



**IPC/WHMA-A-620E-S**

# **Space and Military Applications Electronic Hardware Addendum to IPC/WHMA-A-620E**

If a conflict occurs between the English language and translated versions of this document, the English version will take precedence.

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Users of this publication are encouraged to participate in the development of future revisions.  
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# Space and Military Applications Electronic Hardware Addendum to IPC/WHMA-A-620E, Requirements and Acceptance for Cable and Wire Harness Assemblies

**Table of Contents**

The following topics are addressed in this Addendum.

- 0.1 Scope
- 0.1.1 Purpose
- 0.1.2 Precedence
- 0.1.3 Existing or Previously Approved Designs
- 0.1.4 Use of this Addendum
- 0.1.5 Lead (Pb)-FreeTin
- 0.1.6 Red Plague (Cuprous Oxide Corrosion)
- 0.1.7 White Plague (Fluorine Attack)

The following reference numbers are to IPC/WHMA-A-620E Clauses that are modified or added in this Addendum.

1.1	Scope
1.2	Purpose
1.3	Classification
1.5.1.2.1	Disposition
1.6	Process Control
1.10	Personnel Proficiency
1.12.2.1	Lighting
1.12.2.2	Magnification Aids
1.16	Materials and Processes
3.1	Stripping
3.2	Strand Damage and End Cuts
4.1.1.1	Materials and Components – Materials –Solder
4.1.1.2	Materials and Components – Materials –Flux
4.1.2	Materials and Components – Gold Removal
4.2.1	Cleanliness – Presoldering
4.2.2	Cleanliness – Postsoldering
4.3.2.2	Solder Connection – Soldering Anomalies – Partially Visible or Hidden Solder Connections
4.4	Wire/Lead Preparation, Tinning
4.8	Terminals
4.8.1.2	Terminals – Turrets and Straight Pins – Solder
4.8.2.2	Terminals – Bifurcated – Lead/Wire Placement – Bottom and Top Route

4.8.2.4	Terminals – Bifurcated – Solder
4.8.4.2	Terminals – Pierced/Perforated/ Punched – Solder
4.8.5.2	Terminals – Hook – Solder
4.8.6.2	Terminals – Cup – Solder
5.0	Crimp Terminations (Contacts and Lugs)
5.1	Stamped and Formed – Open Barrel
5.1.1	Stamped and Formed – Open Barrel – Insulation Support
5.1.1.1	Stamped and Formed – Open Barrel – Insulation Support – Inspection Window
5.1.1.2	Stamped and Formed – Open Barrel – Insulation Support – Crimp
5.1.2	Stamped and Formed – Open Barrel – Insulation Clearance if No Support Crimp
5.1.3	Stamped and Formed – Open Barrel – Conductor Crimp
5.1.4	Stamped and Formed – Open Barrel – Crimp Bellmouth
5.1.5	Stamped and Formed – Open Barrel – Conductor Brush
5.1.6	Stamped and Formed – Open Barrel – Carrier Cutoff Tab
5.1.7	Stamped and Formed – Open Barrel – Individual Wire Seal
5.2.1	Stamped and Formed – Closed Barrel – Insulation Clearance
5.2.2	Stamped and Formed – Closed Barrel – Insulation Support Crimp
5.2.3	Stamped and Formed – Closed Barrel – Conductor Crimp and Bellmouth
5.3	Machined Contacts
5.3.1	Machined Contacts – Insulation Clearance
6.0	Insulation Displacement Connection (IDC)
7.0 (All)	Ultrasonic Welding
8.1	Soldered Splices
8.1.1	Soldered Splices – Mesh
8.1.2	Soldered Splices – Wrap
8.1.3	Soldered Splices – Hook
8.1.4.1	Soldered Splices – Lap – Two or More Conductors
8.2.1	Crimped Splices – Barrel
8.2.2	Crimped Splices – Double Sided
8.3	Ultrasonic Weld Splices
8.4	Sleeving Over Splices
9.1.1	Hardware Mounting – Jackpost – Height

