


REV	DESCRIPTION	DATE	PREP	APPD
A	NIR-66181	8/29/17	DF/SM	HLW

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 MOUNT HOLLY SPRINGS, PA 17065	Oscillator Specification, Hybrid VCSO For Hi-Rel Standard, Sinewave Output
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THE RECORD OF APPROVAL FOR THIS DOCUMENT IS MAINTAINED ELECTRONICALLY WITHIN THE ERP SYSTEM	CODE IDENT NO	SIZE	DWG. NO.	REV
	00136	A	DOC206559	A
	UNSPECIFIED TOLERANCES: N/A			SHEET 1 OF 16

1. SCOPE

- 1.1 General. This specification defines the design, assembly and functional evaluation of high reliability, hybrid voltage controlled SAW oscillators produced by Vectron International. Devices delivered to this specification represent the standardized Parts, Materials and Processes (PMP) Program developed, implemented and certified for advanced applications and extended environments.
- 1.2 Applications Overview. The designs represented by these products were primarily developed for the MIL-Aerospace community. The lesser Design Pedigrees and Screening Options imbedded within DOC206559 bridge the gap between Space and COTS hardware by providing custom hardware with measures of mechanical, assembly and reliability assurance needed for Military or Ruggedized COTS environments.

2. APPLICABLE DOCUMENTS

- 2.1 Specifications and Standards. The following specifications and standards form a part of this document to the extent specified herein. The issue currently in effect on the date of quotation will be the product baseline, unless otherwise specified. In the event of conflict between the texts of any references cited herein, the text of this document shall take precedence.

Military

MIL-PRF-55310 Oscillators, Crystal Controlled, General Specification For
MIL-PRF-38534 Hybrid Microcircuits, General Specification For

Standards

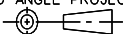
MIL-STD-202 Test Method Standard, Electronic and Electrical Component Parts
MIL-STD-750 Test Method Standard, Test Methods for Semiconductor Devices
MIL-STD-883 Test Methods and Procedures for Microelectronics

Other

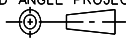
QSP-90100 Quality Systems Manual, Vectron International
VL-65339 Identification Common Documents, Materials and Processes, Hi-Rel
XO
DOC203982 DPA Specification
QSP-91502 Procedure for Electrostatic Discharge Precautions

3. GENERAL REQUIREMENTS

- 3.1 Classification. All devices delivered to this specification are of hybrid technology conforming to Class 2 of MIL-PRF-55310. Primarily developed as a Class S equivalent specification, options are imbedded within it to also produce Class B, Engineering Model and Ruggedized COTS devices. Devices carry a Class 1B ESDS classification per MIL-PRF-38534.

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- 3.2 Item Identification. Unique model number series are utilized to identify device package configurations as listed in Table 1.
- 3.3 Absolute Maximum Ratings.
- | | |
|--|------------------------------|
| a. Supply Voltage Range (V_{CC}): | 0Vdc to $V_{cc} + 2.0V_{dc}$ |
| b. Control Voltage Range (V_c): | -0.5Vdc to +8.0Vdc |
| c. Storage Temperature Range (T_{STG}): | -55°C to +125°C |
| d. Junction Temperature (T_j): | +150°C |
| e. Lead Temperature (soldering, 10 seconds): | +300°C |
- 3.4 Design, Parts, Materials and Processes, Assembly, Inspection and Test.
- 3.4.1 Design. The ruggedized designs implemented for these devices are proven in military and space applications under extreme environments. Designs utilize Established Reliability (MIL-ER) components where possible. When specified, radiation hardening up to 300krad (Si) (RHA level F) is met by utilizing active device lots that have passed testing to that level.
- 3.4.1.1 Design and Configuration Stability. Barring changes to improve performance by reselecting passive chip component values to offset component tolerances, there will not be fundamental changes to the design or assembly or parts, materials and processes after first product delivery of that item without written approval from the procuring activity.
- 3.4.1.2 Environmental Integrity. Designs have passed the environmental qualification levels of MIL-PRF-55310. These designs have also passed extended dynamic levels of at least:
- Sine Vibration: MIL-STD-202, Method 204, Condition G (30g pk.)
 - Random Vibration: MIL-STD-202, Method 214, Condition II-J (43.92g rms, three minute duration in each of three mutually perpendicular directions)
 - Mechanical Shock: MIL-STD-202, Method 213, Condition F (1500g, 0.5ms)
- 3.4.2 Prohibited Parts, Materials and Processes. The items listed are prohibited for use in high reliability devices produced to this specification.
- Gold metallization of package elements without a barrier metal.
 - Zinc chromate as a finish.
 - Cadmium, zinc, or pure tin external or internal to the device.
 - Plastic encapsulated semiconductor devices.
 - Ultrasonically cleaned electronic parts.
 - Heterojunction Bipolar Transistor (HBT) technology.
- 3.4.3 Assembly. Manufacturing utilizes standardized procedures, processes and verification methods to produce MIL-PRF-55310 Class S / MIL-PRF-38534 Class K equivalent devices. MIL-PRF-38534 Group B Option 1 in-line inspection is included on radiation hardened part numbers to further verify lot pedigree. Traceability of all components and production lots are in accordance with MIL-PRF-38534, as a minimum. Tabulated records are provided as a part of the deliverable data package. Devices are handled in accordance with Vectron document QSP-91502 (Procedure for Electrostatic Discharge Precautions).

