

INTERNATIONAL STANDARD



**Fixed capacitors for use in electronic equipment –
Part 1: Generic specification**

IECNORM.COM : Click to view the full PDF of IEC 60384-1:2016 RLV



THIS PUBLICATION IS COPYRIGHT PROTECTED

Copyright © 2016 IEC, Geneva, Switzerland

All rights reserved. Unless otherwise specified, no part of this publication may be reproduced or utilized in any form or by any means, electronic or mechanical, including photocopying and microfilm, without permission in writing from either IEC or IEC's member National Committee in the country of the requester. If you have any questions about IEC copyright or have an enquiry about obtaining additional rights to this publication, please contact the address below or your local IEC member National Committee for further information.

IEC Central Office
3, rue de Varembe
CH-1211 Geneva 20
Switzerland

Tel.: +41 22 919 02 11
Fax: +41 22 919 03 00
info@iec.ch
www.iec.ch

About the IEC

The International Electrotechnical Commission (IEC) is the leading global organization that prepares and publishes International Standards for all electrical, electronic and related technologies.

About IEC publications

The technical content of IEC publications is kept under constant review by the IEC. Please make sure that you have the latest edition, a corrigenda or an amendment might have been published.

IEC Catalogue - webstore.iec.ch/catalogue

The stand-alone application for consulting the entire bibliographical information on IEC International Standards, Technical Specifications, Technical Reports and other documents. Available for PC, Mac OS, Android Tablets and iPad.

IEC publications search - www.iec.ch/searchpub

The advanced search enables to find IEC publications by a variety of criteria (reference number, text, technical committee,...). It also gives information on projects, replaced and withdrawn publications.

IEC Just Published - webstore.iec.ch/justpublished

Stay up to date on all new IEC publications. Just Published details all new publications released. Available online and also once a month by email.

Electropedia - www.electropedia.org

The world's leading online dictionary of electronic and electrical terms containing 20 000 terms and definitions in English and French, with equivalent terms in 15 additional languages. Also known as the International Electrotechnical Vocabulary (IEV) online.

IEC Glossary - std.iec.ch/glossary

65 000 electrotechnical terminology entries in English and French extracted from the Terms and Definitions clause of IEC publications issued since 2002. Some entries have been collected from earlier publications of IEC TC 37, 77, 86 and CISPR.

IEC Customer Service Centre - webstore.iec.ch/csc

If you wish to give us your feedback on this publication or need further assistance, please contact the Customer Service Centre: csc@iec.ch.

IECNORM.COM : Click to view the full text of IEC 60384-1:2016 RVV



IEC 60384-1

Edition 5.0 2016-02
REDLINE VERSION

INTERNATIONAL STANDARD



**Fixed capacitors for use in electronic equipment –
Part 1: Generic specification**

INTERNATIONAL
ELECTROTECHNICAL
COMMISSION

ICS 31.060

ISBN 978-2-8322-3167-8

Warning! Make sure that you obtained this publication from an authorized distributor.

CONTENTS

FOREWORD.....	9
INTRODUCTION.....	11
1 General.....	13
1.1 Scope.....	13
1.2 Normative references.....	13
2 Technical data.....	15
2.1 Symbols, units and abbreviated terms.....	15
2.1.1 General.....	15
2.1.2 Letter symbols.....	15
2.1.3 Abbreviations.....	16
2.2 Terms and definitions.....	16
2.3 Preferred values and additional technical requirements.....	21
2.3.1 General.....	21
2.3.2 Preferred values of nominal capacitance.....	22
2.3.3 Preferred values of rated voltage.....	22
2.3.4 Rated a.c. load.....	22
2.3.5 Rated pulse load.....	22
2.3.6 Temperature derated voltage.....	23
2.4 Marking.....	23
2.4.1 General.....	23
2.4.2 Coding.....	23
3 Quality assessment procedures.....	24
4 Tests and measurement procedures.....	24
4.1 General.....	25
4.2 Standard atmospheric conditions.....	25
4.2.1 Standard atmospheric conditions for testing.....	25
4.2.2 Recovery conditions.....	25
4.2.3 Referee conditions.....	26
4.2.4 Reference conditions.....	26
4.3 Drying.....	26
4.4 Visual examination and check of dimensions.....	26
4.4.1 Visual examination.....	26
4.4.2 Dimensions (gauging).....	27
4.4.3 Dimensions (detail).....	27
4.5 Insulation resistance.....	27
4.5.1 Preconditioning.....	27
4.5.2 Measuring conditions.....	27
4.5.3 Test points.....	27
4.5.4 Test methods.....	28
4.5.5 Temperature compensation.....	28
4.5.6 Conditions to be prescribed in the relevant specification.....	28
4.6 Voltage proof.....	30
4.6.1 General.....	30
4.6.2 Test circuit (for the test between terminations).....	30
4.6.3 Test.....	31
4.6.4 Requirements.....	32

4.6.5	Conditions to be prescribed in the relevant specification	32
4.7	Capacitance	33
4.7.1	Measuring frequency and measuring voltage	33
4.7.2	Measuring equipment	33
4.7.3	Conditions to be prescribed in the relevant specification	33
4.8	Tangent of loss angle and equivalent series resistance (ESR)	33
4.8.1	Tangent of loss angle	33
4.8.2	Equivalent series resistance (ESR)	34
4.9	Leakage current	34
4.9.1	Preconditioning	34
4.9.2	Test method	34
4.9.3	Power source	34
4.9.4	Measuring accuracy	34
4.9.5	Test circuit	34
4.9.6	Conditions to be prescribed in the relevant specification	34
4.10	Impedance	35
4.11	Self-resonant frequency and inductance	36
4.11.1	Self-resonant frequency (f_r)	36
4.11.2	Inductance	39
4.11.3	Conditions to be prescribed in the relevant specification	39
4.12	Outer foil termination	39
4.13	Robustness of terminations	40
4.13.1	General	40
4.13.2	Test Ua ₁ – Tensile	40
4.13.3	Test Ub – Bending (half of the sample)	41
4.13.4	Test Uc – Torsion (remaining sample)	41
4.13.5	Test Ud – Torque	41
4.13.6	Visual examination	41
4.14	Resistance to soldering heat	41
4.14.1	Preconditioning and initial measurement	41
4.14.2	Test procedure	41
4.14.3	Recovery	42
4.15	Solderability	42
4.15.1	General	42
4.15.2	Preconditioning	42
4.15.3	Test procedure	42
4.15.4	Final inspection, measurements and requirements	43
4.16	Rapid change of temperature	43
4.16.1	Initial measurement	43
4.16.2	Test procedure	43
4.16.3	Final inspection, measurements and requirements	43
4.17	Vibration	43
4.17.1	Initial measurement	43
4.17.2	Test procedure	43
4.17.3	Electrical test (intermediate measurement)	43
4.17.4	Final inspection, measurements and requirements	43
4.18	Bump (repetitive shock)	44
4.18.1	Initial measurement	44
4.18.2	Test procedure	44

4.18.3	Final inspection, measurements and requirements	44
4.14.4	Final inspection, measurement and requirements	42
4.19	Shock	44
4.19.1	Initial measurement	44
4.19.2	Test procedure	44
4.19.3	Final inspection, measurements and requirements	44
4.20	Container sealing	44
4.21	Climatic sequence	44
4.21.1	General	44
4.21.2	Initial measurements	44
4.21.3	Dry heat	45
4.21.4	Damp heat, cyclic, Test Db, first cycle	45
4.21.5	Cold	45
4.21.6	Low air pressure	45
4.21.7	Damp heat, cyclic, Test Db, remaining cycles	46
4.21.8	Final measurements	46
4.22	Damp heat, steady state	46
4.22.1	Initial measurement	46
4.22.2	Test procedure	46
4.22.3	Final inspection, measurements and requirements	46
4.23	Endurance	46
4.23.1	Initial measurements	46
4.23.2	Test procedure	46
4.23.3	Conditions to be prescribed in the relevant specification	47
4.23.4	Test voltage	47
4.23.5	Placement in the test chamber	48
4.23.6	Recovery	48
4.23.7	Final inspection, measurements and requirements	48
4.24	Variation of capacitance with temperature	48
4.24.1	Static method	48
4.24.2	Dynamic method	49
4.24.3	Methods of calculation	49
4.25	Storage	51
4.25.1	Storage at high temperature	51
4.25.2	Storage at low temperature	51
4.26	Surge	51
4.26.1	Initial measurement	51
4.26.2	Test procedure	51
4.26.3	Final inspection, measurements and requirements	53
4.26.4	Information to be given in the relevant detail specification	53
4.27	Charge and discharge tests and inrush current test	53
4.27.1	Initial measurement	53
4.27.2	Test procedure	53
4.27.3	Charge and discharge	54
4.27.4	Inrush current	55
4.27.5	Final inspection, measurements and requirements	55
4.28	Pressure relief (for aluminium electrolytic capacitors)	55
4.28.1	General	55
4.28.2	AC test	55

4.28.3	DC test	55
4.28.4	Pneumatic test	55
4.28.5	Final inspection, measurements and requirements	55
4.29	Characteristics at high and low temperature	55
4.29.1	Test procedure	55
4.29.2	Requirements	56
4.30	Thermal stability test	56
4.31	Component solvent resistance	56
4.31.1	Initial measurements	56
4.31.2	Test procedure	56
4.31.3	Final inspection, measurements and requirements	56
4.32	Solvent resistance of marking	56
4.32.1	Test procedure	56
4.32.2	Final inspection, measurements and requirements	57
4.33	Mounting (for surface mount capacitors only)	57
4.33.1	Substrate	57
4.33.2	Wave soldering	57
4.33.3	Reflow soldering	57
4.34	Shear test	60
4.34.1	Test procedure	60
4.34.2	Final inspection, measurements and requirements	60
4.35	Substrate bending test	60
4.35.1	Test procedure	60
4.35.2	Recovery	61
4.35.3	Final inspection and requirements	61
4.36	Dielectric absorption	61
4.36.1	Test procedure	61
4.36.2	Requirement	62
4.37	Damp heat, steady state (for multilayer ceramic capacitors only), accelerated	62
~~4.37.1~~	~~Mounting of capacitors~~	~~62~~
4.37.1	Initial measurements	62
4.37.2	Test methods	62
4.37.3	Test procedures	62
~~4.37.4~~	~~Recovery~~	~~62~~
4.37.4	Final inspection, measurements and requirements	63
4.38	Passive flammability	63
4.38.1	Test procedure	63
4.38.2	Final inspection, measurements and requirements	63
4.39	High surge current test	64
4.39.1	Initial measurements	64
4.39.2	Test procedure	64
4.39.3	Requirements for the charging circuit	64
4.39.4	Nonconforming items	65
4.40	Voltage transient overload (for aluminium electrolytic capacitors with non- solid electrolyte)	65
4.40.1	Initial measurement	65
4.40.2	Test procedure	65
4.40.3	Final inspection, measurements and requirements	66

4.40.4	Conditions to be prescribed in the relevant specification	66
4.41	Whisker growth test.....	67
4.41.1	General	67
4.41.2	Preparation of specimen.....	67
4.41.3	Initial measurement.....	67
4.41.4	Test procedures	67
4.41.5	Test severities	67
4.41.6	Final inspection, measurements and requirements.....	67
Annex A (informative)	Interpretation of sampling plans and procedures as described in IEC 60410 for use within ~~the IECQ system~~ quality assessment systems	68
Annex B (~~normative~~ informative)	Rules for the preparation of detail specifications for capacitors and resistors for electronic equipment for use within ~~the IECQ system~~ quality assessment systems	69
B.1	Drafting.....	69
B.2	Reference standard.....	69
B.3	Circulation	69
Annex C (~~normative~~ informative)	Layout of the first page of a PCP/CQC specification	70
Annex D (~~normative~~ informative)	Requirements for capability approval test report	71
D.1	~~Introduction~~ General.....	71
D.2	~~General~~ Requirements	71
D.3	Summary of test information (for each CQC).....	71
D.4	Measurement record	71
Annex E (informative)	Guide for pulse testing of capacitors.....	72
E.1	~~Introduction~~ Overview.....	72
E.2	Typical capacitor pulse conditions.....	72
E.3	Effect of inductance on pulse testing	73
Annex F (informative)	Guidance for the extension of endurance tests on fixed capacitors.....	75
F.1	~~Introduction~~ Overview.....	75
F.2	Guidelines.....	75
Annex G (normative)	Damp heat, steady state with voltage applied, for metallized film capacitors only	76
G.1	~~Introduction~~ Overview.....	76
G.2	Test procedure.....	76
Annex H (normative)	Accelerated damp heat, steady state, for multilayer ceramic capacitors only	77
H.1	Mounting of capacitors	77
H.2	Initial measurement.....	77
H.3	Test procedure.....	77
H.4	Recovery	77
H.5	Final inspection, measurements and requirements.....	77
Annex Q (~~normative~~ informative)	Quality assessment procedures	78
Q.1	General.....	88
Q.1.1	Scope of this annex	88
Q.1.2	Quality assessment definitions	89
Q.1.3	Rework	89
Q.1.4	Alternative test methods.....	90
Q.1.5	Certified test records of released lots	90
Q.1.6	Unchecked parameters	90

Q.1.7	Delayed delivery	90
Q.1.8	Repair	90
Q.1.9	Registration of approvals.....	91
Q.1.10	Manufacture outside the geographical limits	91
Q.2	Qualification approval (QA) procedures	91
Q.2.1	Eligibility for qualification approval.....	91
Q.2.2	Application for qualification approval	91
Q.2.3	Subcontracting.....	91
Q.2.4	Test procedure for the initial product qualification approval	91
Q.2.5	Granting of qualification approval	91
Q.2.6	Maintenance of qualification approval	92
Q.2.7	Quality conformance inspection.....	92
Q.3	Capability approval (CA) procedures.....	92
Q.3.1	General	92
Q.3.2	Eligibility for capability approval	92
Q.3.3	Application for capability approval	93
Q.3.4	Subcontracting.....	93
Q.3.5	Description of the capability	93
Q.3.6	Demonstration and verification of capability	93
Q.3.7	Granting of capability approval	93
Q.3.8	Maintenance of capability approval.....	93
Q.3.9	Quality conformance inspection.....	93
Q.4	Technology approval (TA) procedure	94
Q.4.1	General	94
Q.4.2	Eligibility for technology approval	94
Q.4.3	Application of technology approval	94
Q.4.4	Subcontracting.....	94
Q.4.5	Description of technology	94
Q.4.6	Demonstration and verification of the technology	94
Q.4.7	Granting of technology approval	95
Q.4.8	Maintenance of technology approval.....	95
Q.4.9	Quality conformance inspection.....	95
Bibliography		96
Figure 1	Reactive power against frequency	22
Figure 2	Relation between category temperature range and applied voltage.....	23
Figure 3	Voltage-proof test circuit.....	30
Figure 4	Schematic diagram of the impedance measuring circuit.....	35
Figure 5	Capacitor mounting arrangement	36
Figure 6	Capacitor mounting arrangement	37
Figure 7	Typical diagram of an absorption oscillator-wavemeter.....	38
Figure 8	Schematic diagram of the measuring circuit	38
Figure 9	Test circuit	40
Figure 10	Test circuit for electrolytic capacitors	48
Figure 11	Relay circuit	52
Figure 12	Thyristor circuit	52
Figure 13	Voltage waveform across capacitor	53

Figure 14 – Voltage and current waveform	54
Figure 15 – Suitable substrate for mechanical tests ~~(may not be suitable for impedance measurements)~~	59
Figure 16 – Suitable substrate for electrical tests	60
Figure 17 – High surge current test	64
Figure 18 – Voltage transient overload test circuit	65
Figure 19 – Voltage waveform	66
~~Figure Q.1 – General scheme for capability approval~~	~~66~~
Table 1 – Referee conditions	26
Table 2 – Measurement of insulation resistance	27
Table 3 – Measuring points	29
Table 4 – Tensile force	40
Table 5 – Torque	41
Table 6 – Number of cycles	46
Table 7 – Severities and requirements	63

IECNORM.COM : Click to view the full PDF of IEC 60384-1:2016 RLV

INTERNATIONAL ELECTROTECHNICAL COMMISSION

FIXED CAPACITORS FOR USE IN ELECTRONIC EQUIPMENT –**Part 1: Generic specification****FOREWORD**

- 1) The International Electrotechnical Commission (IEC) is a worldwide organization for standardization comprising all national electrotechnical committees (IEC National Committees). The object of IEC is to promote international co-operation on all questions concerning standardization in the electrical and electronic fields. To this end and in addition to other activities, IEC publishes International Standards, Technical Specifications, Technical Reports, Publicly Available Specifications (PAS) and Guides (hereafter referred to as "IEC Publication(s)"). Their preparation is entrusted to technical committees; any IEC National Committee interested in the subject dealt with may participate in this preparatory work. International, governmental and non-governmental organizations liaising with the IEC also participate in this preparation. IEC collaborates closely with the International Organization for Standardization (ISO) in accordance with conditions determined by agreement between the two organizations.
- 2) The formal decisions or agreements of IEC on technical matters express, as nearly as possible, an international consensus of opinion on the relevant subjects since each technical committee has representation from all interested IEC National Committees.
- 3) IEC Publications have the form of recommendations for international use and are accepted by IEC National Committees in that sense. While all reasonable efforts are made to ensure that the technical content of IEC Publications is accurate, IEC cannot be held responsible for the way in which they are used or for any misinterpretation by any end user.
- 4) In order to promote international uniformity, IEC National Committees undertake to apply IEC Publications transparently to the maximum extent possible in their national and regional publications. Any divergence between any IEC Publication and the corresponding national or regional publication shall be clearly indicated in the latter.
- 5) IEC itself does not provide any attestation of conformity. Independent certification bodies provide conformity assessment services and, in some areas, access to IEC marks of conformity. IEC is not responsible for any services carried out by independent certification bodies.
- 6) All users should ensure that they have the latest edition of this publication.
- 7) No liability shall attach to IEC or its directors, employees, servants or agents including individual experts and members of its technical committees and IEC National Committees for any personal injury, property damage or other damage of any nature whatsoever, whether direct or indirect, or for costs (including legal fees) and expenses arising out of the publication, use of, or reliance upon, this IEC Publication or any other IEC Publications.
- 8) Attention is drawn to the Normative references cited in this publication. Use of the referenced publications is indispensable for the correct application of this publication.
- 9) Attention is drawn to the possibility that some of the elements of this IEC Publication may be the subject of patent rights. IEC shall not be held responsible for identifying any or all such patent rights.

This redline version of the official IEC Standard allows the user to identify the changes made to the previous edition. A vertical bar appears in the margin wherever a change has been made. Additions are in green text, deletions are in strikethrough red text.

International Standard IEC 60384-1 has been prepared by IEC technical committee 40: Capacitors and resistors for electronic equipment

This fifth edition cancels and replaces the fourth edition published in 2008 and constitutes a technical revision, including minor revisions related to tables, figures and references.

This edition contains the following significant technical changes with respect to the previous edition:

- INTRODUCTION added;
- 4.41 Whisker growth test added;
- Annex Q completely restructured.

The text of this standard is based on the following documents:

FDIS	Report on voting
40/2420/FDIS	40/2444/RVD

Full information on the voting for the approval of this standard can be found in the report on voting indicated in the above table.

A list of all the parts of the IEC 60384 series, under the general title *Fixed capacitors for use in electronic equipment*, can be found on the IEC website.

This publication has been drafted in accordance with the ISO/IEC Directives, Part 2.

The committee has decided that the contents of this publication will remain unchanged until the stability date indicated on the IEC website under "<http://webstore.iec.ch>" in the data related to the specific publication. At this date, the publication will be

- reconfirmed,
- withdrawn,
- replaced by a revised edition, or
- amended.

IMPORTANT – The “colour inside” logo on the cover page of this publication indicates that it contains colours which are considered to be useful for the correct understanding of its contents. Users should therefore print this publication using a colour printer.

INTRODUCTION

The specification system for fixed capacitors for use in electronic equipment is structured in a hierarchical system consisting of the following specification types.

Generic specification

The generic specification covers all subjects mainly common to the family of fixed capacitors for use in electronic equipment, such as terminology, methods of measurement and tests. Where the individual subjects require the prescription conditions or parameters specific to the particular subfamily or type of fixed capacitor, such prescriptions are required to be given by one of the subordinate specifications.

For the scope of fixed capacitors, the numeric reference to the generic specification is IEC 60384-1.

Sectional specification

Sectional specifications cover all subjects additional to those given in the generic specification, which are specific to a defined sub-group of fixed capacitors. These subjects normally are preferred values for dimensions and characteristics, additional test methods and relevant prescriptions for test methods given in the generic specification, prescriptions for sampling and for the preparation of specimen, recommended test severities and preferred acceptance criteria. The sectional specification also outlines the structure and scope of the test schedules which are to be applied in all subordinate detail specifications.

For the scope of fixed capacitors, the numeric references to the sectional specifications reach from IEC 60384-2 for polyester film capacitors to currently IEC 60384-26 for aluminium electrolytic capacitors with conductive polymer solid electrolyte. The variety of sectional specifications may be adapted to the portfolio of different technologies of fixed capacitors.

Detail specification

Detail specifications give directly, or by making reference to other specifications, all information necessary to completely describe a given type and range of fixed capacitors, including prescriptions of all values for dimensions and characteristics. They also give all information required for the quality assessment of the covered type and range of fixed capacitors within a suitable quality assessment system, including prescriptions for all applied test severities and acceptance criteria, and the completed test schedules.

Detail specifications can be either specifications within the IEC system, another specification system linked to IEC, or specified by the manufacturer or user. For the scope of fixed capacitors, the numeric references to detail specifications are for example IEC 60384-3-101, if related to the sectional specification IEC 60384-3 and to the ancillary blank detail specification IEC 60384-3-1.

Blank detail specification

The hierarchical system of specifications is supplemented by one or more blank detail specifications to a sectional specification, which are used to ensure a uniform presentation of detail specifications. The blank detail specifications provide the specification writer with a template on the layout to be adopted and on the information to be given and with guidance for the preparation of detail specifications in line with the requirements of the superior generic or sectional specifications. Blank detail specifications are not considered as relevant specifications since they do not themselves describe any particular component.

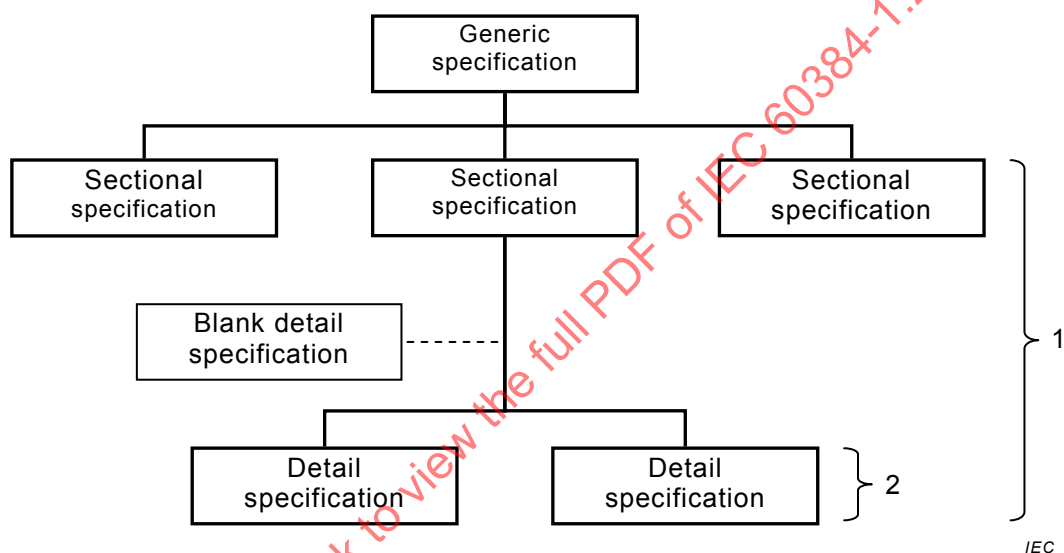
The presence of an established hierarchical specification system with blank detail specifications permits the preparation of detail specifications even outside of the relevant IEC technical committee.

For the scope of fixed capacitors, the numeric references to blank detail specifications are, for example, IEC 60384-3-1, if related to the sectional specification IEC 60384-3.

Relevant specification

In this system the term “relevant specification” addresses subordinate specifications containing specific requirements, where applicable.

Any generic or sectional specification may use abstract and universal references to subordinate specifications of either hierarchical level by use of the expression “relevant specification”.



Key

- 1 Indicates the range of “*Relevant specifications*” to the superior generic specification, where applicable.
- 2 Indicates the range of “*Relevant specifications*” to the superior sectional specification, where applicable.

FIXED CAPACITORS FOR USE IN ELECTRONIC EQUIPMENT –

Part 1: Generic specification

1 General

1.1 Scope

This part of IEC 60384 is a generic specification and is applicable to fixed capacitors for use in electronic equipment.

It establishes standard terms, inspection procedures and methods of test for use in sectional and detail specifications of electronic components for quality assessment or any other purpose.

1.2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

IEC 60027 (all parts), *Letter symbols to be used in electrical technology*

IEC 60050 (all parts), *International Electrotechnical Vocabulary* ~~(IEV)~~¹

IEC 60062, *Marking codes for resistors and capacitors*

IEC 60063, *Preferred number series for resistors and capacitors*

IEC 60068-1:1988 2013, *Environmental testing – Part 1: General and guidance*

IEC 60068-2-1:2007, *Environmental testing – Part 2-1: Tests – Tests A: Cold*

IEC 60068-2-2:2007, *Environmental testing – Part 2-2: Tests – Tests B: Dry heat*

IEC 60068-2-6:2007, *Environmental testing – Part 2-6: Tests – Test Fc: Vibration (sinusoidal)*

IEC 60068-2-13:1983, *Environmental testing – Part 2-13: Tests – Test M: Low air pressure*

IEC 60068-2-14:1984 2009, *Environmental testing – Part 2-14: Tests – Test N: Change of temperature*

IEC 60068-2-17:1994, *Environmental testing – Part 2-17: Tests – Test Q: Sealing*

IEC 60068-2-20:1979 2008, *Environmental testing – Part 2-20: Tests – Test T: ~~Soldering~~ Test methods for solderability and resistance to soldering heat of devices with leads*

IEC 60068-2-21:2006, *Environmental testing – Part 2-21: Tests – Test U: Robustness of terminations and integral mounting devices*

¹ www.electropedia.org

IEC 60068-2-27:2008, *Environmental testing – Part 2-27: Tests – Test Ea and guidance: Shock*

~~IEC 60068-2-29:1987, *Environmental testing – Part 2-29: Tests – Test Eb and guidance: Bump*~~

IEC 60068-2-30:2005, *Environmental testing – Part 2-30: Tests – Test Db: Damp heat, cyclic (12 h + 12 h cycle)*

IEC 60068-2-45:1980, *Environmental testing – Part 2-45: Tests – Test XA and guidance: Immersion in cleaning solvents*

IEC 60068-2-45:1980/AMD1:1993

IEC 60068-2-54:2006, *Environmental testing – Part 2-54: Tests – Test Ta: Solderability testing of electronic components by the wetting balance method*

IEC 60068-2-58:2004 2015, *Environmental testing – Part 2-58: Tests – Test Td: Test methods for solderability, resistance to dissolution of metallization and to soldering heat of surface mounting devices (SMD)*

IEC 60068-2-67:1995, *Environmental testing – Part 2-67: Tests – Test Cy: Damp heat, steady state, accelerated test primarily intended for components*

IEC 60068-2-69:2007, *Environmental testing – Part 2-69: Tests – Test Te: Solderability testing of electronic components for surface mounting devices (SMD) by the wetting balance method*

IEC 60068-2-78:2004 2012, *Environmental testing – Part 2-78: Tests – Test Cab: Damp heat, steady state*

IEC 60068-2-82:2007, *Environmental testing – Part 2-82: Tests – Test XW1: Whisker test methods for electronic and electric components*

IEC 60294, *Measurement of the dimensions of a cylindrical component having two with axial terminations*

~~IEC 60410:1973, *Sampling plans and procedures for inspection by attributes*~~

IEC 60617, *Graphical symbols for diagrams*

IEC 60695-11-5:2004, *Fire hazard testing – Part 11-5: Test flames – Needle-flame test method – Apparatus, confirmatory test arrangement and guidance*

IEC 60717, *Method for the determination of the space required by capacitors and resistors with unidirectional terminations*

IEC 61193-2, *Quality assessment systems – Part 2: Selection and use of sampling plans for inspection of electronic components and packaging packages*²

IEC 61249-2-7:2002, *Materials for printed boards and other interconnecting structures – Part 2-7: Reinforced base materials clad and unclad – Epoxide woven E-glass laminated sheet of defined flammability (vertical burning test), copper-clad*

² ~~To be published.~~

~~IEC QC 001002-3, Rules of Procedure – Part 3: Approval procedures~~

ISO 3, Preferred numbers – Series of preferred numbers

~~ISO 1000, SI units and recommendations for the use of their multiples and of certain other units~~

~~ISO 9000, Quality management systems – Fundamentals and vocabulary~~

ISO 80000-1, Quantities and units – Part 1: General

2 Technical data

2.1 Symbols, units and abbreviated terms

2.1.1 General

Units, graphical symbols and letter symbols should, whenever possible, be taken from the following publications:

- IEC 60027 (series);
- IEC 60050 (series);
- IEC 60617;
- ISO ~~1000~~ 80000-1.

When further items are required, they should be derived in accordance with the principles of the publications listed above.

2.1.2 Letter symbols

C_N	Nominal capacitance
DA	Dielectric Absorption
du/dt	Pulse handling capability
f_r	Self-resonant frequency
I_{leak}	leakage current
k_0	Maximum permissible pulse characteristics
L	Self-inductance
R_{INS}	Insulation resistance
T_A	Lower category temperature
$\tan \delta$	Tangent of loss angle
T_B	Upper category temperature
T_C	Category temperature
T_{op}	Operating temperature

T_R	Rated temperature
U_C	Category voltage
U_{op}	Operating voltage
U_R	Rated voltage
U_{RS}	Surge voltage
Z	Impedance
α	Temperature coefficient of capacitance
τ	$= C_N \times R_{INS}$ Time constant

2.1.3 Abbreviations

CA	Capability Approval
CB	Certification Body
CQC	Capability Qualifying Components
DMR	Designated Management Representative
ESR	Equivalent Series Resistance
IPA	Isopropyl alcohol
PCP	Process Control Plan
QA	Qualifying Approval
SMD	Surface Mount Device
TA	Technology Approval
TADD	Technology Approval Declaration Document

2.2 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

NOTE They have been listed in alphabetical order.

2.2.1

a.c. capacitor

capacitor designed essentially for application with alternating voltages

2.2.2

bipolar capacitor

<electrolytic capacitor> capacitor designed to withstand an alternating voltage and/or reversal of the applied direct voltage

2.2.3**category of passive flammability**

category ~~of passive flammability is given by~~ indicating the maximum burning time after a specified time of flame application

2.2.4**category temperature range**

ambient temperature range for which the capacitor has been designed to operate continuously

Note 1 to entry: ~~this is given~~ The temperature range is limited by the lower and upper category temperature (see 2.2.10 and 2.2.41).

2.2.5**category voltage**

U_C

maximum voltage that ~~may~~ can be applied continuously to a capacitor at its upper category temperature (2.2.41)

2.2.6**d.c. capacitor**

capacitor designed essentially for application with direct voltage

Note 1 to entry: It may not be suitable for use on a.c. supplies.

2.2.7**family**

<electronic components> group of components which predominantly displays a particular physical attribute and/or fulfils a defined function

2.2.8**grade**

term to indicate an additional general characteristic concerning the intended application of the component

2.2.9**insulated capacitor**

capacitor in which all terminations of a section may be raised to a potential different (but not less than the rated voltage) from that of any conducting surface with which the case is liable to come into contact in normal use

2.2.10**lower category temperature**

minimum ambient temperature for which a capacitor has been designed to operate continuously

2.2.11**maximum storage temperature**

maximum ambient temperature which the capacitor withstands in the non-operating condition without damage

2.2.12**maximum temperature of a capacitor**

temperature at the hottest point of its external surface

Note 1 to entry: The terminations are considered to be part of the external surface.

2.2.13**minimum storage temperature**

minimum ambient temperature which the capacitor withstands in the non-operating condition without damage

2.2.14

minimum temperature of a capacitor

temperature at the coldest point of the external surface

Note 1 to entry: The terminations are considered to be part of the external surface.

2.2.15

nominal capacitance

C_N

designated capacitance value, usually indicated on the capacitor

2.2.16

passive flammability

ability of a capacitor to burn with a flame as a consequence of the application of an external source of heat

2.2.17

polar capacitor

<electrolytic capacitor> capacitor intended for use with a unidirectional voltage connected according to the polarity indication

2.2.18

pulse capacitor

capacitor for use with pulses of current or voltage

Note 1 to entry: The definitions of IEC 60469-1 and IEC 60469-2 apply.

2.2.19

pulse equivalent circuit of a capacitor

equivalent circuit consisting of an ideal capacitor in series with its residual inductance and the equivalent series resistance (ESR)

Note 1 to entry: For pulse operation the equivalent series resistance will be similar to, but not identical with, the ESR measured with a sinusoidal voltage. The pulse ESR ~~should take into account~~ depends on the series of harmonics in the pulse and the variation of the losses with frequency.

2.2.20

rated a.c. load

maximum sinusoidal a.c. load which may be applied continuously to the terminations of a capacitor at any temperature between the lower category temperature (2.2.10) and the rated temperature (2.2.24)

2.2.21

rated pulse load

maximum pulse load which may be applied at a certain pulse repetition frequency to the terminations of a capacitor at any temperature between the lower category temperature (2.2.10) and the rated temperature (2.2.24); ~~it may be expressed as a) and b) and any of the remaining items:~~

- ~~a) peak current per μF or dI/dt ($\text{V}/\mu\text{s}$);~~
- ~~b) relative duration of charge and discharge periods;~~
- ~~c) current;~~
- ~~d) peak voltage;~~
- ~~e) peak reverse voltage;~~
- ~~f) pulse repetition frequency (see note 1);~~
- ~~g) maximum active power.~~

~~These parameters are fixed for periodic pulses.~~

~~NOTE 1 In the case of intermittent pulses, the duty cycle should be specified. In the case of random pulses, the total number expected over a given time period should be stated.~~

~~NOTE 2 The r.m.s. pulse current should be calculated in accordance with IEC 60469-1, 2.5.2.4. In the case of intermittent or random pulses, the time interval should be chosen to correspond with the maximum temperature rise.~~

2.2.22

rated ripple current

r.m.s. value of the maximum allowable alternating current of a specified frequency, at which the capacitor ~~may~~ can be operated continuously at a specified temperature

Note 1 to entry: As the ripple current will generate a ripple voltage across the capacitor, the sum of the direct voltage and the peak value of the alternating voltage applied to the capacitor should not exceed the rated voltage or temperature derated voltage, as applicable.

2.2.23

rated ripple voltage

r.m.s. value of the maximum allowable alternating voltage at a specified frequency superimposed on the d.c. voltage at which the capacitor may be operated continuously at a specified temperature

Note 1 to entry: The sum of the direct voltage and the peak value of the alternating voltage applied to the capacitor should not exceed the rated voltage or temperature derated voltage, as applicable.

2.2.24

rated temperature

maximum ambient temperature at which the rated voltage may be continuously applied

2.2.25

rated voltage

U_R

2.2.25.1

rated d.c. voltage

maximum d.c. voltage which may be applied continuously to a capacitor at the rated temperature (2.2.24)

Note 1 to entry: The maximum d.c. voltage is the sum of the d.c. voltage and peak a.c. voltage or peak pulse voltage applied to the capacitor.

2.2.25.2

rated a.c. voltage

maximum r.m.s. alternating voltage which may be applied continuously to a capacitor at the rated temperature (2.2.24) and at a given frequency

2.2.25.3

rated pulse voltage

peak value of the pulse voltage within a given pulse wave form which may be applied continuously to a capacitor at the rated temperature (2.2.24)

2.2.26

reverse voltage

<polar capacitor> voltage applied to the capacitor terminations in the reverse polarity direction

Note 1 to entry: Reverse voltage applies to polar capacitors only.

2.2.27

self-healing

process by which the electrical properties of the capacitor, after a local breakdown of the dielectric, are rapidly and essentially restored to the values before the breakdown

2.2.28

style

subdivision of a type (2.2.39), generally based on dimensional factors, which may include several variants, generally of a mechanical order

2.2.29

subfamily

<electronic components> group of components within a family (2.2.7) manufactured by similar technological methods

2.2.30

surface mount capacitor

fixed capacitor whose small dimensions and nature or shape of terminations make it suitable for use in hybrid circuits and on printed boards

2.2.31

surge voltage ratio

quotient of the maximum instantaneous voltage which ~~may~~ can be applied to the terminations of the capacitor for a specified time at any temperature within the category temperature range (2.2.4) and the rated voltage (2.2.25) or the temperature derated voltage (2.2.36), as appropriate

~~NOTE The number of times per hour that this voltage may be applied should be specified.~~

2.2.32

tangent of loss angle

$\tan \delta$

power loss of the capacitor divided by the reactive power of the capacitor at a sinusoidal voltage at a specified frequency

2.2.33

temperature characteristics of capacitance

maximum variation of capacitance produced over a given temperature range within the category temperature range, ~~normally expressed as a percentage of the capacitance related to a reference temperature of 20 °C (2.2.4)~~

Note 1 to entry: The term characterizing this property applies mainly to capacitors of which the variations of capacitance as a function of temperature, linear or non-linear, cannot be expressed with precision and certainty.

Note 2 to entry: This characteristic is normally expressed as a percentage of the capacitance related to a reference temperature of 20 °C.

2.2.34

temperature coefficient of capacitance

α

rate of change of capacitance with temperature measured over a specified range of temperature

Note 1 to entry: The term characterizing this property applies to capacitors of which the variations of capacitance as a function of temperature are linear or approximately linear and can be expressed with a certain precision.

Note 2 to entry: This coefficient is normally expressed in parts per million per Kelvin ($10^{-6}/K$).

2.2.35

temperature cyclic drift of capacitance

maximum irreversible variation of capacitance observed at room temperature during or after the completion of a number of specified temperature cycles

Note 1 to entry: The term characterizing this property applies to capacitors of which the variations of capacitance as a function of temperature are linear or approximately linear and can be expressed with a certain precision.

Note 2 to entry: ~~The conditions of measurement, during or after temperature cycling, a description of the temperature cycle and the number of cycles, should be stated.~~ This drift is normally expressed as a percentage of the capacitance related to a reference temperature, usually 20 °C.

2.2.36

temperature derated voltage

maximum voltage that may be applied continuously to a capacitor, when it is at any temperature between the rated temperature (2.2.24) and the upper category temperature (2.2.41)

Note 1 to entry: Refer to 2.3.6.

2.2.37

temperature rise

temperature rise of the capacitor relative to the ambient temperature resulting from the losses in the capacitor due to operation under a.c., pulse or charge/discharge conditions

2.2.38

time constant

τ

product of the insulation resistance and the capacitance,

Note 1 to entry: The time constant is normally expressed in seconds.

2.2.39

type

group of components having similar design features and manufacturing techniques, enabling them to be considered together, either for qualification approval or for quality conformance inspection

Note 1 to entry: These components are generally covered by a single detail specification.

Note 2 to entry: Components described in several detail specifications, may, in some cases, be considered as belonging to the same type.

2.2.40

uninsulated capacitor

capacitor in which one or more of the terminations of a section cannot be raised to a potential different (but not less than the rated voltage) from that of any conducting surface with which the case is liable to come into contact in normal use

2.2.41

upper category temperature

maximum ambient temperature for which a capacitor has been designed to operate continuously

2.2.42

~~variation of capacitance with temperature~~

~~variation of capacitance with temperature expressed either as the temperature characteristics of capacitance or as the temperature coefficient of capacitance~~

2.2.42

visible damage

visible damage which reduces the usability of the capacitor for its intended purpose

2.3 Preferred values and additional technical requirements

2.3.1 General

Each sectional specification shall prescribe the preferred values appropriate to the subfamily; for nominal capacitance, see also 2.3.2.

2.3.2 Preferred values of nominal capacitance

The preferred values of nominal capacitance shall be taken from the series specified in IEC 60063.

2.3.3 Preferred values of rated voltage

The preferred values of the rated voltage are the values of the R10 series of ISO 3: 1,0 – 1,25 – 1,6 – 2,0 – 2,5 – 3,15 – 4,0 – 5,0 – 6,3 – 8,0 and their decimal multiples ($\times 10^n$, n : integer).

2.3.4 Rated a.c. load

The rated a.c. load may be expressed:

- a) at low frequencies as a rated a.c. voltage;
- b) at high frequencies as a rated a.c. current;
- c) at intermediate frequencies as a rated reactive power (var).

This is shown in Figure 1.

NOTE 1 For a particular type of capacitor, it may be necessary to specify one or more of the above characteristics.

NOTE 2 Capacitors within the scope of this standard are normally less than 500 var at 50 Hz to 60 Hz. Low frequencies may be 50 Hz to 60 Hz, 100 Hz to 120 Hz, or 400 Hz. Voltages may be up to 600 V r.m.s. at 50 Hz to 60 Hz. However, capacitors for filters, transmitter or converter circuits may be required to operate under power over a wide range of frequencies and up to 10 kvar at the higher frequencies with voltages up to 1 000 V r.m.s.