9.2.1	Strain Relief – Clamp Fit
9.4.2	Connector Damage – Limits – Hard Face – Mating Surface
9.4.3	Connector Damage – Limits – Soft Face – Mating Surface or Rear Seal Area
9.4.4	Connector Damage – Contacts
9.4.4.1 [New]	Connector Damage – Contacts – Exposed Sockets, Protected Pins, e.g., MIL-DTL-83513 Micro D
9.4.5 [New]	Connector Damage – Seals/Gaskets
9.5	Installation of Contacts and Sealing Plugs into Connectors
10.0	Over-Molding/Potting
12.0	Marking/Labeling
12.4	Location and Orientation
12.6.2	Marker Sleeve – Tubular
13.0	Coaxial and Biaxial Cable Assemblies
13.1	Stripping
13.7.2	Coaxial Connector – Terminal Cover – Press Fit
14.1	Tie Wrap/Lacing Application
14.2.1	Breakouts – Individual Wires
15.1	Braided
15.1.1	Braided – Direct Applied
15.1.2	Braided – Prewoven
15.2	Shield Termination
15.2.1.1	Shield Termination – Shield Jumper Wire – Attached Lead
15.2.1.1.1	Shield Termination – Shield Jumper Wire – Attached Lead – Solder
15.2.1.2	Shield Termination – Shield Jumper Wire – Shield Braid
15.2.1.3	Shield termination – Shield Jumper Wire – Daisy Chain
15.3.1	Shield Termination – Connector – Shrink

15.3.2	Shield Termination – Connector – Crimp
15.3.3	Shield Termination – Connector – Shield Jumper Wire Attachment
15.4.1	Shield Termination – Splicing Prewoven – Soldered
15.7	Shrink Tubing – Conductive Lined
16.1.2	Braid – Prewoven
16.3	Spiral Plastic Wrap (Spiral Wrap Sleeving)
17.0	Finished Assembly Installation
17.1	General
17.2	Hardware Installation
17.2.2	Hardware Installation– Wires
18.0 (All)	Solderless Wrap
19.4	Electrical Test
19.4.1	Electrical Test – Selection
19.5.2	Electrical Test Methods – Shorts
19.5.3	Electrical Test Methods – Dielectric Withstanding Voltage (DWV)
19.5.4	Electrical Test Methods – Insulation Resistance (IR)
19.6.1	Mechanical Test – Selection
19.7.1	Mechanical Test Methods – Crimp Height (Dimensional Analysis)
19.7.2	Mechanical Test Methods – Pull Force (Tensile)
19.7.2.1	Mechanical Test Methods – Pull Force (Tensile) – Without Documented Process Control
19.7.5	Mechanical Test Methods – Contact Retention Verification
19.7.5.1 [New]	Mechanical Test Methods – Contact Retention Verification – Push Testing
19.7.5.2 [New]	Mechanical Test Methods – Contact Retention Verification – Pull Testing
19.7.6	Mechanical Test Methods – RF Connector Shield Pull Force (Tensile)

**0.1 Scope** This Addendum provides modified and additional requirements over those published in IPC/WHMA-A-620E to ensure the performance of cable and wire harness assemblies that must survive the vibration and thermal excursions encountered getting to and operating in the military and space environments.

Where content criteria are not supplemented or replaced, the Class 3 requirements of IPC/WHMA-A-620E apply.

**0.1.1 Purpose** When required by the contract or engineering documentation, this Addendum supplements or replaces specifically identified requirements of IPC/WHMA-A-620E.

**0.1.2 Precedence** The contract takes precedence over this Addendum, referenced standards and User-approved drawings. In the event of a conflict between this Addendum and the reference documents cited herein, this Addendum takes precedence. (See IPC/WHMA-A-620E 1.7 Order of Precedence.)

**0.1.3 Existing or Previously Approved Designs** This Addendum **shall not** constitute the sole cause for the redesign of previously approved designs. When drawings for existing or previously approved designs undergo revision, they should be reviewed and changes made that allow for compliance with the requirements of this Addendum.