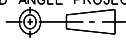
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- 3.4.4 Inspection. The inspection requirements of MIL-PRF-55310 apply to all devices delivered to this document. Inspection conditions and standards are documented in accordance with the Quality Assurance, ISO-9001 and AS9100 derived, System of QSP-90100.
- 3.4.5 Test. The Screening test matrix of Table 5 is tailored for selectable-combination testing to eliminate costs associated with the development/maintenance of device-specific documentation packages while maintaining performance integrity.
- 3.4.6 Marking. Device marking shall be in accordance with the requirements of MIL-PRF-55310.
- 3.4.7 Ruggedized COTS Design Implementation. Design Pedigree “D” devices (see ¶ 5.2) use the same robust designs found in the other device pedigrees. They do not include the provisions of traceability or the Class-qualified components noted in paragraphs 3.4.3 and 4.1.

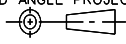
4. DETAIL REQUIREMENTS

4.1 Components

- 4.1.1 Resonators. VCSO designs utilize a Surface Acoustic Wave (SAW) resonator as the frequency determining device. The SAW is manufactured and sealed in its own package prior to mounting in the hybrid. Resonators used in flight models will come from lots that have passed MIL-PRF-38534 Lot Acceptance Test for SAW devices plus 100% screening and electrical test prior to installation into the VCSO.
- 4.1.2 Passive Components. Passive components will have the same pedigree as the die specified in paragraph 7.1. When required, established Reliability (ER) failure level R minimum passive components are procured from QPL suppliers where possible. Lot evaluations are in accordance with MIL-PRF-38534 or Enhanced Element Evaluation as specified in Table 8. When used, inductors may be open construction and may use up to 47 gauge wire.
- 4.1.3 Class S/K Active Devices. Active Devices are procured from wafer lots that have passed MIL-PRF-38534 Lot Acceptance Tests for Class K devices. When optionally specified, further testing in accordance with MIL-PRF-55310 and MIL-PRF-38534 is performed for radiation hardness assurance (excluding varactor diodes) and for Enhanced Element Evaluation as specified in Tables 6 and 7. All active devices are acceptable for use in environments of up to 300 krad(Si) total dose by Radiation Lot Acceptance Testing of the individual components. ELDRS tolerance on the bipolar transistors is verified by performing an LDR test to 50 krad(Si) and comparing the results to devices from the same lot that were tested at a HDR to 50 krad(Si) and then 300krad(Si). In addition, bipolar semiconductors are considered insensitive to Single Event Effects. Varactor diodes are considered radiation tolerant by design.
 - 4.1.3.1 Class B Active Devices. When specified, active devices assembled into DOC206559 design pedigree letters “B” and “C” devices (¶ 5.2a) are procured from wafer lots that have passed MIL-PRF-55310 element evaluations for Class B devices.

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- 4.1.4 Packages. Packages are procured that meet the construction, lead materials and finishes as specified in MIL-PRF-55310. All leads are Kovar with gold plating over a nickel underplate. Package lots are upscreened in accordance with the requirements of MIL-PRF-38534 as applicable.
- 4.1.5 Traceability and Homogeneity. All design pedigrees except option D have active device lots that are traceable to the manufacturer's individual wafer; all other elements and materials are traceable to their manufacturer and incoming inspection lots. Design pedigrees E and F have homogenous material.
- 4.1.6 Enhanced Element Evaluation. When Design Pedigree Option "E" is specified, active and passive devices with Enhanced Element Evaluation as listed in Table 6 and 7 shall be implemented for the highest reliability preference.
- 4.2 Mechanical.
- 4.2.1 Package Outline. See Table.
- 4.2.2 Thermal Characteristics. Because these VCSO's are multichip hybrid designs, the actual θ_{jc} to any one given semiconductor die will vary, but the combined average for all active devices results in a θ_{jc} of approximately 90°C/W. The typical die temperature rise at any one given semiconductor is 8°C to 14°C. With the oscillator operating at +85°C, the average junction temperature is approximately +99°C and under no circumstance will it ever exceed the maximum manufacturer's rated junction temperature.
- 4.2.3 Weight. 3.5 grams typical
- 4.3 Electrical.
- 4.3.1 Input Power. Devices are designed for standard +3.3V, +5.0V or +12V dc operation, ±5%.
- 4.3.2 Temperature Range. Operating range is -40°C to +85°C.
- 4.3.3 Absolute Pull Range. Absolute pull range is defined as the minimum guaranteed amount the VCXO can be varied, about the center frequency (fo). It accounts for degradations including initial frequency tolerance, temperature stability (-40 to 85°C), aging (15 years), radiation effects, power supply variations (±5%) and load variations (±10%).
- 4.3.4 Frequency Aging. When tested in accordance with MIL-PRF-55310 Group B inspection, the 15-year aging projection shall not cause the minimum APR limit to be exceeded.
- 4.3.5 All devices include an External Frequency Control (EFC) pin for the purpose of externally setting each VCSO to its nominal frequency.
- 4.3.6 Output Load. Standard Sinewave (50 ohms)

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5. QUALITY ASSURANCE PROVISIONS AND VERIFICATION

5.1 Verification and Test. Device lots shall be tested prior to delivery in accordance with the applicable Screening Option letter as stated by the 15th character of the part number. Table 5 tests are conducted in the order shown and annotated on the appropriate process travelers and data sheets of the governing test procedure. For devices that require Screening Options that include MIL-PRF-55310 Group A testing, the Post-Burn-In Electrical Test and the Group A Electrical Test are combined into one operation.