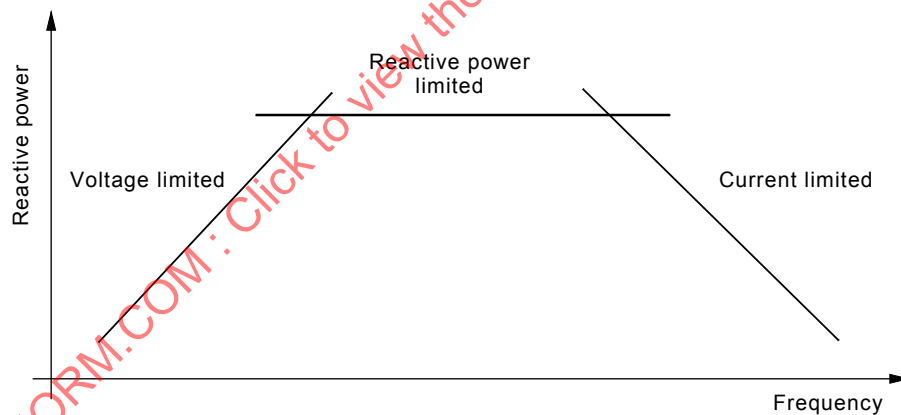


Figure 1 – Reactive power against frequency

2.3.5 Rated pulse load

The rated pulse load may be expressed as a) and b) and any of the remaining items:

- a) peak current per μF or du/dt ($\text{V}/\mu\text{s}$);
- b) relative duration of charge and discharge periods;
- c) current;
- d) peak voltage;
- e) peak reverse voltage;
- f) pulse repetition frequency;

g) maximum active power.

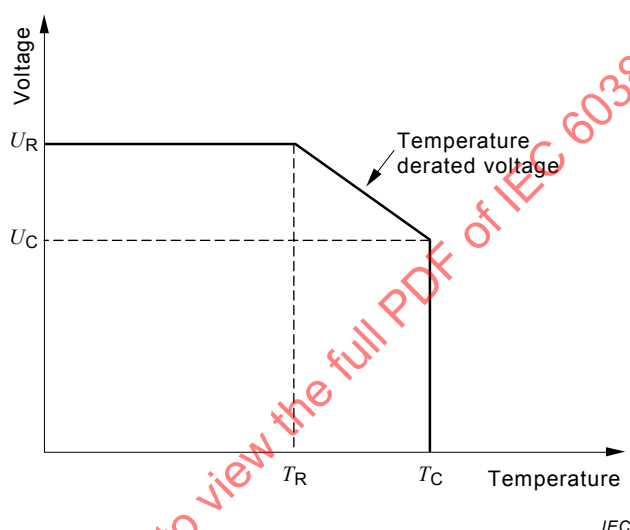
These parameters are fixed for periodic pulses.

In the case of intermittent pulses, the duty cycle should be specified. In the case of random pulses, the total number expected over a given time period should be stated.

The r.m.s. pulse current should be calculated in accordance with IEC 60469:2013, 3.2.17.5. In the case of intermittent or random pulses, the time interval should be chosen to correspond to the maximum temperature rise.

2.3.6 Temperature derated voltage

NOTE Information on the voltage/temperature dependence at temperatures between the rated temperature and the upper category temperature should, if applicable, be given in the relevant specification (see Figure 2).



Key

- U_R is the rated voltage
- U_C is the category voltage
- T_R is the rated temperature
- T_C is the category temperature

Figure 2 – Relation between category temperature range and applied voltage

2.4 Marking

2.4.1 General

The sectional specification shall indicate the identification criteria and other information to be shown on the capacitor and/or packaging.

The order of priority for marking small capacitors shall be specified.

2.4.2 Coding

When coding is used for capacitance value, tolerance or date of manufacture, the method shall be selected from those given in IEC 60062.

3 Quality assessment procedures

~~When this standard and related standards are used for the purpose of a full quality assessment system such as IEC Quality Assessment System for Electronic Components (IECQ), the relevant clauses of Annex Q apply.~~

~~NOTE Clause 3 has been moved to Annex Q. To maintain reference to previous editions of this standard, the clause numbers of Clause 3 have been converted into the clause numbers of Annex Q as shown by the following examples:~~

~~Clause 3.1 → Clause Q.1
Clause 3.1.2 → Clause Q.1.2~~

See Annex Q.

4 Tests and measurement procedures

General information on test and measurement procedures	Subclause
General	4.1
Standard atmospheric conditions	4.2
Drying	4.3
Storage	4.25
Mounting (for surface mount capacitors only)	4.33
Electrical tests and measurements	
Insulation resistance	4.5
Voltage proof	4.6
Capacitance	4.7
Tangent of loss angle and equivalent series resistance (ESR)	4.8
Leakage current	4.9
Impedance	4.10
Self-resonant frequency and inductance	4.11
Variation of capacitance with temperature	4.24
Surge	4.26
High surge current test	4.39
Charge and discharge tests and inrush current test	4.27
Dielectric absorption	4.36
Voltage transient overload (for aluminium electrolytic capacitors with non-solid electrolyte)	4.40
Mechanical tests and measurements	
Visual examination and check of dimensions	4.4
Outer foil termination	4.12
Robustness of terminations	4.13
Vibration	4.17
Bump (repetitive shock)	4.18
Shock	4.19
Container sealing	4.20
Shear test	4.34
Substrate bending test	4.35
Environmental and climatic tests	
Rapid change of temperature	4.16
Climatic sequence	4.21
Damp heat, steady state	4.22
Endurance	4.23
Characteristics at high and low temperature	4.29
Thermal stability test	4.30

Damp heat, steady state ~~(for multilayer ceramic capacitors only)~~ , accelerated	4.37
---	------

Tests related to component assembly

Resistance to soldering heat	4.14
Solderability	4.15
Component solvent resistance	4.31
Solvent resistance of marking	4.32
Whisker growth test	4.41

Test related to safety

Pressure relief (for aluminium electrolytic capacitors)	4.28
Passive flammability	4.38

4.1 General

The sectional and/or blank detail specification shall indicate the tests to be made, which measurements are to be made before and after each test or subgroup of tests, and the sequence in which they shall be made. The stages of each test shall be carried out in the order written. The measuring conditions shall be the same for initial and final measurements.

If national specifications within any quality assessment system include methods other than those specified in the above specifications, they shall be fully described.

Limits given in all specifications are absolute limits. The principle to take measurement uncertainty into account shall be applied ~~(see IEC QC 001002-3, Annex C to Clause 2)~~.

4.2 Standard atmospheric conditions

4.2.1 Standard atmospheric conditions for testing

Unless otherwise specified, all tests and measurements shall be carried out under standard atmospheric conditions for testing as given in IEC 60068-1:2013, 4.3:

- temperature: 15 °C to 35 °C;
- relative humidity: 25 % to 75 %;
- air pressure: 86 kPa to 106 kPa.

Before the measurements are made, the capacitor shall be stored at the measuring temperature for a time sufficient to allow the entire capacitor to reach this temperature. The period as prescribed for recovery at the end of a test is normally sufficient for this purpose.

When measurements are made at a temperature other than the specified temperature, the results shall, where necessary, be corrected to the specified temperature. The ambient temperature during the measurements shall be stated in the test report. In the event of a dispute, the measurements shall be repeated using one of the referee temperatures (as given in 4.2.3) and such other conditions as are prescribed in this standard.

When tests are conducted in a sequence, the final measurements of one test may be taken as the initial measurements for the succeeding test.

During measurements the capacitor shall not be exposed to draughts, direct sunlight or other influences likely to cause error.

4.2.2 Recovery conditions

Unless otherwise specified recovery shall take place under the standard atmospheric conditions for testing (4.2.1).

If recovery under closely controlled conditions is necessary, the controlled recovery conditions of IEC 60068-1:2013, 4.4.2, shall be used.

Unless otherwise specified in the relevant specification, a duration of 1 h to 2 h shall be used.

The definition of recovery is as given in IEC 60068-1:2013, 3.4, being further restricted for capacitors as follows:

When a recovery period is specified as, for example, 1 h to 2 h, this means that measurement (or other subsequent action) on a batch of capacitors may start after 1 h and shall be completed before 2 h from the beginning of the recovery period.

The preferred method of specifying a recovery period is in the form "x h to y h".

4.2.3 Referee conditions

For referee purposes, one of the standard atmospheric conditions for referee tests taken from IEC 60068-1:2013, 4.2, as given in Table 1 below, shall be selected.

Table 1 – Referee conditions

Temperature	Relative humidity	Air pressure
°C	%	kPa
20 ± 1	63 to 67	86 to 106
23 ± 1	48 to 52	86 to 106
25 ± 1	48 to 52	86 to 106
27 ± 1	63 to 67	86 to 106

4.2.4 Reference conditions

For reference purposes, the standard atmospheric conditions for reference given in IEC 60068-1:2013, 4.1, apply:

- temperature: 20 °C;
- air pressure: 101,3 kPa.

4.3 Drying

Unless otherwise specified in the relevant specification, the capacitor shall be conditioned for 96 h ± 4 h by heating in a circulating air oven at a temperature of 55 °C ± 2 °C and a relative humidity not exceeding 20 %.

The capacitor shall then be allowed to cool in a desiccator using a suitable desiccant, such as activated alumina or silica gel, and shall be kept therein from the time of removal from the oven to the beginning of the specified tests.

4.4 Visual examination and check of dimensions

4.4.1 Visual examination

The condition, workmanship and finish shall be satisfactory, as checked by visual examination (see 2.2.42).

Marking shall be legible, as checked by visual examination and shall conform with the requirements of the detail specification.

4.4.2 Dimensions (gauging)

The dimensions indicated in the detail specification as being suitable for gauging shall be checked, and shall comply with the values prescribed in the detail specification.

When applicable, measurements shall be made in accordance with IEC 60294 or IEC 60717.

4.4.3 Dimensions (detail)

All dimensions prescribed in the detail specification shall be checked and shall comply with the values prescribed.

4.5 Insulation resistance

4.5.1 Preconditioning

Before this measurement is made, the capacitors shall be fully discharged.

4.5.2 Measuring conditions

Unless otherwise specified in the relevant specification, the insulation resistance shall be measured at the voltage specified in Table 2.

The insulation resistance shall be measured after the voltage has been applied for $60 \text{ s} \pm 5 \text{ s}$, unless otherwise prescribed in the detail specification.

Table 2 – Measurement of insulation resistance

Voltage rating of capacitor V	Measuring voltage V
U_R or $U_c < 10$	U_R or $U_c \pm 10 \%$
$10 \leq U_R$ or $U_c < 100$	10 ± 1^a
$100 \leq U_R$ or $U_c < 500$	100 ± 15
$500 \leq U_R$ or U_c	500 ± 50
^a When it can be demonstrated that the voltage has no influence on the measuring result, or that a known relationship exists, measurements can be performed at voltages up to the rated or category voltage. In case of dispute, 10 V shall be used, unless otherwise specified in the sectional specification.	

U_R is the rated voltage for use in defining the measuring voltage to be used under standard atmospheric conditions for testing.

U_c is the category voltage for use in defining the measuring voltage to be used at the upper category temperature.

4.5.3 Test points

The insulation resistance shall be measured between the measuring points defined in Table 3, specified in the relevant specification.

Test A, between terminations, applies to all capacitors, whether insulated or not.

Test B, internal insulation, applies to insulated capacitors in uninsulated metal cases and to insulated and uninsulated multiple section capacitors.

Test C, external insulation, applies to insulated capacitors in non-metallic cases or in insulated metal cases. For this test, the measuring voltage shall be applied using one of the three following methods as specified in the relevant specification:

4.5.4 Test methods

4.5.4.1 Foil method

A metal foil shall be closely wrapped around the body of the capacitor.

For capacitors with axial terminations this foil shall extend beyond each end by not less than 5 mm, provided that a minimum distance of 1 mm can be maintained between the foil and the terminations. If this minimum distance cannot be maintained, the extension of the foil shall be reduced by as much as is necessary to establish the distance of 1 mm.

For capacitors with unidirectional terminations, a minimum distance of 1 mm shall be maintained between the edge of the foil and each termination.

4.5.4.2 Method for capacitors with mounting devices

The capacitor shall be mounted in its normal manner on a metal plate, which extends at least 12,7 mm in all directions beyond the mounting face of the capacitor.

4.5.4.3 V-block method

The capacitor shall be clamped in the trough of a 90° metallic V-block of such size that the capacitor body does not extend beyond the extremities of the block.

The clamping force shall be such as to guarantee adequate contact between the capacitor and the block.

The capacitor shall be positioned in accordance with the following:

- a) for cylindrical capacitors: the capacitor shall be positioned in the block so that the termination furthest from the axis of the capacitor is nearest to one of the faces of the block;
- b) for rectangular capacitors: the capacitor shall be positioned in the block so that the termination nearest the edge of the capacitor is nearest to one of the faces of the block.

For cylindrical and rectangular capacitors having axial terminations any out-of-centre positioning of the terminations at their emergence from the capacitor body shall be ignored.

4.5.5 Temperature compensation

When prescribed in the detail specification, the temperature at which the measurement is made shall be noted. If this temperature differs from 20 °C, a correction shall be made to the measured value by multiplying the value by the appropriate correction factor prescribed in the sectional specification.

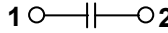
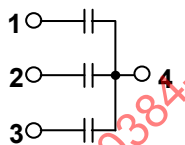
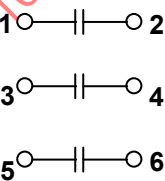
4.5.6 Conditions to be prescribed in the relevant specification

The relevant specification shall prescribe:

- a) the measuring points and the measuring voltage corresponding to each of these test points;
- b) the method of applying the voltage (one of the methods described in 4.5.4);
- c) time of electrification if other than 1 min;
- d) any special precautions to be taken during measurements;

- e) any correction factors required for measurement over the range of temperatures covered by the standard atmospheric conditions for testing;
- f) the temperature of measurement if other than the standard atmospheric conditions for testing;
- g) the minimum value of insulation resistance for the various measuring points (see Table 3).

Table 3 – Measuring points

Test	Applicable to:	1: Single-section capacitors e.g. 	2: Multiple-section capacitors having common termination for all sections e.g. 	3: Multiple-section capacitors having no common termination e.g. 
A. Between terminations ^a	All capacitors	1a: Between terminations (1-2)	2a: Between each of the terminations and the common termination (1-4, 2-4, 3-4)	3a: Between terminations of each section (1-2, 3-4, 5-6)
B. Internal insulation	Insulated single- and multiple-section capacitors in uninsulated metal cases (1b, 2b, 3b)	1b: Between terminations connected together and the case [(1 to 2)- case]	2b: Between all terminations connected together and the case [(1 to 4)- case]	3b: Between all terminations connected together and the case [(1 to 6)- case]
	Insulated and uninsulated multiple-section capacitors (2c and 3c)		2c: Between the non-common termination of each section and all the other terminations connected together e.g. [2-(1, 3, 4)]	3c: Between the terminations of separate sections, the two terminations of each section being connected together e.g. [(1 to 2)-(3 to 6)]
C. External insulation	Insulated capacitors in non-metallic cases or in insulated metal cases	1c: Between the two terminations connected together and, as appropriate, the metal foil, the metal plate or the metal V-block [(1 to 2)-metal jig]	2d: [(1 to 4)-metal jig]	3d: [(1 to 6)-metal jig]
			Between all terminations connected together and, as appropriate: the metal foil, the metal plate or the metal V-block	

^a Where a capacitor has more than two terminations, the measuring points are the two terminations which are insulated from one another by the capacitor's element dielectric. For example, for a coaxial lead-through capacitor, the measuring points should be one of the terminations connected to the central conductor and the coaxial metal case or mounting face.

4.6 Voltage proof

4.6.1 General

The test prescribed below is a d.c. test. When ~~the relevant specification prescribes~~ an a.c. test ~~is applied~~, the test circuit shall be prescribed ~~by that in the relevant specification~~.

4.6.2 Test circuit (for the test between terminations)

The test circuit elements shall be selected in such a way as to ensure that the conditions relating to the charging and discharging currents and the time constant for charging, prescribed in the relevant specification, are maintained.

Figure 3 specifies the characteristics of a suitable test circuit.

The resistance of the voltmeter shall be not less than 10 000 Ω/V .

The resistor R_1 includes the internal resistance of the voltage source.

The resistors R_1 and R_2 shall have a value sufficient to limit the charging and discharging current to the value prescribed in the relevant specification.

The capacitance of capacitor C_1 shall be not less than 10 times the capacitance of the capacitor under test.

If applicable, the time constant $R_1 \times (C_X + C_1)$ shall be less than, or equal to, the value prescribed in the relevant specification.

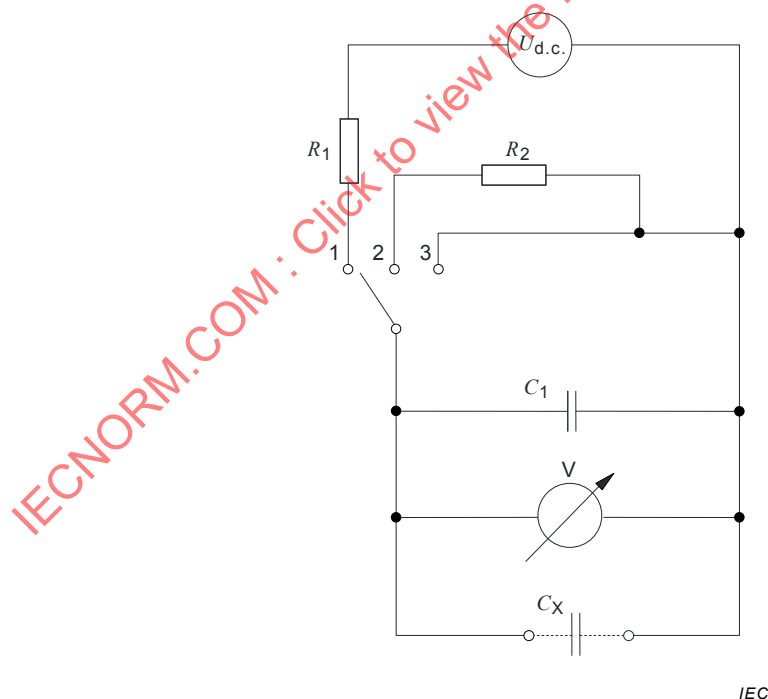


Figure 3 – Voltage-proof test circuit

NOTE The capacitor C_1 may be omitted for the testing of certain types of capacitors. This should be stated in the sectional specification.

4.6.3 Test

4.6.3.1 General

Depending on the case, the test comprises one or more parts in accordance with Table 3 and the requirements of the relevant specification.

Repeated application of the voltage proof test may cause permanent damage to the capacitor and should be avoided as far as possible.

4.6.3.2 Test A – Between terminations

4.6.3.2.1 Test points

The test voltage is applied to 1a, 2a, 3a of Table 3 in accordance with the requirements of the relevant specification.

4.6.3.2.2 Procedure

With the switch in position 2, connect the two terminals in Figure 3 to a variable d.c. supply of sufficient power adjusted to the required test voltage.

Connect the capacitor to be tested (C_X) to the test circuit as indicated in Figure 3.

Move the switch to position 1 so as to charge capacitors C_1 and C_X via R_1 .

The switch remains in this position for the time specified after the test voltage has been reached.

Discharge the capacitors C_1 and C_X through R_2 by moving the switch to position 2. As soon as the voltmeter reading has fallen to zero, short-circuit the capacitors by moving the switch to position 3 and disconnect the capacitor C_X .

4.6.3.3 Test B – Internal insulation

4.6.3.3.1 Test points

The test voltage is applied to 1b, 2b, 2c, 3b, 3c of Table 3 in accordance with the requirements of the relevant specification.

4.6.3.3.2 Procedure

The specified test voltage is applied instantaneously via the internal resistance of the power supply for the time specified in the relevant specification. For point 2c use the test circuit and the procedure indicated for the test between terminations (4.6.2 and 4.6.3.2).

4.6.3.4 Test C – External insulation (applicable only to insulated capacitors in a non-metallic case or in an insulated metal case)

4.6.3.4.1 Test points

The test voltage is applied to 1c, 2d or 3d, using one of the three following methods for the application of the voltage in accordance with the requirements of the relevant specification.

4.6.3.4.2 Foil method

A metal foil shall be closely wrapped around the body of the capacitor.

For capacitors with axial terminations this foil shall extend beyond each end by not less than 5 mm, provided that a minimum distance of 1 mm/kV can be maintained between the foil and the terminations. If this minimum cannot be maintained, the extension of the foil shall be reduced by as much as is necessary to establish the distance of 1 mm/kV of test voltage.

For capacitors with unidirectional terminations, a minimum distance of 1 mm/kV shall be maintained between the edge of the foil and each termination.

In no case shall the distance between the foil and the terminations be less than 1 mm.

4.6.3.4.3 Method for capacitors with mounting devices

The capacitor shall be mounted in its normal manner on a metal plate which extends by not less than 12,7 mm in all directions beyond the mounting face of the capacitor.

4.6.3.4.4 V-block method

The capacitor shall be clamped in the trough of a 90° metallic V-block of such a size that the capacitor body does not extend beyond the extremities of the block.

The clamping force shall be such as to guarantee adequate contact between the capacitor and the block.

The capacitor shall be positioned as follows:

- a) for cylindrical capacitors: the capacitor shall be positioned in the block so that the termination furthest from the axis of the capacitor is nearest to one of the faces of the block;
- b) for rectangular capacitors: the capacitor shall be positioned in the block so that the termination nearest the edge of the capacitor is nearest to one of the faces of the block.

For cylindrical and rectangular capacitors having axial terminations any out-of-centre positioning of the termination at its emergence from the capacitor body shall be ignored.

4.6.3.4.5 Procedure

The specified test voltage is applied instantaneously through the internal resistance of the power source for the time specified in the relevant specification.

4.6.4 Requirements

For each of the specified test points there shall be no sign of breakdown or flashover during the test period.

4.6.5 Conditions to be prescribed in the relevant specification

The relevant specification shall prescribe:

- a) the test points (see Table 3) and the test voltage corresponding to each of these points;
- b) for the external insulation test (test C), the method of applying the test voltage (one of the methods described in 4.6.3.4);
- c) the time for which the voltage is applied;
- d) the maximum charging and discharging currents;
- e) when applicable, the maximum value of the time constant for charging ($R_1 \times (C_1 + C_X)$).

4.7 Capacitance

4.7.1 Measuring frequency and measuring voltage

The capacitance shall be measured at one of the following frequencies, unless otherwise prescribed in the relevant specification:

– electrolytic capacitors:		100 Hz to 120 Hz
– other capacitors:	$\epsilon_R C_N \leq 1 \text{ nF}$:	100 kHz, 1 MHz or 10 MHz (1 MHz shall be reference)
	$1 \text{ nF} < \epsilon_R C_N \leq 10 \text{ }\mu\text{F}$:	1 kHz or 10 kHz (1 kHz shall be reference)
	$\epsilon_R C_N > 10 \text{ }\mu\text{F}$:	50 Hz (60 Hz) or 100 Hz (120 Hz)

The tolerance on all frequencies for measuring purposes shall not exceed $\pm 20 \%$.

The measuring voltage shall not exceed 3 % of U_R or 5 V, whichever is the smaller, unless otherwise prescribed in the relevant specification.

4.7.2 Measuring equipment

The accuracy of the measuring equipment shall be such that the error does not exceed:

- for absolute capacitance measurements: 10 % of the capacitance tolerance or 2 % absolute, whichever is the smaller;
- for measurement of variation of capacitance: 10 % of the specified maximum change of capacitance.

In neither case a) nor case b) need the accuracy be better than the minimum absolute measurement error (for example 0,5 pF) prescribed in the relevant specification.

4.7.3 Conditions to be prescribed in the relevant specification

The relevant specification shall prescribe:

- the measurement temperature if other than the standard atmospheric conditions for testing;
- the frequencies for measurement and the capacitance range over which they apply, if different from those specified in 4.7.1;
- the absolute measurement error, when applicable (for example 0,5 pF);
- measuring voltage if different from the one specified in 4.7.1;
- the applied polarizing voltage, when applicable.

4.8 Tangent of loss angle and equivalent series resistance (ESR)

4.8.1 Tangent of loss angle

4.8.1.1 Measuring frequency

The tangent of loss angle shall be measured under the same conditions as those given for the measurement of capacitance at one or more frequencies taken from the list in 4.7.1, as prescribed in the relevant specification.

4.8.1.2 Measuring accuracy

Unless otherwise specified in the sectional specification, the measuring method shall be such that the error does not exceed 10 % of the specified value or 0,000 3, whichever is the greater.

4.8.2 Equivalent series resistance (ESR)

4.8.2.1 Measuring frequency

The ESR shall be measured at one of the following frequencies, unless otherwise prescribed in the relevant specification:

50 Hz, 60 Hz, 100 Hz, 120 Hz, 1 kHz, 10 kHz, 100 kHz, 1 MHz and 10 MHz.

4.8.2.2 Measuring accuracy

The accuracy of the measuring equipment shall be such that the error does not exceed 10 % of the requirement, unless otherwise specified in the relevant specification.

4.8.2.3 Conditions to be prescribed in the relevant specification

The relevant specification shall prescribe

- a) the frequency of measurement;
- b) the absolute error measurement;
- c) the measuring voltage, if different from that specified in 4.7.1;
- d) the applied polarizing voltage, where applicable;
- e) the temperature at which measurements shall be made, if other than the standard atmospheric conditions for testing.

4.9 Leakage current

4.9.1 Preconditioning

Before this measurement is made, the capacitors shall be fully discharged.

4.9.2 Test method

The leakage current shall be measured, unless otherwise prescribed in the relevant specification, using the direct voltage (U_R or U_C) appropriate to the test temperature, after a maximum electrification period of 5 min. The full 5 min electrification need not be applied if the specified leakage current limit is reached in a shorter time.

4.9.3 Power source

For the object of test, a steady source of power such as a regulated power supply shall be used.

4.9.4 Measuring accuracy

The measurement error shall not exceed ± 5 % or 0,1 μA , whichever is the greater.

4.9.5 Test circuit

When prescribed in the relevant specification, a 1 000 Ω protective resistor shall be placed in series with the capacitor to limit the charging current.

4.9.6 Conditions to be prescribed in the relevant specification

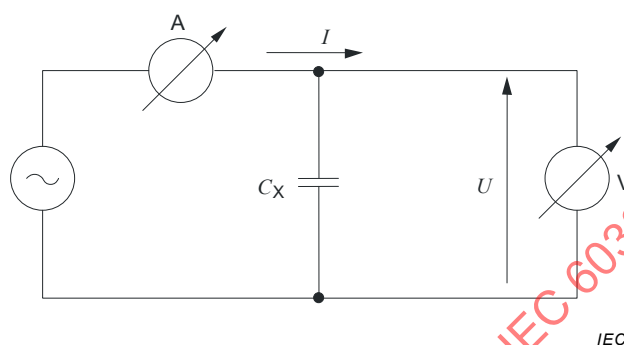
The relevant specification shall prescribe:

- a) the leakage current limit at a reference temperature of 20 °C, and at other specified temperatures;

- b) when necessary, the correction factor, if the measurements are made at a temperature other than 20 °C, but within the range of temperatures covered by the standard atmospheric conditions for testing;
- c) the electrification time, if different from 5 min;
- d) whether or not a 1 000 Ω protective resistor shall be placed in series with the capacitor to limit the charging current as defined in 4.9.5.

4.10 Impedance

Impedance shall be measured by the voltmeter-ammeter method according to the circuit of Figure 4, or equivalent.



Key

C_X	capacitance of specimen
U	measuring voltage
I	measuring current
A	ammeter
V	voltmeter

Figure 4 – Schematic diagram of the impedance measuring circuit

The impedance Z_X of the capacitor C_X is given by $Z_X = \frac{U}{I}$.

The frequency of the measuring voltage shall, preferably, be chosen from the following values:

50 Hz, 60 Hz, 100 Hz, 120 Hz, 1 kHz, 10 kHz, 100 kHz, 1 MHz and 10 MHz.

The accuracy of the measuring equipment shall be such that the error does not exceed 10 % of the requirement, unless otherwise specified in the relevant specification.

NOTE At frequencies above 120 Hz, precautions are necessary to avoid errors arising from stray currents. The current flowing through the capacitor should be limited so that the measuring result is not significantly affected by the rise of the temperature of the capacitor.

The relevant specification shall prescribe:

- a) the frequency of measurement;
- b) the temperature(s) at which measurements shall be made;
- c) the limits of impedance, or ratio of impedances measured at different temperatures.

4.11 Self-resonant frequency and inductance

4.11.1 Self-resonant frequency (f_r)

4.11.1.1 General

For this measurement three methods are described. The first method is for general application; the other methods may be particularly suitable for measuring certain types of capacitors having low capacitance.

The accuracy of the measuring equipment shall be such that the error does not exceed 10 % of the requirement, unless otherwise specified in the relevant specification.

4.11.1.2 Method 1

Using the impedance measuring method of 4.10 and a variable frequency source, the lowest frequency shall be determined at which the impedance passes through a minimum. This is the self-resonant frequency.

NOTE When it is difficult to determine precisely the frequency at which the impedance is at a minimum, then use may be made of a phase-meter to compare the phase of the voltage across the capacitor with the phase of the voltage across a low-inductance resistor connected in series with the capacitor. The resonant frequency is then the frequency when there is no phase difference. A Q-meter may be used for this purpose.

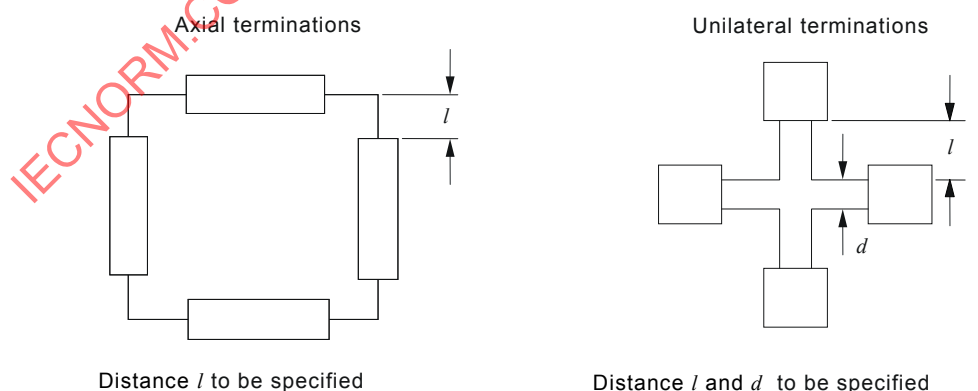
4.11.1.3 Method 2

4.11.1.3.1 General

For this measuring method, use shall be made of an absorption oscillator-wavemeter (grid dip meter).

4.11.1.3.2 Mounting of capacitors with terminations for general use

Four capacitors of nearly equal value and configuration shall be soldered in series at right angles to form a closed loop. The wires shall be of the specified length and no additional wiring or connections shall be employed (see Figure 5). This loop shall be coupled as loosely as possible to an absorption oscillator-wavemeter and the resonant frequency shall then be determined.



IEC

Figure 5 – Capacitor mounting arrangement

4.11.1.3.3 Mounting of capacitors with terminations for printed circuit use

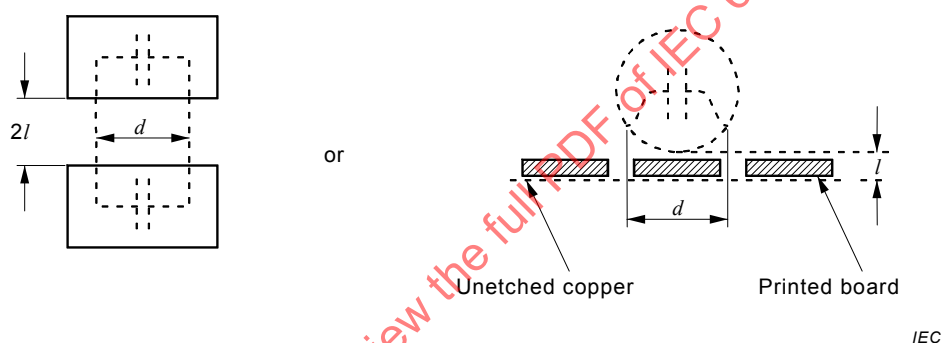
To determine the resonant frequency under the conditions of the capacitor being mounted on a printed circuit board and where the configuration of the case and/or the terminations does not permit a four capacitor loop to be formed correctly, the loop shall be formed by two (nearly) identical capacitors with straight terminations of specified length (see Figure 6).

The second capacitor may be substituted by its mirror image on a conductive plane in the following way.

A copper-clad, unetched sheet of printed circuit base material, whose edges are at least three times as long as the maximum dimension of the capacitor is drilled in its centre to accommodate the capacitor in its normal way.

The relevant specification shall prescribe the details of mounting. The capacitor is soldered in place with the capacitor being short-circuited by the copper laminate. Then the capacitor is coupled to the search coil and measured as in 4.11.1.3.5.

NOTE Metal-cased capacitors may necessitate special arrangements for coupling, which should be prescribed in the relevant specification.



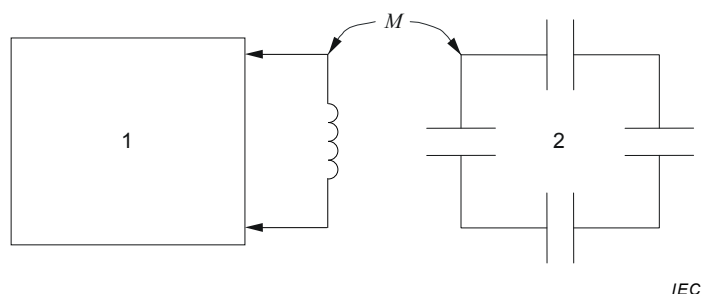
Distances l and d to be specified, where l is to be measured from the seating plane.

Figure 6 – Capacitor mounting arrangement

4.11.1.3.4 Description of the method

The absorption oscillator-wavemeter is a variable frequency L-C oscillator with the inductor formed as an external search coil. When the search coil is coupled into another resonant circuit, power is absorbed causing a change in the mean grid (gate on FETs (field effect transistor)) voltage. This is monitored and hence "dips" at the resonant frequency of the coupled circuit. This coupled circuit consists of four capacitors mounted as described in 4.11.1.3.2 and connected in series to minimize the mutual inductance.

A typical diagram showing the use of an absorption oscillator-wavemeter is given in Figure 7.



Key

- 1 absorption oscillator-wavemeter (grid-dip meter)
- 2 coupled resonant circuit
- M coupling factor

Figure 7 – Typical diagram of an absorption oscillator-wavemeter

4.11.1.3.5 Use of the absorption oscillator-wavemeter

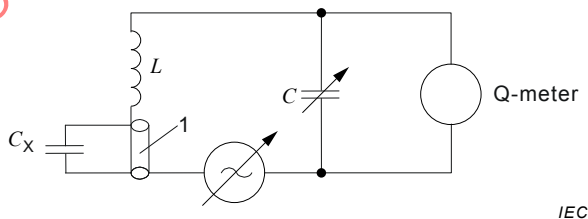
With the search coil of the wavemeter close to the capacitors under investigation, the resonant frequency is approached from a lower frequency. Dips should be checked by moving the wavemeter away from the capacitors (reducing the absorbed power) to make sure the dip is not due to internal effects of the wavemeter. The resonant frequency should be measured with as loose a coupling as is practical to avoid pulling the oscillator.

4.11.1.3.6 Requirements

The resonant frequency shall not exceed the limits prescribed in the relevant specification.

4.11.1.4 Method 3

This method is particularly suitable for capacitors of low capacitance and with a self-resonant frequency within Q-meter operating range. Using a Q-meter and the circuit shown in Figure 8, the lowest frequency shall be determined at which the same resonant frequency is obtained, whether the capacitor shorting strap is in place or not. This frequency can be shown to be equal to the self-resonant frequency of the capacitor.



Key

- 1 shunting strap
- C_x capacitor under test
- C variable capacitor
- L inductor
- Q Q-meter

Figure 8 – Schematic diagram of the measuring circuit

4.11.2 Inductance

The series inductance L_X of a capacitor is calculated from the measured self-resonant frequency f_r of the capacitor using the formula given below:

$$L_X = \frac{1}{4\pi^2 \times f_r^2 \times C_X}$$

where C_X is the capacitance of the capacitor measured in accordance with 4.7 and the requirements of the relevant sectional specification.

4.11.3 Conditions to be prescribed in the relevant specification

The relevant specification shall prescribe:

- a) which test method is preferred;
- b) the lead length of the capacitor to be employed in the measurement;
- c) any special mounting arrangement;
- d) the limits of series inductance or self-resonant frequency.

4.12 Outer foil termination

The correct indication of the termination which is connected to the outside metal foil shall be checked in such a way that the capacitor is not damaged.

A suitable method is given in Figure 9.

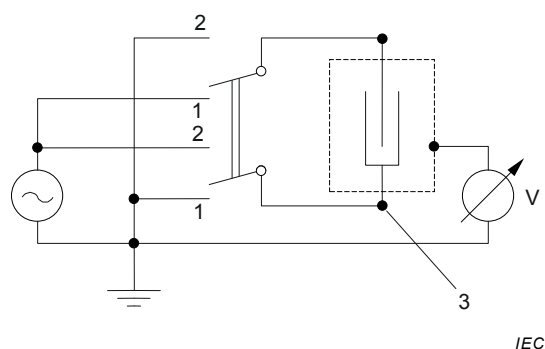
The frequency of the generator may be from 50 Hz to a few thousand Hertz and shall be so chosen as to give a clear result of measurement, the most appropriate value being dependent on the type of capacitor under test.

The voltage shall be of the order of 10 V.

The voltmeter shall have an input impedance of not less than 1 MΩ.

The stray capacitance of the wiring shall be kept low.

With the switch in position 1, the deflection of the voltmeter shall be markedly less than with the switch in position 2.

**Key**

- 1, 2 switching terminations
- 3 outer foil terminations
- V voltmeter

Figure 9 – Test circuit**4.13 Robustness of terminations****4.13.1 General**

The capacitors shall be subjected to ~~Tests~~ IEC 60068-2-21, **Tests** U_{a1} , U_b , U_c , and U_d , as applicable.

4.13.2 Test U_{a1} – Tensile

The force applied shall be:

- for terminations other than wire terminations: 20 N;
- for wire terminations: see Table 4.

Table 4 – Tensile force

Nominal cross-sectional area (S) ^a mm ²	Corresponding diameter (d) for circular-section wires mm	Force with tolerance of $\pm 10\%$ N
$S \leq 0,05$	$d \leq 0,25$	1
$0,05 < S \leq 0,1$	$0,25 < d \leq 0,35$	2,5
$0,1 < S \leq 0,2$	$0,35 < d \leq 0,5$	5
$0,2 < S \leq 0,5$	$0,5 < d \leq 0,8$	10
$0,5 < S \leq 1,2$	$0,8 < d \leq 1,25$	20
$1,2 < S$	$1,25 < d$	40

^a For circular-section wires, strips or pins: the nominal cross-sectional area is equal to the value calculated from the nominal dimension(s) given in the relevant specification. For stranded wires, the nominal cross-sectional area is obtained by taking the sum of the cross-sectional areas of the individual strands of the conductor specified in the relevant specification.

4.13.3 Test Ub – Bending (half of the sample)

Method 1: Two consecutive bends shall be applied in each direction. This test shall not apply if, in the detail specification, the terminations are described as rigid.

4.13.4 Test Uc – Torsion (remaining sample)

Method ~~A~~ 1, severity 2 (two successive rotations of 180°) shall be used.

This test shall not apply if in the detail specification the terminations are described as rigid and to components with unidirectional terminations designed for printed wiring applications.

4.13.5 Test Ud – Torque

This test shall apply to capacitors for terminations with threaded studs or screws and for integral mounting devices. Torque and severity shall be selected from Table 5.

Table 5 – Torque

Severity	Torque Nm								
	Nominal thread diameter mm								
	2,6	3	3,5	4	5	6	8	10	12
1	0,4	0,5	0,8	1,2	2,0	2,5	5	7	12
2	0,2	0,25	0,4	0,6	1,0	1,25	2,5	3,5	6

4.13.6 Visual examination

After each of these tests, the capacitors shall be visually examined. There shall be no visible damage.

4.14 Resistance to soldering heat

4.14.1 Preconditioning and initial measurement

When prescribed in the relevant specification, the capacitors shall be dried using the method of 4.3.

The capacitors shall be measured as prescribed in the relevant specification.

4.14.2 Test procedure

Unless otherwise stated in the relevant specification, one of the following tests as set out in the same specification shall be applied.

The test conditions shall be defined in the relevant specification.

- For all capacitors except those of item b) and c) below:
IEC 60068-2-20, Test Tb, method 1 (solder bath).
- For capacitors not designed for use in printed boards, but with connections intended for soldering as indicated by the detail specification:
 - IEC 60068-2-20, Test Tb, method 1 (solder bath),
 - IEC 60068-2-20, Test Tb, method 2 (soldering iron).
- For surface mount capacitors
IEC 60068-2-58, reflow or solder bath method.

