unqualified components, the need for Lot Validation Testing shall be determined by the Orderer and the required testing shall be as stipulated in the Purchase Order (ref. ESCC Basic Specification No. [23100](#)).

12.2 CHART F2 – PRODUCTION CONTROL

COMPONENT LOT MANUFACTURING	
SPECIAL IN-PROCESS CONTROLS	
Para. 5.2.1	Internal Visual Inspection
-	Encapsulation/Coating
Para. 5.2.2	Dimension Check (1)
Para. 5.2.3	Weight (2)
TO CHART F3 – SCREENING TESTS	

**NOTES:**

1. Performed on a sample basis.
2. Guaranteed but not tested.

12.3 CHART F3 – SCREENING TESTS

COMPONENTS FROM PRODUCTION CONTROL	
Para. 8.2.1	Rapid Change of Temperature
Para. 8.3	Surge Current
Para. 8.4.2	Room Temperature Electrical Measurements (1)
Para. 8.5	Burn-in
Para. 8.4.2	Room Temperature Electrical Measurements (2)
Para. 8.4.3	High and Low Temperatures Electrical Measurements (2) (3)
Para. 6.4	Check for Lot Failure (4)
Para. 8.6	Seal (Fine and Gross Leak) (5)
Para. 8.7	External Visual Inspection
TO CHART F4 WHEN APPLICABLE	

**NOTES:**

1. Optional at the Manufacturer's discretion.
2. The lot failure criteria of Para. 6.4 apply to this test.
3. Performed on a sample basis.
4. Check for Lot Failure shall take into account all electrical parameter failures that may occur during Screening Tests in accordance with Paras 8.4.2 and 8.4.3 subsequent to Burn-in.
5. Performed on hermetically sealed components.