5.1.1 Screening Options. The Screening Options, by letter, are summarized as:

- A Modified MIL-PRF-38534 Class K
- B Modified MIL-PRF-55310 Class B Screening & Group A Quality Conformance Inspection (QCI)
- C Modified MIL-PRF-55310 Class S Screening & Group A QCI
- D Modified MIL-PRF-38534 Class K with Group B Aging
- E Modified MIL-PRF-55310 Class B Screening, Groups A & B QCI
- F Modified MIL-PRF-55310 Class S Screening, Groups A & B QCI
- G Modified MIL-PRF-55310 Class B Screening & Post Burn-in Nominal Electricals
- X Engineering Model (EM)

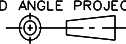
5.2 Optional Design, Test and Data Parameters. The following is a list of design, assembly, inspection and test options that can be selected or added by purchase order request.

- a. Design Pedigree (choose one as the 5th character in the part number):
 - (E) Enhanced Element Evaluation, 300krad Class K die
 - (F) Hi-Rel design w/ 300krad Class K die
 - (B) Hi-Rel design w/ Class B die
 - (D) Hi-Rel design w/ commercial grade components
- b. Input Voltage, (A) for +3.3V, (B) for 5.0V and (C) for +12.0V as the 14th character
- c. Radiographic Inspection
- d. Group C Inspection: MIL-PRF-55310 (requires 8 destruct specimens)
- e. Group C Inspection: MIL-PRF-38534, Table C-Xc, Condition PI [requires 8 destruct specimens – Life (5), RGA (3)]. Subgroup 1 fine leak test to be performed per MIL-STD-202, Method 112, Condition C.
- f. Qualification: In accordance with EEE-INST-002, Section C4, Table 3, Level 1 or 2 (requires 11 destruct specimens)
- g. Qualification: In accordance with MIL-PRF-55310, Table IV (requires 11 destruct specimens).
- g. Internal Water-Vapor Content (RGA) samples and test performance
- h. MTBF Reliability Calculations
- i. Worst Case/Derating Analysis (MIL-HDBK-1547) with $T_j \text{ Max} = +105^\circ\text{C}$; Derated Maximum Operating Temp = $T_j \text{ Max} - \Delta T_j$
- j. Deliverable Process Identification Documentation (PID)
- k. Customer Source Inspection (pre-cap / final)
- l. Destruct Physical Analysis (DPA): MIL-STD-1580 with exceptions as specified in Vectron DOC203982.

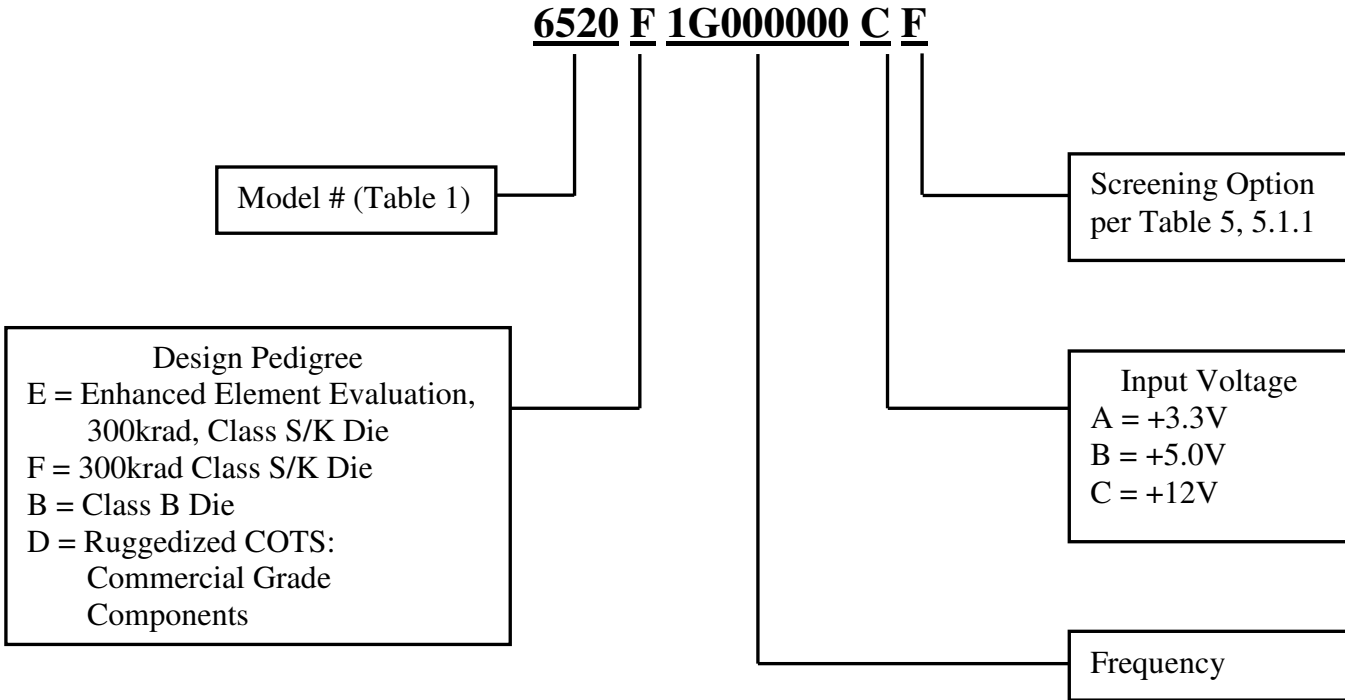
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- m. High Resolution Digital Pre-Cap Photographs (20 Megapixels minimum)
- n. Hot solder dip of leads with Sn63/Pb37 solder prior to shipping.