4.14.3 Recovery

The period of recovery shall, unless otherwise specified in the detail specification, be not less than 1 h nor more than 2 h, except for surface mount capacitors, for which the period of recovery shall be $24 \text{ h} \pm 2 \text{ h}$.

4.14.4 Final inspection, measurement and requirements

For all capacitors, except surface mount capacitors, the following shall apply:

- when the test has been carried out the capacitors shall be visually examined;
- there shall be no visible damage and the marking shall be legible;
- the capacitors shall then be measured as prescribed in the relevant specification.

Surface mount capacitors shall be visually examined and measured and shall meet the requirements as prescribed in the relevant specification.

4.15 Solderability

4.15.1 General

~~NOTE—Not applicable~~ This test shall not be applied to those terminations which the detail specification describes as not designed for soldering.

4.15.2 Preconditioning

The relevant specification shall prescribe whether ageing is to be applied. If accelerated ageing is required, one of the ageing procedures given in IEC 60068-2-20 shall be applied.

Unless otherwise stated in the relevant specification, the test shall be carried out with non-activated flux.

4.15.3 Test procedure

Unless otherwise stated in the relevant specification, one of the following tests as set out in the same specification shall be applied.

The test conditions shall be defined in the relevant specification.

a) For all capacitors except those of item b) and c) below:

1) IEC 60068-2-20, Test Ta, method 1 (solder bath)

Depth of immersion (from the seating plane or component body):

$2,0 \text{ mm} \begin{smallmatrix} 0 \\ -0,5 \end{smallmatrix}$ mm, using a thermal insulating screen of $1,5 \text{ mm} \pm 0,5 \text{ mm}$ thickness;

2) IEC 60068-2-20, Test Ta, method 2 (soldering iron)

3) IEC 60068-2-54, solder bath wetting balance method.

NOTE IEC 60068-2-54 is applicable only when prescribed in the detail specification or when agreed upon between manufacturer and customer.

b) For capacitors not designed for use in printed boards, but with connections intended for soldering as indicated by the detail specification:

1) IEC 60068-2-20, Test Ta, method 1 (solder bath)

Depth of immersion (from the seating plane or component body): $3,5 \text{ mm} \begin{smallmatrix} 0 \\ -0,5 \end{smallmatrix}$ mm.

2) IEC 60068-2-20, Test Ta, method 2 (soldering iron).

c) For surface mount capacitors

1) IEC 60068-2-58, reflow or solder bath method

- 2) IEC 60068-2-69, solder bath wetting balance or solder globule wetting balance method.

NOTE IEC 60068-2-69 is applicable only when prescribed in the detail specification or when agreed upon between manufacturer and customer.

4.15.4 Final inspection, measurements and requirements

The terminations shall be examined for good tinning as evidenced by free flowing of the solder with wetting of the terminations.

The capacitors shall meet the requirements as prescribed in the relevant specification.

4.16 Rapid change of temperature

4.16.1 Initial measurement

The measurements prescribed in the relevant specification shall be made.

4.16.2 Test procedure

The capacitors shall be subjected to IEC 60068-2-14, Test Na, using the degree of severity as prescribed in the relevant specification.

4.16.3 Final inspection, measurements and requirements

After recovery, the capacitors shall be visually examined. There shall be no visible damage.

The measurements prescribed in the relevant specification shall then be made.

4.17 Vibration

4.17.1 Initial measurement

The measurements prescribed in the relevant specification shall be made.

4.17.2 Test procedure

The capacitors shall be subjected to IEC 60068-2-6, Test Fc, using the mounting method and the degree of severity prescribed in the relevant specification.

4.17.3 Electrical test (intermediate measurement)

When specified in the detail specification, during the last 30 min of the vibration test an electrical measurement shall be made in each direction of movement to check intermittent contacts, or open or short circuits.

The method of measurement shall be prescribed in the detail specification.

The duration of the measurement shall be the time needed for one sweep of the frequency range from one frequency extreme to the other.

4.17.4 Final inspection, measurements and requirements

After the test the capacitors shall be visually examined. There shall be no visible damage. When capacitors are tested as specified in 4.17.3, the requirements shall be stated in the detail specification.

The measurements prescribed in the relevant specification shall then be made.

4.18 Bump (**repetitive shock**)

4.18.1 Initial measurement

The measurements prescribed in the relevant specification shall be made.

4.18.2 Test procedure

The capacitors shall be subjected to IEC ~~60068-2-29, test Eb~~ 60068-2-27, Test Ea (**repetitive shock**), using the mounting method and the ~~degree of~~ severity prescribed in the relevant specification.

Preferred conditions are:

- pulse shape: half-sine;
- number of shocks in each direction: a minimum of 100;
- peak acceleration: to be chosen from recommended severities.

4.18.3 Final inspection, measurements and requirements

After the test, the capacitors shall be visually examined. There shall be no visible damage.

The measurements prescribed in the relevant specification shall then be made.

4.19 Shock

4.19.1 Initial measurement

The measurements prescribed in the relevant specification shall be made.

4.19.2 Test procedure

The capacitors shall be subjected to IEC 60068-2-27, Test Ea (**non-repetitive shock**), using the mounting method and the severity prescribed in the relevant specification.

4.19.3 Final inspection, measurements and requirements

After the test the capacitors shall be visually examined. There shall be no visible damage.

The measurements prescribed in the relevant specification shall then be made.

4.20 Container sealing

The capacitors shall be subjected to the procedure of the appropriate method of IEC 60068-2-17, Test Q, as prescribed in the relevant specification.

4.21 Climatic sequence

4.21.1 General

In the climatic sequence, an interval of a maximum of three days is permitted between any of the tests, except that the cold test shall be applied immediately after the recovery period for the first cycle of the damp heat, cyclic, IEC 60068-2-30, Test Db.

4.21.2 Initial measurements

The measurements prescribed in the relevant specification shall be made.

4.21.3 Dry heat

The capacitors shall be subjected to IEC 60068-2-2, Test Bb, for 16 h, using the degree of severity of the upper category temperature, as prescribed in the detail specification.

The test specimens may be introduced into the chamber at any temperature from laboratory temperature to the upper category temperature.

While still at the specified high temperature and at the end of the period of high temperature, the measurements prescribed in the relevant specification shall be made.

After the specified conditioning, the capacitors shall be removed from the chamber and exposed to standard atmospheric conditions for testing for not less than 4 h.

4.21.4 Damp heat, cyclic, Test Db, first cycle

The capacitors shall be subjected to IEC 60068-2-30, Test Db, for one cycle of 24 h, using a temperature of 55 °C (severity b).

Unless otherwise specified in the relevant specification, variant 2 shall be used.

After recovery the capacitors shall be subjected immediately to the cold test.

4.21.5 Cold

The capacitors shall be subjected to IEC 60068-2-1, Test Ab, for 2 h, using the degree of severity of the lower category temperature, as prescribed in the relevant specification.

The test specimens may be introduced into the chamber at any temperature from laboratory temperature to the lower category temperature.

While still at specified low temperature and at the end of the period of low temperature, the measurements prescribed in the relevant specification shall be made.

After the specified conditioning, the capacitors shall be removed from the chamber and exposed to standard atmospheric conditions for testing for not less than 4 h.

4.21.6 Low air pressure

The capacitors shall be subjected to IEC 60068-2-13, Test M, using the appropriate degree of severity prescribed in the relevant specification. The duration of the test shall be 10 min, unless otherwise stated in the relevant specification.

The relevant specification shall prescribe:

- a) duration of test; if other than 10 min;
- b) temperature;
- c) degree of severity.

While at the specified low pressure, the rated voltage shall be applied during the last 60 s of the test period, unless otherwise prescribed in the relevant specification.

During and after the test, there shall be no evidence of permanent breakdown, flashover, harmful deformation of the case, or seepage of impregnant.

4.21.7 Damp heat, cyclic, Test Db, remaining cycles

The capacitors shall be subjected to IEC 60068-2-30, Test Db, for the following number of cycles of 24 h as indicated in Table 6, under the same conditions as used for the first cycle.

Table 6 – Number of cycles

Climatic categories	Number of cycles
-/-/56	5
-/-/21	1
-/-/10	1
-/-/04	None

4.21.8 Final measurements

After the prescribed recovery, the measurements prescribed in the relevant specification shall be made.

4.22 Damp heat, steady state

4.22.1 Initial measurement

The measurements prescribed in the relevant specification shall be made.

4.22.2 Test procedure

The capacitors shall be subjected to IEC 60068-2-78, Test Cab, using the degree of severity corresponding to the climatic category of the capacitor as indicated in the detail specification. The temperature and humidity of test shall be $(40 \pm 2) ^\circ\text{C}$, $(93 \pm 3) \% \text{RH}$, unless otherwise specified in the relevant specification.

When specified in the blank detail specification, the detail specification may specify the application of a polarizing voltage during the whole period of damp heat conditioning. For metallized film capacitors this test should be carried out in accordance with Annex G.

With the exception of electrolytic capacitors, within 15 min after removal from the test chamber, the voltage proof test of 4.6 shall be carried out at test point A only, using the rated voltage, unless otherwise specified in the detail specification.

4.22.3 Final inspection, measurements and requirements

After recovery, the capacitors shall be visually examined. There shall be no visible damage. The measurements prescribed in the relevant specification shall then be made.

In case of testing metallized film capacitors, when specified in the blank detail specification, the permissible deviation of the average C-value of test group with and the test group without d.c. voltage shall be described in the relevant detail specification.

4.23 Endurance

4.23.1 Initial measurements

The measurements prescribed in the relevant specification shall be made.

4.23.2 Test procedure

The tests of IEC 60068-2-2 apply as follows:

- a) d.c. tests – Test Bb;
- b) a.c. tests – Test Bb or Bd as applicable;
- c) pulse tests – Test Bb or Bd as applicable.

The test specimens may be introduced into the chamber at any temperature, from laboratory temperature to the upper category temperature, but the voltage shall not be applied to the capacitor before it has reached the chamber temperature.

4.23.3 Conditions to be prescribed in the relevant specification

The relevant specification shall prescribe:

- a) duration of the test (for example, hours or number of pulses);
- b) test temperature (for example, room, rated or upper category temperature);
- c) voltage and/or current to be applied (see also 4.23.4).

When capacitors have to meet additional requirements for electric shock hazard protection, additional test conditions for endurance testing (for example, pulse voltage application) shall be prescribed in the relevant specification.

4.23.4 Test voltage

Unless otherwise specified in the relevant specification, the voltage to be applied during the test shall be selected from the following.

- a) d.c. tests

The test shall be carried out at a multiplying factor times the rated voltage (d.c.) at temperatures up to the rated temperature. The test temperature and the value of the multiplying factor shall be specified in the relevant specification. For tests at the upper category temperature the derating factor for the voltage shall also be given.

- b) a.c. tests (sinusoidal voltage)

The test shall be made at 50 Hz to 60 Hz and at a multiplying factor times the rated voltage (a.c.) (see 2.3.4 a)) at temperatures up to the rated temperature, or at the upper category temperature with a derating factor for the voltage. The test temperature and the value of the multiplying factor/derating factor for the voltage shall be specified in the relevant specification.

- c) a.c. tests (sinusoidal current)

This test shall be made with a current applied in accordance with 2.3.4 b). The test temperature, the value of current and frequency shall be specified in the relevant specification.

NOTE 1 To facilitate testing, the test may be made with a voltage of specified frequency applied to a group of capacitors in parallel or in series/parallel.

- d) sinusoidal a.c. tests (reactive power)

This test shall be made with reactive power in accordance with 2.3.4 c). The test temperature, the value of the reactive power, and the frequency shall be specified in the relevant specification.

NOTE 2 To facilitate testing, the test may be made with a voltage of specified frequency applied to a group of capacitors in parallel or in series/parallel.

A thermal stability test (see 4.30) may constitute an alternative to this test. The test to be carried out shall be specified in the detail specification.

- e) pulse tests

This test shall be made with pulses applied in accordance with 2.3.5 and as specified in the relevant specification. Guidance for pulse tests is given in Annex E.

- f) sinusoidal a.c. or pulse tests with superimposed d.c.

Tests b) to e) may be carried out with superimposed d.c. as required in the relevant specification (see also 2.2.23).

An example of a test circuit suitable for electrolytic capacitors is given in Figure 10.

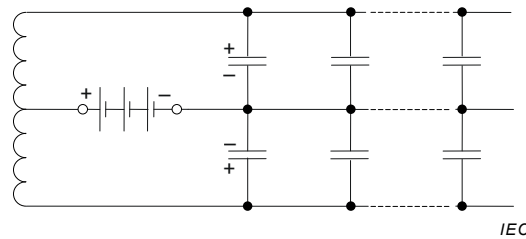


Figure 10 – Test circuit for electrolytic capacitors

4.23.5 Placement in the test chamber

The capacitors shall be placed in the test chamber in such a manner that

- a) for heat dissipating capacitors, no capacitor is within 25 mm of any other capacitor,
- b) for non-heat dissipating capacitors, no capacitor is within 5 mm of any other capacitor.

4.23.6 Recovery

After the specified period, the capacitors shall be allowed to cool to standard atmospheric conditions for testing and where specified in the relevant specification, the capacitors shall be subjected to recovery.

4.23.7 Final inspection, measurements and requirements

The capacitors shall then be visually examined.

The measurements prescribed in the relevant specification shall then be made. A capacitor shall be considered to have failed when the requirements of the relevant specification during or at the end of the test are not satisfied.

4.24 Variation of capacitance with temperature

4.24.1 Static method

4.24.1.1 Initial measurement

Measurements of capacitance shall be made under the conditions prescribed in the relevant specification.

4.24.1.2 Test procedure

The capacitor shall be maintained at each of the following temperatures in turn:

- a) $20\text{ }^{\circ}\text{C} \pm 2\text{ }^{\circ}\text{C}$;
- b) lower category temperature $\pm 3\text{ }^{\circ}\text{C}$;
- c) intermediate temperatures, if required in the detail specification;
- d) $20\text{ }^{\circ}\text{C} \pm 2\text{ }^{\circ}\text{C}$;
- e) intermediate temperatures, if required in the detail specification;
- f) upper category temperature $\pm 2\text{ }^{\circ}\text{C}$;
- g) $20\text{ }^{\circ}\text{C} \pm 2\text{ }^{\circ}\text{C}$.

If required for a particular type of capacitor, the relevant specification shall prescribe whether thermal shock is to be avoided or whether a maximum rate of change of temperature shall be specified.

The conditions of measurement, during or after temperature cycling, a description of the temperature cycle and the number of cycles, should be stated.

4.24.1.3 Measuring method

Capacitance measurements shall be made at each of the temperatures specified above, after the capacitor has reached thermal stability.

The condition of thermal stability is judged as having been reached when two readings of capacitance taken at an interval of not less than 5 min do not differ by an amount greater than that which can be attributed to the measuring apparatus.

The measurement of the actual temperature shall be made with a precision compatible with the requirements of the detail specification.

Care ~~must~~ shall be taken during measurements to avoid condensation or frost on the surface of the capacitors.

4.24.1.4 Reduced procedure

For the lot-by-lot quality conformance testing, the detail specification may prescribe a reduced procedure, for example, measurements d), f) and g) in 4.24.1.2 covering the temperature range from 20 °C to the upper category temperature.

4.24.2 Dynamic method

As an alternative to the static method of 4.24.1, a dynamic plotting method may be employed. The capacitors shall be subjected to a slowly varying temperature.

A temperature-sensing device shall be embedded in a dummy capacitor to be included with the capacitor under test in a manner that will ensure that the measured temperature is the same as that occurring in the capacitor under test. The capacitance shall be measured using a self-balancing bridge or comparator.

The output of the bridge or comparator shall be coupled to the "Y" axis of a plotting table.

The output of the temperature sensing device shall be coupled to the "X" axis of a plotting table.

The temperature shall be varied slowly enough to produce a uniform curve with no loop at the lower or upper category temperature. The temperature shall be varied subsequently from 20 °C to the lower category temperature, then to the upper category temperature and back to 20 °C. Two cycles shall be carried out.

This method may be employed only when it can be demonstrated that the results are the same as for the method employing stabilized temperatures.

In case of dispute, the static method shall be used.

4.24.3 Methods of calculation

4.24.3.1 General

The following applies:

- C_0 is the capacitance measured at point d) of 4.24.1.2;
 T_0 is the temperature measured at point d) of 4.24.1.2;
 C_i is the capacitance measured at the test temperature, other than at points a), d) and g) of 4.24.1.2;
 T_i is the temperature measured on test.

4.24.3.2 Temperature characteristics of capacitance

The variation of capacitance as a function of temperature shall be calculated for all the values of C_i as follows:

$$\frac{\Delta C}{C_0} = \frac{C_i - C_0}{C_0}$$

The variation of capacitance is normally expressed in per cent.

4.24.3.3 Temperature coefficient of capacitance and temperature cyclic drift of capacitance

Temperature coefficient of capacitance and temperature cyclic drift of capacitance shall be calculated as follows:

a) Temperature coefficient of capacitance (α)

Temperature coefficient of capacitance (α) shall be calculated for all the values of C_i as follows:

$$\alpha_i = \frac{C_i - C_0}{C_0(T_i - T_0)} \times 10^6$$

The temperature coefficient is normally expressed in parts per million per Kelvin ($10^{-6}/K$).

b) Temperature cyclic drift of capacitance

The temperature cyclic drift of capacitance shall be calculated for the points of measurement of 4.24.1.2 a), d) and g) in the following manner:

$$\delta_{da} = \frac{C_0 - C_a}{C_0}$$

$$\delta_{gd} = \frac{C_g - C_0}{C_0}$$

$$\delta_{ga} = \frac{C_g - C_a}{C_0}$$

as required in the relevant specification. The largest of these values is the "temperature cyclic drift of capacitance".

The capacitance drift is normally expressed in per cent.

4.25 Storage

4.25.1 Storage at high temperature

4.25.1.1 Initial measurement

The measurements prescribed in the relevant specification shall be made.

4.25.1.2 Test procedure

The capacitors shall be subjected to IEC 60068-2-2, Test Bb, using the following severities:

- temperature: upper category temperature;
- duration: 96 h $\pm$ 4 h.

The test specimens may be introduced into the chamber at any temperature from laboratory temperature to the upper category temperature.

4.25.1.3 Final inspection, measurements and requirements

After recovery for at least 16 h, the measurements prescribed in the relevant specification shall be made.

4.25.2 Storage at low temperature

4.25.2.1 Initial measurement

The measurements prescribed in the relevant specification shall be made.

4.25.2.2 Test procedure

The capacitors shall be subjected to IEC 60068-2-1, Test Ab. The capacitors shall be stored at $-40\text{ }^{\circ}\text{C}$ for either a period of 4 h after thermal stability has been reached, or for 16 h, whichever is the shorter period.

The test specimens may be introduced into the chamber at any temperature from laboratory temperature to $-40\text{ }^{\circ}\text{C}$.

4.25.2.3 Final inspection, measurements and requirements

After recovery for at least 16 h, the measurements prescribed in the relevant specification shall be made.

4.26 Surge

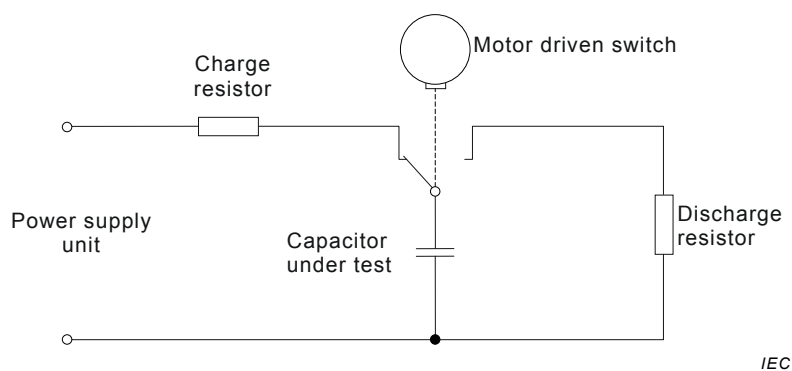
4.26.1 Initial measurement

The measurements specified in the relevant specification shall be made.

4.26.2 Test procedure

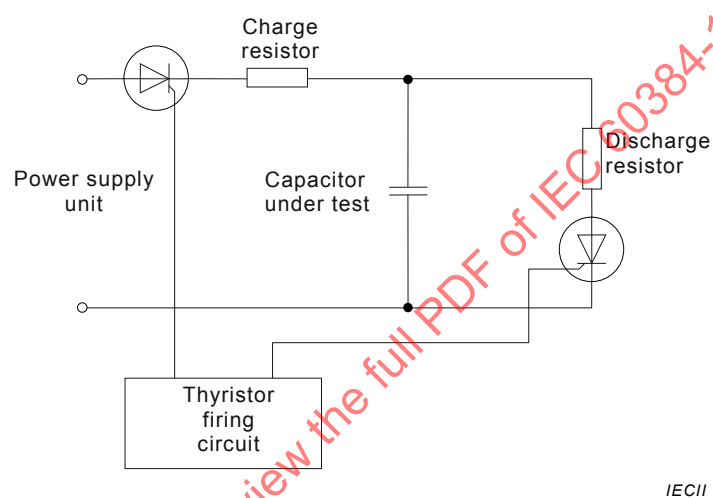
Suitable test circuits are shown in Figure 11 and Figure 12.

NOTE The thyristor circuit has the advantage of high repetition rates and is free from troubles associated with dirty contacts and contact bounce.



IEC

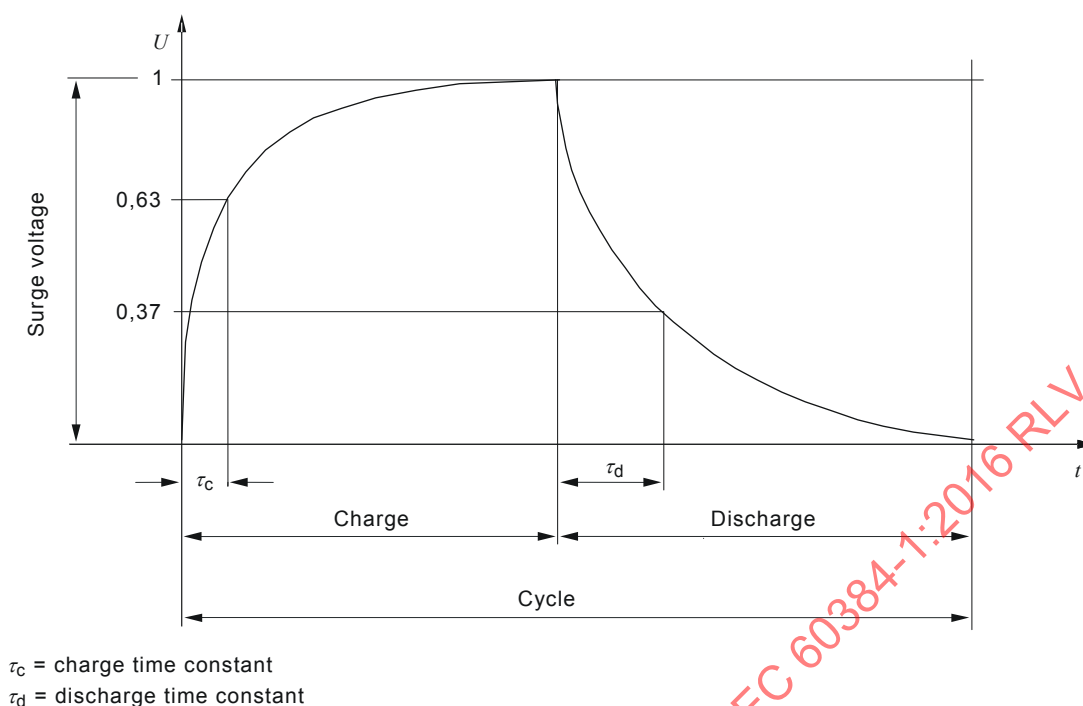
Figure 11 – Relay circuit



IECII

Figure 12 – Thyristor circuit

The voltage waveform across the capacitor under test shall be approximately as shown in Figure 13.



IEC

Figure 13 – Voltage waveform across capacitor

4.26.3 Final inspection, measurements and requirements

The measurements specified in the relevant specification shall be made.

4.26.4 Information to be given in the relevant detail specification

The following information shall be given in the relevant specification:

- the charge time constant arising from the internal resistance of the power supply and the resistance of the charge circuit and the capacitance of the capacitor under test;
- the discharge time constant arising from the resistance of the discharge circuit and the capacitance of the capacitor under test;
- the ratio of the surge voltage to rated or category voltage (as appropriate);
 The number of times per hour that this voltage may be applied should be specified.
- the number of cycles of test;
- the duration of the charge period;
- the duration of the discharge period;
- the repetition rate (cycles per second);
- temperature, if different from standard atmospheric conditions for testing.

4.27 Charge and discharge tests and inrush current test

4.27.1 Initial measurement

The measurements specified in the relevant specification shall be made.

4.27.2 Test procedure

Suitable test circuits are given in 4.26.2, Figure 11 and Figure 12.

The voltage and current waveforms across and through the capacitor under test are approximately as shown in Figure 14.

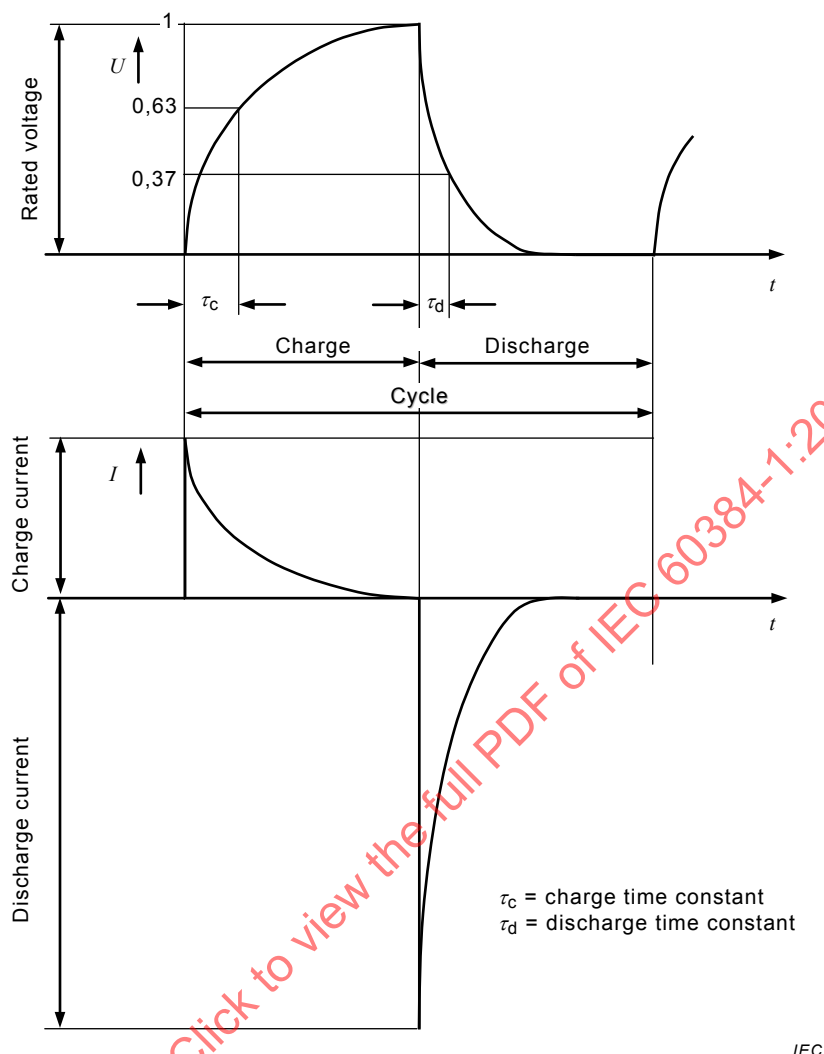


Figure 14 – Voltage and current waveform

4.27.3 Charge and discharge

The following information shall be given in the relevant specification:

- the charge time constant arising from the internal resistance of power supply and the resistance of the charge circuit and the capacitance of the capacitor under test;
- the discharge time constant arising from the resistance of the discharge circuit and the capacitance of the capacitor under test;
- the voltage to be applied during the charge period, if different from the rated voltage;
- the number of cycles of test;
- the duration of the charge period;
- the duration of the discharge period;
- the repetition rate (cycles per second);
- temperature, if different from standard atmospheric conditions for testing.

4.27.4 Inrush current

The following information shall be given in the relevant specification:

- a) the peak charge current;
- b) the voltage to be applied during the charge period if different from the rated voltage;
- c) the number of cycles of test;
- d) the duration of the charge period in milliseconds;
- e) the duration of the discharge period;
- f) the repetition rate;
- g) the temperature if different from standard atmospheric conditions for testing.

4.27.5 Final inspection, measurements and requirements

The measurements specified in the relevant specification shall be made.

4.28 Pressure relief (for aluminium electrolytic capacitors)

4.28.1 General

Unless otherwise specified in the relevant specification, one of the following tests shall be used to test the pressure relief device of the capacitors.

4.28.2 AC test

Applied voltage: alternating voltage with r.m.s. value not exceeding 0,7 times the rated direct voltage.

Frequency of the applied voltage: 50 Hz or 60 Hz.

Series resistor: $R = 0,5$ times the impedance of the capacitor at the test frequency.

4.28.3 DC test

Applied voltage: direct voltage applied in the reverse direction, of an amplitude necessary to produce a current of 1 A to 10 A.

4.28.4 Pneumatic test

Applied pneumatic pressure: gas pressure introduced from outside shall be increased at a rate of 20 kPa/s continuously.

4.28.5 Final inspection, measurements and requirements

The measurements specified in the relevant specification shall be made.

4.29 Characteristics at high and low temperature

4.29.1 Test procedure

The capacitors shall be subjected to the procedures of the dry heat and cold test (4.21.3 and 4.21.5, respectively) with the following details.

The degree of severity for these tests shall be the same as for the dry heat and cold tests. Tests at intermediate temperatures may be prescribed in the relevant specification.

Measurements shall be made at each of the specified temperatures after the capacitor has reached thermal stability.

The condition of thermal stability is judged to be reached when two readings of a characteristic, taken in an interval of not less than 5 min, do not differ by an amount greater than that which can be attributed to the measuring apparatus.

4.29.2 Requirements

The capacitors shall not exceed the limits prescribed in the relevant specification.

4.30 Thermal stability test

A thermal stability test may constitute an alternative to the endurance test in accordance with 4.23.4 d). The test to be carried out shall be specified in the detail specification.

The capacitor shall be loaded with a specified factor times the rated reactive power dissipation at the rated temperature and duration as specified in the relevant specification.

A test for thermal stability shall be made by measuring the temperature rise as a function of time over the last part of the specified duration. The temperature rise shall be within specified limits.

The measurement of the temperature rise may be made by the use of a thermocouple, thermistor, infrared thermometer, infrared photography, etc. Care should be taken to ensure that the error of measurement does not exceed $\pm 1^\circ\text{C}$ and that errors due to heat conduction along measuring connections are kept to a minimum.

The relevant specification shall specify the point at which the measurements shall be made and the method of mounting (see IEC 60068-2-2:2007, 6.4).

4.31 Component solvent resistance

4.31.1 Initial measurements

The measurements prescribed in the relevant specification shall be made.

4.31.2 Test procedure

The components shall be subjected to IEC 60068-2-45, Test XA, with the following details:

- a) solvent to be used: IPA (IEC 60068-2-45:1980/AMD1:1993, 3.1.2);
- b) solvent temperature: $23^\circ\text{C} \pm 5^\circ\text{C}$, unless otherwise specified in the detail specification;
- c) conditioning: method 2, (without rubbing);
- d) recovery time: 48 h, unless otherwise stated in the detail specification.

4.31.3 Final inspection, measurements and requirements

The measurements prescribed in the relevant specification shall then be made and the specified requirements be met.

4.32 Solvent resistance of marking

4.32.1 Test procedure

The components shall be subjected to IEC 60068-2-45, Test XA, with the following details:

- a) solvent to be used: IPA (IEC 60068-2-45:1980/AMD1:1993, 3.1.2);

- b) solvent temperature: $23\text{ °C} \pm 5\text{ °C}$;
- c) conditioning: method 1 (with rubbing);
- d) rubbing material: cotton wool;
- e) recovery time: not applicable, unless otherwise stated in the detail specification.

4.32.2 Final inspection, measurements and requirements

After the test the marking shall be legible.

4.33 Mounting (for surface mount capacitors only)

4.33.1 Substrate

Surface mount capacitors shall be mounted on a suitable substrate, the method of mounting being dependent on the capacitor construction. The substrate material shall normally be an epoxide woven glass fabric laminated printed board (as defined in IEC 61249-2-7) with a thickness of $1,6\text{ mm} \pm 0,20\text{ mm}$ or $0,8\text{ mm} \pm 0,10\text{ mm}$, or a 90 % to 98 % alumina substrate having a thickness of $0,635\text{ mm} \pm 0,05\text{ mm}$ or more, and shall not affect the result of any test or measurement. The detail specification shall indicate which material is to be used for the electrical measurements.

The substrate shall have metallized land areas of proper spacing to permit mounting of surface mount capacitors and shall provide electrical connection to the surface mount capacitor terminals. The details shall be specified in the detail specification.

Examples of test substrates for mechanical and electrical tests are shown in Figure 15 and Figure 16, respectively.

If another method of mounting applies, the method should be clearly described in the detail specification.

4.33.2 Wave soldering

When the detail specification specifies wave soldering, suitable glue, details of which may be specified in the detail specification, shall be used to fasten the component to the substrate before soldering is performed.

Small dots of the glue shall be applied between the conductors of the substrate by means of a suitable device securing repeatable results.

The surface mount capacitors shall be placed on the dots using tweezers. To ensure that no glue is applied to the conductors, the surface mount capacitors shall not be moved about.

The substrate with the surface mount capacitors shall be heat-treated in an oven at 100 °C for 15 min.

The substrate shall be soldered in a wave soldering apparatus. The apparatus shall be adjusted to have a pre-heating temperature of 80 °C to 100 °C , a solder bath at $260\text{ °C} \pm 5\text{ °C}$ and a soldering time of $5\text{ s} \pm 0,5\text{ s}$.

The substrate shall be cleaned for 3 min in a suitable solvent (see IEC 60068-2-45:1980/AMD1:1993, 3.1.2).

4.33.3 Reflow soldering

When the detail specification specifies reflow soldering, the following mounting procedure applies.

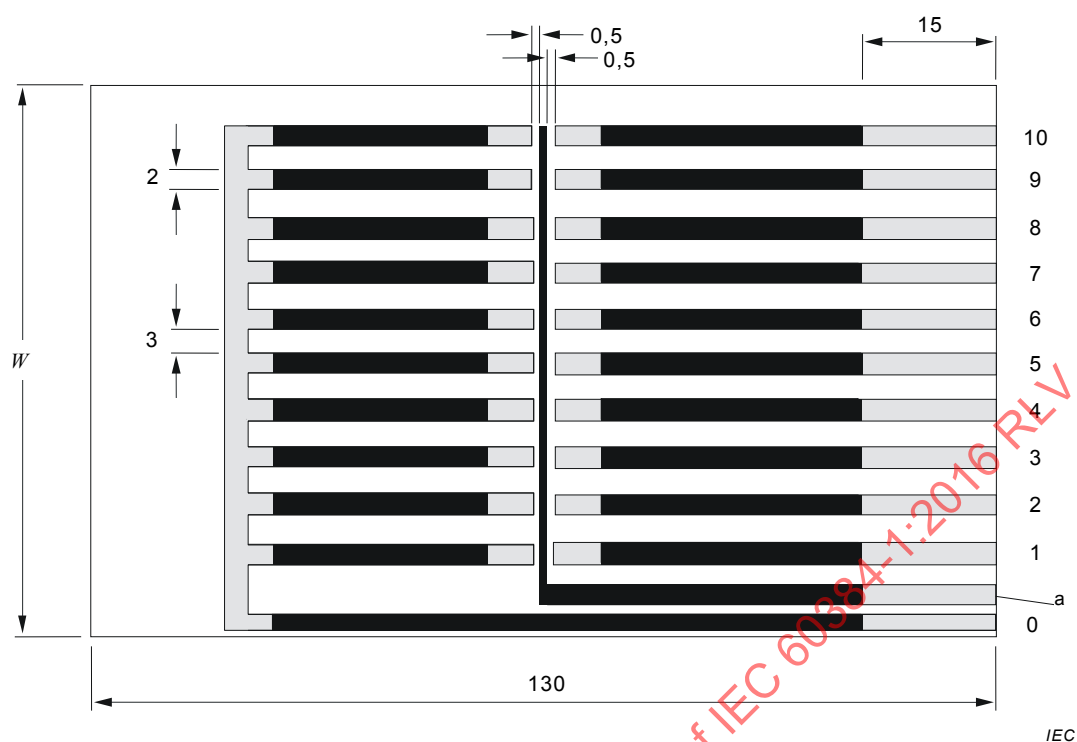
- a) The solder used in preform or paste form shall be silver bearing (2 % minimum) eutectic Sn/Pb solder together with a flux as stated in IEC 60068-2-20. Alternative solders such as 60/40 or 63/37 may be used on chips whose construction includes solder leach barriers. Pb-free solder used in preform or paste form shall be Sn96,5Ag3,0Cu0,5 or derivative solder together with a flux as stated in IEC 60068-2-58, or as defined in the relevant specification.
- b) The surface mount capacitor shall then be placed across the metallized land areas of the test substrate so as to make contact between surface mount and substrate land areas.
- c) The substrate shall then be placed in or on a suitable heating system (molten solder, hot plate, tunnel oven, etc.). The temperature of the unit shall be maintained between 215 °C and 260 °C, until the solder melts and reflows forming a homogeneous solder bond, but for not longer than 10 s.

NOTE 1 Flux should be removed by a suitable solvent (see IEC 60068-2-45:1980/AMD1:1993, 3.1.2). All subsequent handling should be such as to avoid contamination. Care should be taken to maintain cleanliness in test chambers and during post test measurements.

NOTE 2 The detail specification may require a more restricted temperature range.

NOTE 3 If vapour phase soldering is applied, the same method may be used with the temperatures adapted.

A suitable substrate for mechanical tests is shown in Figure 15. Note that this substrate may not be suitable for impedance measurements. A suitable substrate for electrical tests is shown in Figure 16.

**Key**

- Solderable areas
- Non-solderable areas (covered with non-solderable lacquer)

All dimensions are in millimetres. Tolerances: medium.

Material: epoxide woven glass

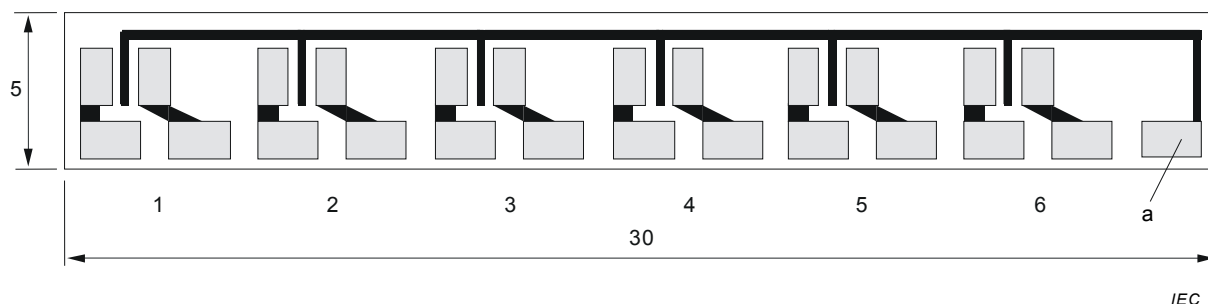
Thickness: 1,6 mm $\pm$ 0,20 mm, or 0,8 mm $\pm$ 0,10 mm

Dimensions not given should be chosen according to the design and size of the specimens to be tested.

Dimension W is dependent on the design of the test equipment.

^a This conductor may be omitted or used as a guard electrode.

Figure 15 – Suitable substrate for mechanical tests
~~(may not be suitable for impedance measurements)~~



Key

- Solderable areas
- Non-solderable areas (covered with non-solderable lacquer)

All dimensions are in millimetres. Tolerances: medium.

Material: 90 % to 98 % alumina substrate

Thickness: 0,635 mm $\pm$ 0,05 mm, or more

Dimensions not given should be chosen according to the design and size of the specimens to be tested.

Dimension *W* depends on the design of the test equipment.

^a This conductor may be omitted or used as a guard electrode.

Figure 16 – Suitable substrate for electrical tests

4.34 Shear test

4.34.1 Test procedure

The surface mount capacitors shall be mounted as described in IEC 60068-2-21, Test U.

The capacitors shall be subjected to IEC 60068-2-21, Test Ue3, under the following condition.

A force shall be applied to the surface mount capacitor body progressively, without shock, and shall be maintained for a period of 10 s $\pm$ 1 s. Unless otherwise specified in the relevant specification, a force shall be selected from 1 N, 2 N, 5 N or 10 N.