12.4 CHART F4 – QUALIFICATION, PERIODIC TESTING AND LOT VALIDATION TESTING

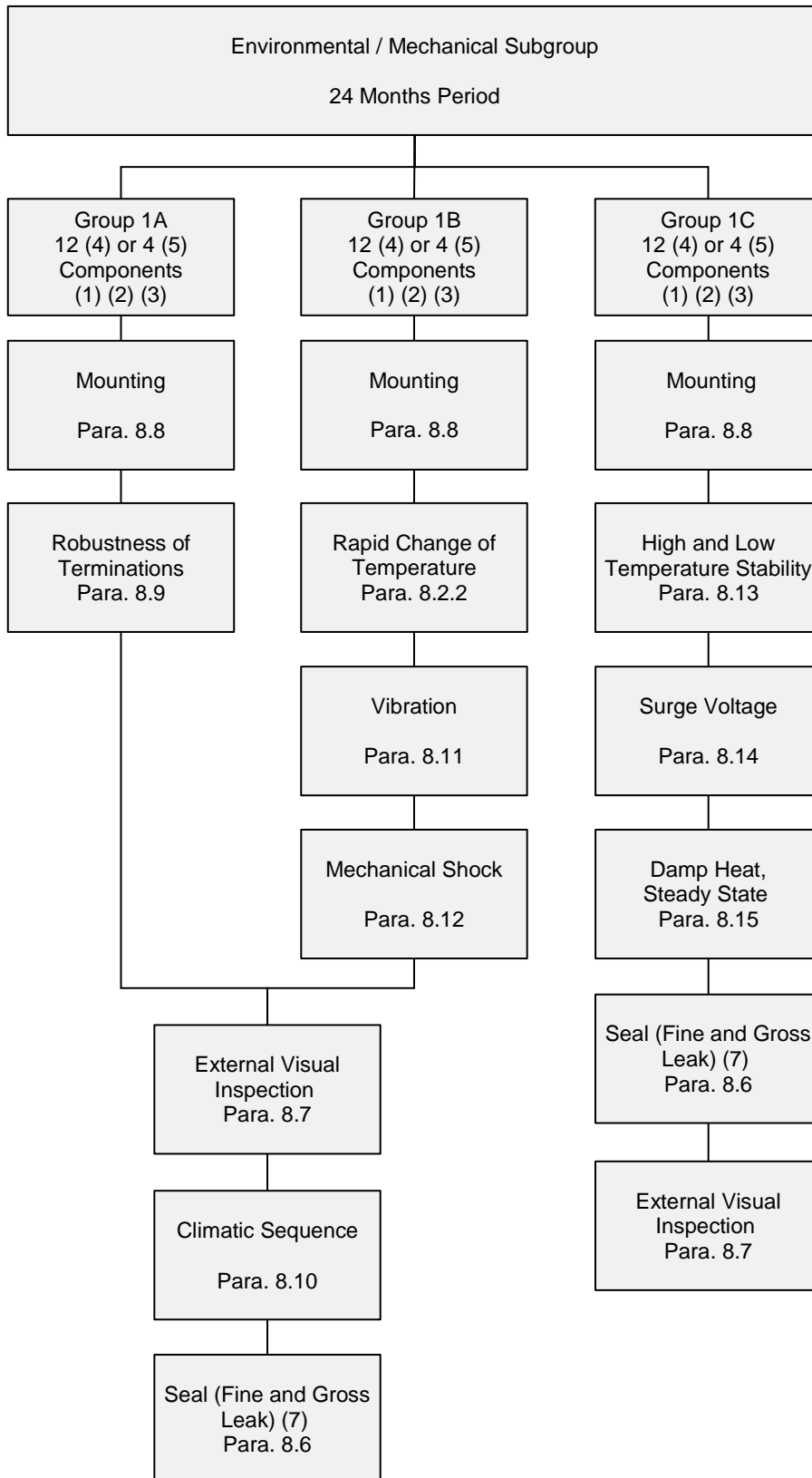
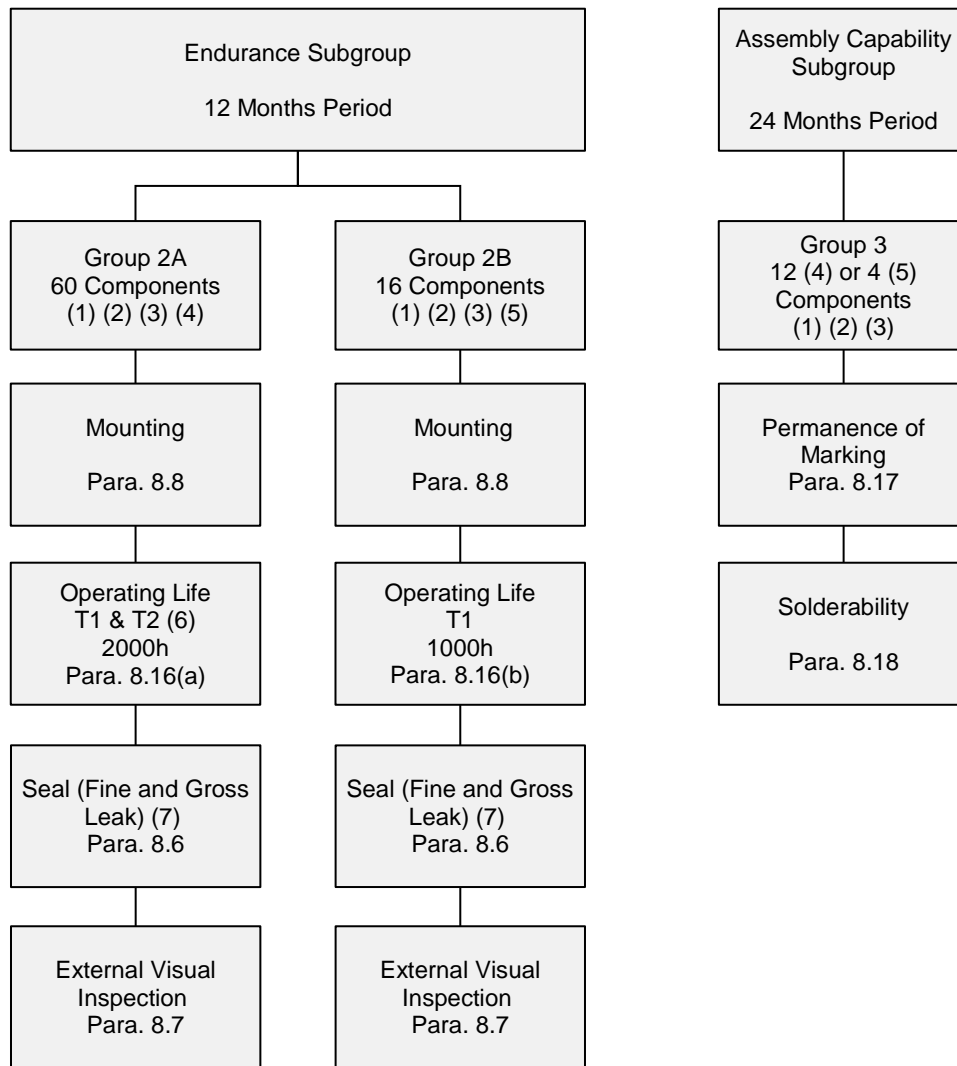




CHART F4 CONTINUED



**NOTES:**

1. For distribution within the subgroups, see Para. 7.1.2 for Qualification Testing, Para. 7.3 for Periodic Testing, and Para. 7.4 for Lot Validation Testing.
2. All components shall be serialised prior to testing.
3. No failures are permitted.
4. Applicable to Qualification Testing, and to Periodic Testing for renewal of qualification after lapse.
5. Applicable to Periodic Testing for extension of qualification.
6. Test samples divided between test temperatures in the ratio 3:2 (T1:T2).
7. Applicable to hermetically sealed components.