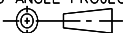
- 5.2.1 NASA EEE-INST-002. A combination of Design Pedigree E or R, Option F Screening, Group C Inspection in accordance with Table VII of MIL-PRF-55310 and RGA, meet the requirements of Level 1 device reliability. A combination of Design Pedigree B, Option E Screening, Radiographic Inspection, Group C Inspection in accordance with Table VII of MIL-PRF-55310 and RGA, meet the requirements of Level 2 device reliability.
- 5.3 Test Conditions. Unless otherwise stated herein, inspections are performed in accordance with those specified in MIL-PRF-55310 and MIL-PRF-38534, in that order. Process travelers identify the applicable methods, conditions and procedures to be used. Examples of electrical test procedures that correspond to MIL-PRF-55310 requirements are shown in Table 3.
- 5.4 Deliverable Data. The manufacturer supplies the following data, as a minimum, with each lot of devices:
 - a. Completed assembly and screening lot travelers, including rework history and Certificate of Conformance.
 - b. Electrical test variables data, identified by unique serial number.
 - c. Frequency-Temperature Data, Radiographic films, Group C data and RGA data as required by purchase order.
 - d. Traceability, component LAT, enclosure LAT and RLAT (if specifically requested on the purchase order).
- 5.5 Discrepant Material. All MRB authority resides with the procuring activity.
- 5.6 Failure Analysis. Any catastrophic failure (no clocking, no current) at Post Burn-In or after will be evaluated for root cause. The customer will be notified after occurrence and upon completion of the evaluation.
- 6. PREPARATION FOR DELIVERY
 - 6.1 Packaging. Devices will be packaged in a manner that prevents handling, ESD and transit damage during shipping.
- 7. ORDERING INFORMATION
 - 7.1 Ordering Part Number. The ordering part number is made up of an alphanumeric series of 15 characters. Design-affected product options, identified by the parenthetic letter on the Optional Parameters list (§ 5.2a and b), are included within the device part number.

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The Part Number breakdown is described as:



- 7.1.1 Model Number. The device model number is the four (4) digit number assigned to a corresponding package and output combination per Table 1.
- 7.1.2 Design Pedigree. Class S variants correspond to either letter “E” or “F” and are described in paragraph 5.2a. Class B variant corresponds to letter “B” and is described in paragraph 5.2a. Ruggedized COTS, using commercial grade components, corresponds to letter “D”.
- 7.1.3 Output Frequency. The nominal output frequency is expressed in the format as specified in MIL-PRF-55310 utilizing eight (8) characters.
- 7.1.4 Input Voltage. Voltage is the 14th character, letters “A” = +3.3V, “B” = +5.0V and “C” = +12V.
- 7.1.5 Screening Options. The 15th character is the Screening Option (letter A thru G or X) selected from Table 5.
- 7.2 Optional Design, Test and Data Parameters. Test and documentation requirements above that of the standard high reliability model shall be specified by separate purchase order line items (as listed in ¶ 5.2c thru n).

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HI-REL STANDARD MODEL #	PACKAGE	PIN I/O <u>1/</u>				MECHANICAL OUTLINE
		Vcc	Vc	Output	Gnd/Case	
6504	20 Lead Flatpack	20	1	9	2, 8, 10	FIGURE 2
6520 <u>2/</u>	20 Lead Flatpack	20	1	9	2, 8, 10	FIGURE 3

1/. All unassigned pins have no internal connections or ties.

2/. 6520 is a lead formed version of 6504.

TABLE 1 - Item Identification and Package Outline

Frequency Range: 300 MHz to 1.100 GHz (Vcc = +3.3V, +5V or +12V)						
Temperature Range: -40°C to +85°C						
Initial Tolerance: -50 ppm to +150 ppm typical						
Frequency-Voltage Tolerance: ±5 ppm typical (Vcc ±5%)						
Frequency Aging: ±30 ppm typical (projected over 15 years)						
Absolute Pull Range: ±20 ppm min. (See paragraph 4.3.3)						
Control Voltage (Vc) Range, Vcc = +3.3V: 0 V to +3.3V						
Control Voltage (Vc) Range, Vcc = +5V: 0 V to +5V						
Control Voltage (Vc) Range, Vcc = +12V: 0 V to +6V						
Input Impedance: 100kΩ min.						
Modulation Bandwidth: 100kHz min.						
Slope: Positive						
Linearity: ±10% max.						
F vs. V Gain: 90 ppm/V typical						
Sub-Harmonics: None						
Harmonics: -25 dBc typical, -20 dBc max.						
Phase Noise: See Figure 1 herein						
Frequency Range (MHz)	Current (mA max)			Output Power, Sinewave, into 50Ω (dBm min)		
Vcc	+3.3V	+5.0V	+12V	+3.3V	+5.0V	+12V
300 – 1.1GHz	50	60	60	+3	+3	+5

TABLE 2 - Electrical Performance Characteristics

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OPERATION LISTING	REQUIREMENTS AND CONDITIONS
@ all Electrical tests	
Input Current	MIL-PRF-55310, Para 4.8.5.1
Initial Accuracy @ Ref. Temp.	MIL-PRF-55310, Para 4.8.6
@ Post Burn-In Electrical only	
Initial Freq. – Temp. Accuracy	MIL-PRF-55310, Para 4.8.10.1
Freq. – Voltage Tolerance	MIL-PRF-55310, Para 4.8.14