4.34.2 Final inspection, measurements and requirements

The surface mount capacitors shall be visually examined in the mounted state. There shall be no visible damage.

4.35 Substrate bending test

4.35.1 Test procedure

The surface mount capacitor shall be mounted on an epoxide woven glass printed board as described in 4.33.

- a) The capacitance of the surface mount capacitor shall be measured as specified in 4.7 and in the relevant sectional specification.
- b) The capacitor shall be subjected to IEC 60068-2-21, Test Ue, using the conditions as prescribed in the relevant specification for the deflection *D* and the number of bends.
- c) The capacitance of the surface mount capacitors shall be measured as specified in a) with the board in the bent position. The change of capacitance shall not exceed the limits prescribed in the relevant specification.

4.35.2 Recovery

The printed board shall be allowed to recover from the bent position and then removed from the test jig.

4.35.3 Final inspection and requirements

The surface mount capacitors shall be visually examined, and there shall be no visible damage.

4.36 Dielectric absorption

4.36.1 Test procedure

The capacitor under test shall be placed in a screened enclosure to reduce the effect of electric fields.

For the measurement of the voltage an electrometer or other suitable instrument having an input resistance of minimum 10 000 MΩ shall be used.

The resistance of any jigs, switches, etc. used shall not affect the input resistance of the measuring system.

The capacitor shall then be charged at the d.c. voltage rating for 60 min ± 1 min. The initial surge current shall not exceed 50 mA.

At the end of this period the capacitor shall be disconnected from the power source and shall be discharged through a 5 Ω ± 5 % resistor for 10 s ± 1 s, unless the specified du/dt value is exceeded.

The discharge resistor shall be disconnected from the capacitor at the end of the 10 s discharge period. The voltage remaining or regained on the capacitor (recovery voltage) shall be measured.

NOTE The recovery voltage is the maximum voltage occurring across the capacitor terminations within a 15 min period.

The dielectric absorption shall be calculated from the following formula:

$$\%DA = \frac{U_1}{U_2} \times 100 \times \frac{C_X + C_0}{C_X}$$

where

$\%DA$ is the per cent dielectric absorption;

U_1 is the recovery voltage;

U_2 is the charging voltage;

C_X is the capacitance of capacitor under test;

C_0 is the input capacitance of measuring system.

If C_0 is less than 10 % of C_X , the above formula can be simplified to:

$$\%DA = \frac{U_1}{U_2} \times 100$$

4.36.2 Requirement

The dielectric absorption calculated shall not exceed the limit specified in the detail specification.

4.37 Damp heat, steady state ~~(for multilayer ceramic capacitors only)~~, accelerated

NOTE This test is also known as humidity load test or (85/85)-test.

4.37.1 ~~Mounting of capacitors~~

~~The capacitors shall be mounted so that each capacitor is connected in series with a resistor. Half of the capacitors shall be connected in series with resistors of $100\text{ k}\Omega \pm 10\%$ and half in series with resistors of $6,8\text{ k}\Omega \pm 10\%$.~~

4.37.1 Initial measurements

The capacitors, ~~mounted as in 4.37.1,~~ shall be measured for insulation resistance with a voltage of $1,5\text{ V} \pm 0,1\text{ V}$ applied across the capacitor and resistor in series as prescribed in the relevant specification.

~~The insulation resistance shall meet the requirements given in the relevant specification.~~

4.37.2 Test methods

The capacitors shall be subjected to IEC 60068-2-67, Test Cy.

Preferred test durations: 168 h, 504 h or 1 000 h.

4.37.3 Test procedures

~~The capacitors with associated resistors shall be subjected to conditioning at $(85 \pm 2)^\circ\text{C}$, $(85 \pm 3)\%$ RH for a duration to be specified in the relevant specification. Those capacitors connected to $100\text{ k}\Omega$ resistors shall have a voltage of $(1,5 \pm 0,1)\text{ V}$ applied, and those connected to $6,8\text{ k}\Omega$ resistors shall have $(50 \pm 0,1)\text{ V}$ or U_R , whichever is the lower, applied. In both cases the voltage shall be applied across the capacitor/resistor combination.~~

~~Care shall be taken to avoid condensation of water on to the capacitors or substrates. Condensation may happen if the door is opened during the test before the humidity is lowered.~~

Test condition: rated voltage applied, unless otherwise prescribed in the relevant specification.

For metallized film capacitors this test should be carried out in accordance with Annex G, for multilayer ceramic capacitors in accordance with Annex H.

With the exception of electrolytic capacitors, within 15 min after removal from the test chamber, the voltage proof test of 4.6 shall be carried out at test point A only, using the rated voltage, unless otherwise specified in the detail specification.

4.37.4 ~~Recovery~~

~~The applied voltage shall be disconnected and the capacitors and resistors shall be removed from the test chamber and allowed to recover for 4 h to 24 h in standard atmospheric conditions for testing.~~

4.37.4 Final inspection, measurements and requirements

~~The capacitors, mounted as in 4.37.1, shall be measured for insulation resistance as in 4.37.2 above.~~

~~The insulation resistance shall be greater than 0,1 times the initial limit.~~

After recovery (4 h to 24 h), the capacitors shall be visually examined. There shall be no visible damage. The measurements prescribed in the relevant specification shall then be made.

In case of testing metallized film capacitors, when specified in the blank detail specification, the permissible deviation of the average C-value of test group with and the test group without d.c. voltage shall be described in the relevant detail specification.

4.38 Passive flammability

4.38.1 Test procedure

The test shall be made according to IEC 60695-11-5.

The capacitor under test shall be held in the flame in the position which best promotes burning (if this position is not given in the detail specification it shall be evaluated by pre-testing). Each specimen shall be exposed only once to the flame.

The smallest, a medium (in the case of more than four case sizes), and the biggest case size shall be tested. Of each case size, three specimens of the maximum and three specimens of the minimum capacitance shall be tested, resulting in six specimens per case size.

For time of exposure to flame and burning time, see Table 7. If applicable, the detail specification shall specify the category of passive flammability.

4.38.2 Final inspection, measurements and requirements

The burning time of any specimen shall not exceed the time specified in Table 7.

Burning droplets or glowing parts falling down shall not ignite the tissue paper.

Table 7 – Severities and requirements

Category of flammability	Severities Flame exposure time, in seconds, for capacitor volume ranges				Maximum burning time s
	Volume $\leq 250 \text{ mm}^3$	Volume $> 250 \text{ mm}^3$ $\leq 500 \text{ mm}^3$	Volume $> 500 \text{ mm}^3$ $\leq 1\,750 \text{ mm}^3$	Volume $> 1\,750 \text{ mm}^3$	
A	15	30	60	120	3
B	10	20	30	60	10
C	5	10	20	30	30

4.39 High surge current test

4.39.1 Initial measurements

Not required.

4.39.2 Test procedure

The test shall be carried out at a temperature of $(23 \pm 3) ^\circ\text{C}$.

The test circuit is shown in Figure 17. The switch may be mechanical or electronic but is preferably electronic. With the switch in position A, the capacitor under test is charged for 1 s from a low-impedance electrolytic capacitor of capacitance at least $20\,000\ \mu\text{F}$ to the rated voltage of the capacitor under test ($U_R \pm 2\%$) from a regulated power supply capable of delivering 10 A. The impedance of the circuit through which the capacitor under test is charged shall meet the requirements of 4.39.3. After 1 s charging time the capacitor under test shall be discharged for 1 s with the switch in position B through a circuit whose resistance is greater than $0,05\ \Omega$, but less than $0,2\ \Omega$.

The voltage across the capacitor under test shall be monitored. Four further chargings and dischargings of the capacitor under test shall be carried out under the same conditions.

Capacitors may be tested in parallel provided that

- a) their total capacitance is less than 2 % of the capacitance of the reservoir capacitor, and
- b) all the conditions specified above are met for each capacitor under test.

The fuse may be a wire fuse designed to blow between 0,5 A and 2,0 A or an electronic circuit designed to trip in the same current range.

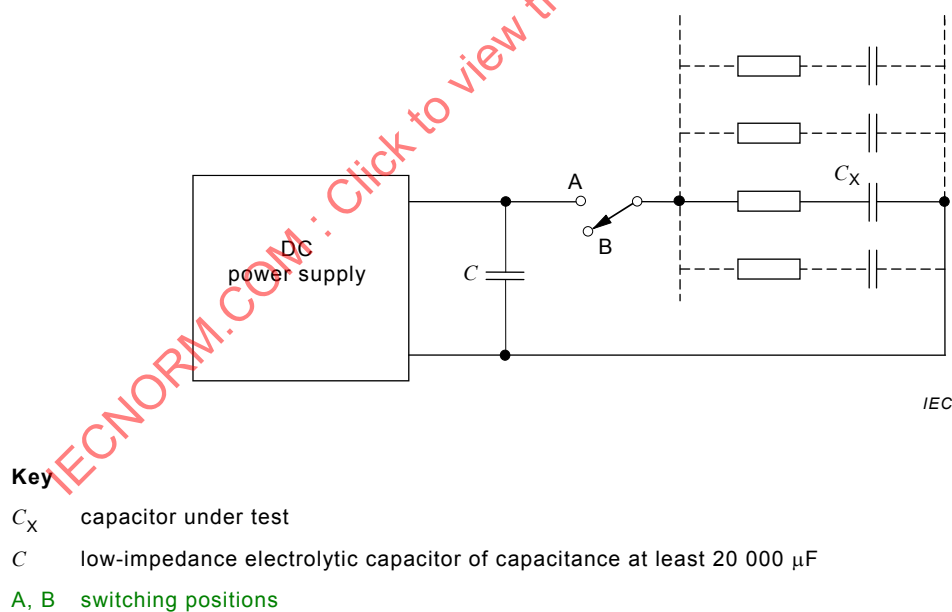


Figure 17 – High surge current test

4.39.3 Requirements for the charging circuit

The test procedure of 4.39.2 shall be carried out with a capacitor of $47\ \mu\text{F} \pm 10\%$, 35 V in the test position, or in every one of the test positions if provision is made for testing capacitors in parallel. The monitoring of the voltage across the capacitor under test shall demonstrate that the peak voltage across the capacitor during charging is $U_R^{+5}_{-2}\%$, and that 90 % of the measured peak voltage is achieved within $60\ \mu\text{s}$ from the time of closure of the switch and

without unwanted transients due to switch bounce or circuit inductance. Where there is provision for testing capacitors in parallel, this requirement shall be verified for each capacitor under test.

NOTE It is unlikely that this requirement will be met unless the d.c. resistance of the charging circuit including wiring, fuse, fixtures, and the series resistance of the tank capacitor is less than $0,5 \Omega$.

4.39.4 Nonconforming items

A capacitor shall be considered a nonconforming item if the fuse blows or the electronic circuit trips at any single charging or discharging of the capacitor.

4.40 Voltage transient overload (for aluminium electrolytic capacitors with non-solid electrolyte)

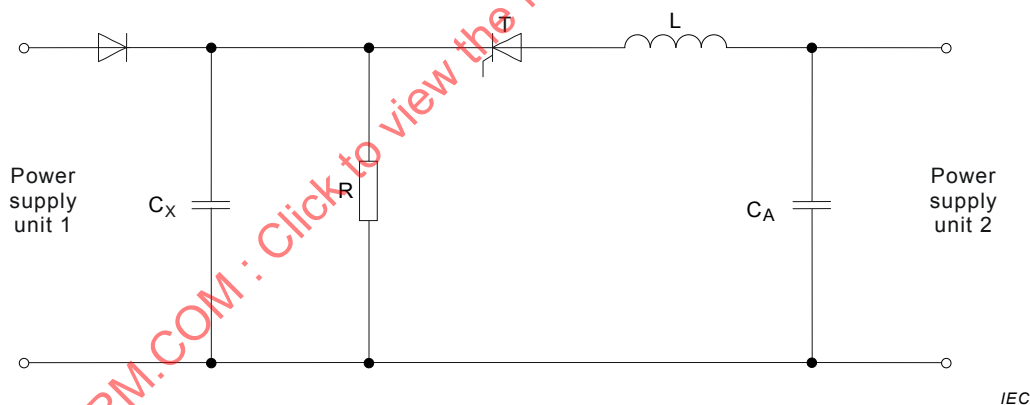
4.40.1 Initial measurement

The measurements prescribed in the detail specification shall be made.

4.40.2 Test procedure

The capacitor(s) shall then be conditioned at the test temperature by having $U_R \pm 1\%$ applied from a regulated power supply. At the end of this period, the test may commence but not later than 48 h after conditioning.

An example of a test circuit is shown in Figure 18.



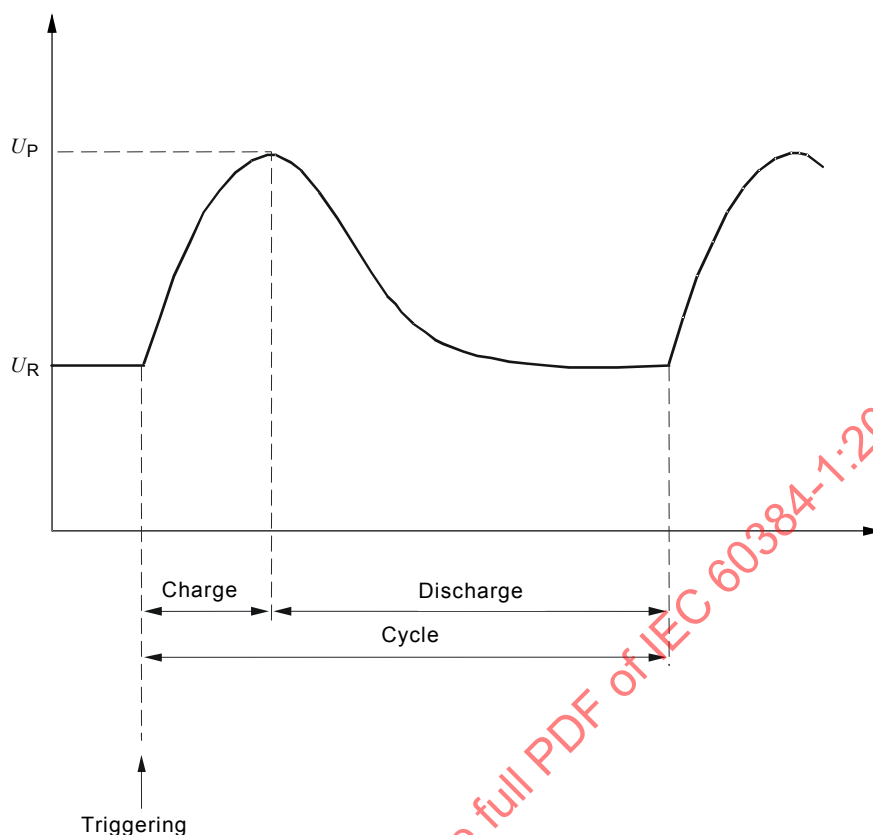
Key

- C_X capacitor under test
- C_A bank capacitor to give a maximum charge time
- R resistor to give a maximum charge time
- L inductor to give a maximum charge time
- T thyristor

Figure 18 – Voltage transient overload test circuit

The capacitor under test C_X is charged from the power supply unit 1, and the auxiliary capacitor bank C_A is charged to a voltage higher than the test voltage U_P from the power supply unit 2. On triggering the thyristor T, the capacitor bank C_A is discharged through the inductor L charging the test capacitor C_X to U_P . On turning the thyristor off, the test capacitor C_X is discharged through the resistor R from U_P down to U_R .

The voltage waveform across the capacitor under test shall be approximately as shown in Figure 19.



IEC

Key

U_P transient peak voltage

U_R rated voltage

Figure 19 – Voltage waveform

4.40.3 Final inspection, measurements and requirements

The measurements specified in the relevant specification shall be made.

4.40.4 Conditions to be prescribed in the relevant specification

The relevant specification shall prescribe:

- the duration of the conditioning period;
- the value of the transient peak voltage U_P ;
- the value of C_A , L and R to give a maximum charge time of 15 ms;
- the duration of each test cycle;
- the number of test cycles;
- the temperature if different from standard atmospheric conditions of testing.

4.41 Whisker growth test

4.41.1 General

If prescribed in the relevant specification, the whisker test shall be based on the recommendations of IEC 60068-2-82.

The relevant specification shall prescribe a suitable fixing jig for the support of the specimen during this test.

4.41.2 Preparation of specimen

The preparation of specimen shall be according IEC 60068-2-82:2007, Clause 5.

Capacitors intended for soldering shall receive a preconditioning by heat treatment according to IEC 60068-2-82:2007, 5.5.

Capacitors with leads shall receive a preconditioning by leads forming according to IEC 60068-2-82:2007, 5.6.

4.41.3 Initial measurement

The appearance of capacitors shall be examined according to IEC 60068-2-82:2007, 7.2.

4.41.4 Test procedures

The ambient test, the damp heat test and the temperature cycling test shall be applied according to the prescriptions in IEC 60068-2-82:2007, Clause 6.

4.41.5 Test severities

The severities of IEC 60068-2-82:2007, Table 6 according to the component's material composition shall be applied.

The following discrimination shall be applied to the selection of the severity of the temperature cycling test:

- a) the severity N, $-55\text{ °C} / 125\text{ °C}$ shall be applied for capacitors with LCT = -55 °C or below and UCT = 125 °C or above,
- b) the severity K, $-40\text{ °C} / 85\text{ °C}$ shall be applied for capacitors with LCT above -55 °C and/or UCT below 125 °C .

4.41.6 Final inspection, measurements and requirements

The capacitors shall be examined for appearance according to IEC 60068-2-82:2007, Annex A.

The whisker shall not exceed the limit prescribed in the detail specification.

Annex A (informative)

Interpretation of sampling plans and procedures as described in IEC 60410 for use within ~~the IECQ system~~ **quality assessment systems**

When using IEC 60410 for inspection by attributes, the interpretations of the clauses and subclauses of IEC 60410, as indicated below, apply for the purpose of this standard.

- 1 The responsible authority is the national authorized institution implementing the basic rules and rules of procedure.
- 1.5 The unit of product is the electronic component defined in a detail specification.
- 2 Only the following definitions from this clause are required:
 - a “defect” is any nonconformance of the unit of product to specified requirements;
 - a “defective” is a unit of product which contains one or more nonconformances.
- 3.1 The extent of nonconformance of a product shall be expressed in terms of per cent defective.
- 3.3 Not applicable.
- 4.5 The responsible authority is the IEC technical committee drafting the blank detail specification which forms part of the generic or sectional specification.
- 5.4 The responsible authority is the designated management representative (DMR), acting in accordance with the procedures prescribed in the document describing the inspection department of the approved manufacturer, and approved by the ~~national supervising inspectorate~~ **Certification Body (CB)**.
- 6.2 The responsible authority is the DMR.
- 6.3 Not applicable.
- 6.4 The responsible authority is the DMR.
- 8.1 Normal inspection shall always be used at the start of inspection.
- 8.3.3 d) The responsible authority is the DMR.
- 8.4 The responsible authority is the national supervising inspectorate.
- 9.2 The responsible authority is the IEC technical committee drafting the blank detail specification which forms part of the generic or sectional specification.
- 9.4 (Fourth sentence only) Not applicable.
(Fifth sentence only) The responsible authority is the DMR.
- 10.2 Not applicable.

Annex B **(~~normative~~ informative)**

Rules for the preparation of detail specifications for capacitors and resistors for electronic equipment for use within ~~the IECQ system~~ quality assessment systems

B.1 Drafting

The drafting of a complete detail specification ~~by IEC technical committee 40~~, if required, shall begin only when all the following conditions have been met.

- a) The generic specification has been approved.
- b) The sectional specification, when appropriate, has been circulated for approval as an Final Draft International Standard (FDIS).
- c) The associated blank detail specification has been circulated for approval as an FDIS.
- d) There is evidence that at least three national committees have formally approved, as their own national standard, specifications covering a component of closely similar performance.

When a national committee formally asserts that substantial or significant use is made within its country of a part described by some other national standard, this assertion may count towards the foregoing requirement.

B.2 Reference standard

Detail specifications ~~prepared under the responsibility of technical committee 40~~ shall use the standard of preferred values, ratings and characteristics and severities for environmental tests, etc., which are given in the appropriate generic or sectional specifications.

~~An exception to this rule may only be granted for a specified detail specification, when agreed by technical committee 40.~~

B.3 Circulation

The detail specification should not be circulated as an FDIS until the sectional and blank detail specifications have been approved for publication.

Annex C
(~~normative~~ **informative**)

Layout of the first page of a PCP/CQC specification

Manufacturer's name

Location

Capability approval number

PCP/CQC specification number

Issue

Capability manual reference number

Date

Description of PCP/CQC

Purpose of PCP/CQC

Drawing reference

Part identity

IECNORM.COM : Click to view the full PDF of IEC 60384-1:2016 RLV

Annex D (~~normative~~ **informative**)

Requirements for capability approval test report

D.1 ~~Introduction~~ General

Capability approval is described in Q.1.1 b).

The test report shall ~~be dated and shall~~ include the information given in Clauses D.2, D.3 and D.4.

D.2 ~~General~~ Requirements

The test report shall be dated and include the following general information:

- manufacturer's name and address;
- place of manufacture, if different from above;
- generic and sectional specification number, issue and amendment date;
- the issue number and date of the description of capability;
- reference to PCP/CQC specification;
- reference to the test programme for capability approval, as applicable;
- a list of test equipment used together with appropriate uncertainties of measurement.

D.3 Summary of test information (for each CQC)

The test report shall include the following summary of test information:

- tests;
- number of specimens tested;
- number of nonconforming items allowed;
- number of nonconforming items found.

D.4 Measurement record

A record of the results of the measurements is taken before and after the various mechanical, environmental, and endurance tests for which post-test limits or final measurements are specified.

Annex E (informative)

Guide for pulse testing of capacitors

E.1 Introduction Overview

Existing testing methods covered by this standard are suitable for capacitors operating in circuits where the applied voltage is predominantly direct voltage. There are now an increasing number of applications in which the applied voltage is in the form of pulse with or without a reversal of polarity. These pulses may be continuous, intermittent, or random in occurrence.

This annex specifies the factors affecting pulse ratings and the way in which these ratings may be checked by appropriate endurance tests. The parameters of a pulse are defined. Different combinations of these parameters can give rise to different causes of failure as follows.

Type	Cause of failure	Test
Electrolytic	Surge voltage exceeded	Surge voltage
	Reverse voltage exceeded	Reverse voltage
	Overheating (I^2R)	Pulse or a.c.
Metallized types	Peak current	Charge/discharge (intermittent)
	du/dt	Pulse
	Overheating (I^2R)	Pulse or a.c.
	Ionization	a.c.
All other	du/dt	Pulse
	Overheating (I^2R)	Pulse or a.c.
	Excess peak voltage	Surge
	Ionization	a.c.

E.2 Typical capacitor pulse conditions

The figures listed below for typical applications show that test specifications requiring 100 000 or 1 million pulses correspond to operations of only 5 s to 50 s.

It is not possible to produce one circuit which will reproduce all of the required conditions.

It is likely, however, that circuits can be produced which will reproduce various groups of conditions. It does not appear possible at the present time to specify accelerated test conditions to simulate, for example, a five-year operation.

a) Examples for TV applications

• S-correction

Typical peak voltage: 25 V, 50 V, 180 V

Typical peak currents: 5 A to 15 A

 du/dt : about 5 V/ μ s

Frequency: 15 kHz to 20 kHz

Reactive power: up to 250 var

• Line tuning

Typical peak voltage: up to 1 500 V

Typical peak current: 5 A

 du/dt : 180 V/ μ s

• Multiplier capacitors

Typical peak voltage: 10 kV d.c. with ripple

Typical peak current: 0,1 A

 du/dt : up to 1 000 V/ μ s

b) Examples for power electronics

Typical peak voltages: 60 V to 100 V

Typical peak currents: 40 A to 100 A

 du/dt : 1 V/ μ s to 20 V/ μ s

Frequencies: 50 Hz to 20 kHz

Reactive power: up to 500 var

c) Example for d.c.-d.c. convertors

Typical peak voltage: 30 V

Typical peak current: 6 A

 du/dt : 600 V/ μ s

Frequency: up to 20 kHz

d) Examples for switch-mode power supplies

Typical peak voltages: 15 V to 400 V

Typical peak currents: 2 A to 10 A

Frequencies: 100 Hz to 40 kHz

e) Examples for lasers and pulse light sources

Typical peak voltages: 1 kV to 3 kV

Typical peak current: 1 000 A

 du/dt : about 500 V/ μ s

Frequencies: 1 kHz to 5 kHz

E.3 Effect of inductance on pulse testing

Proposed pulse test methods are likely to consist of test circuits involving repetitive charge and discharge of capacitors in resistive circuits. This will result in conventional exponential current and voltage characteristics.

In many applications, however, inductive effects are of considerable importance and have a major influence on the suitability of the capacitor for the application.

These are particularly important at high values of du/dt . If the conditions for critical damping exist ($R^2 = 4 \times L/C$), the effect is a minor modification of the shape of the charge or discharge curve which will have little effect on the severity of the test.

If, however, $R^2 < 4 \times L/C$, there can be overshoot with or without damped oscillations.

These can result in overstress and increased power dissipation.

IECNORM.COM : Click to view the full PDF of IEC 60384-1:2016 RLV

Annex F (informative)

Guidance for the extension of endurance tests on fixed capacitors

F.1 ~~Introduction~~ Overview

The regular repetition of endurance tests under the quality conformance inspection ~~of the IECQ~~ within a quality system offers the opportunity to collect not only their results for the certified test records (CTR), but to accumulate them, wherever possible, for the evaluation of reliability data. As the usual duration of endurance tests on capacitors is 1 000 h or 2 000 h, interested parties may wish to extend these tests to evaluate the long-term behaviour of the components concerned and to improve the base for the reliability evaluation. In the following, guidance is given for the performance and evaluation of such extended endurance tests.

F.2 Guidelines

The following guidelines apply.

- a) Test conditions should preferably be the same as for the standard endurance test. If, for any good reason, different test conditions are chosen, they should be clearly indicated.
- b) For final measurements, the same characteristic should be measured as for the standard endurance test.
- c) The preferred duration for such extended endurance tests is 8 000 h.
- d) The extended test is for information only on long-term behaviour and reliability. The measured values are therefore noted for variable analyses or other reliability evaluation without being linked to the failure criteria as specified.
- e) Intermediate measurements (between 2 000 h and 8 000 h) may be made.
- f) If agreed between the parties concerned, the results of the test may be included in the certified test record (CTR) of released lots.
- g) The “translation” of the results of accumulated tests into reliability data is normally the responsibility of the manufacturer. If somebody else wants to use these accumulated test results for his own reliability evaluation, an appropriate acceleration factor for the components concerned ~~must~~ shall be taken into account.

Annex G (normative)

Damp heat, steady state with voltage applied, for metallized film capacitors only

G.1 ~~Introduction~~ Overview

For corrosion sensitivity detection of the metallization of the dielectric film an additional test for damp heat, steady state test with applied ~~d.c.~~ voltage shall be carried out.

The deviation of the average capacitance values of the test group with, and the test group without ~~d.c.~~ voltage, indicates a possible corrosion of the metallization.

G.2 Test procedure

The damp heat, steady state test shall be carried out with applied a.c. or d.c. voltage, depending on the specified rated voltage of the capacitors.

The damp heat, steady state test with applied ~~d.c.~~ voltage shall be carried out on an additional test group. The specimens for both test groups with and without ~~d.c.~~ voltage can only be prepared by the manufacturer of the components, who will take care that the specimen for both groups are produced with identical materials and in identical production processes. The number of specimens for an additional test group with ~~d.c.~~ voltage is the same as the number for the test group without ~~d.c.~~ voltage.

Annex H (normative)

Accelerated damp heat, steady state, for multilayer ceramic capacitors only

H.1 Mounting of capacitors

The capacitors shall be mounted so that each capacitor is connected in series with a resistor. Half of the capacitors shall be connected in series with resistors of $100\text{ k}\Omega \pm 10\%$ and half in series with resistors of $6,8\text{ k}\Omega \pm 10\%$.

H.2 Initial measurement

The capacitors, mounted as in Clause H.1, shall be measured for insulation resistance with a voltage of $1,5\text{ V} \pm 0,1\text{ V}$ applied across the capacitor and resistor in series.

The insulation resistance shall meet the requirements given in the relevant specification.

H.3 Test procedure

The capacitors with associated resistors shall be subjected to conditioning at $(85 \pm 2)^\circ\text{C}$, $(85 \pm 3)\%$ RH for a duration to be specified in the relevant specification. Those capacitors connected to $100\text{ k}\Omega$ resistors shall have a voltage of $(1,5 \pm 0,1)\text{ V}$ applied, and those connected to $6,8\text{ k}\Omega$ resistors shall have $(50 \pm 0,1)\text{ V}$ or U_R applied, whichever is the lower. In both cases the voltage shall be applied across the capacitor/resistor combination.

Care shall be taken to avoid condensation of water on to the capacitors or substrates. Condensation may happen if the door is opened during the test before the humidity is lowered.

H.4 Recovery

The applied voltage shall be disconnected and the capacitors and resistors shall be removed from the test chamber and allowed to recover for 4 h to 24 h in standard atmospheric conditions for testing.

H.5 Final inspection, measurements and requirements

The capacitors, mounted as in accordance with Clause H.1, shall be measured for insulation resistance as in Clause H.2 above.

The insulation resistance shall be greater than 0,1 times the initial limit.

Annex Q (~~normative~~ informative)

Quality assessment procedures

~~Q.1 General~~

~~When this standard, and any related standards are used for the purpose of a full quality assessment system such as the IEC Quality Assessment System for Electronic Components (IECQ), compliance with Clauses Q.5, Q.6 or Q.14 is required.~~

~~When such standards are used outside quality assessment systems for purposes such as design proving or type testing, the procedures and requirements of Q.5.1 and Q.5.3 b) may be used, but, if used, the tests and parts of tests shall be applied in the order given in the test schedules.~~

~~Before components can be qualified according to the procedures of this clause, the manufacturer shall obtain the approval of his organization in accordance with the provisions of IEC QC 001002-3.~~

~~The methods that are available for the approval of components of assessed quality and which are covered by the following subclauses, are:~~

- ~~— qualification approval according to the provisions of IEC QC 001002-3, Clause 3;~~
- ~~— capability approval according to the provisions of IEC QC 001002-3, Clause 4;~~
- ~~— technology approval according to the provisions of IEC QC 001002-3, Clause 6.~~

~~For a given subfamily of components, separate sectional specifications for qualification approval and capability approval are necessary and capability approval is therefore available only when a relevant sectional specification has been published.~~

~~Q.1.1 Applicability of qualification approval~~

~~Qualification approval is appropriate for a standard range of components manufactured to similar design and production processes and conforming to a published detail specification.~~

~~The programme of tests defined in the detail specification for the appropriate assessment and performance levels applies directly to the component range to be qualified, as prescribed in Clause Q.5 and the relevant sectional specification.~~

~~Q.1.2 Applicability of capability approval~~

~~Capability approval is appropriate when components based on common design rules are fabricated by a group of common processes. It is particularly appropriate when components are manufactured to a user's specific requirements.~~

~~Under capability approval, detail specifications fall into the following three categories.~~

~~Q.1.2.1 Capability qualifying components (CQCs), including process validation test vehicles~~

~~A detail specification shall be prepared for each CQC as agreed with the national supervising inspectorate (NSI). It shall identify the purpose of the CQC and include all relevant test severities and limits.~~

~~Q.1.2.2 — Standard catalogue components~~

~~When the manufacturer requires a component approved under the capability approval procedure to be listed in the IECQ register of approvals, a capability approval detail specification complying with the blank detail specification shall be written. Such specifications shall be registered by the IECQ and the component shall be listed in IEC QC 001005³ approved under the IECQ system, including ISO 9000.~~

~~Q.1.2.3 — Customer specific components~~

~~The content of the detail specification (often known as a customer detail specification (CDS)) shall be by agreement between the manufacturer and customer in accordance with IEC QC 001002-3, 4.4.3.~~

~~Further information on these detail specifications is given in the relevant sectional specification.~~

~~Approval is given to a manufacturing facility on the basis of validated design rules, processes and quality control procedures and the results of tests on capability qualifying components, including any process validation test vehicles. See Clause Q.6 and the relevant sectional specification for further information.~~

~~Q.1.3 — Applicability of technology approval~~

~~Technology approval is appropriate when the complete technological process (design, process realization, product manufacture, test and shipment) covers the qualification aspects common to all components determined by the technology.~~

~~Q.2 — Primary stage of manufacture~~

~~The primary stage of manufacture shall be specified in the sectional specification.~~

~~Q.3 — Subcontracting~~

~~If subcontracting of the primary stage of manufacture and/or subsequent stages is employed it shall be in accordance with IEC QC 001002-3, 4.2.2.~~

~~The sectional specification may restrict subcontracting in accordance with of IEC QC 001002-3, 4.2.2.2.~~

~~Q.4 — Structurally similar components~~

~~The grouping of structurally similar components for qualification approval testing or for quality conformance testing under qualification approval, capability approval or technology approval shall be prescribed in the relevant sectional specification.~~

~~Q.5 — Qualification approval procedures~~

~~Q.5.1 — Eligibility for qualification approval~~

~~The manufacturer shall comply with IEC QC 001002-3, 3.1.1.~~

³ IEC QC 001005 has been withdrawn; see www.iecq.org/certificates for relevant information.

~~Q.5.2 — Application for qualification approval~~

~~The manufacturer shall comply with IEC QC 001002-3, 3.1.3.~~

~~Q.5.3 — Test procedure for qualification approval~~

~~One of the following procedures shall be used.~~

- ~~a) The manufacturer shall produce test evidence of conformance to the specification requirements on three inspection lots for lot by lot inspection taken in as short a time as possible, and on one lot for periodic inspection. No major changes in the manufacturing process shall be made in the period during which the inspection lots are taken.~~

~~Samples shall be taken from the lots in accordance with IEC 60410 (see Annex A). Normal inspection shall be used, but if the sample size gives acceptance on zero non-conformances, additional specimens shall be taken to meet the sample size requirements to give acceptance on one nonconforming item.~~

- ~~b) The manufacturer shall produce test evidence to show conformance to the specification requirements on the fixed sample size test schedule given in the sectional specification.~~

~~The specimens taken to form the sample shall be selected at random from current production or as agreed with the NSI.~~

~~For the two procedures, the sample sizes and the number of permissible non-conformances shall be of comparable order. The test conditions and requirements shall be the same.~~

~~Q.5.4 — Granting of qualification approval~~

~~Qualification approval shall be granted when the procedures in accordance with IEC QC 001002-3, 3.1.4 have been completed satisfactorily.~~

~~Q.5.5 — Maintenance of qualification approval~~

~~Qualification approval shall be maintained by regular demonstration of compliance with the requirements for quality conformance (see Q.5.6).~~

~~Q.5.6 — Quality conformance inspection~~

~~The blank detail specification(s) associated with the sectional specification shall prescribe the test schedule for quality conformance inspection. This schedule shall also specify the grouping, sampling and periodicity for the lot by lot and periodic inspection.~~

~~Operation of the switching rule for reduced inspection in Group C is permitted in all subgroups except endurance.~~

~~Sampling plans and inspection levels shall be selected from those given in IEC 60410 or IEC 61193-2.~~

~~If required, more than one schedule may be specified.~~

~~Q.6 — Capability approval procedures~~

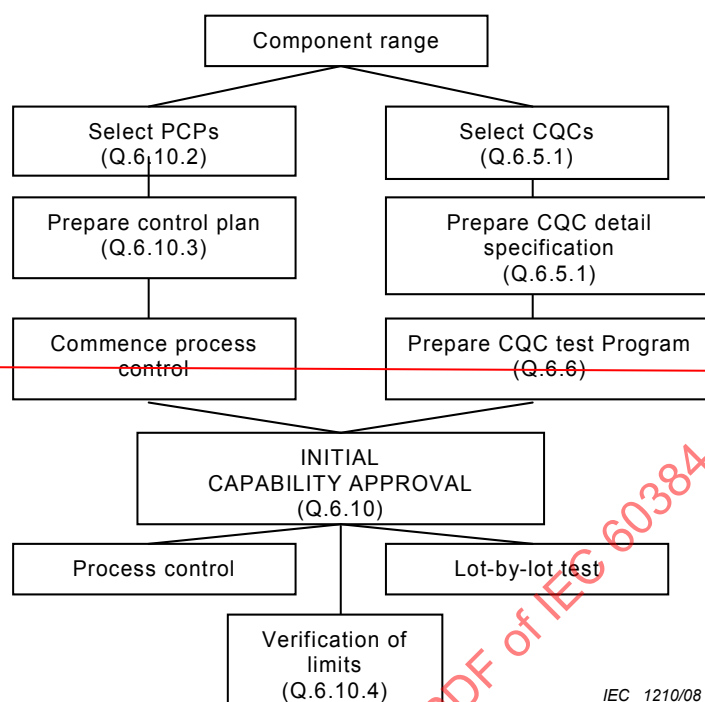
~~Q.6.1 — General~~

~~Capability approval covers~~

- ~~— the complete design, material preparation and manufacturing techniques, including control procedures and tests;~~
- ~~— the performance limits claimed for the processes and products, that is, those specified for the capability qualifying components (CQCs) and process control parameters (PCPs);~~

— the range of mechanical structures for which approval is granted.

For a general overview of capability approval see Figure Q.1.



IEC 1210/08

Figure Q.1 — General scheme for capability approval

Q.6.2 — Eligibility for capability approval

The manufacturer shall comply with the requirements of IEC QC 001002-3, 4.2.1.

Q.6.3 — Application for capability approval

The manufacturer shall comply with the requirements of IEC QC 001002-3, 4.2.4, and with the requirements of the relevant sectional specification.

Q.6.4 — Description of capability

The capability shall be described in a capability manual in accordance with IEC QC 001002-3, 4.2.5, and the requirements of the relevant sectional specification. The manual shall include or make reference to the following as a minimum:

- a general introduction and description of the technologies involved;
- aspects of customer liaison including provisions of design rules (if appropriate) and assistance to customers in the formulation of their requirements;
- a detailed description of the design rules to be used;
- the procedure for checking that the design rules are complied with for the relevant component technology manufactured to a detail specification;
- a list of all materials used, with reference to the corresponding purchasing specifications and goods inward inspection specifications;
- a flow chart for the total process, showing quality control points and permitted rework loops and containing references to all process and quality control procedures;
- a declaration of processes for which approval has been sought in accordance with the requirements of the relevant sectional specification;

- ~~— a declaration of limits for which approval has been sought in accordance with the requirements of the relevant sectional specification;~~
- ~~— a list of CQCs used to assess the capability, with a general description of each, supported by a detailed table showing where the declared limits of capability are demonstrated by a particular CQC design;~~
- ~~— detail specification for each CQC;~~
- ~~— a detailed control plan including PCPs used to control processes, with a general description of each PCP and showing the relation between a given PCP and the related properties and performance of the finished component;~~
- ~~— guidance on the application of structural similarity in sampling for quality conformance testing.~~

~~The NSI shall treat the capability manual as a confidential document. The manufacturer may, if he so wishes, disclose part or all of it to a third party.~~

Q.6.5 — Demonstration and verification of capability

~~The manufacturer shall demonstrate and verify the capability in accordance with IEC QC 001002-3, 4.2.6, and the requirements of the relevant sectional specification with the following details:~~

Q.6.5.1 — CQCs for demonstrating capability

~~The manufacturer shall agree with the NSI the process qualifying parameters and the range of capability qualifying components which are necessary to demonstrate the capability range specified in the capability manual.~~

~~The demonstration shall be made by testing the agreed range of CQCs, which shall be designed, manufactured and the process parameters controlled in accordance with the capability manual. The CQCs shall comply with the following requirements:~~

- ~~a) The range of CQCs used shall represent all the limits of the declared capability. The CQCs shall be chosen to demonstrate mutually attainable combinations of limits.~~
- ~~b) The CQCs shall be one of the following:

 - ~~— components specially designed to demonstrate a combination of limits of capability, or~~
 - ~~— components of designs used in general production, or~~
 - ~~— a combination of both of these, provided the requirements of a) are met.~~~~

~~When CQCs are designed and produced solely for capability approval, the manufacturer shall use the same design rules, materials and manufacturing processes as those applied to released products.~~

~~A detail specification shall be prepared for each CQC and shall have a front page format in accordance with Annex C. The detail specification shall identify the purpose of the CQC and shall include all relevant stress levels and test limits. It may refer to internal control documentation which specifies production testing and recording in order to demonstrate control and maintenance of processes and limits of capability.~~

Q.6.5.2 — Limits of capability

~~The limits of capability shall be described in the relevant sectional specification.~~

Q.6.6 — Programme for capability approval

~~In accordance with IEC QC 001002-3, 4.2.6, the manufacturer shall prepare a programme for the assessment of the declared capability. This programme shall be so designed that each declared limit of capability is verified by an appropriate CQC.~~

~~The programme shall include the following:~~

- ~~— a bar chart or other means of showing the proposed timetable for the approval exercise;~~
- ~~— details of all the CQCs to be used with references to their detail specifications;~~
- ~~— a chart showing the features to be demonstrated by each CQC;~~
- ~~— reference to the control plans to be used for process control.~~

Q.6.7 — Capability approval test report

~~In accordance with IEC QC 001002-3, 4.2.6.3, a capability approval test report shall be issued. The report shall meet the specific requirements of Annex D of this specification and shall contain the following information:~~

- ~~— the issue number and date of the capability manual;~~
- ~~— the programme for capability approval in accordance with Q.6.6;~~
- ~~— all the test results obtained during the performance of the programme;~~
- ~~— the test methods used;~~
- ~~— reports on actions taken in the event of failure (see Q.6.10.1).~~

~~The report shall be signed by the designated management representative (DMR) as a true statement of the results obtained and submitted to the body designated in the national rules, which is responsible for the granting of capability approval.~~

Q.6.8 — Abstract of description of capability

~~The abstract is intended for formal publication in IEC QC 001005⁴ after capability approval has been granted.~~

~~The abstract shall include a concise description of the manufacturer's capability and give sufficient information on the technology, methods of construction and range of products for which the manufacturer has been approved.~~

Q.6.9 — Modifications likely to affect the capability approval

~~Any modifications likely to affect the capability approval shall satisfy the requirements of IEC QC 001002-3, 4.2.11.~~

Q.6.10 — Initial capability approval

~~The approval is granted when~~

- ~~— the selected range of CQCs has collectively satisfied the assessment requirements of the CQC detail specifications, with no nonconforming item allowed;~~
- ~~— the control plan has been fully implemented in the process control system.~~

Q.6.10.1 — Procedure in the event of failure

~~See IEC QC 001002-3, 4.2.10, with the following details:~~

~~In the event of the failure of the specimens to meet the test requirements, the manufacturer shall notify the NSI and shall state his intention to follow one of the actions described in a) and b) below:~~

- ~~a) to modify the proposed scope of his capability.~~
- ~~b) to conduct an investigation to establish the cause of failure as being either~~

⁴ ~~IEC QC 001005 has been withdrawn; see www.iecq.org/certificates for relevant information.~~

- failure of the test itself, for example, test equipment failure or operator error;
- or
- design or process failure.