**0.1.4 Use of this Addendum** This Addendum **shall not** be used as a stand-alone document.

Where criteria are not supplemented by this Addendum, the Class 3 requirements of IPC/WHMA-A-620E **shall** apply. Clauses found only in this Addendum will have “[NEW]” after the clause number in IPC/WHMA-A-620ES Table 1. If an IPC/WHMA-A-620E requirement is changed or added by this Addendum, the clause is identified and only the process requirements and defects for that clause are listed in Table 1 of this Addendum, i.e., Acceptable conditions, are not listed. If a feature is not listed as a defect, it **shall** be considered acceptable. Acceptable conditions (except where changed by this Addendum) and Figures are provided in IPC/WHMA-A-620E.

The clauses modified by this Addendum do not include subordinate clauses unless specifically stated, i.e., changes made to 1.4 do not affect 1.4.1 unless 1.4.1 is also addressed in this Addendum. Clauses, Tables, Figures, etc., in IPC/WHMA-A-620E that are not listed in this Addendum are to be used as-published.

When a paragraph refers to an entire chapter, for example the first paragraph in 15.1 Braided of this Addendum, it is the user of the standard’s responsibility to determine which clauses from that chapter are used from IPC/WHMA-A-620E and which clauses are covered by this Addendum.

**0.1.5 Lead (Pb)-Free Tin** For this document, the definition of lead (Pb)-free tin is tin containing less than 3% Pb by weight as an alloying constituent. See Table 1 of this Addendum 4.1.1.1 Materials and Components – Materials – Solder.

The use of components, assemblies, packaging technology, mechanical hardware and materials identified as having external surfaces (platings, metallization, etc.) of Pb-free tin or assembled with Pb-free tin solder alloys **shall** be prohibited unless documented and controlled through a User-approved Pb-Free Control Plan (LFCP). Solder alloy Sn96.3Ag3.7 is exempt from this requirement for a LFCP.

**0.1.6 Red Plague (Cuprous Oxide Corrosion)** Red Plague (cuprous oxide corrosion) can develop in silver-coated soft or annealed copper wire when a galvanic cell forms between the copper base metal and the silver coating in the presence of moisture (H<sub>2</sub>O) and oxygen (O<sub>2</sub>). Once initiated, the sacrificial corrosion of the copper base conductor can continue indefinitely in the presence of oxygen. The color of the corrosion by-product (cuprous oxide crystals) may vary depending on the different levels of oxygen available, but is commonly noted as a red/reddish-brown discoloration on the silver coating surface.

The use of silver-coated copper wire and cable **shall** require the implementation of a User-approved Red Plague Control Plan (RPCP). See IPC-WP-113 for technical guidance and a generic RPCP template.

**0.1.7 White Plague (Fluorine Attack)** During the manufacturing of fluoropolymer-insulated electrical wires and cables made with tin-coated, silver-coated, or nickel-coated copper or copper alloy conductors, the extrusion of fluorocarbon resin to form the insulation jacket occurs at a temperature high enough that oxidative degradation of the polymer may occur, possibly resulting in the evolution or outgassing of a number of materials, including carbonyl fluoride (COF<sub>2</sub>), an extremely reactive compound. This outgassing from the insulation is both internal, e.g., to the wire strand/cable bundle, and external, e.g., to the surrounding environment. In the presence of trace atmospheric moisture, e.g., humidity, the carbonyl-difluoride hydrolyzes to generate carbon dioxide (CO<sub>2</sub>) and hydrogen fluoride (HF). The hydrogen fluoride (HF) will then hydrate to form concentrated hydrofluoric acid (HF aq), an extremely corrosive agent that attacks metal and metal oxides, including, but not limited to, conductors, contacts, connector shells, etc.

The use of fluoropolymer-insulated copper wire and cable may require the implementation of a User-approved White Plague Control Plan (WPCP). See IPC-WP-114 for technical guidance and a generic WPCP template.