TABLE 3 - Electrical Test Parameters

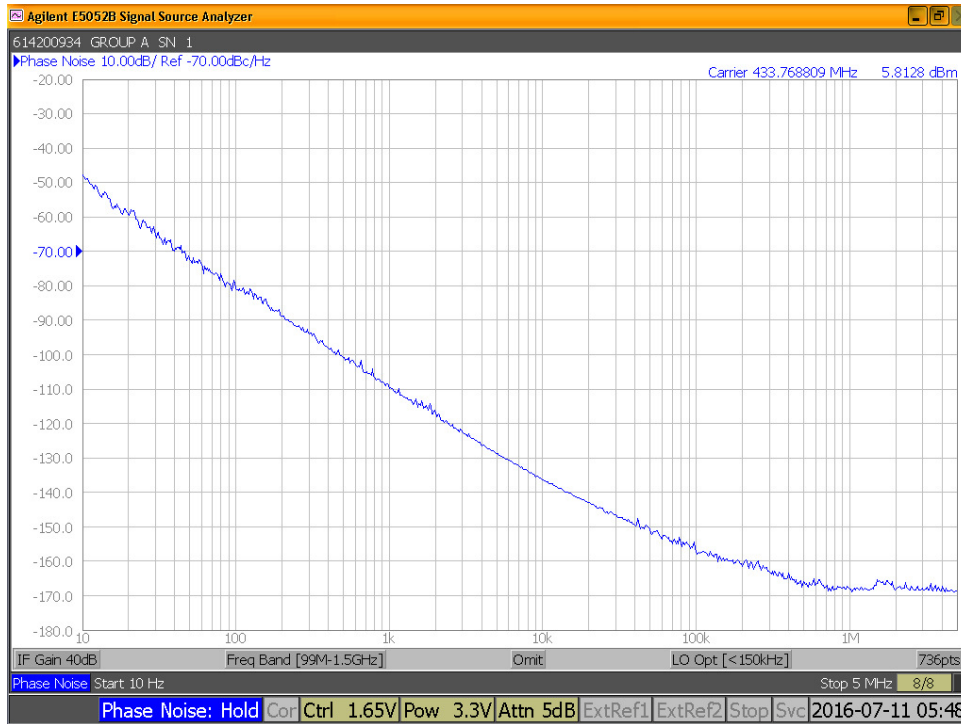
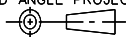


Figure 1A – Typical Phase Noise @ 433.768MHz

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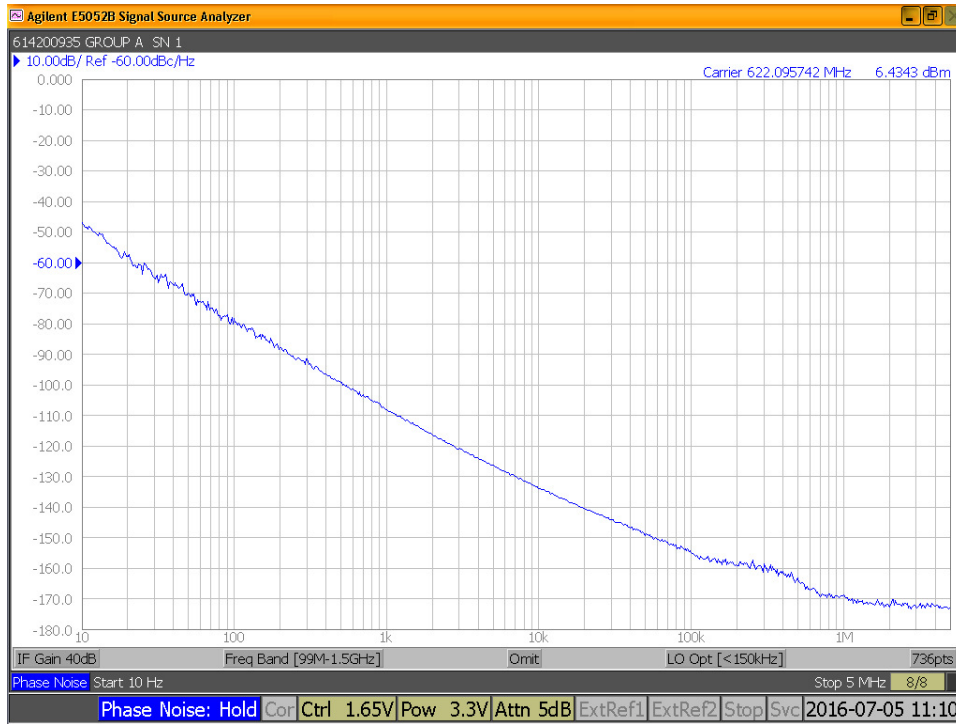