If the cause of failure is established as a failure of the test itself, then either the specimen which apparently failed or a new one, if appropriate, shall be returned to the test schedule after the necessary corrective action has been taken. If a new specimen is to be used, it shall be subjected to all of the tests in the given sequence of the test schedule(s) appropriate to the apparently failed specimen.

If the cause of failure is established as a design or process failure, a test programme shall be carried out to demonstrate that the cause of failure has been eradicated and that all corrective measures, including documentation, have been carried out. When this has been accomplished, the test sequences in which the failure has occurred shall be repeated in full using new CQCs.

After the action is complete the manufacturer shall send a report to the NSI, and shall include a copy in the capability approval test report (see Q.6.7).

Q.6.10.2 — General plan for the selection of PCPs and CQCs

Each manufacturer shall prepare a process flow chart, based on the example given in the relevant sectional specification. For all the process steps included in his flow chart, the manufacturer shall include the corresponding process controls.

Controls shall be denoted by the manufacturer as shown in the example in the relevant sectional specification.

Q.6.10.3 — Process control test plans

The test plans shall form part of the process control system used by the manufacturer. When statistical process control (SPC) is used, implementation shall be in accordance with SPC basic requirements. The SPC plans represent mandatory controls at process nodes.

For each process step where production equipment is employed, the manufacturer shall monitor the process parameters at regular intervals and compare the readings to the control and action limits which he will establish.

Q.6.10.4 — Test plans for CQCs demonstrating limits of capability

Test plans for CQCs for the demonstration of limits of capability shall be prescribed in the relevant sectional specification.

Q.6.11 — Granting of capability approval

Capability approval shall be granted when the procedures in accordance with IEC QC 001002-3, 4.2.6, have been completed satisfactorily and the requirements of the relevant sectional specification have been met.

Q.6.12 — Maintenance of capability approval

Capability approval shall be maintained by complying with the requirements of IEC QC 001002-3, 4.2.9, and with the requirements declared in the capability manual following the schedule of maintenance given in the relevant sectional specification.

Additionally, the following details apply.

- a) capability approval remains valid without retesting for two years.

- b) ~~the programme for the retesting of CQCs shall be defined by the manufacturer. For process control, the manufacturer shall establish a control system. An example of a control programme chart may be given in the sectional specification. For verifying limits of capability, the manufacturer shall ensure that all the test plans of Q.6.10.4 which are relevant to his capability approval are repeated at least every two years.~~
- c) ~~quality conformance inspection of components for delivery may be used to support the maintenance of capability approval where relevant. In particular, where the manufacturer holds qualification approval for a range of components which are manufactured by the same processes and which also fall within the limits of capability for which he holds capability approval, process control test results and periodic quality conformance test results arising from the qualification approval may be used to support the maintenance of capability approval.~~
- d) ~~the manufacturer shall ensure that the range of CQCs remains representative of the products released and in accordance with the requirements of the relevant sectional specification.~~
- e) ~~the manufacturer shall maintain production, so that~~
- ~~— the processes specified in the capability manual, with the exception of any additions or deletions agreed with the NSI following the procedure of Q.6.9, remain unchanged;~~
 - ~~— no change has occurred in the place of manufacture, and final test;~~
 - ~~— no break exceeding six months has occurred in the manufacturer's production under capability approval.~~
- f) ~~the manufacturer shall maintain a record of the progress of the maintenance of capability programme so that at any time the limits of capability which have been verified and those which are awaiting verification in the specified period can be established.~~

Q.6.13 — Extension of capability approval

~~The manufacturer may extend the limits of his capability approval by carrying out the test plan from Q.6.10.4, which relates to the type of limit to be extended. If the proposed extension refers to a different type of limit from those described in Q.6.10.4, the manufacturer shall propose the sampling and tests to be used and these shall be approved by the NSI. The manufacturer shall also establish process control over any new processes needed for manufacture to the new limits.~~

~~An application for an extension of capability shall be made in the same way as for the original approval.~~

Q.6.14 — Quality conformance inspection

~~The quality conformance test requirements are given in the detail specification and shall be carried out in accordance with IEC QC 001002 3, 4.3.1.~~

Q.7 — Rework and repair

Q.7.1 — Rework

~~Rework as defined in IEC QC 001002 3, 4.1.4, shall not be carried out if prohibited by the relevant sectional specification. The relevant sectional specification shall state if there is a restriction on the number of occasions that rework may take place on a specific component.~~

~~All rework shall be carried out prior to the formation of the inspection lot offered for inspection in accordance with the requirements of the detail specification.~~

~~Such rework procedures shall be fully described in the relevant documentation produced by the manufacturer and shall be carried out under the direct control of the DMR. Rework shall not be subcontracted.~~

~~Q.7.2 Repair~~

~~Components which have been repaired as defined in IEC QC 001002-3, 4.1.5, shall not be released under the IECQ system.~~

~~Q.8 Release for delivery~~

~~Components shall be released for delivery according to Q.5.6 and IEC QC 001002-3, 4.3.2, after the quality conformance inspection prescribed in the detail specification has been carried out.~~

~~Q.8.1 Release for delivery under qualification approval before the completion of Group B tests~~

~~When the conditions of IEC 60410 for changing to reduced inspection have been satisfied for all Group B tests, the manufacturer is permitted to release components before the completion of such tests.~~

~~Q.9 Certified test records of released lots~~

~~When certified test records are requested by a purchaser, they shall be specified in the detail specification.~~

~~NOTE For capability approval, the certified test records refer only to tests carried out on capability qualifying components.~~

~~Q.10 Delayed delivery~~

~~Components held for a period exceeding two years (unless otherwise specified in the sectional specification) following the release of the lot shall, before delivery, be re-examined for solderability and electrical characteristics as specified in the detail specification.~~

~~The re-examination procedure adopted by the manufacturer's DMR shall be approved by the NSI.~~

~~Once a lot has been satisfactorily re-inspected, its quality is reassured for the specified period.~~

~~Q.11 Alternative test methods~~

~~See IEC QC 001002-3, 3.2.3.7, with the following details.~~

~~In case of dispute, for referee and reference purposes, only the specified methods shall be used.~~

~~Q.12 Manufacture outside the geographical limits of IECQ NSIs~~

~~A manufacturer may have his approval extended to cover partial or complete manufacture of components in a factory of his company located in a country which does not have an NSI for the technical area concerned, whether this country is a IECQ member country or not, provided that the requirements of IEC QC 001002-3, 2.5.1.3, are met.~~

Q.13 Unchecked parameters

Only those parameters of a component which have been specified in a detail specification and which were subject to testing shall be assumed to be within the specified limits. It cannot be assumed that any unspecified parameter will remain unchanged from one component to another. If it is necessary, for any reason, to control one or more additional parameters, then a new, more extensive specification shall be used.

The additional test method(s) shall be fully described and appropriate limits, sampling plans and inspection levels specified.

Q.14 Technology approval procedures

Q.14.1 General

Technology approval of components covers the complete technological process. It extends the existing concepts – qualification and capability approval – by adding as mandatory

- a) the use of in-process control methods, for example, SPC;
- b) continuous quality improvement strategy;
- c) monitoring the overall technologies and operations;
- d) procedural flexibility due to the quality assurance management system and market sector requirements;
- e) the acceptance of a manufacturer's operational documentation to provide means for rapid approval or extension of approval.

Q.14.2 Eligibility for technology approval

The manufacturer shall comply with IEC QC 001002-3, 6.2.1.

Q.14.3 Application of technology approval

The manufacturer shall comply with IEC QC 001002-3, 6.2.2.

Q.14.4 Description of technology

The technology shall be described in a Technology Approval Declaration Document (TADD) and a Technology Approval Schedule (TAS) in accordance with IEC QC 001002-3, 6.4.

Q.14.5 Demonstration and verification of the technology

The manufacturer shall demonstrate and verify the technology in accordance with IEC QC 001002-3, 6.4 and 6.5.

Q.14.6 Granting of technology approval

Technology approval shall be granted when the procedures in accordance with IEC QC 001002-3, 6.7.3 have been completely satisfied.

Q.14.7 Maintenance of technology approval

Technology approval shall be maintained by complying with the requirements of IEC QC 001002-3, 6.7.5.

Q.14.8 Quality conformance inspection

The quality conformance test and requirements shall be carried out in accordance with the relevant detail specification and technology approval schedules.

~~Q.14.9 Failure rate level determination~~

~~The determination of failure rate level and certification shall be described in the relevant specification.~~

~~Q.14.10 Outgoing quality level~~

~~The definition shall be agreed between customer and manufacturer.~~

Q.1 General

Q.1.1 Scope of this annex

This generic specification and related sectional and detail specifications can be used for the purpose of a full quality assessment system. The following types of approval are provided.

- a) Qualification Approval (QA) is applicable to an identified component or range of components manufactured to similar design and production processes, for which a detail specification exists. Such a detail specification shall be based on this generic specification and a relevant sectional specification and shall give provisions for a QA.

QA is granted to a manufacturer according to the provisions of Clause Q.2 when it has been established that the components meet the requirements of the detail specification.

The test schedules prescribed in the detail specification for the initial product qualification approval and for the product quality conformance inspections apply directly to the component or range to be qualified.

- b) Capability Approval (CA) is applicable to an identified component manufacturing process and set of design rules for which an applicable sectional specification exists. Such a sectional specification shall be based on this generic specification and shall give provisions for a CA.

CA is granted to a manufacturer according to the provisions of Clause Q.3 when it has been established that his capability for manufacturing processes and quality control methods covering a specific component technology meet the requirements of the relevant specifications.

There are different detail specifications used under CA. At least one detail specification is released for the Capability Qualifying Components (CQC), identifying the component's purpose and prescribing the relevant tests and requirements. Other detail specifications are released for the deliverable components and thus may cover standard catalogue components or customer specific components.

- c) Technology Approval (TA) is appropriate when the complete technological process (design, process realization, product manufacture, test and shipment) covers the qualification aspects common to all components determined by the technology. It incorporates the most recent principles and techniques in quality management and provides for the use of statistical methods and tools, continuous improvement and procedural flexibility.

TA is applicable to an identified electronic component manufacturing activity for which a Technology Approval Schedule (TAS) exists.

TA is granted to a manufacturer according to the provisions of Clause Q.4, when it has been demonstrated that the quality management system established for his electronic component manufacturing activity complies with the contents of his/her Technology Approval Declaration Document (TADD), and meets the requirements of the TAS.

The identification of an electronic component manufacturing activity shall be based on component(s) or range(s) of components manufactured to similar design and production processes, for which detail specification(s) exist(s). Such detail specification(s) shall be based on this generic specification and relevant sectional specification(s) and shall give relevant provisions for a technology approval. Such applied detail specifications are to be referenced in the TA.

A prerequisite for obtaining any of these approvals is that a manufacturer has obtained the approval of manufacturer in accordance with the provisions of the relevant certification body.

Q.1.2 Quality assessment definitions

Q.1.2.1 Primary stage of manufacture

The primary stage of manufacture shall be specified in the sectional specification.

Examples of the primary stage of manufacture are:

- For film capacitors:
the winding of the capacitor element or the equivalent operation.
- For ceramic capacitors:
the first common firing of the dielectric-electrode assembly.
- For electrolytic capacitors:
the capacitor manufacturer's evaluation of the formed anode foil.

Q.1.2.2 Structurally similar components

The grouping of structurally similar components for the initial product qualification approval testing or for the product quality conformance testing under QA, CA or TA shall be prescribed in the relevant sectional specification.

Q.1.2.3 Assessment level

An assessment level prescribes the severity of the test schedules, the sampling plans and the number of permissible non-conforming items in each test group. Assessment levels EZ and DZ meet the requirements of the zero defect approach and align the assessment procedures and levels with the current industry practices, e.g. by setting the number of permitted non-conformities (acceptance number) to zero. The sectional specifications shall prescribe the requirements to the test schedules for use in all related detail specifications.

NOTE 1 A variety of assessment levels existed historically, e.g. with different numbers of permissible non-conformities per test. Only the assessment levels EZ and DZ are used in recent specifications.

The sampling plans and inspection levels for assessment levels EZ and DZ shall be selected from those given in IEC 61193-2, except for those elements of the test schedule which are based on fixed sample sizes, irrespective of the size of the lot being inspected.

NOTE 2 The assessment of a quality level close or equal to zero defects by sampling only would lead to an unreasonable increase of inspection efforts. Hence, zero acceptance number sampling plans can only apply to the inspection of products that are manufactured under suitable process control with the target of a zero-defect quality level before sampling inspection.

Q.1.2.4 Failure rate level determination (if applied)

The determination of failure rate level and certification shall be described in the relevant specification.

Q.1.3 Rework

Rework is the rectification of a processing error by means not differing from those used in the current process, or by an explicitly permitted rework process prior to release of the component.

Rework shall not be carried out if prohibited by the relevant sectional or detail specification.

Applicable rework procedures shall be permitted by the relevant sectional or detail specification and shall be fully described in the relevant documentation produced by the

manufacturer. All rework shall be carried out under supervision of the Designated Management Representative (DMR) prior to the formation of the inspection lot offered for inspection to the requirements of the detail specification.

Q.1.4 Alternative test methods

The test and measurement methods given by the relevant specification are intended to unify test and measurement procedures. They are not necessarily the only methods which can be used except when specifically designated as referee or reference methods.

An approved manufacturer shall demonstrate to the Certification Body (CB) that any alternative method he uses will give results equivalent to those obtained by the specified method.

In case of dispute, the specified methods take precedence over any alternative method.

Q.1.5 Certified test records of released lots

When certified test records are prescribed in the relevant specification and are requested by a customer, the following information shall be given as a minimum.

- a) Attributes information (that is the number of components tested and the number of non-conforming components) for tests in the sub-groups covered by periodic inspection without reference to the parameter for which rejection was made.
- b) Variables information (that is average and range for the change in capacitance and number of tested components) for periodic tests specified in the relevant sectional specification.

NOTE Under CA a certified test record refers only to tests carried out on capability qualifying components.

Q.1.6 Unchecked parameters

Only those parameters of a component which have been specified in the detail specification and which were subject to testing shall be assumed to be within the specified limits. It cannot be assumed that any unspecified parameter will remain unchanged from one component to another.

A new, more extensive specification shall be used if control of any additional parameter is required. Then the additional test method shall be fully described with specification of sampling plans, inspection levels and requirements and applied in a relevant test schedule.

Q.1.7 Delayed delivery

Components are considered to meet the stated requirements for a period of two years after manufacture and lot release when stored under appropriate conditions, unless otherwise specified in the relevant specification.

Components held for a period exceeding that retention period shall prior to delivery be re-examined for solderability and for electrical characteristics as prescribed in the relevant specification. The sampling and procedure applied for re-examination shall be approved by the Certification Body (CB).

Components are qualified for another retention period, if all relevant requirements were met in the re-examination.

Q.1.8 Repair

Repair consists of rendering an approved component usable which has been damaged or has become defective after its release.

Components which have been repaired shall not be released under any specified quality assessment system.

Q.1.9 Registration of approvals

Approvals shall be based on a published detail specification complying with this generic specification and a relevant sectional specification.

The achieved approvals shall be entered in a relevant and published Register of Approvals, e.g. in the approvals section “online certificates” of the website www.iecq.org. Such entries shall contain all necessary details on the approval, including the applied specifications and the scope of the approval, e.g. designation, variant(s) and range(s) of the approved component(s).

Q.1.10 Manufacture outside the geographical limits

See the requirements of the specified quality assessment system (if any).

Q.2 Qualification approval (QA) procedures

Q.2.1 Eligibility for qualification approval

A qualification approval may be granted to a manufacturer holding a manufacturer's approval.

A component is eligible for QA if the manufacturing process, including the prescribed primary stage of manufacture, is carried out under direct supervision of the relevant Designated Management Representative (DMR).

Q.2.2 Application for qualification approval

The manufacturer shall comply with the specified quality assessment system (if any).

Q.2.3 Subcontracting

The relevant specification may restrict subcontracting according to the specified quality assessment system (if any).

If subcontracting of the primary stage of manufacture and/or subsequent stages is employed, it shall be in accordance with the specified quality assessment system (if any).

Q.2.4 Test procedure for the initial product qualification approval

The detail specification shall prescribe the test schedule and the requirements for the initial product qualification approval testing.

The sampling and formation of inspection lots shall be prescribed in the sectional specification or in the detail specification. The sampling plan for the initial product qualification approval testing is based on the fixed sample size procedure, with the number of permissible non-conforming specimen set to zero (e.g. assessment level EZ).

The specimen for an inspection lot shall be collected at random over a short time within an inspection period, not including any major change of the manufacturing process.

Q.2.5 Granting of qualification approval

Qualification approval shall be granted when the procedures in accordance with the specified quality assessment system (if any) have been completed satisfactorily.

Q.2.6 Maintenance of qualification approval

A QA shall be maintained by regular quality conformance inspections in order to demonstrate the compliance with the requirements for quality conformance prescribed in the detail specification.

Q.2.7 Quality conformance inspection

The test schedule and the requirements for the product quality conformance inspection shall be prescribed in the detail specification.

The sampling and formation of inspection lots shall be prescribed in the sectional specification or in the detail specification. The sampling plans and inspection levels shall be selected from those given in IEC 61193-2, for the part of the product quality conformance inspection schedule based on variable sample sizes, as used for the lot-by-lot testing. The sampling plan for the periodic product quality conformance inspection testing is based on the fixed sample size procedure. The number of permissible nonconforming specimen for each test group of both test schedules is set to zero (e.g. assessment level EZ).

The specimen for an inspection lot shall be collected at random over a short time within an inspection period, not including any major change of the manufacturing process.

Utilisation of the switching rule for reduced inspection in Group C of the test schedule is permitted in all subgroups except endurance, unless otherwise prescribed in the relevant specification.

Q.3 Capability approval (CA) procedures

Q.3.1 General

Capability Approval covers a manufacturing process and quality control methods (including design aspects as applicable) for a specific component technology with clearly defined scope and limits of the employed manufacturing capability.

The capability shall be demonstrated on Capability Qualifying Components (CQC), which serve as specimen for initial qualification testing and for subsequent quality conformance inspections. There shall be a detail specification for a CQC, based on this generic specification and on a sectional specification, giving the provisions for a CA.

A detailed Process Control Plan (PCP) shall be used for inspections to be carried out during the manufacturing process applied to the manufacturing of components for release.

There shall be specific detail specifications for standard catalogue components and for customer specific components to be released under capability approval. They shall be based on this generic specification and on the same sectional specification supporting the detail specification for the CQC.

Q.3.2 Eligibility for capability approval

The manufacturer shall comply with the requirements of the specified quality assessment system (if any).

A component manufacturer is eligible for CA if the manufacturing process, including the prescribed primary stage of manufacture, is carried out under direct supervision of the relevant Designated Management Representative (DMR).

Q.3.3 Application for capability approval

The manufacturer shall comply with the requirements of the specified quality assessment system (if any), and with the requirements of the relevant sectional specification.

Q.3.4 Subcontracting

The relevant specification may restrict subcontracting according to the rules of the specified quality assessment system (if any).

If subcontracting of the primary stage of manufacture and/or subsequent stages is employed, it shall be in accordance with the specified quality assessment system (if any).

Q.3.5 Description of the capability

The manufacturer shall describe the capability relevant to the manufacturing technology and range of products involved in a Capability Manual (CM), which shall meet the requirements of the specified quality assessment system (if any). The CM shall state the limits of the covered technology, and design rules, if applicable.

The CM may be subject to confidentiality, hence the manufacturer shall provide an abstract of the description of capability suitable for publication.

Q.3.6 Demonstration and verification of capability

The verification of the claimed capability shall demonstrate compliance with the contents of the CM and utilize Capability Qualifying Components (CQC) and the Process Control Plan (PCP), as required by the specified quality assessment system (if any).

The CQCs shall be used to demonstrate the limits of capability and compliance with the relevant detail specification.

Q.3.7 Granting of capability approval

Capability approval shall be granted when the procedures in accordance with the specified quality assessment system (if any) have been completed satisfactorily and the requirements of the relevant sectional specification have been met.

Q.3.8 Maintenance of capability approval

A Capability Approval shall be maintained according to the specified quality assessment system (if any) and to the respective descriptions of the CM by regular quality conformance inspections on the CQCs in order to demonstrate the compliance with the requirements for quality conformance prescribed in the relevant detail specification.

Q.3.9 Quality conformance inspection

Quality conformance inspections shall be executed according to the provisions of the specified quality assessment system (if any) and to the respective descriptions of the CM.

The test schedule and the requirements for the quality conformance inspection shall be prescribed in the relevant detail specification(s) for deliverable components, e.g. the specific detail specifications for standard catalogue components or for customer specific components.

The sampling and formation of inspection lots shall be prescribed in the sectional specification or in the detail specification. The sampling plans and inspection levels shall be selected from those given in IEC 61193-2, except for those elements of the test schedule which are based on fixed sample sizes.

The specimen for an inspection lot shall be collected at random over a short time within an inspection period, not including any major change of the manufacturing process.

Q.4 Technology approval (TA) procedure

Q.4.1 General

Technology Approval is a method of approving a complete technological process covering the approval aspects common to all products as determined by the technology under consideration. It extends the existing suite of approval concepts (QA and CA) by adding the following principles as mandatory aspects:

- a) a formal system for quality management, actively involving all employees in the commitment to quality;
- b) use of in-process control methods, for example, SPC, to be defined in a Technology Approval Schedule (TAS);
- c) a strategy for continuous quality improvement;
- d) monitoring the overall technologies and operations associated with the design and manufacturing processes as well as the components themselves;
- e) procedural flexibility due to the underlying quality assurance management system and market sector requirements;
- f) acceptance of a manufacturer's operational documentation to provide means for rapid approval or extension of approval.

Q.4.2 Eligibility for technology approval

A TA may be granted to a manufacturer holding an Approval of Manufacturer to the specified quality assessment system (if any).

Prerequisite to a TA is a Technology Approval Schedule (TAS) covering the entire scope of technology for which approval is intended, written according to the requirements of the specified quality assessment system (if any).

Q.4.3 Application of technology approval

The procedure and requirements for an application for TA are given in the specified quality assessment system (if any).

Q.4.4 Subcontracting

The TAS or the relevant specification may restrict subcontracting according to the rules of the specified quality assessment system (if any).

Q.4.5 Description of technology

The manufacturer shall describe the implementation of the TAS in his organisation in a Technology Approval Declaration Document (TADD) which shall meet the requirements of the specified quality assessment system (if any). The TADD shall describe the relevant scope of technology and relate to, but not exceed the range of activities covered by the TAS.

Q.4.6 Demonstration and verification of the technology

For verification of the operational and technological processes, the manufacturer shall demonstrate compliance with the contents of the TADD, as required in the specified quality assessment system (if any).

For manufacturing verification, characterisation and evaluation of process performance shall be performed on components, for which a detail specification exists. Such detail specification

shall be based on this generic specification and a sectional specification and shall give provisions for a TA.

Q.4.7 Granting of technology approval

TA shall be granted by the Certification Body (CB) when the requirements of the specified quality assessment system (if any) have been met.

Q.4.8 Maintenance of technology approval

A TA shall be maintained according to the provisions of the specified quality assessment system (if any).

Q.4.9 Quality conformance inspection

The quality conformance inspection shall be carried out in accordance with the relevant TAS.

The quality conformance inspection of the manufacturing shall be performed on components for which a detail specification has been registered in the TADD. The test schedule and the requirements for the quality conformance inspection shall be prescribed in the detail specification.

The sampling and formation of inspection lots shall be prescribed in the sectional specification or in the detail specification. The sampling plans and inspection levels shall be selected from those given in IEC 61193-2, except for those elements of the test schedule which are based on fixed sample sizes.

The specimen for an inspection lot shall be collected at random over a short time within an inspection period, not including any major change of the manufacturing process.

Utilisation of the switching rule for reduced inspection in Group C of the test schedule is permitted in all subgroups except endurance, unless otherwise prescribed in the relevant specification.

Bibliography

IEC 60384-2, *Fixed capacitors for use in electronic equipment – Part 2: Sectional specification – Fixed metallized polyethylene terephthalate film dielectric d.c. capacitors*

IEC 60384-3, *Fixed capacitors for use in electronic equipment – Part 3: Sectional specification – Surface mount fixed tantalum electrolytic capacitors with manganese dioxide solid electrolyte*

IEC 60384-3-1, *Fixed capacitors for use in electronic equipment – Part 3-1: Blank detail specification: Surface mount fixed tantalum electrolytic capacitors with manganese dioxide solid electrolyte – Assessment level EZ*

IEC 60384-3-101, *Fixed capacitors for use in electronic equipment – Part 3-101: Detail specification – Fixed tantalum chip capacitors for surface mounting with solid electrolyte and porous anode, style I – Assessment level E*

IEC 60384-26, *Fixed capacitors for use in electronic equipment – Part 26: Sectional specification – Fixed aluminium electrolytic capacitors with conductive polymer solid electrolyte*

IEC 60410, *Sampling plans and procedures for inspection by attributes*

IEC 60469:2013, *Transitions, pulses and related waveforms – Terms, definitions and algorithms*

~~IEC 60469-1, *Pulse techniques and apparatus – Part 1: Pulse terms and definitions*~~

~~IEC 60469-2, *Pulse techniques and apparatus – Part 2: Pulse measurement and analysis, general considerations*~~

ISO 9000, *Quality management systems – Fundamentals and vocabulary*

INTERNATIONAL STANDARD

NORME INTERNATIONALE

**Fixed capacitors for use in electronic equipment –
Part 1: Generic specification**

**Condensateurs fixes utilisés dans les équipements électroniques –
Partie 1: Spécification générique**

IECNORM.COM : Click to view the full PDF of IEC 60384-1:2016 RLV

CONTENTS

FOREWORD.....	9
INTRODUCTION.....	11
1 General.....	13
1.1 Scope.....	13
1.2 Normative references.....	13
2 Technical data.....	15
2.1 Symbols, units and abbreviated terms.....	15
2.1.1 General.....	15
2.1.2 Letter symbols.....	15
2.1.3 Abbreviations.....	16
2.2 Terms and definitions.....	16
2.3 Preferred values and additional technical requirements.....	21
2.3.1 General.....	21
2.3.2 Preferred values of nominal capacitance.....	21
2.3.3 Preferred values of rated voltage.....	21
2.3.4 Rated a.c. load.....	21
2.3.5 Rated pulse load.....	22
2.3.6 Temperature derated voltage.....	22
2.4 Marking.....	23
2.4.1 General.....	23
2.4.2 Coding.....	23
3 Quality assessment procedures.....	23
4 Tests and measurement procedures.....	24
4.1 General.....	25
4.2 Standard atmospheric conditions.....	25
4.2.1 Standard atmospheric conditions for testing.....	25
4.2.2 Recovery conditions.....	25
4.2.3 Referee conditions.....	26
4.2.4 Reference conditions.....	26
4.3 Drying.....	26
4.4 Visual examination and check of dimensions.....	26
4.4.1 Visual examination.....	26
4.4.2 Dimensions (gauging).....	26
4.4.3 Dimensions (detail).....	26
4.5 Insulation resistance.....	27
4.5.1 Preconditioning.....	27
4.5.2 Measuring conditions.....	27
4.5.3 Test points.....	27
4.5.4 Test methods.....	27
4.5.5 Temperature compensation.....	28
4.5.6 Conditions to be prescribed in the relevant specification.....	28
4.6 Voltage proof.....	29
4.6.1 General.....	29
4.6.2 Test circuit (for the test between terminations).....	29
4.6.3 Test.....	30
4.6.4 Requirements.....	32

4.6.5	Conditions to be prescribed in the relevant specification	32
4.7	Capacitance	32
4.7.1	Measuring frequency and measuring voltage	32
4.7.2	Measuring equipment	33
4.7.3	Conditions to be prescribed in the relevant specification	33
4.8	Tangent of loss angle and equivalent series resistance (ESR)	33
4.8.1	Tangent of loss angle	33
4.8.2	Equivalent series resistance (ESR)	33
4.9	Leakage current	34
4.9.1	Preconditioning	34
4.9.2	Test method	34
4.9.3	Power source	34
4.9.4	Measuring accuracy	34
4.9.5	Test circuit	34
4.9.6	Conditions to be prescribed in the relevant specification	34
4.10	Impedance	34
4.11	Self-resonant frequency and inductance	35
4.11.1	Self-resonant frequency (f_r)	35
4.11.2	Inductance	38
4.11.3	Conditions to be prescribed in the relevant specification	38
4.12	Outer foil termination	38
4.13	Robustness of terminations	39
4.13.1	General	39
4.13.2	Test Ua ₁ – Tensile	39
4.13.3	Test Ub – Bending (half of the sample)	40
4.13.4	Test Uc – Torsion (remaining sample)	40
4.13.5	Test Ud – Torque	40
4.13.6	Visual examination	40
4.14	Resistance to soldering heat	41
4.14.1	Preconditioning and initial measurement	41
4.14.2	Test procedure	41
4.14.3	Recovery	41
4.14.4	Final inspection, measurement and requirements	41
4.15	Solderability	41
4.15.1	General	41
4.15.2	Preconditioning	41
4.15.3	Test procedure	42
4.15.4	Final inspection, measurements and requirements	42
4.16	Rapid change of temperature	42
4.16.1	Initial measurement	42
4.16.2	Test procedure	42
4.16.3	Final inspection, measurements and requirements	42
4.17	Vibration	42
4.17.1	Initial measurement	42
4.17.2	Test procedure	43
4.17.3	Electrical test (intermediate measurement)	43
4.17.4	Final inspection, measurements and requirements	43
4.18	Bump (repetitive shock)	43
4.18.1	Initial measurement	43

4.18.2	Test procedure.....	43
4.18.3	Final inspection, measurements and requirements.....	43
4.19	Shock	43
4.19.1	Initial measurement.....	43
4.19.2	Test procedure.....	43
4.19.3	Final inspection, measurements and requirements.....	44
4.20	Container sealing	44
4.21	Climatic sequence.....	44
4.21.1	General	44
4.21.2	Initial measurements	44
4.21.3	Dry heat.....	44
4.21.4	Damp heat, cyclic, Test Db, first cycle	44
4.21.5	Cold.....	44
4.21.6	Low air pressure	45
4.21.7	Damp heat, cyclic, Test Db, remaining cycles	45
4.21.8	Final measurements.....	45
4.22	Damp heat, steady state.....	45
4.22.1	Initial measurement.....	45
4.22.2	Test procedure.....	45
4.22.3	Final inspection, measurements and requirements.....	46
4.23	Endurance	46
4.23.1	Initial measurements	46
4.23.2	Test procedure.....	46
4.23.3	Conditions to be prescribed in the relevant specification	46
4.23.4	Test voltage.....	46
4.23.5	Placement in the test chamber	47
4.23.6	Recovery	47
4.23.7	Final inspection, measurements and requirements.....	47
4.24	Variation of capacitance with temperature.....	48
4.24.1	Static method.....	48
4.24.2	Dynamic method	48
4.24.3	Methods of calculation	49
4.25	Storage.....	50
4.25.1	Storage at high temperature	50
4.25.2	Storage at low temperature	50
4.26	Surge.....	51
4.26.1	Initial measurement.....	51
4.26.2	Test procedure.....	51
4.26.3	Final inspection, measurements and requirements.....	52
4.26.4	Information to be given in the relevant detail specification.....	52
4.27	Charge and discharge tests and inrush current test.....	52
4.27.1	Initial measurement.....	52
4.27.2	Test procedure.....	52
4.27.3	Charge and discharge	53
4.27.4	Inrush current	54
4.27.5	Final inspection, measurements and requirements.....	54
4.28	Pressure relief (for aluminium electrolytic capacitors).....	54
4.28.1	General	54
4.28.2	AC test	54

4.28.3	DC test	54
4.28.4	Pneumatic test	54
4.28.5	Final inspection, measurements and requirements	54
4.29	Characteristics at high and low temperature	54
4.29.1	Test procedure	54
4.29.2	Requirements	55
4.30	Thermal stability test	55
4.31	Component solvent resistance	55
4.31.1	Initial measurements	55
4.31.2	Test procedure	55
4.31.3	Final inspection, measurements and requirements	55
4.32	Solvent resistance of marking	55
4.32.1	Test procedure	55
4.32.2	Final inspection, measurements and requirements	56
4.33	Mounting (for surface mount capacitors only)	56
4.33.1	Substrate	56
4.33.2	Wave soldering	56
4.33.3	Reflow soldering	56
4.34	Shear test	59
4.34.1	Test procedure	59
4.34.2	Final inspection, measurements and requirements	59
4.35	Substrate bending test	59
4.35.1	Test procedure	59
4.35.2	Recovery	60
4.35.3	Final inspection and requirements	60
4.36	Dielectric absorption	60
4.36.1	Test procedure	60
4.36.2	Requirement	61
4.37	Damp heat, steady state, accelerated	61
4.37.1	Initial measurements	61
4.37.2	Test methods	61
4.37.3	Test procedures	61
4.37.4	Final inspection, measurements and requirements	61
4.38	Passive flammability	61
4.38.1	Test procedure	61
4.38.2	Final inspection, measurements and requirements	62
4.39	High surge current test	62
4.39.1	Initial measurements	62
4.39.2	Test procedure	62
4.39.3	Requirements for the charging circuit	63
4.39.4	Nonconforming items	63
4.40	Voltage transient overload (for aluminium electrolytic capacitors with non-solid electrolyte)	63
4.40.1	Initial measurement	63
4.40.2	Test procedure	63
4.40.3	Final inspection, measurements and requirements	65
4.40.4	Conditions to be prescribed in the relevant specification	65
4.41	Whisker growth test	65
4.41.1	General	65

4.41.2	Preparation of specimen.....	66
4.41.3	Initial measurement.....	66
4.41.4	Test procedures	66
4.41.5	Test severities	66
4.41.6	Final inspection, measurements and requirements.....	66
Annex A (informative) Interpretation of sampling plans and procedures as described in IEC 60410 for use within quality assessment systems.....		67
Annex B (informative) Rules for the preparation of detail specifications for capacitors and resistors for electronic equipment for use within quality assessment systems		68
B.1	Drafting.....	68
B.2	Reference standard.....	68
B.3	Circulation	68
Annex C (informative) Layout of the first page of a PCP/CQC specification		69
Annex D (informative) Requirements for capability approval test report		70
D.1	General.....	70
D.2	Requirements.....	70
D.3	Summary of test information (for each CQC).....	70
D.4	Measurement record	70
Annex E (informative) Guide for pulse testing of capacitors.....		71
E.1	Overview.....	71
E.2	Typical capacitor pulse conditions	71
E.3	Effect of inductance on pulse testing	72
Annex F (informative) Guidance for the extension of endurance tests on fixed capacitors.....		74
F.1	Overview.....	74
F.2	Guidelines.....	74
Annex G (normative) Damp heat, steady state with voltage applied, for metallized film capacitors only		75
G.1	Overview.....	75
G.2	Test procedure.....	75
Annex H (normative) Accelerated damp heat, steady state, for multilayer ceramic capacitors only		76
H.1	Mounting of capacitors	76
H.2	Initial measurement.....	76
H.3	Test procedure.....	76
H.4	Recovery	76
H.5	Final inspection, measurements and requirements.....	76
Annex Q (informative) Quality assessment procedures		77
Q.1	General.....	77
Q.1.1	Scope of this annex	77
Q.1.2	Quality assessment definitions	78
Q.1.3	Rework	78
Q.1.4	Alternative test methods.....	79
Q.1.5	Certified test records of released lots	79
Q.1.6	Unchecked parameters	79
Q.1.7	Delayed delivery	79
Q.1.8	Repair	79
Q.1.9	Registration of approvals.....	80
Q.1.10	Manufacture outside the geographical limits	80

Q.2	Qualification approval (QA) procedures	80
Q.2.1	Eligibility for qualification approval.....	80
Q.2.2	Application for qualification approval	80
Q.2.3	Subcontracting.....	80
Q.2.4	Test procedure for the initial product qualification approval	80
Q.2.5	Granting of qualification approval	80
Q.2.6	Maintenance of qualification approval.....	81
Q.2.7	Quality conformance inspection.....	81
Q.3	Capability approval (CA) procedures.....	81
Q.3.1	General	81
Q.3.2	Eligibility for capability approval	81
Q.3.3	Application for capability approval	82
Q.3.4	Subcontracting.....	82
Q.3.5	Description of the capability	82
Q.3.6	Demonstration and verification of capability	82
Q.3.7	Granting of capability approval	82
Q.3.8	Maintenance of capability approval.....	82
Q.3.9	Quality conformance inspection.....	82
Q.4	Technology approval (TA) procedure	83
Q.4.1	General	83
Q.4.2	Eligibility for technology approval	83
Q.4.3	Application of technology approval	83
Q.4.4	Subcontracting.....	83
Q.4.5	Description of technology	83
Q.4.6	Demonstration and verification of the technology	83
Q.4.7	Granting of technology approval.....	84
Q.4.8	Maintenance of technology approval.....	84
Q.4.9	Quality conformance inspection.....	84
Bibliography		85
Figure 1	– Reactive power against frequency	22
Figure 2	– Relation between category temperature range and applied voltage.....	23
Figure 3	– Voltage-proof test circuit.....	30
Figure 4	– Schematic diagram of the impedance measuring circuit.....	35
Figure 5	– Capacitor mounting arrangement	36
Figure 6	– Capacitor mounting arrangement	37
Figure 7	– Typical diagram of an absorption oscillator-wavemeter.....	37
Figure 8	– Schematic diagram of the measuring circuit	38
Figure 9	– Test circuit	39
Figure 10	– Test circuit for electrolytic capacitors	47
Figure 11	– Relay circuit	51
Figure 12	– Thyristor circuit	51
Figure 13	– Voltage waveform across capacitor.....	52
Figure 14	– Voltage and current waveform	53
Figure 15	– Suitable substrate for mechanical tests	58
Figure 16	– Suitable substrate for electrical tests.....	59

Figure 17 – High surge current test	63
Figure 18 – Voltage transient overload test circuit	64
Figure 19 – Voltage waveform	65
Table 1 – Referee conditions	26
Table 2 – Measurement of insulation resistance	27
Table 3 – Measuring points	29
Table 4 – Tensile force	40
Table 5 – Torque	40
Table 6 – Number of cycles	45
Table 7 – Severities and requirements	62

IECNORM.COM : Click to view the full PDF of IEC 60384-1:2016 RLV

INTERNATIONAL ELECTROTECHNICAL COMMISSION

FIXED CAPACITORS FOR USE IN ELECTRONIC EQUIPMENT –**Part 1: Generic specification****FOREWORD**

- 1) The International Electrotechnical Commission (IEC) is a worldwide organization for standardization comprising all national electrotechnical committees (IEC National Committees). The object of IEC is to promote international co-operation on all questions concerning standardization in the electrical and electronic fields. To this end and in addition to other activities, IEC publishes International Standards, Technical Specifications, Technical Reports, Publicly Available Specifications (PAS) and Guides (hereafter referred to as "IEC Publication(s)"). Their preparation is entrusted to technical committees; any IEC National Committee interested in the subject dealt with may participate in this preparatory work. International, governmental and non-governmental organizations liaising with the IEC also participate in this preparation. IEC collaborates closely with the International Organization for Standardization (ISO) in accordance with conditions determined by agreement between the two organizations.
- 2) The formal decisions or agreements of IEC on technical matters express, as nearly as possible, an international consensus of opinion on the relevant subjects since each technical committee has representation from all interested IEC National Committees.
- 3) IEC Publications have the form of recommendations for international use and are accepted by IEC National Committees in that sense. While all reasonable efforts are made to ensure that the technical content of IEC Publications is accurate, IEC cannot be held responsible for the way in which they are used or for any misinterpretation by any end user.
- 4) In order to promote international uniformity, IEC National Committees undertake to apply IEC Publications transparently to the maximum extent possible in their national and regional publications. Any divergence between any IEC Publication and the corresponding national or regional publication shall be clearly indicated in the latter.
- 5) IEC itself does not provide any attestation of conformity. Independent certification bodies provide conformity assessment services and, in some areas, access to IEC marks of conformity. IEC is not responsible for any services carried out by independent certification bodies.
- 6) All users should ensure that they have the latest edition of this publication.
- 7) No liability shall attach to IEC or its directors, employees, servants or agents including individual experts and members of its technical committees and IEC National Committees for any personal injury, property damage or other damage of any nature whatsoever, whether direct or indirect, or for costs (including legal fees) and expenses arising out of the publication, use of, or reliance upon, this IEC Publication or any other IEC Publications.
- 8) Attention is drawn to the Normative references cited in this publication. Use of the referenced publications is indispensable for the correct application of this publication.
- 9) Attention is drawn to the possibility that some of the elements of this IEC Publication may be the subject of patent rights. IEC shall not be held responsible for identifying any or all such patent rights.