Figure 1B – Typical Phase Noise @ 622.080MHz

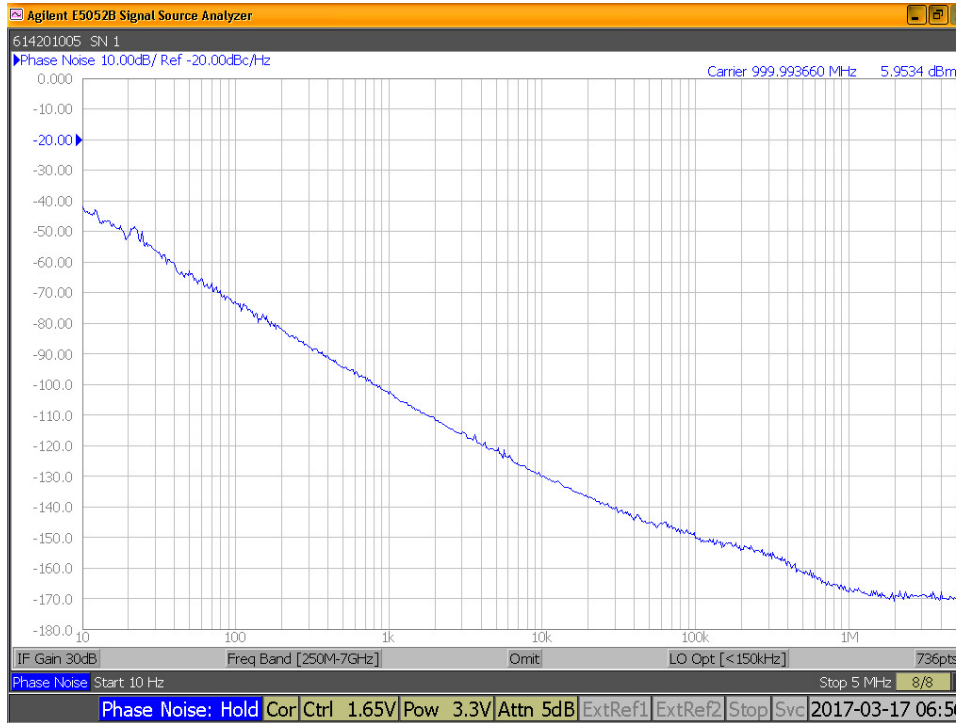
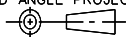


Figure 1C – Typical Phase Noise @ 1.000GHz

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OPN. NO.	OPERATION LISTING	REQUIREMENTS AND CONDITIONS	Option A	Option B	Option C	Option D	Option E	Option F	Option G	Option X
	SCREENING	MIL Class Similarity	K	B-	S-	K+	B	S		EM
			100%	100%	100%	100%	100%	100%	100%	100%
1	Non-Destruct Bond Pull	MIL-STD-883, Meth 2023	X	NR	X	X	NR	X	NR	NR
2	Internal Visual	MIL-STD-883, Meth 2017 Class K, Meth 2032 Class K	X	X	X	X	X	X	X	X
3	Stabilization (Vacuum) Bake	MIL-STD-883, Meth 1008, Cond C, 150°C	X 48 hrs.	X 24 hrs.	X 48 hrs.	X 48 hrs.	X 24 hrs.	X 48 hrs.	X 24 hrs.	X 24 hrs.
4	Thermal Shock	MIL-STD-883, Meth 1011, Cond A	NR	NR	X	NR	NR	X	NR	NR
5	Temperature Cycle	MIL-STD-883, Meth 1010, Cond. B, 10 cycles min.	X	X	X	X	X	X	X	NR
6	Constant Acceleration	MIL-STD-883, Meth 2001, Cond A, Y1 plane only, 5000 g's	X	X	X	X	X	X	X	NR
7	Particle Impact Noise Detection	MIL-STD-883, Meth 2020, Cond B	X	X	X	X	X	X	NR	X
8	Electrical Testing, Pre Burn-In	Perform tests in Table 3. Nominal Vcc, nominal temperature	X	X	X	X	X	X	X	X
9	1 st Burn-In	MIL-STD-883, Meth 1015, Condition B	X 160 hrs.	X 160 hrs.	X 240 hrs.	X 160 hrs.	X 160 hrs.	X 240 hrs.	X 160 hrs.	NR
10	Electrical Testing, Intermediate	Perform tests in Table 3. Nominal Vcc, nominal temperature	X	NR	NR	X	NR	NR	NR	NR
11	2 nd Burn-In	MIL-STD-883, Meth 1015, Condition B	X 160 hrs.	NR	NR	X 160 hrs.	NR	NR	NR	NR
12	Electrical Testing, Post Burn-In (Group A)	Perform tests in Table 3. Nominal Vcc & extremes, nominal temperature & extremes	X	X	X	X	X	X	X nom. Vcc	NR
13	Seal: Fine Leak	MIL-STD-202, Meth 112, Cond C 5 x 10 ⁻⁸ atm cc/sec max	X	X	X	X	X	X	X	X
14	Seal: Gross Leak	MIL-STD-202, Meth 112, Cond D	X	X	X	X	X	X	X	X
15	Radiographic Inspection	MIL-STD-883, Meth 2012	X	AR	AR	X	AR	X	NR	NR
16	Solderability	MIL-STD-883, Meth 2003	<u>1/</u>	<u>1/</u>	<u>1/</u>	<u>1/</u>	<u>1/</u>	<u>1/</u>	<u>1/</u>	NR
17	External Visual & Mechanical	MIL-STD-883, Meth 2009	X <u>2/</u>	X <u>2/</u>	X <u>2/</u>	X <u>2/</u>	X <u>2/</u>	X <u>2/</u>	X <u>2/</u>	X <u>2/</u>
18	Aging, 30 Day <u>3/</u> (M55310 Group B)	MIL-PRF-55310, para. 4.8.35.1	NR	NR	NR	X	13 pcs.	X	NR	NR

LEGEND: X = Required, NR = Not Required, AR = As Required

TABLE 5 - Test Matrix

1/ Performed at package LAT. Include LAT data sheet

2/ When specified, RGA samples will be removed from the lot after completion of this operation. Use of Screening failures require customer concurrence.

3/ By customer request, the Aging test may be terminated after 15 days if the measured aging rate is less than one-half the specified aging rate, as described in paragraph 4.3.4.1 herein. See the customer PO.

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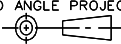
Subgroup	Class K	Test	Mil-STD-750		Quantity (accept number)	Mil-PRF-38534 Reference Paragraph
			Method	Condition		
1	X	Element Electrical A. May perform at wafer level B. All failures shall be removed from the lot		Perform at room ambient	100%	C.3.3.1
2	X	Element Visual	2069, 2070, 2072, 2073		100%	C.3.3.2
3	X	Internal Visual	2069, 2070, 2072, 2073, 2074		10(0) or 22(0) (Notes 1 & 2)	C.3.3.3 C.3.3.4.2
4	X	Temperature Cycling	1051	C	10(0) 22(0) (See Notes 1 & 2)	C.3.3.3
	X	Surge Current (when applicable)	4066	A or B as specified		
	X	Constant Acceleration	2006 2001	Y1 direction 20,000 G / 10,000 G for Pd ≥ 10W		
	X	Interim Electrical				C.3.3.4.3
	X	High Temperature Reverse Bias (HTRB)	1039 1042 1038	A B A		
	X	Interim Electrical & Delta		Complete Within 16 hrs of HTRB completion		
	X	Burn-In 240 hours	1039, 1042 1038 1040	B A B		
	X	Post Burn-In Electrical				C.3.3.4.3
	X	Steady State Life 1000 hours	1026 1037 1042 1048			
	X	Final Electrical				C.3.3.4.3
5	X	Wire Bond Evaluation	2011		10(0) wires or 20(1) wires	C.3.3.3 C.3.3.5
6	X	SEM	2018 2077		See method 2018 or 2077 & Note 2	C.3.3.6

TABLE 6: SEMICONDUCTOR ENHANCED ELEMENT EVALUATION

SIZE A	CODE IDENT NO. 00136	THIRD ANGLE PROJECTION 	UNSPECIFIED TOLERANCES N/A	DWG NO. DOC206559	REV. A	SHEET 13
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Part Type	Test	Requirements Paragraph	Sample Size	Allowable Rejects
Ceramic capacitors (Production lot definition shall be per M55681 or M123 for chips, or M49470 T-level for stacks)				
M55681 FRL S or M123 (chips)	N/A	N/A	N/A	N/A
DSCC Dwg COTS (chips)	Ultrasonic scan or CSAM	M123	100%	N/A
	Group A	M123	M123	M123
	Group B, Subgroups 1 & 2	M123	M123	M123
T-level M49470 (stacked)	N/A	N/A	N/A	N/A
General purpose M49470, DSCC dwg or COTS (stacked)	Ultrasonic scan or CSAM	M49470 for T-level	100%	N/A
	Group A	M49470 for T-level	M49470 for T-level	M49470 for T-level
	Group B, Subgroups 2, 4 & 5b	M49470 for T-level	M49470 for T-level	M49470 for T-level
Tantalum Chip Capacitors (Note: Stacking tantalum chips will require a repeat of the entire Group A in M55365 with minimum Weibull C and surge current option C. Production lot definition shall be per M55365.)				
M55365	Group A (Weibull C minimum with surge current option C)	M55365	M55365	M55365
DSCC Dwg, COTS	Group A (Weibull C minimum with surge current option C)	M55365	M55365	M55365
	Group B	M55365	M55365	M55365
Resistor Chips (Note: Gluing one resistor chip on top of another to change a design or save on real estate is not allowable without extensive design/process verification, long term testing, and hybrid re-qualification. Production lot definition shall be per M55342).				
M55342 FRL R or S	N/A	N/A	N/A	N/A
DSCC Dwg, COTS	Group A	M55342 for T-level	M55342 for T-level	M55342 for T-level
	Group B	M55342 for T-level	M55342 for T-level	M55342 for T-level
Inductors (See Paragraph 4.1.2)				
Magnetics, Closed Construction Leaded and Surface Mount (transformers, inductors, coils) (Note: Stacking magnetics shall be qualified and the effects of the long term performance of the hybrids verified. When stacking magnetics, a repeat of the thermal cycling plus electrical measurements as specified in Group A of Mil-Std-981. Design, workmanship and materials/processes shall conform to MIL-STD-981 requirements).				
Magnetics, Open Construction are unencapsulated and unpotted self-leaded parts consisting of magnet wire wound around a magnetic core. These parts are fully visually inspectable. Open construction magnetics shall be subjected to 100% electrical measurements and visual inspection per Mil-Std-981.				
Custom closed magnetics	Group A	Mil-STD-981	Mil-STD-981	Mil-STD-981
	Group B	Mil-STD-981	Mil-STD-981	Mil-STD-981