International Standard IEC 60384-1 has been prepared by IEC technical committee 40: Capacitors and resistors for electronic equipment

This fifth edition cancels and replaces the fourth edition published in 2008 and constitutes a technical revision, including minor revisions related to tables, figures and references.

This edition contains the following significant technical changes with respect to the previous edition:

- INTRODUCTION added;
- 4.41 Whisker growth test added;
- Annex Q completely restructured.

The text of this standard is based on the following documents:

FDIS	Report on voting
40/2420/FDIS	40/2444/RVD

Full information on the voting for the approval of this standard can be found in the report on voting indicated in the above table.

A list of all the parts of the IEC 60384 series, under the general title *Fixed capacitors for use in electronic equipment*, can be found on the IEC website.

This publication has been drafted in accordance with the ISO/IEC Directives, Part 2.

The committee has decided that the contents of this publication will remain unchanged until the stability date indicated on the IEC website under "<http://webstore.iec.ch>" in the data related to the specific publication. At this date, the publication will be

- reconfirmed,
- withdrawn,
- replaced by a revised edition, or
- amended.

IECNORM.COM : Click to view the full PDF of IEC 60384-1:2016 RLV

INTRODUCTION

The specification system for fixed capacitors for use in electronic equipment is structured in a hierarchical system consisting of the following specification types.

Generic specification

The generic specification covers all subjects mainly common to the family of fixed capacitors for use in electronic equipment, such as terminology, methods of measurement and tests. Where the individual subjects require the prescription conditions or parameters specific to the particular subfamily or type of fixed capacitor, such prescriptions are required to be given by one of the subordinate specifications.

For the scope of fixed capacitors, the numeric reference to the generic specification is IEC 60384-1.

Sectional specification

Sectional specifications cover all subjects additional to those given in the generic specification, which are specific to a defined sub-group of fixed capacitors. These subjects normally are preferred values for dimensions and characteristics, additional test methods and relevant prescriptions for test methods given in the generic specification, prescriptions for sampling and for the preparation of specimen, recommended test severities and preferred acceptance criteria. The sectional specification also outlines the structure and scope of the test schedules which are to be applied in all subordinate detail specifications.

For the scope of fixed capacitors, the numeric references to the sectional specifications reach from IEC 60384-2 for polyester film capacitors to currently IEC 60384-26 for aluminium electrolytic capacitors with conductive polymer solid electrolyte. The variety of sectional specifications may be adapted to the portfolio of different technologies of fixed capacitors.

Detail specification

Detail specifications give directly, or by making reference to other specifications, all information necessary to completely describe a given type and range of fixed capacitors, including prescriptions of all values for dimensions and characteristics. They also give all information required for the quality assessment of the covered type and range of fixed capacitors within a suitable quality assessment system, including prescriptions for all applied test severities and acceptance criteria, and the completed test schedules.

Detail specifications can be either specifications within the IEC system, another specification system linked to IEC, or specified by the manufacturer or user. For the scope of fixed capacitors, the numeric references to detail specifications are for example IEC 60384-3-101, if related to the sectional specification IEC 60384-3 and to the ancillary blank detail specification IEC 60384-3-1.

Blank detail specification

The hierarchical system of specifications is supplemented by one or more blank detail specifications to a sectional specification, which are used to ensure a uniform presentation of detail specifications. The blank detail specifications provide the specification writer with a template on the layout to be adopted and on the information to be given and with guidance for the preparation of detail specifications in line with the requirements of the superior generic or sectional specifications. Blank detail specifications are not considered as relevant specifications since they do not themselves describe any particular component.

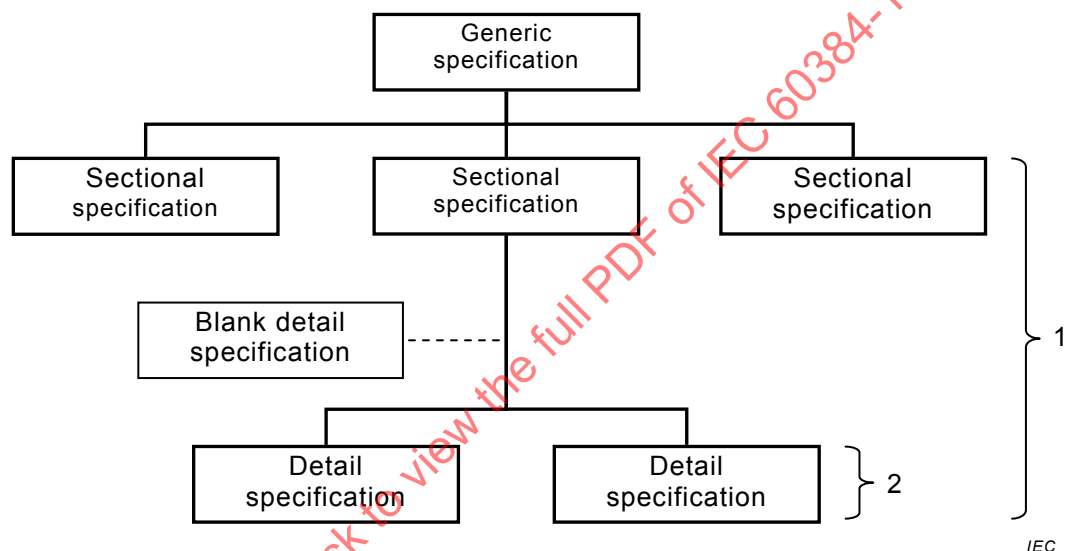
The presence of an established hierarchical specification system with blank detail specifications permits the preparation of detail specifications even outside of the relevant IEC technical committee.

For the scope of fixed capacitors, the numeric references to blank detail specifications are, for example, IEC 60384-3-1, if related to the sectional specification IEC 60384-3.

Relevant specification

In this system the term “relevant specification” addresses subordinate specifications containing specific requirements, where applicable.

Any generic or sectional specification may use abstract and universal references to subordinate specifications of either hierarchical level by use of the expression “relevant specification”.



Key

- 1 Indicates the range of “*Relevant specifications*” to the superior generic specification, where applicable.
- 2 Indicates the range of “*Relevant specifications*” to the superior sectional specification, where applicable.

FIXED CAPACITORS FOR USE IN ELECTRONIC EQUIPMENT –

Part 1: Generic specification

1 General

1.1 Scope

This part of IEC 60384 is a generic specification and is applicable to fixed capacitors for use in electronic equipment.

It establishes standard terms, inspection procedures and methods of test for use in sectional and detail specifications of electronic components for quality assessment or any other purpose.

1.2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

IEC 60027 (all parts), *Letter symbols to be used in electrical technology*

IEC 60050 (all parts), *International Electrotechnical Vocabulary*¹

IEC 60062, *Marking codes for resistors and capacitors*

IEC 60063, *Preferred number series for resistors and capacitors*

IEC 60068-1:2013, *Environmental testing – Part 1: General and guidance*

IEC 60068-2-1:2007, *Environmental testing – Part 2-1: Tests – Tests A: Cold*

IEC 60068-2-2:2007, *Environmental testing – Part 2-2: Tests – Tests B: Dry heat*

IEC 60068-2-6:2007, *Environmental testing – Part 2-6: Tests – Test Fc: Vibration (sinusoidal)*

IEC 60068-2-13:1983, *Environmental testing – Part 2-13: Tests – Test M: Low air pressure*

IEC 60068-2-14:2009, *Environmental testing – Part 2-14: Tests – Test N: Change of temperature*

IEC 60068-2-17:1994, *Environmental testing – Part 2-17: Tests – Test Q: Sealing*

IEC 60068-2-20:2008, *Environmental testing – Part 2-20: Tests – Test T: Test methods for solderability and resistance to soldering heat of devices with leads*

IEC 60068-2-21:2006, *Environmental testing – Part 2-21: Tests – Test U: Robustness of terminations and integral mounting devices*

¹ www.electropedia.org

IEC 60068-2-27:2008, *Environmental testing – Part 2-27: Tests – Test Ea and guidance: Shock*

IEC 60068-2-30:2005, *Environmental testing – Part 2-30: Tests – Test Db: Damp heat, cyclic (12 h + 12 h cycle)*

IEC 60068-2-45:1980, *Environmental testing – Part 2-45: Tests – Test XA and guidance: Immersion in cleaning solvents*
IEC 60068-2-45:1980/AMD1:1993

IEC 60068-2-54:2006, *Environmental testing – Part 2-54: Tests – Test Ta: Solderability testing of electronic components by the wetting balance method*

IEC 60068-2-58:2015, *Environmental testing – Part 2-58: Tests – Test Td: Test methods for solderability, resistance to dissolution of metallization and to soldering heat of surface mounting devices (SMD)*

IEC 60068-2-67:1995, *Environmental testing – Part 2-67: Tests – Test Cy: Damp heat, steady state, accelerated test primarily intended for components*

IEC 60068-2-69:2007, *Environmental testing – Part 2-69: Tests – Test Te: Solderability testing of electronic components for surface mounting devices (SMD) by the wetting balance method*

IEC 60068-2-78:2012, *Environmental testing – Part 2-78: Tests – Test Cab: Damp heat, steady state*

IEC 60068-2-82:2007, *Environmental testing – Part 2-82: Tests – Test XW1: Whisker test methods for electronic and electric components*

IEC 60294, *Measurement of the dimensions of a cylindrical component with axial terminations*

IEC 60617, *Graphical symbols for diagrams*

IEC 60695-11-5:2004, *Fire hazard testing – Part 11-5: Test flames – Needle-flame test method – Apparatus, confirmatory test arrangement and guidance*

IEC 60717, *Method for the determination of the space required by capacitors and resistors with unidirectional terminations*

IEC 61193-2, *Quality assessment systems – Part 2: Selection and use of sampling plans for inspection of electronic components and packages*

IEC 61249-2-7:2002, *Materials for printed boards and other interconnecting structures – Part 2-7: Reinforced base materials clad and unclad – Epoxide woven E-glass laminated sheet of defined flammability (vertical burning test), copper-clad*

ISO 3, *Preferred numbers – Series of preferred numbers*

ISO 80000-1, *Quantities and units – Part 1: General*

2 Technical data

2.1 Symbols, units and abbreviated terms

2.1.1 General

Units, graphical symbols and letter symbols should, whenever possible, be taken from the following publications:

- IEC 60027 (series);
- IEC 60050 (series);
- IEC 60617;
- ISO 80000-1.

When further items are required, they should be derived in accordance with the principles of the publications listed above.

2.1.2 Letter symbols

C_N Nominal capacitance

DA Dielectric Absorption

du/dt Pulse handling capability

f_r Self-resonant frequency

I_{leak} leakage current

k_0 Maximum permissible pulse characteristics

L Self-inductance

R_{INS} Insulation resistance

T_A Lower category temperature

$\tan \delta$ Tangent of loss angle

T_B Upper category temperature

T_C Category temperature

T_{op} Operating temperature

T_R Rated temperature

U_C Category voltage

U_{op} Operating voltage

U_R Rated voltage

U_{RS} Surge voltage

Z	Impedance
α	Temperature coefficient of capacitance
τ	$= C_N \times R_{INS}$ Time constant

2.1.3 Abbreviations

CA	Capability Approval
CB	Certification Body
CQC	Capability Qualifying Components
DMR	Designated Management Representative
ESR	Equivalent Series Resistance
IPA	Isopropyl alcohol
PCP	Process Control Plan
QA	Qualifying Approval
SMD	Surface Mount Device
TA	Technology Approval
TADD	Technology Approval Declaration Document

2.2 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

NOTE They have been listed in alphabetical order.

2.2.1

a.c. capacitor

capacitor designed essentially for application with alternating voltages

2.2.2

bipolar capacitor

<electrolytic capacitor> capacitor designed to withstand an alternating voltage and/or reversal of the applied direct voltage

2.2.3

category of passive flammability

category indicating the maximum burning time after a specified time of flame application

2.2.4

category temperature range

ambient temperature range for which the capacitor has been designed to operate continuously

Note 1 to entry: The temperature range is limited by the lower and upper category temperature (see 2.2.10 and 2.2.41).

2.2.5**category voltage** U_C

maximum voltage that can be applied continuously to a capacitor at its upper category temperature (2.2.41)

2.2.6**d.c. capacitor**

capacitor designed essentially for application with direct voltage

Note 1 to entry: It may not be suitable for use on a.c. supplies.

2.2.7**family**

<electronic components> group of components which predominantly displays a particular physical attribute and/or fulfils a defined function

2.2.8**grade**

term to indicate an additional general characteristic concerning the intended application of the component

2.2.9**insulated capacitor**

capacitor in which all terminations of a section may be raised to a potential different (but not less than the rated voltage) from that of any conducting surface with which the case is liable to come into contact in normal use

2.2.10**lower category temperature**

minimum ambient temperature for which a capacitor has been designed to operate continuously

2.2.11**maximum storage temperature**

maximum ambient temperature which the capacitor withstands in the non-operating condition without damage

2.2.12**maximum temperature of a capacitor**

temperature at the hottest point of its external surface

Note 1 to entry: The terminations are considered to be part of the external surface.

2.2.13**minimum storage temperature**

minimum ambient temperature which the capacitor withstands in the non-operating condition without damage

2.2.14**minimum temperature of a capacitor**

temperature at the coldest point of the external surface

Note 1 to entry: The terminations are considered to be part of the external surface.

2.2.15**nominal capacitance** C_N

designated capacitance value, usually indicated on the capacitor

2.2.16

passive flammability

ability of a capacitor to burn with a flame as a consequence of the application of an external source of heat

2.2.17

polar capacitor

<electrolytic capacitor> capacitor intended for use with a unidirectional voltage connected according to the polarity indication

2.2.18

pulse capacitor

capacitor for use with pulses of current or voltage

Note 1 to entry: The definitions of IEC 60469 apply.

2.2.19

pulse equivalent circuit of a capacitor

equivalent circuit consisting of an ideal capacitor in series with its residual inductance and the equivalent series resistance (ESR)

Note 1 to entry: For pulse operation the equivalent series resistance will be similar to, but not identical with, the ESR measured with a sinusoidal voltage. The pulse ESR depends on the series of harmonics in the pulse and the variation of the losses with frequency.

2.2.20

rated a.c. load

maximum sinusoidal a.c. load which may be applied continuously to the terminations of a capacitor at any temperature between the lower category temperature (2.2.10) and the rated temperature (2.2.24)

2.2.21

rated pulse load

maximum pulse load which may be applied at a certain pulse repetition frequency to the terminations of a capacitor at any temperature between the lower category temperature (2.2.10) and the rated temperature (2.2.24)

2.2.22

rated ripple current

r.m.s. value of the maximum allowable alternating current of a specified frequency, at which the capacitor can be operated continuously at a specified temperature

Note 1 to entry: As the ripple current will generate a ripple voltage across the capacitor, the sum of the direct voltage and the peak value of the alternating voltage applied to the capacitor should not exceed the rated voltage or temperature derated voltage, as applicable.

2.2.23

rated ripple voltage

r.m.s. value of the maximum allowable alternating voltage at a specified frequency superimposed on the d.c. voltage at which the capacitor may be operated continuously at a specified temperature

Note 1 to entry: The sum of the direct voltage and the peak value of the alternating voltage applied to the capacitor should not exceed the rated voltage or temperature derated voltage, as applicable.

2.2.24

rated temperature

maximum ambient temperature at which the rated voltage may be continuously applied

2.2.25**rated voltage** U_R **2.2.25.1****rated d.c. voltage**

maximum d.c. voltage which may be applied continuously to a capacitor at the rated temperature (2.2.24)

Note 1 to entry: The maximum d.c. voltage is the sum of the d.c. voltage and peak a.c. voltage or peak pulse voltage applied to the capacitor.

2.2.25.2**rated a.c. voltage**

maximum r.m.s. alternating voltage which may be applied continuously to a capacitor at the rated temperature (2.2.24) and at a given frequency

2.2.25.3**rated pulse voltage**

peak value of the pulse voltage within a given pulse wave form which may be applied continuously to a capacitor at the rated temperature (2.2.24)

2.2.26**reverse voltage**

<polar capacitor> voltage applied to the capacitor terminations in the reverse polarity direction

Note 1 to entry: Reverse voltage applies to polar capacitors only.

2.2.27**self-healing**

process by which the electrical properties of the capacitor, after a local breakdown of the dielectric, are rapidly and essentially restored to the values before the breakdown

2.2.28**style**

subdivision of a type (2.2.39), generally based on dimensional factors, which may include several variants, generally of a mechanical order

2.2.29**subfamily**

<electronic components> group of components within a family (2.2.7) manufactured by similar technological methods

2.2.30**surface mount capacitor**

fixed capacitor whose small dimensions and nature or shape of terminations make it suitable for use in hybrid circuits and on printed boards

2.2.31**surge voltage ratio**

quotient of the maximum instantaneous voltage which can be applied to the terminations of the capacitor for a specified time at any temperature within the category temperature range (2.2.4) and the rated voltage (2.2.25) or the temperature derated voltage (2.2.36), as appropriate

2.2.32

tangent of loss angle

$\tan \delta$

power loss of the capacitor divided by the reactive power of the capacitor at a sinusoidal voltage at a specified frequency

2.2.33

temperature characteristics of capacitance

maximum variation of capacitance produced over a given temperature range within the category temperature range (2.2.4)

Note 1 to entry: The term characterizing this property applies mainly to capacitors of which the variations of capacitance as a function of temperature, linear or non-linear, cannot be expressed with precision and certainty.

Note 2 to entry: This characteristic is normally expressed as a percentage of the capacitance related to a reference temperature of 20 °C.

2.2.34

temperature coefficient of capacitance

α

rate of change of capacitance with temperature measured over a specified range of temperature

Note 1 to entry: The term characterizing this property applies to capacitors of which the variations of capacitance as a function of temperature are linear or approximately linear and can be expressed with a certain precision.

Note 2 to entry: This coefficient is normally expressed in parts per million per Kelvin ($10^{-6}/K$).

2.2.35

temperature cyclic drift of capacitance

maximum irreversible variation of capacitance observed at room temperature during or after the completion of a number of specified temperature cycles

Note 1 to entry: The term characterizing this property applies to capacitors of which the variations of capacitance as a function of temperature are linear or approximately linear and can be expressed with a certain precision.

Note 2 to entry: This drift is normally expressed as a percentage of the capacitance related to a reference temperature, usually 20 °C.

2.2.36

temperature derated voltage

maximum voltage that may be applied continuously to a capacitor, when it is at any temperature between the rated temperature (2.2.24) and the upper category temperature (2.2.41)

Note 1 to entry: Refer to 2.3.6.

2.2.37

temperature rise

temperature rise of the capacitor relative to the ambient temperature resulting from the losses in the capacitor due to operation under a.c., pulse or charge/discharge conditions

2.2.38

time constant

τ

product of the insulation resistance and the capacitance

Note 1 to entry: The time constant is normally expressed in seconds.

2.2.39**type**

group of components having similar design features and manufacturing techniques, enabling them to be considered together, either for qualification approval or for quality conformance inspection

Note 1 to entry: These components are generally covered by a single detail specification.

Note 2 to entry: Components described in several detail specifications, may, in some cases, be considered as belonging to the same type.

2.2.40**uninsulated capacitor**

capacitor in which one or more of the terminations of a section cannot be raised to a potential different (but not less than the rated voltage) from that of any conducting surface with which the case is liable to come into contact in normal use

2.2.41**upper category temperature**

maximum ambient temperature for which a capacitor has been designed to operate continuously

2.2.42**visible damage**

visible damage which reduces the usability of the capacitor for its intended purpose

2.3 Preferred values and additional technical requirements**2.3.1 General**

Each sectional specification shall prescribe the preferred values appropriate to the subfamily; for nominal capacitance, see also 2.3.2.

2.3.2 Preferred values of nominal capacitance

The preferred values of nominal capacitance shall be taken from the series specified in IEC 60063.

2.3.3 Preferred values of rated voltage

The preferred values of the rated voltage are the values of the R10 series of ISO 3: 1,0 – 1,25 – 1,6 – 2,0 – 2,5 – 3,15 – 4,0 – 5,0 – 6,3 – 8,0 and their decimal multiples ($\times 10^n$, n : integer).

2.3.4 Rated a.c. load

The rated a.c. load may be expressed:

- at low frequencies as a rated a.c. voltage;
- at high frequencies as a rated a.c. current;
- at intermediate frequencies as a rated reactive power (var).

This is shown in Figure 1.

For a particular type of capacitor, it may be necessary to specify one or more of the above characteristics.

Capacitors within the scope of this standard are normally less than 500 var at 50 Hz to 60 Hz. Low frequencies may be 50 Hz to 60 Hz, 100 Hz to 120 Hz, or 400 Hz. Voltages may be up to 600 V r.m.s. at 50 Hz to 60 Hz. However, capacitors for filters, transmitter or converter circuits

may be required to operate under power over a wide range of frequencies and up to 10 kvar at the higher frequencies with voltages up to 1 000 V r.m.s.

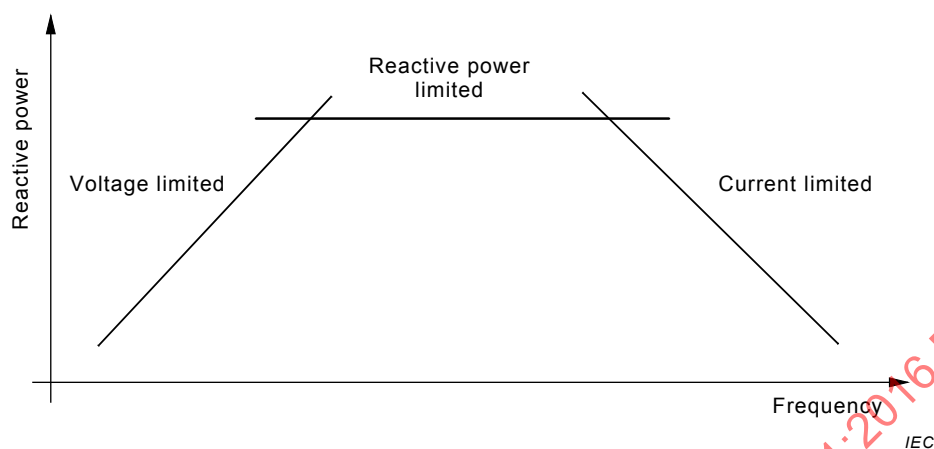


Figure 1 – Reactive power against frequency

2.3.5 Rated pulse load

The rated pulse load may be expressed as a) and b) and any of the remaining items:

- a) peak current per μF or du/dt ($\text{V}/\mu\text{s}$);
- b) relative duration of charge and discharge periods;
- c) current;
- d) peak voltage;
- e) peak reverse voltage;
- f) pulse repetition frequency;
- g) maximum active power.

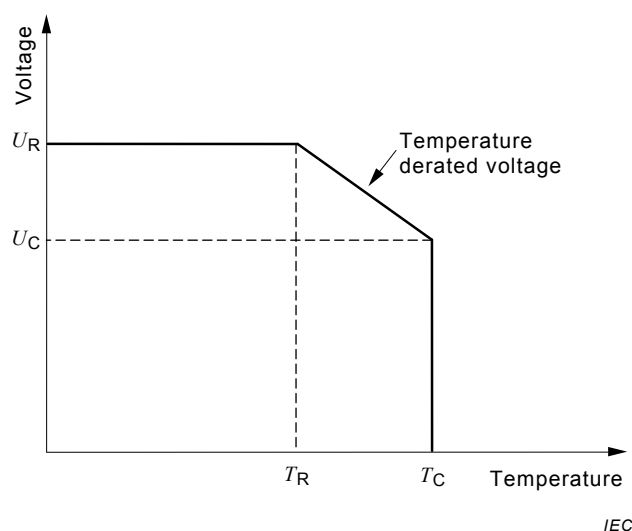
These parameters are fixed for periodic pulses.

In the case of intermittent pulses, the duty cycle should be specified. In the case of random pulses, the total number expected over a given time period should be stated.

The r.m.s. pulse current should be calculated in accordance with IEC 60469:2013, 3.2.17.5. In the case of intermittent or random pulses, the time interval should be chosen to correspond to the maximum temperature rise.

2.3.6 Temperature derated voltage

Information on the voltage/temperature dependence at temperatures between the rated temperature and the upper category temperature should, if applicable, be given in the relevant specification (see Figure 2).

**Key**

- U_R is the rated voltage
 U_C is the category voltage
 T_R is the rated temperature
 T_C is the category temperature

Figure 2 – Relation between category temperature range and applied voltage

2.4 Marking

2.4.1 General

The sectional specification shall indicate the identification criteria and other information to be shown on the capacitor and/or packaging.

The order of priority for marking small capacitors shall be specified.

2.4.2 Coding

When coding is used for capacitance value, tolerance or date of manufacture, the method shall be selected from those given in IEC 60062.

3 Quality assessment procedures

See Annex Q.

4 Tests and measurement procedures

General information on test and measurement procedures	Subclause
General	4.1
Standard atmospheric conditions	4.2
Drying	4.3
Storage	4.25
Mounting (for surface mount capacitors only)	4.33
Electrical tests and measurements	
Insulation resistance	4.5
Voltage proof	4.6
Capacitance	4.7
Tangent of loss angle and equivalent series resistance (ESR)	4.8
Leakage current	4.9
Impedance	4.10
Self-resonant frequency and inductance	4.11
Variation of capacitance with temperature	4.24
Surge	4.26
High surge current test	4.39
Charge and discharge tests and inrush current test	4.27
Dielectric absorption	4.36
Voltage transient overload (for aluminium electrolytic capacitors with non-solid electrolyte)	4.40
Mechanical tests and measurements	
Visual examination and check of dimensions	4.4
Outer foil termination	4.12
Robustness of terminations	4.13
Vibration	4.17
Bump (repetitive shock)	4.18
Shock	4.19
Container sealing	4.20
Shear test	4.34
Substrate bending test	4.35
Environmental and climatic tests	
Rapid change of temperature	4.16
Climatic sequence	4.21
Damp heat, steady state	4.22
Endurance	4.23
Characteristics at high and low temperature	4.29
Thermal stability test	4.30
Damp heat, steady state, accelerated	4.37
Tests related to component assembly	
Resistance to soldering heat	4.14
Solderability	4.15
Component solvent resistance	4.31
Solvent resistance of marking	4.32
Whisker growth test	4.41
Test related to safety	
Pressure relief (for aluminium electrolytic capacitors)	4.28
Passive flammability	4.38

4.1 General

The sectional and/or blank detail specification shall indicate the tests to be made, which measurements are to be made before and after each test or subgroup of tests, and the sequence in which they shall be made. The stages of each test shall be carried out in the order written. The measuring conditions shall be the same for initial and final measurements.

If national specifications within any quality assessment system include methods other than those specified in the above specifications, they shall be fully described.

Limits given in all specifications are absolute limits. The principle to take measurement uncertainty into account shall be applied.

4.2 Standard atmospheric conditions

4.2.1 Standard atmospheric conditions for testing

Unless otherwise specified, all tests and measurements shall be carried out under standard atmospheric conditions for testing as given in IEC 60068-1:2013, 4.3:

- temperature: 15 °C to 35 °C;
- relative humidity: 25 % to 75 %;
- air pressure: 86 kPa to 106 kPa.

Before the measurements are made, the capacitor shall be stored at the measuring temperature for a time sufficient to allow the entire capacitor to reach this temperature. The period as prescribed for recovery at the end of a test is normally sufficient for this purpose.

When measurements are made at a temperature other than the specified temperature, the results shall, where necessary, be corrected to the specified temperature. The ambient temperature during the measurements shall be stated in the test report. In the event of a dispute, the measurements shall be repeated using one of the referee temperatures (as given in 4.2.3) and such other conditions as are prescribed in this standard.

When tests are conducted in a sequence, the final measurements of one test may be taken as the initial measurements for the succeeding test.

During measurements the capacitor shall not be exposed to draughts, direct sunlight or other influences likely to cause error.

4.2.2 Recovery conditions

Unless otherwise specified recovery shall take place under the standard atmospheric conditions for testing (4.2.1).

If recovery under closely controlled conditions is necessary, the controlled recovery conditions of IEC 60068-1:2013, 4.4.2, shall be used.

Unless otherwise specified in the relevant specification, a duration of 1 h to 2 h shall be used.

The definition of recovery is as given in IEC 60068-1:2013, 3.4, being further restricted for capacitors as follows:

When a recovery period is specified as, for example, 1 h to 2 h, this means that measurement (or other subsequent action) on a batch of capacitors may start after 1 h and shall be completed before 2 h from the beginning of the recovery period.

The preferred method of specifying a recovery period is in the form "x h to y h".

4.2.3 Referee conditions

For referee purposes, one of the standard atmospheric conditions for referee tests taken from IEC 60068-1:2013, 4.2, as given in Table 1 below, shall be selected.

Table 1 – Referee conditions

Temperature °C	Relative humidity %	Air pressure kPa
20 ± 1	63 to 67	86 to 106
23 ± 1	48 to 52	86 to 106
25 ± 1	48 to 52	86 to 106
27 ± 1	63 to 67	86 to 106

4.2.4 Reference conditions

For reference purposes, the standard atmospheric conditions for reference given in IEC 60068-1:2013, 4.1, apply:

- temperature: 20 °C;
- air pressure: 101,3 kPa.

4.3 Drying

Unless otherwise specified in the relevant specification, the capacitor shall be conditioned for $96\text{ h} \pm 4\text{ h}$ by heating in a circulating air oven at a temperature of $55\text{ °C} \pm 2\text{ °C}$ and a relative humidity not exceeding 20 %.

The capacitor shall then be allowed to cool in a desiccator using a suitable desiccant, such as activated alumina or silica gel, and shall be kept therein from the time of removal from the oven to the beginning of the specified tests.

4.4 Visual examination and check of dimensions

4.4.1 Visual examination

The condition, workmanship and finish shall be satisfactory, as checked by visual examination (see 2.2.42).

Marking shall be legible, as checked by visual examination and shall conform with the requirements of the detail specification.

4.4.2 Dimensions (gauging)

The dimensions indicated in the detail specification as being suitable for gauging shall be checked, and shall comply with the values prescribed in the detail specification.

When applicable, measurements shall be made in accordance with IEC 60294 or IEC 60717.

4.4.3 Dimensions (detail)

All dimensions prescribed in the detail specification shall be checked and shall comply with the values prescribed.

4.5 Insulation resistance

4.5.1 Preconditioning

Before this measurement is made, the capacitors shall be fully discharged.

4.5.2 Measuring conditions

Unless otherwise specified in the relevant specification, the insulation resistance shall be measured at the voltage specified in Table 2.

The insulation resistance shall be measured after the voltage has been applied for $60\text{ s} \pm 5\text{ s}$, unless otherwise prescribed in the detail specification.

Table 2 – Measurement of insulation resistance

Voltage rating of capacitor V	Measuring voltage V
U_R or $U_c < 10$	U_R or $U_c \pm 10\%$
$10 \leq U_R$ or $U_c < 100$	10 ± 1^a
$100 \leq U_R$ or $U_c < 500$	100 ± 15
$500 \leq U_R$ or U_c	500 ± 50
^a When it can be demonstrated that the voltage has no influence on the measuring result, or that a known relationship exists, measurements can be performed at voltages up to the rated or category voltage. In case of dispute, 10 V shall be used, unless otherwise specified in the sectional specification.	

U_R is the rated voltage for use in defining the measuring voltage to be used under standard atmospheric conditions for testing.

U_c is the category voltage for use in defining the measuring voltage to be used at the upper category temperature.

4.5.3 Test points

The insulation resistance shall be measured between the measuring points defined in Table 3, specified in the relevant specification.

Test A, between terminations, applies to all capacitors, whether insulated or not.

Test B, internal insulation, applies to insulated capacitors in uninsulated metal cases and to insulated and uninsulated multiple section capacitors.

Test C, external insulation, applies to insulated capacitors in non-metallic cases or in insulated metal cases. For this test, the measuring voltage shall be applied using one of the three following methods as specified in the relevant specification:

4.5.4 Test methods

4.5.4.1 Foil method

A metal foil shall be closely wrapped around the body of the capacitor.

For capacitors with axial terminations this foil shall extend beyond each end by not less than 5 mm, provided that a minimum distance of 1 mm can be maintained between the foil and the terminations. If this minimum distance cannot be maintained, the extension of the foil shall be reduced by as much as is necessary to establish the distance of 1 mm.

For capacitors with unidirectional terminations, a minimum distance of 1 mm shall be maintained between the edge of the foil and each termination.

4.5.4.2 Method for capacitors with mounting devices

The capacitor shall be mounted in its normal manner on a metal plate, which extends at least 12,7 mm in all directions beyond the mounting face of the capacitor.

4.5.4.3 V-block method

The capacitor shall be clamped in the trough of a 90° metallic V-block of such size that the capacitor body does not extend beyond the extremities of the block.

The clamping force shall be such as to guarantee adequate contact between the capacitor and the block.

The capacitor shall be positioned in accordance with the following:

- a) for cylindrical capacitors: the capacitor shall be positioned in the block so that the termination furthest from the axis of the capacitor is nearest to one of the faces of the block;
- b) for rectangular capacitors: the capacitor shall be positioned in the block so that the termination nearest the edge of the capacitor is nearest to one of the faces of the block.

For cylindrical and rectangular capacitors having axial terminations any out-of-centre positioning of the terminations at their emergence from the capacitor body shall be ignored.

4.5.5 Temperature compensation

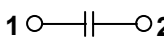
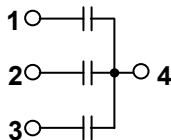
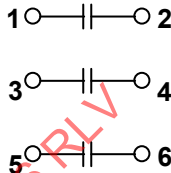
When prescribed in the detail specification, the temperature at which the measurement is made shall be noted. If this temperature differs from 20 °C, a correction shall be made to the measured value by multiplying the value by the appropriate correction factor prescribed in the sectional specification.

4.5.6 Conditions to be prescribed in the relevant specification

The relevant specification shall prescribe:

- a) the measuring points and the measuring voltage corresponding to each of these test points;
- b) the method of applying the voltage (one of the methods described in 4.5.4);
- c) time of electrification if other than 1 min;
- d) any special precautions to be taken during measurements;
- e) any correction factors required for measurement over the range of temperatures covered by the standard atmospheric conditions for testing;
- f) the temperature of measurement if other than the standard atmospheric conditions for testing;
- g) the minimum value of insulation resistance for the various measuring points (see Table 3).

Table 3 – Measuring points

Test	Applicable to:	1: Single-section capacitors	2: Multiple-section capacitors having common termination for all sections	3: Multiple-section capacitors having no common termination
		e.g. 	e.g. 	e.g. 
A. Between terminations ^a	All capacitors	1a: Between terminations (1-2)	2a: Between each of the terminations and the common termination (1-4, 2-4, 3-4)	3a: Between terminations of each section (1-2, 3-4, 5-6)
B. Internal insulation	Insulated single- and multiple-section capacitors in uninsulated metal cases (1b, 2b, 3b)	1b: Between terminations connected together and the case [(1 to 2)- case]	2b: Between all terminations connected together and the case [(1 to 4)- case]	3b: Between all terminations connected together and the case [(1 to 6)- case]
	Insulated and uninsulated multiple-section capacitors (2c and 3c)		2c: Between the non-common termination of each section and all the other terminations connected together e.g. [2-(1, 3, 4)]	3c: Between the terminations of separate sections, the two terminations of each section being connected together e.g. [(1 to 2)-(3 to 6)]
C. External insulation	Insulated capacitors in non-metallic cases or in insulated metal cases	1c: Between the two terminations connected together and, as appropriate, the metal foil, the metal plate or the metal V-block [(1 to 2)-metal jig]	2d: [(1 to 4)-metal jig]	3d: [(1 to 6)-metal jig]
			Between all terminations connected together and, as appropriate: the metal foil, the metal plate or the metal V-block	
^a Where a capacitor has more than two terminations, the measuring points are the two terminations which are insulated from one another by the capacitor's element dielectric. For example, for a coaxial lead-through capacitor, the measuring points should be one of the terminations connected to the central conductor and the coaxial metal case or mounting face.				

4.6 Voltage proof

4.6.1 General

The test prescribed below is a d.c. test. When an a.c. test is applied, the test circuit shall be prescribed in the relevant specification.

4.6.2 Test circuit (for the test between terminations)

The test circuit elements shall be selected in such a way as to ensure that the conditions relating to the charging and discharging currents and the time constant for charging, prescribed in the relevant specification, are maintained.

Figure 3 specifies the characteristics of a suitable test circuit.

The resistance of the voltmeter shall be not less than 10 000 Ω/V .

The resistor R_1 includes the internal resistance of the voltage source.

The resistors R_1 and R_2 shall have a value sufficient to limit the charging and discharging current to the value prescribed in the relevant specification.

The capacitance of capacitor C_1 shall be not less than 10 times the capacitance of the capacitor under test.

If applicable, the time constant $R_1 \times (C_X + C_1)$ shall be less than, or equal to, the value prescribed in the relevant specification.

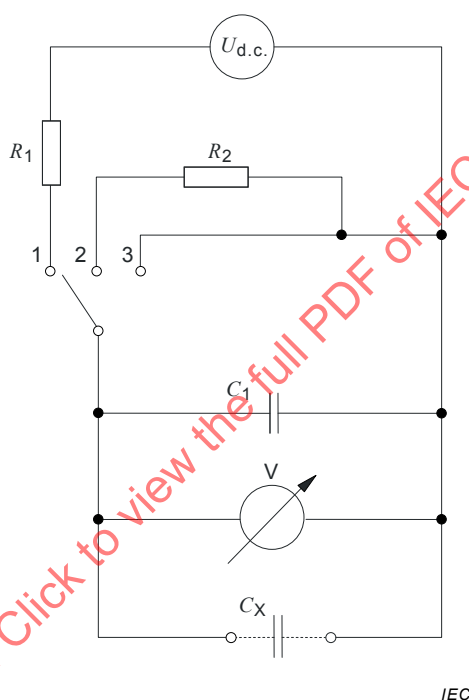


Figure 3 – Voltage-proof test circuit

The capacitor C_1 may be omitted for the testing of certain types of capacitors. This should be stated in the sectional specification.

4.6.3 Test

4.6.3.1 General

Depending on the case, the test comprises one or more parts in accordance with Table 3 and the requirements of the relevant specification.

Repeated application of the voltage proof test may cause permanent damage to the capacitor and should be avoided as far as possible.

4.6.3.2 Test A – Between terminations

4.6.3.2.1 Test points

The test voltage is applied to 1a, 2a, 3a of Table 3 in accordance with the requirements of the relevant specification.

4.6.3.2.2 Procedure

With the switch in position 2, connect the two terminals in Figure 3 to a variable d.c. supply of sufficient power adjusted to the required test voltage.

Connect the capacitor to be tested (C_X) to the test circuit as indicated in Figure 3.

Move the switch to position 1 so as to charge capacitors C_1 and C_X via R_1 .

The switch remains in this position for the time specified after the test voltage has been reached.

Discharge the capacitors C_1 and C_X through R_2 by moving the switch to position 2. As soon as the voltmeter reading has fallen to zero, short-circuit the capacitors by moving the switch to position 3 and disconnect the capacitor C_X .

4.6.3.3 Test B – Internal insulation

4.6.3.3.1 Test points

The test voltage is applied to 1b, 2b, 2c, 3b, 3c of Table 3 in accordance with the requirements of the relevant specification.

4.6.3.3.2 Procedure

The specified test voltage is applied instantaneously via the internal resistance of the power supply for the time specified in the relevant specification. For point 2c use the test circuit and the procedure indicated for the test between terminations (4.6.2 and 4.6.3.2).

4.6.3.4 Test C – External insulation (applicable only to insulated capacitors in a non-metallic case or in an insulated metal case)

4.6.3.4.1 Test points

The test voltage is applied to 1c, 2d or 3d, using one of the three following methods for the application of the voltage in accordance with the requirements of the relevant specification.