TABLE 7: PASSIVE COMPONENT ENHANCED ELEMENT EVALUATION

SIZE A	CODE IDENT NO. 00136	THIRD ANGLE PROJECTION 	UNSPECIFIED TOLERANCES N/A	DWG NO. DOC206559	REV. A	SHEET 14
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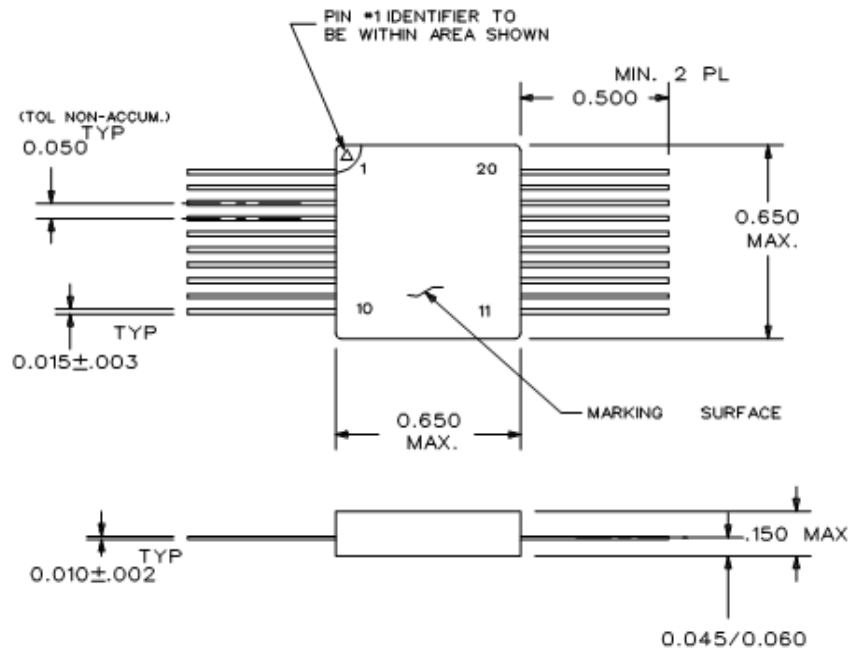


FIGURE 2
Model 6504 Package Outline

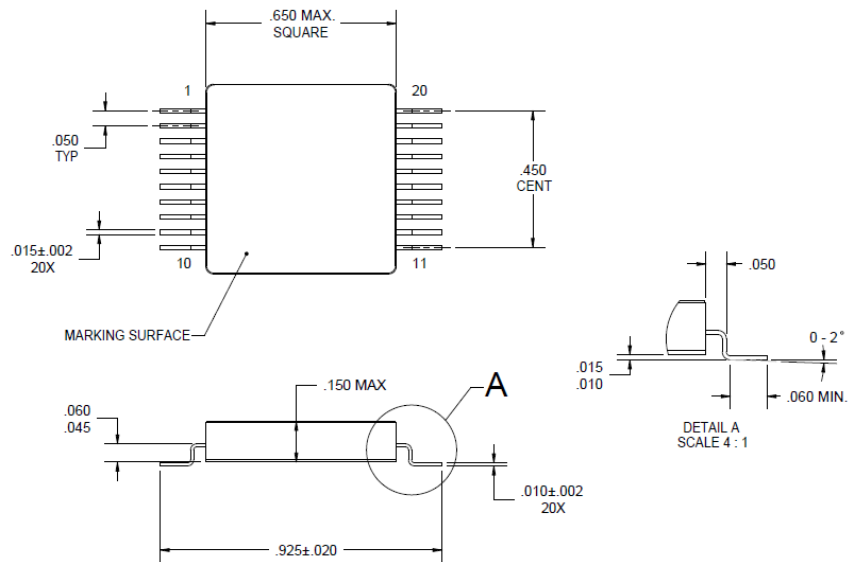
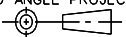
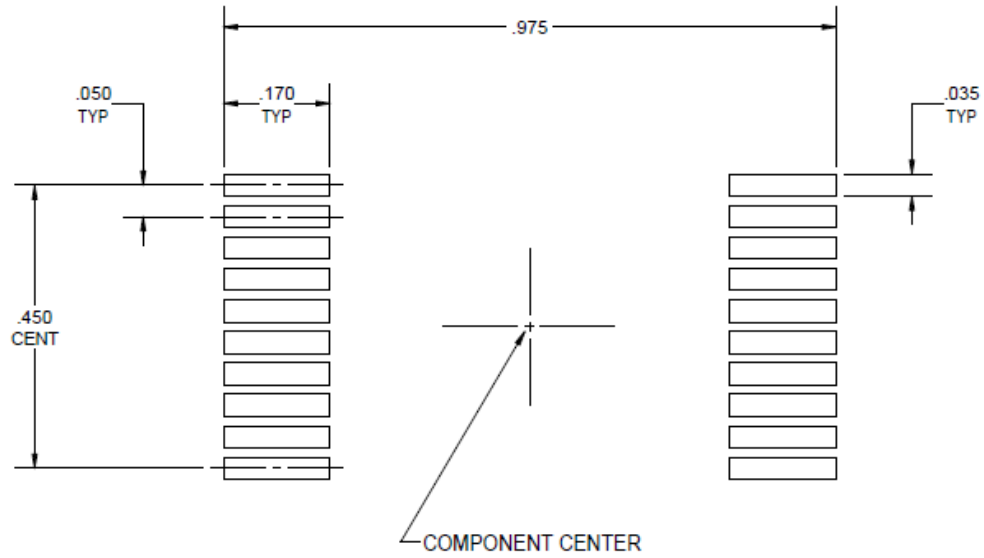


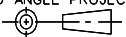
FIGURE 3
Model 6520 Package Outline

SIZE	CODE IDENT NO.	THIRD ANGLE PROJECTION	UNSPECIFIED TOLERANCES	DWG NO.	REV.	SHEET
A	00136		N/A	DOC206559	A	15

APPENDIX A
Recommended Land Pattern



Model 6520

SIZE A	CODE IDENT NO. 00136	THIRD ANGLE PROJECTION 	UNSPECIFIED TOLERANCES N/A	DWG NO. DOC206559	REV. A	SHEET 16
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