4.6.3.4.2 Foil method

A metal foil shall be closely wrapped around the body of the capacitor.

For capacitors with axial terminations this foil shall extend beyond each end by not less than 5 mm, provided that a minimum distance of 1 mm/kV can be maintained between the foil and the terminations. If this minimum cannot be maintained, the extension of the foil shall be reduced by as much as is necessary to establish the distance of 1 mm/kV of test voltage.

For capacitors with unidirectional terminations, a minimum distance of 1 mm/kV shall be maintained between the edge of the foil and each termination.

In no case shall the distance between the foil and the terminations be less than 1 mm.

4.6.3.4.3 Method for capacitors with mounting devices

The capacitor shall be mounted in its normal manner on a metal plate which extends by not less than 12,7 mm in all directions beyond the mounting face of the capacitor.

4.6.3.4.4 V-block method

The capacitor shall be clamped in the trough of a 90° metallic V-block of such a size that the capacitor body does not extend beyond the extremities of the block.

The clamping force shall be such as to guarantee adequate contact between the capacitor and the block.

The capacitor shall be positioned as follows:

- a) for cylindrical capacitors: the capacitor shall be positioned in the block so that the termination furthest from the axis of the capacitor is nearest to one of the faces of the block;
- b) for rectangular capacitors: the capacitor shall be positioned in the block so that the termination nearest the edge of the capacitor is nearest to one of the faces of the block.

For cylindrical and rectangular capacitors having axial terminations any out-of-centre positioning of the termination at its emergence from the capacitor body shall be ignored.

4.6.3.4.5 Procedure

The specified test voltage is applied instantaneously through the internal resistance of the power source for the time specified in the relevant specification.

4.6.4 Requirements

For each of the specified test points there shall be no sign of breakdown or flashover during the test period.

4.6.5 Conditions to be prescribed in the relevant specification

The relevant specification shall prescribe:

- a) the test points (see Table 3) and the test voltage corresponding to each of these points;
- b) for the external insulation test (test C), the method of applying the test voltage (one of the methods described in 4.6.3.4);
- c) the time for which the voltage is applied;
- d) the maximum charging and discharging currents;
- e) when applicable, the maximum value of the time constant for charging ($R_1 \times (C_1 + C_X)$).

4.7 Capacitance

4.7.1 Measuring frequency and measuring voltage

The capacitance shall be measured at one of the following frequencies, unless otherwise prescribed in the relevant specification:

- | | | |
|----------------------------|---|--|
| – electrolytic capacitors: | | 100 Hz to 120 Hz |
| – other capacitors: | $C_N \leq 1 \text{ nF}$: | 100 kHz, 1 MHz or 10 MHz
(1 MHz shall be reference) |
| | $1 \text{ nF} < C_N \leq 10 \text{ } \mu\text{F}$: | 1 kHz or 10 kHz
(1 kHz shall be reference) |
| | $C_N > 10 \text{ } \mu\text{F}$: | 50 Hz (60 Hz) or 100 Hz (120 Hz) |

The tolerance on all frequencies for measuring purposes shall not exceed ± 20 %.

The measuring voltage shall not exceed 3 % of U_R or 5 V, whichever is the smaller, unless otherwise prescribed in the relevant specification.

4.7.2 Measuring equipment

The accuracy of the measuring equipment shall be such that the error does not exceed:

- a) for absolute capacitance measurements: 10 % of the capacitance tolerance or 2 % absolute, whichever is the smaller;
- b) for measurement of variation of capacitance: 10 % of the specified maximum change of capacitance.

In neither case a) nor case b) need the accuracy be better than the minimum absolute measurement error (for example 0,5 pF) prescribed in the relevant specification.

4.7.3 Conditions to be prescribed in the relevant specification

The relevant specification shall prescribe:

- a) the measurement temperature if other than the standard atmospheric conditions for testing;
- b) the frequencies for measurement and the capacitance range over which they apply, if different from those specified in 4.7.1;
- c) the absolute measurement error, when applicable (for example 0,5 pF);
- d) measuring voltage if different from the one specified in 4.7.1;
- e) the applied polarizing voltage, when applicable.

4.8 Tangent of loss angle and equivalent series resistance (ESR)

4.8.1 Tangent of loss angle

4.8.1.1 Measuring frequency

The tangent of loss angle shall be measured under the same conditions as those given for the measurement of capacitance at one or more frequencies taken from the list in 4.7.1, as prescribed in the relevant specification.

4.8.1.2 Measuring accuracy

Unless otherwise specified in the sectional specification, the measuring method shall be such that the error does not exceed 10 % of the specified value or 0,000 3, whichever is the greater.

4.8.2 Equivalent series resistance (ESR)

4.8.2.1 Measuring frequency

The ESR shall be measured at one of the following frequencies, unless otherwise prescribed in the relevant specification:

50 Hz, 60 Hz, 100 Hz, 120 Hz, 1 kHz, 10 kHz, 100 kHz, 1 MHz and 10 MHz.

4.8.2.2 Measuring accuracy

The accuracy of the measuring equipment shall be such that the error does not exceed 10 % of the requirement, unless otherwise specified in the relevant specification.

4.8.2.3 Conditions to be prescribed in the relevant specification

The relevant specification shall prescribe

- a) the frequency of measurement;
- b) the absolute error measurement;
- c) the measuring voltage, if different from that specified in 4.7.1;
- d) the applied polarizing voltage, where applicable;
- e) the temperature at which measurements shall be made, if other than the standard atmospheric conditions for testing.

4.9 Leakage current

4.9.1 Preconditioning

Before this measurement is made, the capacitors shall be fully discharged.

4.9.2 Test method

The leakage current shall be measured, unless otherwise prescribed in the relevant specification, using the direct voltage (U_R or U_C) appropriate to the test temperature, after a maximum electrification period of 5 min. The full 5 min electrification need not be applied if the specified leakage current limit is reached in a shorter time.

4.9.3 Power source

For the object of test, a steady source of power such as a regulated power supply shall be used.

4.9.4 Measuring accuracy

The measurement error shall not exceed $\pm 5\%$ or $0,1\ \mu\text{A}$, whichever is the greater.

4.9.5 Test circuit

When prescribed in the relevant specification, a $1\ 000\ \Omega$ protective resistor shall be placed in series with the capacitor to limit the charging current.

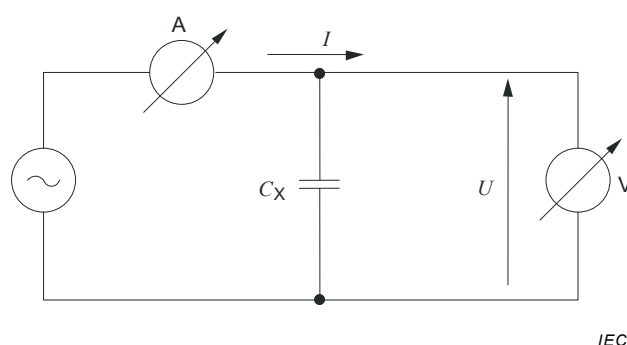
4.9.6 Conditions to be prescribed in the relevant specification

The relevant specification shall prescribe:

- a) the leakage current limit at a reference temperature of $20\ ^\circ\text{C}$, and at other specified temperatures;
- b) when necessary, the correction factor, if the measurements are made at a temperature other than $20\ ^\circ\text{C}$, but within the range of temperatures covered by the standard atmospheric conditions for testing;
- c) the electrification time, if different from 5 min;
- d) whether or not a $1\ 000\ \Omega$ protective resistor shall be placed in series with the capacitor to limit the charging current as defined in 4.9.5.

4.10 Impedance

Impedance shall be measured by the voltmeter-ammeter method according to the circuit of Figure 4, or equivalent.

**Key**

C_X	capacitance of specimen
U	measuring voltage
I	measuring current
A	ammeter
V	voltmeter

Figure 4 – Schematic diagram of the impedance measuring circuit

The impedance Z_X of the capacitor C_X is given by $Z_X = \frac{U}{I}$.

The frequency of the measuring voltage shall, preferably, be chosen from the following values:

50 Hz, 60 Hz, 100 Hz, 120 Hz, 1 kHz, 10 kHz, 100 kHz, 1 MHz and 10 MHz.

The accuracy of the measuring equipment shall be such that the error does not exceed 10 % of the requirement, unless otherwise specified in the relevant specification.

At frequencies above 120 Hz, precautions are necessary to avoid errors arising from stray currents. The current flowing through the capacitor should be limited so that the measuring result is not significantly affected by the rise of the temperature of the capacitor.

The relevant specification shall prescribe:

- the frequency of measurement;
- the temperature(s) at which measurements shall be made;
- the limits of impedance, or ratio of impedances measured at different temperatures.

4.11 Self-resonant frequency and inductance**4.11.1 Self-resonant frequency (f_r)****4.11.1.1 General**

For this measurement three methods are described. The first method is for general application; the other methods may be particularly suitable for measuring certain types of capacitors having low capacitance.

The accuracy of the measuring equipment shall be such that the error does not exceed 10 % of the requirement, unless otherwise specified in the relevant specification.

4.11.1.2 Method 1

Using the impedance measuring method of 4.10 and a variable frequency source, the lowest frequency shall be determined at which the impedance passes through a minimum. This is the self-resonant frequency.

When it is difficult to determine precisely the frequency at which the impedance is at a minimum, then use may be made of a phase-meter to compare the phase of the voltage across the capacitor with the phase of the voltage across a low-inductance resistor connected in series with the capacitor. The resonant frequency is then the frequency when there is no phase difference. A Q-meter may be used for this purpose.

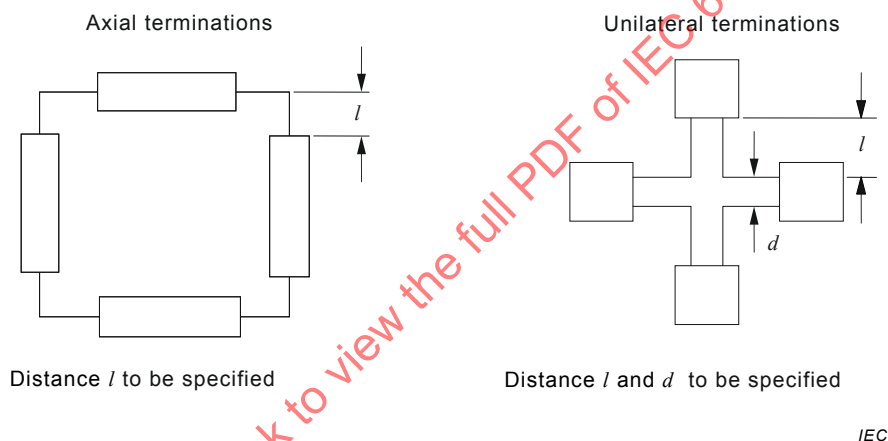
4.11.1.3 Method 2

4.11.1.3.1 General

For this measuring method, use shall be made of an absorption oscillator-wavemeter (grid dip meter).

4.11.1.3.2 Mounting of capacitors with terminations for general use

Four capacitors of nearly equal value and configuration shall be soldered in series at right angles to form a closed loop. The wires shall be of the specified length and no additional wiring or connections shall be employed (see Figure 5). This loop shall be coupled as loosely as possible to an absorption oscillator-wavemeter and the resonant frequency shall then be determined.



IEC

Figure 5 – Capacitor mounting arrangement

4.11.1.3.3 Mounting of capacitors with terminations for printed circuit use

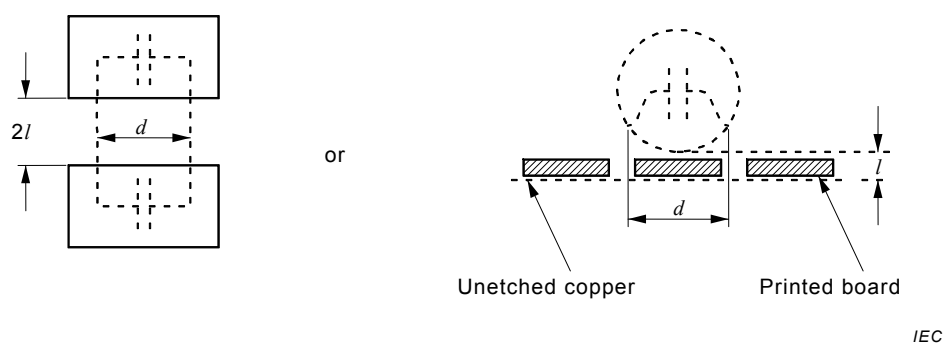
To determine the resonant frequency under the conditions of the capacitor being mounted on a printed circuit board and where the configuration of the case and/or the terminations does not permit a four capacitor loop to be formed correctly, the loop shall be formed by two (nearly) identical capacitors with straight terminations of specified length (see Figure 6).

The second capacitor may be substituted by its mirror image on a conductive plane in the following way.

A copper-clad, unetched sheet of printed circuit base material, whose edges are at least three times as long as the maximum dimension of the capacitor is drilled in its centre to accommodate the capacitor in its normal way.

The relevant specification shall prescribe the details of mounting. The capacitor is soldered in place with the capacitor being short-circuited by the copper laminate. Then the capacitor is coupled to the search coil and measured as in 4.11.1.3.5.

Metal-cased capacitors may necessitate special arrangements for coupling, which should be prescribed in the relevant specification.



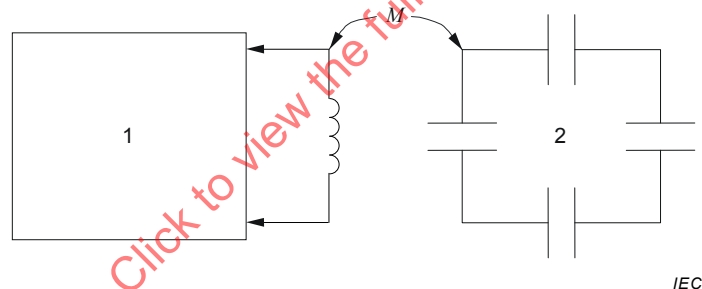
Distances l and d to be specified, where l is to be measured from the seating plane.

Figure 6 – Capacitor mounting arrangement

4.11.1.3.4 Description of the method

The absorption oscillator-wavemeter is a variable frequency L-C oscillator with the inductor formed as an external search coil. When the search coil is coupled into another resonant circuit, power is absorbed causing a change in the mean grid (gate on FETs (field effect transistor)) voltage. This is monitored and hence "dips" at the resonant frequency of the coupled circuit. This coupled circuit consists of four capacitors mounted as described in 4.11.1.3.2 and connected in series to minimize the mutual inductance.

A typical diagram showing the use of an absorption oscillator-wavemeter is given in Figure 7.



Key

- 1 absorption oscillator-wavemeter (grid-dip meter)
- 2 coupled resonant circuit
- M coupling factor

Figure 7 – Typical diagram of an absorption oscillator-wavemeter

4.11.1.3.5 Use of the absorption oscillator-wavemeter

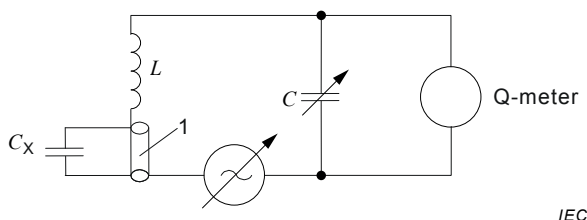
With the search coil of the wavemeter close to the capacitors under investigation, the resonant frequency is approached from a lower frequency. Dips should be checked by moving the wavemeter away from the capacitors (reducing the absorbed power) to make sure the dip is not due to internal effects of the wavemeter. The resonant frequency should be measured with as loose a coupling as is practical to avoid pulling the oscillator.

4.11.1.3.6 Requirements

The resonant frequency shall not exceed the limits prescribed in the relevant specification.

4.11.1.4 Method 3

This method is particularly suitable for capacitors of low capacitance and with a self-resonant frequency within Q-meter operating range. Using a Q-meter and the circuit shown in Figure 8, the lowest frequency shall be determined at which the same resonant frequency is obtained, whether the capacitor shorting strap is in place or not. This frequency can be shown to be equal to the self-resonant frequency of the capacitor.



Key

1	shorting strap
C_X	capacitor under test
C	variable capacitor
L	inductor
Q	Q-meter

Figure 8 – Schematic diagram of the measuring circuit

4.11.2 Inductance

The series inductance L_X of a capacitor is calculated from the measured self-resonant frequency f_r of the capacitor using the formula given below:

$$L_X = \frac{1}{4\pi^2 \times f_r^2 \times C_X}$$

where C_X is the capacitance of the capacitor measured in accordance with 4.7 and the requirements of the relevant sectional specification.

4.11.3 Conditions to be prescribed in the relevant specification

The relevant specification shall prescribe:

- which test method is preferred;
- the lead length of the capacitor to be employed in the measurement;
- any special mounting arrangement;
- the limits of series inductance or self-resonant frequency.

4.12 Outer foil termination

The correct indication of the termination which is connected to the outside metal foil shall be checked in such a way that the capacitor is not damaged.

A suitable method is given in Figure 9.

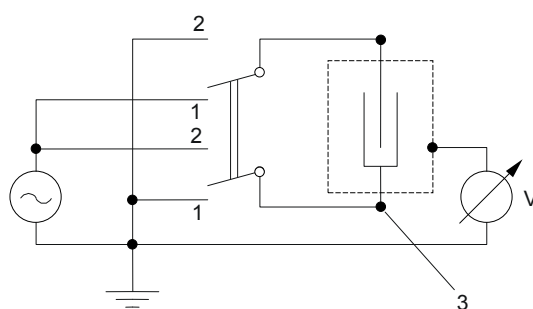
The frequency of the generator may be from 50 Hz to a few thousand Hertz and shall be so chosen as to give a clear result of measurement, the most appropriate value being dependent on the type of capacitor under test.

The voltage shall be of the order of 10 V.

The voltmeter shall have an input impedance of not less than 1 M Ω .

The stray capacitance of the wiring shall be kept low.

With the switch in position 1, the deflection of the voltmeter shall be markedly less than with the switch in position 2.



Key

- 1, 2 switching terminations
- 3 outer foil terminations
- V voltmeter

Figure 9 – Test circuit

4.13 Robustness of terminations

4.13.1 General

The capacitors shall be subjected to IEC 60068-2-21, Tests U_{a1} , U_b , U_c , and U_d , as applicable.

4.13.2 Test U_{a1} – Tensile

The force applied shall be:

- for terminations other than wire terminations: 20 N;
- for wire terminations: see Table 4.

Table 4 – Tensile force

Nominal cross-sectional area (S) ^a mm ²	Corresponding diameter (d) for circular-section wires mm	Force with tolerance of $\pm 10\%$ N
$S \leq 0,05$	$d \leq 0,25$	1
$0,05 < S \leq 0,1$	$0,25 < d \leq 0,35$	2,5
$0,1 < S \leq 0,2$	$0,35 < d \leq 0,5$	5
$0,2 < S \leq 0,5$	$0,5 < d \leq 0,8$	10
$0,5 < S \leq 1,2$	$0,8 < d \leq 1,25$	20
$1,2 < S$	$1,25 < d$	40
^a For circular-section wires, strips or pins: the nominal cross-sectional area is equal to the value calculated from the nominal dimension(s) given in the relevant specification. For stranded wires, the nominal cross-sectional area is obtained by taking the sum of the cross-sectional areas of the individual strands of the conductor specified in the relevant specification.		

4.13.3 Test Ub – Bending (half of the sample)

Method 1: Two consecutive bends shall be applied in each direction. This test shall not apply if, in the detail specification, the terminations are described as rigid.

4.13.4 Test Uc – Torsion (remaining sample)

Method 1, severity 2 (two successive rotations of 180°) shall be used.

This test shall not apply if in the detail specification the terminations are described as rigid and to components with unidirectional terminations designed for printed wiring applications.

4.13.5 Test Ud – Torque

This test shall apply to capacitors for terminations with threaded studs or screws and for integral mounting devices. Torque and severity shall be selected from Table 5.

Table 5 – Torque

Severity	Torque Nm								
	Nominal thread diameter mm								
	2,6	3	3,5	4	5	6	8	10	12
1	0,4	0,5	0,8	1,2	2,0	2,5	5	7	12
2	0,2	0,25	0,4	0,6	1,0	1,25	2,5	3,5	6

4.13.6 Visual examination

After each of these tests, the capacitors shall be visually examined. There shall be no visible damage.

4.14 Resistance to soldering heat

4.14.1 Preconditioning and initial measurement

When prescribed in the relevant specification, the capacitors shall be dried using the method of 4.3.

The capacitors shall be measured as prescribed in the relevant specification.

4.14.2 Test procedure

Unless otherwise stated in the relevant specification, one of the following tests as set out in the same specification shall be applied.

The test conditions shall be defined in the relevant specification.

- a) For all capacitors except those of item b) and c) below:
IEC 60068-2-20, Test Tb, method 1 (solder bath).
- b) For capacitors not designed for use in printed boards, but with connections intended for soldering as indicated by the detail specification:
 - 1) IEC 60068-2-20, Test Tb, method 1 (solder bath),
 - 2) IEC 60068-2-20, Test Tb, method 2 (soldering iron).
- c) For surface mount capacitors
IEC 60068-2-58, reflow or solder bath method.

4.14.3 Recovery

The period of recovery shall, unless otherwise specified in the detail specification, be not less than 1 h nor more than 2 h, except for surface mount capacitors, for which the period of recovery shall be $24 \text{ h} \pm 2 \text{ h}$.

4.14.4 Final inspection, measurement and requirements

For all capacitors, except surface mount capacitors, the following shall apply:

- when the test has been carried out the capacitors shall be visually examined;
- there shall be no visible damage and the marking shall be legible;
- the capacitors shall then be measured as prescribed in the relevant specification.

Surface mount capacitors shall be visually examined and measured and shall meet the requirements as prescribed in the relevant specification.

4.15 Solderability

4.15.1 General

This test shall not be applied to those terminations which the detail specification describes as not designed for soldering.

4.15.2 Preconditioning

The relevant specification shall prescribe whether ageing is to be applied. If accelerated ageing is required, one of the ageing procedures given in IEC 60068-2-20 shall be applied.

Unless otherwise stated in the relevant specification, the test shall be carried out with non-activated flux.

4.15.3 Test procedure

Unless otherwise stated in the relevant specification, one of the following tests as set out in the same specification shall be applied.

The test conditions shall be defined in the relevant specification.

a) For all capacitors except those of item b) and c) below:

1) IEC 60068-2-20, Test Ta, method 1 (solder bath)

Depth of immersion (from the seating plane or component body):

2,0 mm $\begin{smallmatrix} 0 \\ -0,5 \end{smallmatrix}$ mm, using a thermal insulating screen of 1,5 mm $\pm$ 0,5 mm thickness;

2) IEC 60068-2-20, Test Ta, method 2 (soldering iron)

3) IEC 60068-2-54, solder bath wetting balance method.

NOTE IEC 60068-2-54 is applicable only when prescribed in the detail specification or when agreed upon between manufacturer and customer.

b) For capacitors not designed for use in printed boards, but with connections intended for soldering as indicated by the detail specification:

1) IEC 60068-2-20, Test Ta, method 1 (solder bath)

Depth of immersion (from the seating plane or component body): 3,5 mm $\begin{smallmatrix} 0 \\ -0,5 \end{smallmatrix}$ mm.

2) IEC 60068-2-20, Test Ta, method 2 (soldering iron)

c) For surface mount capacitors

1) IEC 60068-2-58, reflow or solder bath method

2) IEC 60068-2-69, solder bath wetting balance or solder globule wetting balance method.

NOTE IEC 60068-2-69 is applicable only when prescribed in the detail specification or when agreed upon between manufacturer and customer.

4.15.4 Final inspection, measurements and requirements

The terminations shall be examined for good tinning as evidenced by free flowing of the solder with wetting of the terminations.

The capacitors shall meet the requirements as prescribed in the relevant specification.

4.16 Rapid change of temperature

4.16.1 Initial measurement

The measurements prescribed in the relevant specification shall be made.

4.16.2 Test procedure

The capacitors shall be subjected to IEC 60068-2-14, Test Na, using the degree of severity as prescribed in the relevant specification.

4.16.3 Final inspection, measurements and requirements

After recovery, the capacitors shall be visually examined. There shall be no visible damage.

The measurements prescribed in the relevant specification shall then be made.

4.17 Vibration

4.17.1 Initial measurement

The measurements prescribed in the relevant specification shall be made.

4.17.2 Test procedure

The capacitors shall be subjected to IEC 60068-2-6, Test Fc, using the mounting method and the degree of severity prescribed in the relevant specification.

4.17.3 Electrical test (intermediate measurement)

When specified in the detail specification, during the last 30 min of the vibration test an electrical measurement shall be made in each direction of movement to check intermittent contacts, or open or short circuits.

The method of measurement shall be prescribed in the detail specification.

The duration of the measurement shall be the time needed for one sweep of the frequency range from one frequency extreme to the other.

4.17.4 Final inspection, measurements and requirements

After the test the capacitors shall be visually examined. There shall be no visible damage. When capacitors are tested as specified in 4.17.3, the requirements shall be stated in the detail specification.

The measurements prescribed in the relevant specification shall then be made.

4.18 Bump (repetitive shock)

4.18.1 Initial measurement

The measurements prescribed in the relevant specification shall be made.

4.18.2 Test procedure

The capacitors shall be subjected to IEC 60068-2-27, Test Ea (repetitive shock), using the mounting method and the severity prescribed in the relevant specification.

Preferred conditions are:

- pulse shape: half-sine;
- number of shocks in each direction: a minimum of 100;
- peak acceleration: to be chosen from recommended severities.

4.18.3 Final inspection, measurements and requirements

After the test, the capacitors shall be visually examined. There shall be no visible damage.

The measurements prescribed in the relevant specification shall then be made.

4.19 Shock

4.19.1 Initial measurement

The measurements prescribed in the relevant specification shall be made.

4.19.2 Test procedure

The capacitors shall be subjected to IEC 60068-2-27, Test Ea (non-repetitive shock), using the mounting method and the severity prescribed in the relevant specification.

4.19.3 Final inspection, measurements and requirements

After the test the capacitors shall be visually examined. There shall be no visible damage.

The measurements prescribed in the relevant specification shall then be made.

4.20 Container sealing

The capacitors shall be subjected to the procedure of the appropriate method of IEC 60068-2-17, Test Q, as prescribed in the relevant specification.

4.21 Climatic sequence

4.21.1 General

In the climatic sequence, an interval of a maximum of three days is permitted between any of the tests, except that the cold test shall be applied immediately after the recovery period for the first cycle of the damp heat, cyclic, IEC 60068-2-30, Test Db.

4.21.2 Initial measurements

The measurements prescribed in the relevant specification shall be made.

4.21.3 Dry heat

The capacitors shall be subjected to IEC 60068-2-2, Test Bb, for 16 h, using the degree of severity of the upper category temperature, as prescribed in the detail specification.

The test specimens may be introduced into the chamber at any temperature from laboratory temperature to the upper category temperature.

While still at the specified high temperature and at the end of the period of high temperature, the measurements prescribed in the relevant specification shall be made.

After the specified conditioning, the capacitors shall be removed from the chamber and exposed to standard atmospheric conditions for testing for not less than 4 h.

4.21.4 Damp heat, cyclic, Test Db, first cycle

The capacitors shall be subjected to IEC 60068-2-30, Test Db, for one cycle of 24 h, using a temperature of 55 °C (severity b).

Unless otherwise specified in the relevant specification, variant 2 shall be used.

After recovery the capacitors shall be subjected immediately to the cold test.

4.21.5 Cold

The capacitors shall be subjected to IEC 60068-2-1, Test Ab, for 2 h, using the degree of severity of the lower category temperature, as prescribed in the relevant specification.

The test specimens may be introduced into the chamber at any temperature from laboratory temperature to the lower category temperature.

While still at specified low temperature and at the end of the period of low temperature, the measurements prescribed in the relevant specification shall be made.

After the specified conditioning, the capacitors shall be removed from the chamber and exposed to standard atmospheric conditions for testing for not less than 4 h.

4.21.6 Low air pressure

The capacitors shall be subjected to IEC 60068-2-13, Test M, using the appropriate degree of severity prescribed in the relevant specification. The duration of the test shall be 10 min, unless otherwise stated in the relevant specification.

The relevant specification shall prescribe:

- a) duration of test; if other than 10 min;
- b) temperature;
- c) degree of severity.

While at the specified low pressure, the rated voltage shall be applied during the last 60 s of the test period, unless otherwise prescribed in the relevant specification.

During and after the test, there shall be no evidence of permanent breakdown, flashover, harmful deformation of the case, or seepage of impregnant.

4.21.7 Damp heat, cyclic, Test Db, remaining cycles

The capacitors shall be subjected to IEC 60068-2-30, Test Db, for the following number of cycles of 24 h as indicated in Table 6, under the same conditions as used for the first cycle.

Table 6 – Number of cycles

Climatic categories	Number of cycles
-/-/56	5
-/-/21	1
-/-/10	1
-/-/04	None

4.21.8 Final measurements

After the prescribed recovery, the measurements prescribed in the relevant specification shall be made.

4.22 Damp heat, steady state

4.22.1 Initial measurement

The measurements prescribed in the relevant specification shall be made.

4.22.2 Test procedure

The capacitors shall be subjected to IEC 60068-2-78, Test Cab, using the degree of severity corresponding to the climatic category of the capacitor as indicated in the detail specification. The temperature and humidity of test shall be $(40 \pm 2) ^\circ\text{C}$, $(93 \pm 3) \% \text{RH}$, unless otherwise specified in the relevant specification.

When specified in the blank detail specification, the detail specification may specify the application of a polarizing voltage during the whole period of damp heat conditioning. For metallized film capacitors this test should be carried out in accordance with Annex G.

With the exception of electrolytic capacitors, within 15 min after removal from the test chamber, the voltage proof test of 4.6 shall be carried out at test point A only, using the rated voltage, unless otherwise specified in the detail specification.

4.22.3 Final inspection, measurements and requirements

After recovery, the capacitors shall be visually examined. There shall be no visible damage. The measurements prescribed in the relevant specification shall then be made.

In case of testing metallized film capacitors, when specified in the blank detail specification, the permissible deviation of the average C-value of test group with and the test group without d.c. voltage shall be described in the relevant detail specification.

4.23 Endurance

4.23.1 Initial measurements

The measurements prescribed in the relevant specification shall be made.

4.23.2 Test procedure

The tests of IEC 60068-2-2 apply as follows:

- a) d.c. tests – Test Bb;
- b) a.c. tests – Test Bb or Bd as applicable;
- c) pulse tests – Test Bb or Bd as applicable.

The test specimens may be introduced into the chamber at any temperature, from laboratory temperature to the upper category temperature, but the voltage shall not be applied to the capacitor before it has reached the chamber temperature.

4.23.3 Conditions to be prescribed in the relevant specification

The relevant specification shall prescribe:

- a) duration of the test (for example, hours or number of pulses);
- b) test temperature (for example, room, rated or upper category temperature);
- c) voltage and/or current to be applied (see also 4.23.4).

When capacitors have to meet additional requirements for electric shock hazard protection, additional test conditions for endurance testing (for example, pulse voltage application) shall be prescribed in the relevant specification.

4.23.4 Test voltage

Unless otherwise specified in the relevant specification, the voltage to be applied during the test shall be selected from the following.

- a) d.c. tests

The test shall be carried out at a multiplying factor times the rated voltage (d.c.) at temperatures up to the rated temperature. The test temperature and the value of the multiplying factor shall be specified in the relevant specification. For tests at the upper category temperature the derating factor for the voltage shall also be given.

- b) a.c. tests (sinusoidal voltage)

The test shall be made at 50 Hz to 60 Hz and at a multiplying factor times the rated voltage (a.c.) (see 2.3.4 a)) at temperatures up to the rated temperature, or at the upper category temperature with a derating factor for the voltage. The test temperature and the

value of the multiplying factor/derating factor for the voltage shall be specified in the relevant specification.

c) a.c. tests (sinusoidal current)

This test shall be made with a current applied in accordance with 2.3.4 b). The test temperature, the value of current and frequency shall be specified in the relevant specification.

To facilitate testing, the test may be made with a voltage of specified frequency applied to a group of capacitors in parallel or in series/parallel.

d) sinusoidal a.c. tests (reactive power)

This test shall be made with reactive power in accordance with 2.3.4 c). The test temperature, the value of the reactive power, and the frequency shall be specified in the relevant specification.

To facilitate testing, the test may be made with a voltage of specified frequency applied to a group of capacitors in parallel or in series/parallel.

A thermal stability test (see 4.30) may constitute an alternative to this test. The test to be carried out shall be specified in the detail specification.

e) pulse tests

This test shall be made with pulses applied in accordance with 2.3.5 and as specified in the relevant specification. Guidance for pulse tests is given in Annex E.

f) sinusoidal a.c. or pulse tests with superimposed d.c.

Tests b) to e) may be carried out with superimposed d.c. as required in the relevant specification (see also 2.2.23).

An example of a test circuit suitable for electrolytic capacitors is given in Figure 10.

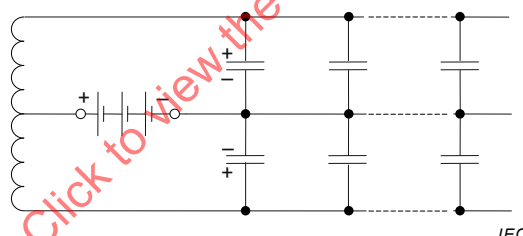


Figure 10 – Test circuit for electrolytic capacitors

4.23.5 Placement in the test chamber

The capacitors shall be placed in the test chamber in such a manner that

- a) for heat dissipating capacitors, no capacitor is within 25 mm of any other capacitor,
- b) for non-heat dissipating capacitors, no capacitor is within 5 mm of any other capacitor.

4.23.6 Recovery

After the specified period, the capacitors shall be allowed to cool to standard atmospheric conditions for testing and where specified in the relevant specification, the capacitors shall be subjected to recovery.

4.23.7 Final inspection, measurements and requirements

The capacitors shall then be visually examined.

The measurements prescribed in the relevant specification shall then be made. A capacitor shall be considered to have failed when the requirements of the relevant specification during or at the end of the test are not satisfied.

4.24 Variation of capacitance with temperature

4.24.1 Static method

4.24.1.1 Initial measurement

Measurements of capacitance shall be made under the conditions prescribed in the relevant specification.

4.24.1.2 Test procedure

The capacitor shall be maintained at each of the following temperatures in turn:

- a) $20\text{ °C} \pm 2\text{ °C}$;
- b) lower category temperature $\pm 3\text{ °C}$;
- c) intermediate temperatures, if required in the detail specification;
- d) $20\text{ °C} \pm 2\text{ °C}$;
- e) intermediate temperatures, if required in the detail specification;
- f) upper category temperature $\pm 2\text{ °C}$;
- g) $20\text{ °C} \pm 2\text{ °C}$.

If required for a particular type of capacitor, the relevant specification shall prescribe whether thermal shock is to be avoided or whether a maximum rate of change of temperature shall be specified.

The conditions of measurement, during or after temperature cycling, a description of the temperature cycle and the number of cycles, should be stated.

4.24.1.3 Measuring method

Capacitance measurements shall be made at each of the temperatures specified above, after the capacitor has reached thermal stability.

The condition of thermal stability is judged as having been reached when two readings of capacitance taken at an interval of not less than 5 min do not differ by an amount greater than that which can be attributed to the measuring apparatus.

The measurement of the actual temperature shall be made with a precision compatible with the requirements of the detail specification.

Care shall be taken during measurements to avoid condensation or frost on the surface of the capacitors.

4.24.1.4 Reduced procedure

For the lot-by-lot quality conformance testing, the detail specification may prescribe a reduced procedure, for example, measurements d), f) and g) in 4.24.1.2 covering the temperature range from 20 °C to the upper category temperature.

4.24.2 Dynamic method

As an alternative to the static method of 4.24.1, a dynamic plotting method may be employed. The capacitors shall be subjected to a slowly varying temperature.

A temperature-sensing device shall be embedded in a dummy capacitor to be included with the capacitor under test in a manner that will ensure that the measured temperature is the

same as that occurring in the capacitor under test. The capacitance shall be measured using a self-balancing bridge or comparator.

The output of the bridge or comparator shall be coupled to the "Y" axis of a plotting table.

The output of the temperature sensing device shall be coupled to the "X" axis of a plotting table.

The temperature shall be varied slowly enough to produce a uniform curve with no loop at the lower or upper category temperature. The temperature shall be varied subsequently from 20 °C to the lower category temperature, then to the upper category temperature and back to 20 °C. Two cycles shall be carried out.

This method may be employed only when it can be demonstrated that the results are the same as for the method employing stabilized temperatures.

In case of dispute, the static method shall be used.

4.24.3 Methods of calculation

4.24.3.1 General

The following applies:

C_0 is the capacitance measured at point d) of 4.24.1.2;

T_0 is the temperature measured at point d) of 4.24.1.2;

C_i is the capacitance measured at the test temperature, other than at points a), d) and g) of 4.24.1.2;

T_i is the temperature measured on test.

4.24.3.2 Temperature characteristics of capacitance

The variation of capacitance as a function of temperature shall be calculated for all the values of C_i as follows:

$$\frac{\Delta C}{C_0} = \frac{C_i - C_0}{C_0}$$

The variation of capacitance is normally expressed in per cent.

4.24.3.3 Temperature coefficient of capacitance and temperature cyclic drift of capacitance

Temperature coefficient of capacitance and temperature cyclic drift of capacitance shall be calculated as follows:

a) Temperature coefficient of capacitance (α)

Temperature coefficient of capacitance (α) shall be calculated for all the values of C_i as follows:

$$\alpha_i = \frac{C_i - C_0}{C_0(T_i - T_0)} \times 10^6$$

The temperature coefficient is normally expressed in parts per million per Kelvin ($10^{-6}/K$).

b) Temperature cyclic drift of capacitance

The temperature cyclic drift of capacitance shall be calculated for the points of measurement of 4.24.1.2 a), d) and g) in the following manner:

$$\delta_{da} = \frac{C_0 - C_a}{C_0}$$

$$\delta_{gd} = \frac{C_g - C_0}{C_0}$$

$$\delta_{ga} = \frac{C_g - C_a}{C_0}$$

as required in the relevant specification. The largest of these values is the "temperature cyclic drift of capacitance".

The capacitance drift is normally expressed in per cent.

4.25 Storage

4.25.1 Storage at high temperature

4.25.1.1 Initial measurement

The measurements prescribed in the relevant specification shall be made.

4.25.1.2 Test procedure

The capacitors shall be subjected to IEC 60068-2-2, Test Bb, using the following severities:

- temperature: upper category temperature;
- duration: 96 h ± 4 h.

The test specimens may be introduced into the chamber at any temperature from laboratory temperature to the upper category temperature.

4.25.1.3 Final inspection, measurements and requirements

After recovery for at least 16 h, the measurements prescribed in the relevant specification shall be made.

4.25.2 Storage at low temperature

4.25.2.1 Initial measurement

The measurements prescribed in the relevant specification shall be made.

4.25.2.2 Test procedure

The capacitors shall be subjected to IEC 60068-2-1, Test Ab. The capacitors shall be stored at –40 °C for either a period of 4 h after thermal stability has been reached, or for 16 h, whichever is the shorter period.

The test specimens may be introduced into the chamber at any temperature from laboratory temperature to –40 °C.

4.25.2.3 Final inspection, measurements and requirements

After recovery for at least 16 h, the measurements prescribed in the relevant specification shall be made.

4.26 Surge

4.26.1 Initial measurement

The measurements specified in the relevant specification shall be made.

4.26.2 Test procedure

Suitable test circuits are shown in Figure 11 and Figure 12.

NOTE The thyristor circuit has the advantage of high repetition rates and is free from troubles associated with dirty contacts and contact bounce.

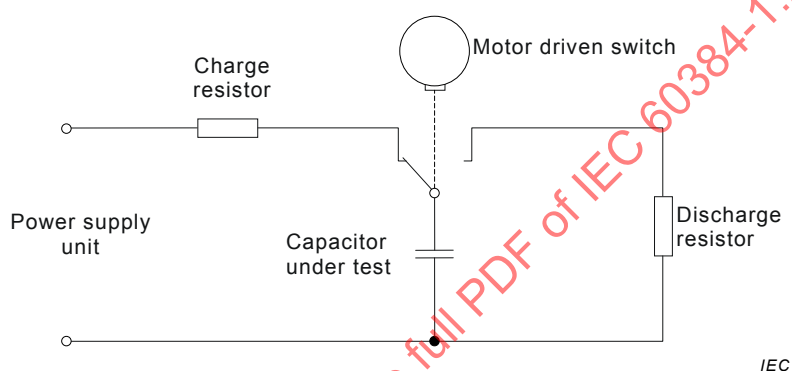


Figure 11 – Relay circuit

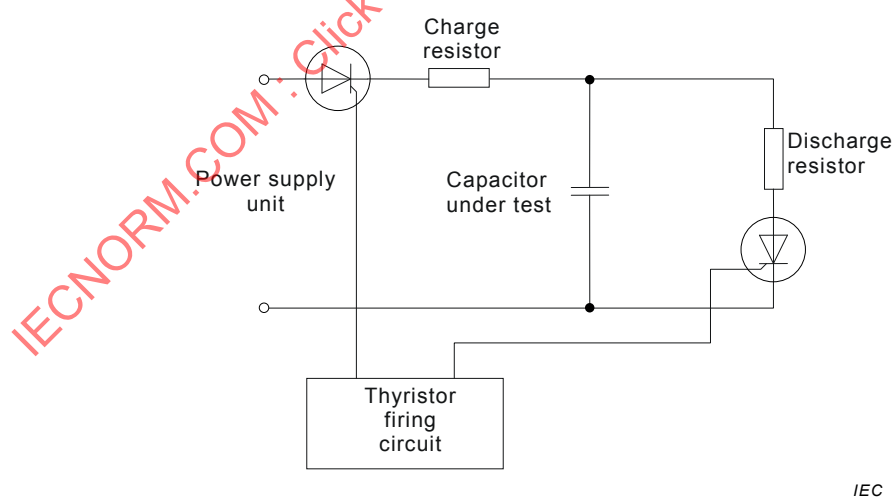
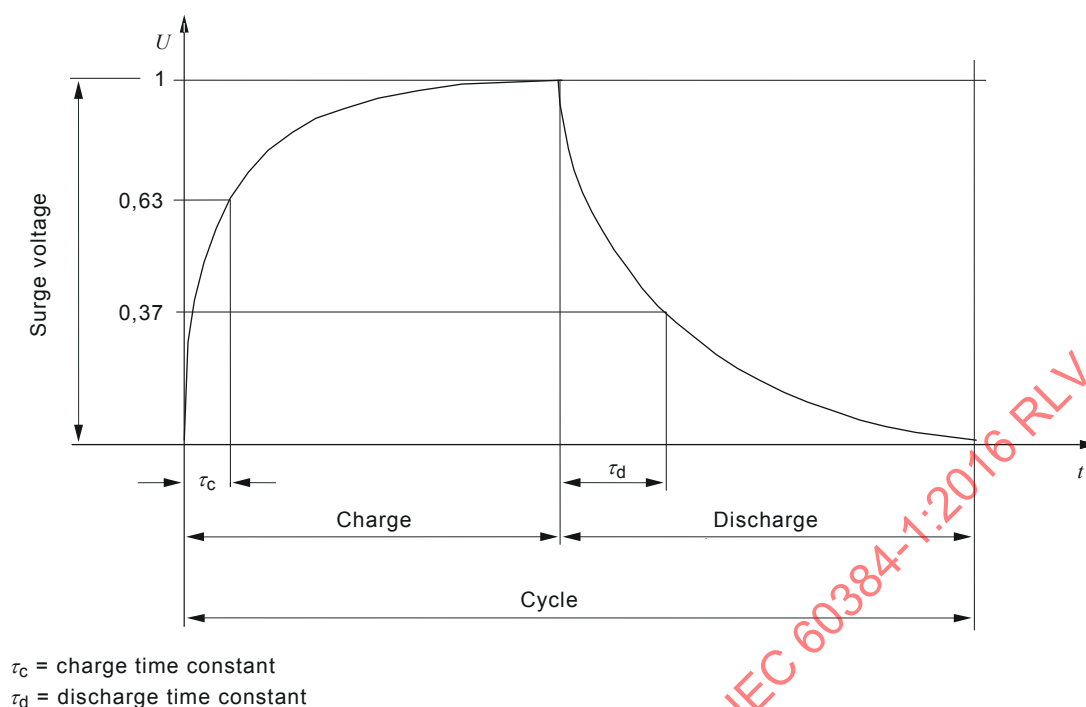


Figure 12 – Thyristor circuit

The voltage waveform across the capacitor under test shall be approximately as shown in Figure 13.



IEC

Figure 13 – Voltage waveform across capacitor

4.26.3 Final inspection, measurements and requirements

The measurements specified in the relevant specification shall be made.

4.26.4 Information to be given in the relevant detail specification

The following information shall be given in the relevant specification:

- the charge time constant arising from the internal resistance of the power supply and the resistance of the charge circuit and the capacitance of the capacitor under test;
- the discharge time constant arising from the resistance of the discharge circuit and the capacitance of the capacitor under test;
- the ratio of the surge voltage to rated or category voltage (as appropriate);
The number of times per hour that this voltage may be applied should be specified.
- the number of cycles of test;
- the duration of the charge period;
- the duration of the discharge period;
- the repetition rate (cycles per second);
- temperature, if different from standard atmospheric conditions for testing.

4.27 Charge and discharge tests and inrush current test

4.27.1 Initial measurement

The measurements specified in the relevant specification shall be made.

4.27.2 Test procedure

Suitable test circuits are given in 4.26.2, Figure 11 and Figure 12.

The voltage and current waveforms across and through the capacitor under test are approximately as shown in Figure 14.

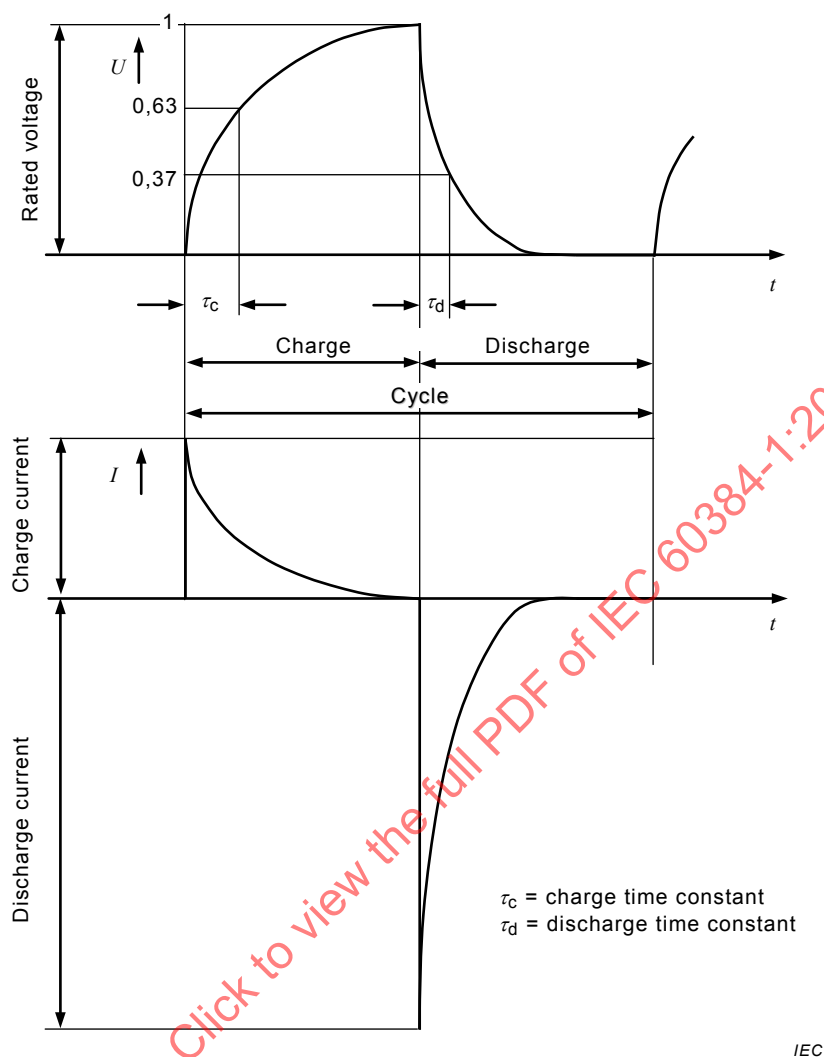


Figure 14 – Voltage and current waveform

4.27.3 Charge and discharge

The following information shall be given in the relevant specification:

- the charge time constant arising from the internal resistance of power supply and the resistance of the charge circuit and the capacitance of the capacitor under test;
- the discharge time constant arising from the resistance of the discharge circuit and the capacitance of the capacitor under test;
- the voltage to be applied during the charge period, if different from the rated voltage;
- the number of cycles of test;
- the duration of the charge period;
- the duration of the discharge period;
- the repetition rate (cycles per second);
- temperature, if different from standard atmospheric conditions for testing.

4.27.4 Inrush current

The following information shall be given in the relevant specification:

- a) the peak charge current;
- b) the voltage to be applied during the charge period if different from the rated voltage;
- c) the number of cycles of test;
- d) the duration of the charge period in milliseconds;
- e) the duration of the discharge period;
- f) the repetition rate;
- g) the temperature if different from standard atmospheric conditions for testing.

4.27.5 Final inspection, measurements and requirements

The measurements specified in the relevant specification shall be made.

4.28 Pressure relief (for aluminium electrolytic capacitors)

4.28.1 General

Unless otherwise specified in the relevant specification, one of the following tests shall be used to test the pressure relief device of the capacitors.

4.28.2 AC test

Applied voltage: alternating voltage with r.m.s. value not exceeding 0,7 times the rated direct voltage.

Frequency of the applied voltage: 50 Hz or 60 Hz.

Series resistor: $R = 0,5$ times the impedance of the capacitor at the test frequency.

4.28.3 DC test

Applied voltage: direct voltage applied in the reverse direction, of an amplitude necessary to produce a current of 1 A to 10 A.

4.28.4 Pneumatic test

Applied pneumatic pressure: gas pressure introduced from outside shall be increased at a rate of 20 kPa/s continuously.

4.28.5 Final inspection, measurements and requirements

The measurements specified in the relevant specification shall be made.

4.29 Characteristics at high and low temperature

4.29.1 Test procedure

The capacitors shall be subjected to the procedures of the dry heat and cold test (4.21.3 and 4.21.5, respectively) with the following details.

The degree of severity for these tests shall be the same as for the dry heat and cold tests. Tests at intermediate temperatures may be prescribed in the relevant specification.

Measurements shall be made at each of the specified temperatures after the capacitor has reached thermal stability.

The condition of thermal stability is judged to be reached when two readings of a characteristic, taken in an interval of not less than 5 min, do not differ by an amount greater than that which can be attributed to the measuring apparatus.

4.29.2 Requirements

The capacitors shall not exceed the limits prescribed in the relevant specification.

4.30 Thermal stability test

A thermal stability test may constitute an alternative to the endurance test in accordance with 4.23.4 d). The test to be carried out shall be specified in the detail specification.

The capacitor shall be loaded with a specified factor times the rated reactive power dissipation at the rated temperature and duration as specified in the relevant specification.

A test for thermal stability shall be made by measuring the temperature rise as a function of time over the last part of the specified duration. The temperature rise shall be within specified limits.

The measurement of the temperature rise may be made by the use of a thermocouple, thermistor, infrared thermometer, infrared photography, etc. Care should be taken to ensure that the error of measurement does not exceed $\pm 1^\circ\text{C}$ and that errors due to heat conduction along measuring connections are kept to a minimum.

The relevant specification shall specify the point at which the measurements shall be made and the method of mounting (see IEC 60068-2-2:2007, 6.4).

4.31 Component solvent resistance

4.31.1 Initial measurements

The measurements prescribed in the relevant specification shall be made.

4.31.2 Test procedure

The components shall be subjected to IEC 60068-2-45, Test XA, with the following details:

- a) solvent to be used: IPA (IEC 60068-2-45:1980/AMD1:1993, 3.1.2);
- b) solvent temperature: $23^\circ\text{C} \pm 5^\circ\text{C}$, unless otherwise specified in the detail specification;
- c) conditioning: method 2, (without rubbing);
- d) recovery time: 48 h, unless otherwise stated in the detail specification.

4.31.3 Final inspection, measurements and requirements

The measurements prescribed in the relevant specification shall then be made and the specified requirements be met.

4.32 Solvent resistance of marking

4.32.1 Test procedure

The components shall be subjected to IEC 60068-2-45, Test XA, with the following details:

- a) solvent to be used: IPA (IEC 60068-2-45:1980/AMD1:1993, 3.1.2);

- b) solvent temperature: $23\text{ °C} \pm 5\text{ °C}$;
- c) conditioning: method 1 (with rubbing);
- d) rubbing material: cotton wool;
- e) recovery time: not applicable, unless otherwise stated in the detail specification.

4.32.2 Final inspection, measurements and requirements

After the test the marking shall be legible.

4.33 Mounting (for surface mount capacitors only)

4.33.1 Substrate

Surface mount capacitors shall be mounted on a suitable substrate, the method of mounting being dependent on the capacitor construction. The substrate material shall normally be an epoxide woven glass fabric laminated printed board (as defined in IEC 61249-2-7) with a thickness of $1,6\text{ mm} \pm 0,20\text{ mm}$ or $0,8\text{ mm} \pm 0,10\text{ mm}$, or a 90 % to 98 % alumina substrate having a thickness of $0,635\text{ mm} \pm 0,05\text{ mm}$ or more, and shall not affect the result of any test or measurement. The detail specification shall indicate which material is to be used for the electrical measurements.

The substrate shall have metallized land areas of proper spacing to permit mounting of surface mount capacitors and shall provide electrical connection to the surface mount capacitor terminals. The details shall be specified in the detail specification.

Examples of test substrates for mechanical and electrical tests are shown in Figure 15 and Figure 16, respectively.

If another method of mounting applies, the method should be clearly described in the detail specification.

4.33.2 Wave soldering

When the detail specification specifies wave soldering, suitable glue, details of which may be specified in the detail specification, shall be used to fasten the component to the substrate before soldering is performed.

Small dots of the glue shall be applied between the conductors of the substrate by means of a suitable device securing repeatable results.

The surface mount capacitors shall be placed on the dots using tweezers. To ensure that no glue is applied to the conductors, the surface mount capacitors shall not be moved about.

The substrate with the surface mount capacitors shall be heat-treated in an oven at 100 °C for 15 min.

The substrate shall be soldered in a wave soldering apparatus. The apparatus shall be adjusted to have a pre-heating temperature of 80 °C to 100 °C , a solder bath at $260\text{ °C} \pm 5\text{ °C}$ and a soldering time of $5\text{ s} \pm 0,5\text{ s}$.

The substrate shall be cleaned for 3 min in a suitable solvent (see IEC 60068-2-45:1980/AMD1:1993, 3.1.2).

4.33.3 Reflow soldering

When the detail specification specifies reflow soldering, the following mounting procedure applies.

- a) The solder used in preform or paste form shall be silver bearing (2 % minimum) eutectic Sn/Pb solder together with a flux as stated in IEC 60068-2-20. Alternative solders such as 60/40 or 63/37 may be used on chips whose construction includes solder leach barriers. Pb-free solder used in preform or paste form shall be Sn96,5Ag3,0Cu0,5 or derivative solder together with a flux as stated in IEC 60068-2-58, or as defined in the relevant specification.
- b) The surface mount capacitor shall then be placed across the metallized land areas of the test substrate so as to make contact between surface mount and substrate land areas.
- c) The substrate shall then be placed in or on a suitable heating system (molten solder, hot plate, tunnel oven, etc.). The temperature of the unit shall be maintained between 215 °C and 260 °C, until the solder melts and reflows forming a homogeneous solder bond, but for not longer than 10 s.

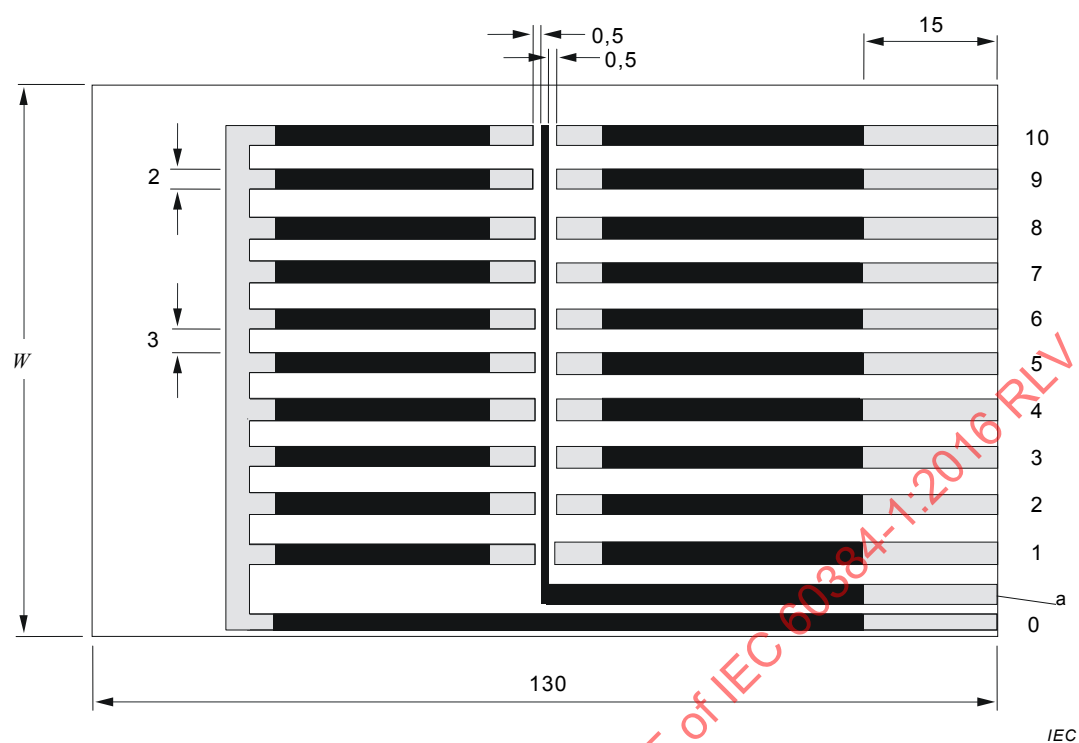
Flux should be removed by a suitable solvent (see IEC 60068-2-45:1980/AMD1:1993, 3.1.2). All subsequent handling should be such as to avoid contamination. Care should be taken to maintain cleanliness in test chambers and during post test measurements.

The detail specification may require a more restricted temperature range.

If vapour phase soldering is applied, the same method may be used with the temperatures adapted.

A suitable substrate for mechanical tests is shown in Figure 15. Note that this substrate may not be suitable for impedance measurements. A suitable substrate for electrical tests is shown in Figure 16.

IECNORM.COM : Click to view the full PDF of IEC 60384-1:2016 PLV



Key

-  Solderable areas
 Non-solderable areas (covered with non-solderable lacquer)

All dimensions are in millimetres. Tolerances: medium.

Material: epoxide woven glass

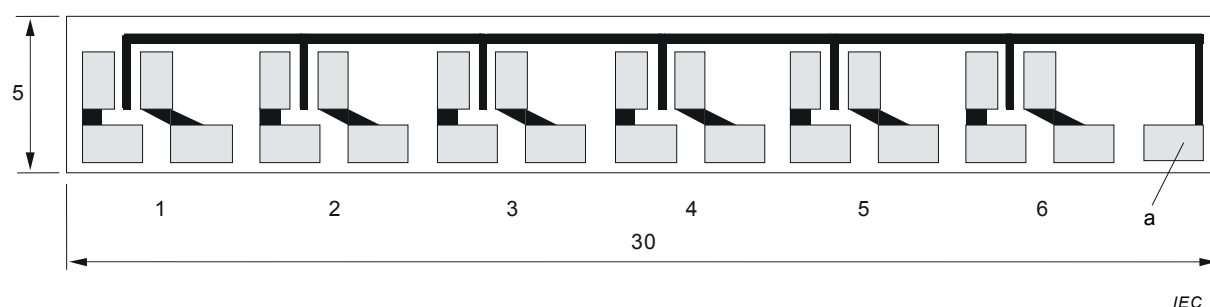
Thickness: 1,6 mm $\pm$ 0,20 mm, or 0,8 mm $\pm$ 0,10 mm

Dimensions not given should be chosen according to the design and size of the specimens to be tested.

Dimension W is dependent on the design of the test equipment.

^a This conductor may be omitted or used as a guard electrode.

Figure 15 – Suitable substrate for mechanical tests

**Key**

-  Solderable areas
 Non-solderable areas (covered with non-solderable lacquer)

All dimensions are in millimetres. Tolerances: medium.

Material: 90 % to 98 % alumina substrate

Thickness: 0,635 mm $\pm$ 0,05 mm, or more

Dimensions not given should be chosen according to the design and size of the specimens to be tested.

Dimension *W* depends on the design of the test equipment.

^a This conductor may be omitted or used as a guard electrode.

Figure 16 – Suitable substrate for electrical tests

4.34 Shear test

4.34.1 Test procedure

The surface mount capacitors shall be mounted as described in IEC 60068-2-21, Test U.

The capacitors shall be subjected to IEC 60068-2-21, Test Ue3, under the following condition.

A force shall be applied to the surface mount capacitor body progressively, without shock, and shall be maintained for a period of 10 s $\pm$ 1 s. Unless otherwise specified in the relevant specification, a force shall be selected from 1 N, 2 N, 5 N or 10 N.

4.34.2 Final inspection, measurements and requirements

The surface mount capacitors shall be visually examined in the mounted state. There shall be no visible damage.

4.35 Substrate bending test

4.35.1 Test procedure

The surface mount capacitor shall be mounted on an epoxide woven glass printed board as described in 4.33.

- The capacitance of the surface mount capacitor shall be measured as specified in 4.7 and in the relevant sectional specification.
- The capacitor shall be subjected to IEC 60068-2-21, Test Ue, using the conditions as prescribed in the relevant specification for the deflection *D* and the number of bends.
- The capacitance of the surface mount capacitors shall be measured as specified in a) with the board in the bent position. The change of capacitance shall not exceed the limits prescribed in the relevant specification.

4.35.2 Recovery

The printed board shall be allowed to recover from the bent position and then removed from the test jig.

4.35.3 Final inspection and requirements

The surface mount capacitors shall be visually examined, and there shall be no visible damage.

4.36 Dielectric absorption

4.36.1 Test procedure

The capacitor under test shall be placed in a screened enclosure to reduce the effect of electric fields.

For the measurement of the voltage an electrometer or other suitable instrument having an input resistance of minimum 10 000 MΩ shall be used.

The resistance of any jigs, switches, etc. used shall not affect the input resistance of the measuring system.

The capacitor shall then be charged at the d.c. voltage rating for 60 min ± 1 min. The initial surge current shall not exceed 50 mA.

At the end of this period the capacitor shall be disconnected from the power source and shall be discharged through a 5 Ω ± 5 % resistor for 10 s ± 1 s, unless the specified du/dt value is exceeded.

The discharge resistor shall be disconnected from the capacitor at the end of the 10 s discharge period. The voltage remaining or regained on the capacitor (recovery voltage) shall be measured.

NOTE The recovery voltage is the maximum voltage occurring across the capacitor terminations within a 15 min period.

The dielectric absorption shall be calculated from the following formula:

$$DA = \frac{U_1}{U_2} \times 100 \times \frac{C_X + C_0}{C_X}$$

where

DA is the per cent dielectric absorption;

U_1 is the recovery voltage;

U_2 is the charging voltage;

C_X is the capacitance of capacitor under test;

C_0 is the input capacitance of measuring system.

If C_0 is less than 10 % of C_X , the above formula can be simplified to:

$$DA = \frac{U_1}{U_2} \times 100$$

4.36.2 Requirement

The dielectric absorption calculated shall not exceed the limit specified in the detail specification.

4.37 Damp heat, steady state, accelerated

NOTE This test is also known as humidity load test or (85/85)-test.

4.37.1 Initial measurements

The capacitors shall be measured as prescribed in the relevant specification.

4.37.2 Test methods

The capacitors shall be subjected to IEC 60068-2-67, Test Cy.

Preferred test durations: 168 h, 504 h or 1 000 h.

4.37.3 Test procedures

Test condition: rated voltage applied, unless otherwise prescribed in the relevant specification.

For metallized film capacitors this test should be carried out in accordance with Annex G, for multilayer ceramic capacitors in accordance with Annex H.

With the exception of electrolytic capacitors, within 15 min after removal from the test chamber, the voltage proof test of 4.6 shall be carried out at test point A only, using the rated voltage, unless otherwise specified in the detail specification.

4.37.4 Final inspection, measurements and requirements

After recovery (4 h to 24 h), the capacitors shall be visually examined. There shall be no visible damage. The measurements prescribed in the relevant specification shall then be made.

In case of testing metallized film capacitors, when specified in the blank detail specification, the permissible deviation of the average C-value of test group with and the test group without d.c. voltage shall be described in the relevant detail specification.

4.38 Passive flammability

4.38.1 Test procedure

The test shall be made according to IEC 60695-11-5.

The capacitor under test shall be held in the flame in the position which best promotes burning (if this position is not given in the detail specification it shall be evaluated by pre-testing). Each specimen shall be exposed only once to the flame.

The smallest, a medium (in the case of more than four case sizes), and the biggest case size shall be tested. Of each case size, three specimens of the maximum and three specimens of the minimum capacitance shall be tested, resulting in six specimens per case size.

For time of exposure to flame and burning time, see Table 7. If applicable, the detail specification shall specify the category of passive flammability.

4.38.2 Final inspection, measurements and requirements

The burning time of any specimen shall not exceed the time specified in Table 7.

Burning droplets or glowing parts falling down shall not ignite the tissue paper.

Table 7 – Severities and requirements

Category of flammability	Severities Flame exposure time, in seconds, for capacitor volume ranges				Maximum burning time s
	Volume $\leq 250 \text{ mm}^3$	Volume $> 250 \text{ mm}^3$ $\leq 500 \text{ mm}^3$	Volume $> 500 \text{ mm}^3$ $\leq 1\,750 \text{ mm}^3$	Volume $> 1\,750 \text{ mm}^3$	
A	15	30	60	120	3
B	10	20	30	60	10
C	5	10	20	30	30

4.39 High surge current test

4.39.1 Initial measurements

Not required.

4.39.2 Test procedure

The test shall be carried out at a temperature of $(23 \pm 3) ^\circ\text{C}$.

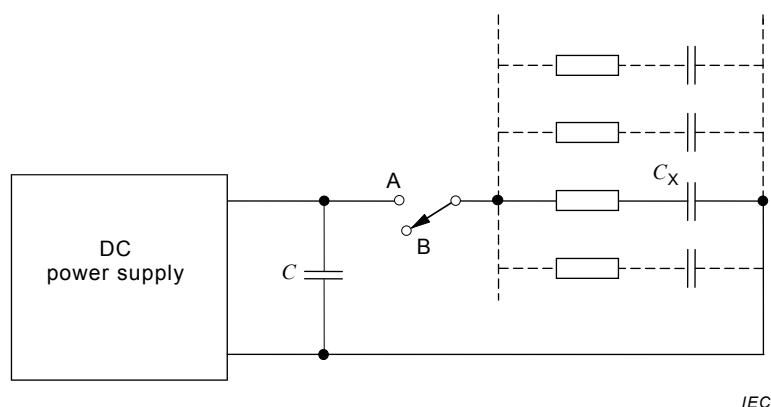
The test circuit is shown in Figure 17. The switch may be mechanical or electronic but is preferably electronic. With the switch in position A, the capacitor under test is charged for 1 s from a low-impedance electrolytic capacitor of capacitance at least $20\,000 \mu\text{F}$ to the rated voltage of the capacitor under test ($U_R \pm 2\%$) from a regulated power supply capable of delivering 10 A. The impedance of the circuit through which the capacitor under test is charged shall meet the requirements of 4.39.3. After 1 s charging time the capacitor under test shall be discharged for 1 s with the switch in position B through a circuit whose resistance is greater than $0,05 \Omega$, but less than $0,2 \Omega$.

The voltage across the capacitor under test shall be monitored. Four further chargings and dischargings of the capacitor under test shall be carried out under the same conditions.

Capacitors may be tested in parallel provided that

- a) their total capacitance is less than 2 % of the capacitance of the reservoir capacitor, and
- b) all the conditions specified above are met for each capacitor under test.

The fuse may be a wire fuse designed to blow between 0,5 A and 2,0 A or an electronic circuit designed to trip in the same current range.

**Key** C_x capacitor under test C low-impedance electrolytic capacitor of capacitance at least 20 000 μF

A, B switching positions

Figure 17 – High surge current test**4.39.3 Requirements for the charging circuit**

The test procedure of 4.39.2 shall be carried out with a capacitor of $47 \mu\text{F} \pm 10 \%$, 35 V in the test position, or in every one of the test positions if provision is made for testing capacitors in parallel. The monitoring of the voltage across the capacitor under test shall demonstrate that the peak voltage across the capacitor during charging is $U_R^{+5}_{-2} \%$, and that 90 % of the measured peak voltage is achieved within 60 μs from the time of closure of the switch and without unwanted transients due to switch bounce or circuit inductance. Where there is provision for testing capacitors in parallel, this requirement shall be verified for each capacitor under test.

It is unlikely that this requirement will be met unless the d.c. resistance of the charging circuit including wiring, fuse, fixtures, and the series resistance of the tank capacitor is less than 0,5 Ω .

4.39.4 Nonconforming items

A capacitor shall be considered a nonconforming item if the fuse blows or the electronic circuit trips at any single charging or discharging of the capacitor.

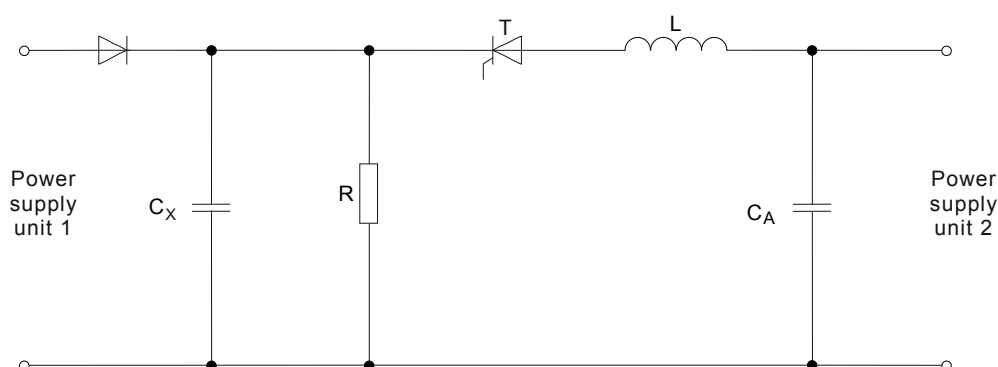
4.40 Voltage transient overload (for aluminium electrolytic capacitors with non-solid electrolyte)**4.40.1 Initial measurement**

The measurements prescribed in the detail specification shall be made.

4.40.2 Test procedure

The capacitor(s) shall then be conditioned at the test temperature by having $U_R \pm 1 \%$ applied from a regulated power supply. At the end of this period, the test may commence but not later than 48 h after conditioning.

An example of a test circuit is shown in Figure 18.



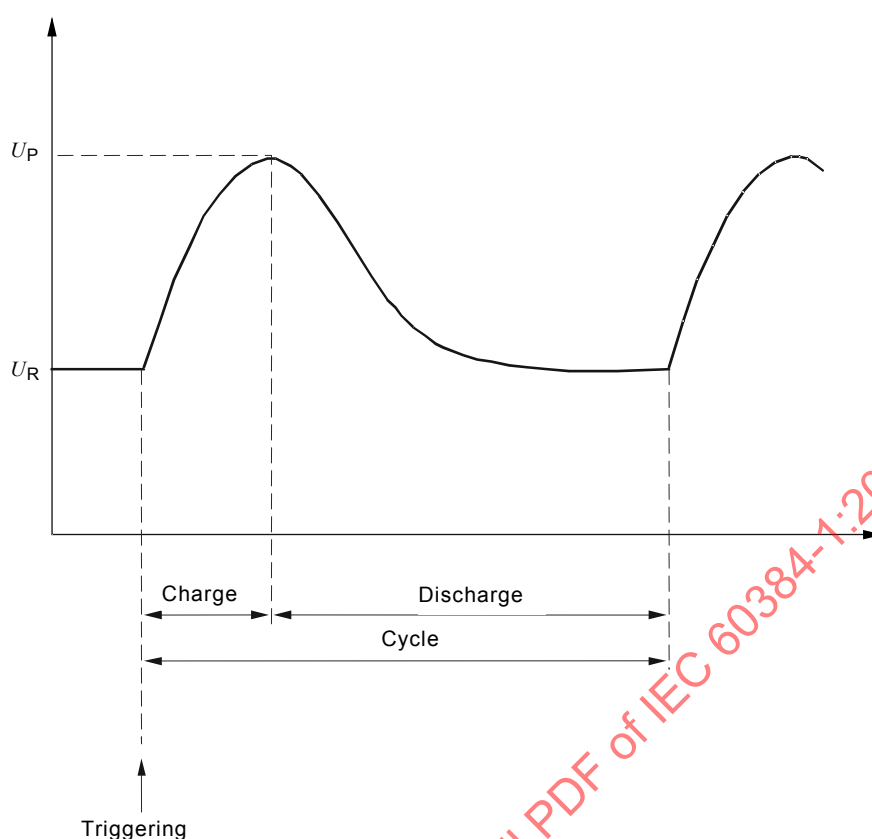
Key

- C_X capacitor under test
- C_A bank capacitor to give a maximum charge time
- R resistor to give a maximum charge time
- L inductor to give a maximum charge time
- T thyristor

Figure 18 – Voltage transient overload test circuit

The capacitor under test C_X is charged from the power supply unit 1, and the auxiliary capacitor bank C_A is charged to a voltage higher than the test voltage U_P from the power supply unit 2. On triggering the thyristor T , the capacitor bank C_A is discharged through the inductor L charging the test capacitor C_X to U_P . On turning the thyristor off, the test capacitor C_X is discharged through the resistor R from U_P down to U_R .

The voltage waveform across the capacitor under test shall be approximately as shown in Figure 19.

**Key** U_P transient peak voltage U_R rated voltage

IEC

Figure 19 – Voltage waveform**4.40.3 Final inspection, measurements and requirements**

The measurements specified in the relevant specification shall be made.

4.40.4 Conditions to be prescribed in the relevant specification

The relevant specification shall prescribe:

- the duration of the conditioning period;
- the value of the transient peak voltage U_P ;
- the value of C_A , L and R to give a maximum charge time of 15 ms;
- the duration of each test cycle;
- the number of test cycles;
- the temperature if different from standard atmospheric conditions of testing.

4.41 Whisker growth test**4.41.1 General**

If prescribed in the relevant specification, the whisker test shall be based on the recommendations of IEC 60068-2-82.

The relevant specification shall prescribe a suitable fixing jig for the support of the specimen during this test.

4.41.2 Preparation of specimen

The preparation of specimen shall be according IEC 60068-2-82:2007, Clause 5.

Capacitors intended for soldering shall receive a preconditioning by heat treatment according to IEC 60068-2-82:2007, 5.5.

Capacitors with leads shall receive a preconditioning by leads forming according to IEC 60068-2-82:2007, 5.6.

4.41.3 Initial measurement

The appearance of capacitors shall be examined according to IEC 60068-2-82:2007, 7.2.

4.41.4 Test procedures

The ambient test, the damp heat test and the temperature cycling test shall be applied according to the prescriptions in IEC 60068-2-82:2007, Clause 6.

4.41.5 Test severities

The severities of IEC 60068-2-82:2007, Table 6 according to the component's material composition shall be applied.

The following discrimination shall be applied to the selection of the severity of the temperature cycling test:

- a) the severity N, $-55\text{ °C} / 125\text{ °C}$ shall be applied for capacitors with LCT = -55 °C or below and UCT = 125 °C or above,
- b) the severity K, $-40\text{ °C} / 85\text{ °C}$ shall be applied for capacitors with LCT above -55 °C and/or UCT below 125 °C .

4.41.6 Final inspection, measurements and requirements

The capacitors shall be examined for appearance according to IEC 60068-2-82:2007, Annex A.

The whisker shall not exceed the limit prescribed in the detail specification.

Annex A

(informative)

Interpretation of sampling plans and procedures as described in IEC 60410 for use within quality assessment systems

When using IEC 60410 for inspection by attributes, the interpretations of the clauses and subclauses of IEC 60410, as indicated below, apply for the purpose of this standard.

- 1 The responsible authority is the national authorized institution implementing the basic rules and rules of procedure.
- 1.5 The unit of product is the electronic component defined in a detail specification.
- 2 Only the following definitions from this clause are required:
 - a “defect” is any nonconformance of the unit of product to specified requirements;
 - a “defective” is a unit of product which contains one or more nonconformances.
- 3.1 The extent of nonconformance of a product shall be expressed in terms of per cent defective.
- 3.3 Not applicable.
- 4.5 The responsible authority is the IEC technical committee drafting the blank detail specification which forms part of the generic or sectional specification.
- 5.4 The responsible authority is the designated management representative (DMR), acting in accordance with the procedures prescribed in the document describing the inspection department of the approved manufacturer, and approved by the Certification Body (CB).
- 6.2 The responsible authority is the DMR.
- 6.3 Not applicable.
- 6.4 The responsible authority is the DMR.
- 8.1 Normal inspection shall always be used at the start of inspection.
- 8.3.3 d) The responsible authority is the DMR.
- 8.4 The responsible authority is the national supervising inspectorate.
- 9.2 The responsible authority is the IEC technical committee drafting the blank detail specification which forms part of the generic or sectional specification.
- 9.4 (Fourth sentence only) Not applicable.
(Fifth sentence only) The responsible authority is the DMR.
- 10.2 Not applicable.

Annex B (informative)

Rules for the preparation of detail specifications for capacitors and resistors for electronic equipment for use within quality assessment systems

B.1 Drafting

The drafting of a complete detail specification, if required, shall begin only when all the following conditions have been met.

- a) The generic specification has been approved.
- b) The sectional specification, when appropriate, has been circulated for approval as an Final Draft International Standard (FDIS).
- c) The associated blank detail specification has been circulated for approval as an FDIS.
- d) There is evidence that at least three national committees have formally approved, as their own national standard, specifications covering a component of closely similar performance.

When a national committee formally asserts that substantial or significant use is made within its country of a part described by some other national standard, this assertion may count towards the foregoing requirement.

B.2 Reference standard

Detail specifications shall use the standard of preferred values, ratings and characteristics and severities for environmental tests, etc., which are given in the appropriate generic or sectional specifications.

B.3 Circulation

The detail specification should not be circulated as an FDIS until the sectional and blank detail specifications have been approved for publication.

Annex C
(informative)

Layout of the first page of a PCP/CQC specification

Manufacturer's name

Location

Capability approval number

PCP/CQC specification number

Issue

Capability manual reference number

Date

Description of PCP/CQC

Purpose of PCP/CQC

Drawing reference

Part identity

IECNORM.COM : Click to view the full PDF of IEC 60384-1:2016 RLV

Annex D (informative)

Requirements for capability approval test report

D.1 General

Capability approval is described in Q.1.1 b).

The test report shall include the information given in Clauses D.2, D.3 and D.4.

D.2 Requirements

The test report shall be dated and include the following general information:

- manufacturer's name and address;
- place of manufacture, if different from above;
- generic and sectional specification number, issue and amendment date;
- the issue number and date of the description of capability;
- reference to PCP/CQC specification;
- reference to the test programme for capability approval, as applicable;
- a list of test equipment used together with appropriate uncertainties of measurement.

D.3 Summary of test information (for each CQC)

The test report shall include the following summary of test information:

- tests;
- number of specimens tested;
- number of nonconforming items allowed;
- number of nonconforming items found.

D.4 Measurement record

A record of the results of the measurements is taken before and after the various mechanical, environmental, and endurance tests for which post-test limits or final measurements are specified.

Annex E (informative)

Guide for pulse testing of capacitors

E.1 Overview

Existing testing methods covered by this standard are suitable for capacitors operating in circuits where the applied voltage is predominantly direct voltage. There are now an increasing number of applications in which the applied voltage is in the form of pulse with or without a reversal of polarity. These pulses may be continuous, intermittent, or random in occurrence.

This annex specifies the factors affecting pulse ratings and the way in which these ratings may be checked by appropriate endurance tests. The parameters of a pulse are defined. Different combinations of these parameters can give rise to different causes of failure as follows.

Type	Cause of failure	Test
Electrolytic	Surge voltage exceeded	Surge voltage
	Reverse voltage exceeded	Reverse voltage
	Overheating (I^2R)	Pulse or a.c.
Metallized types	Peak current	Charge/discharge (intermittent)
	du/dt	Pulse
	Overheating (I^2R)	Pulse or a.c.
	Ionization	a.c.
All other	du/dt	Pulse
	Overheating (I^2R)	Pulse or a.c.
	Excess peak voltage	Surge
	Ionization	a.c.

E.2 Typical capacitor pulse conditions

The figures listed below for typical applications show that test specifications requiring 100 000 or 1 million pulses correspond to operations of only 5 s to 50 s.

It is not possible to produce one circuit which will reproduce all of the required conditions.

It is likely, however, that circuits can be produced which will reproduce various groups of conditions. It does not appear possible at the present time to specify accelerated test conditions to simulate, for example, a five-year operation.

a) Examples for TV applications

• S-correction

Typical peak voltage: 25 V, 50 V, 180 V

Typical peak currents: 5 A to 15 A

 du/dt : about 5 V/ μ s

Frequency: 15 kHz to 20 kHz

Reactive power: up to 250 var

• Line tuning

Typical peak voltage: up to 1 500 V

Typical peak current: 5 A

 du/dt : 180 V/ μ s

• Multiplier capacitors

Typical peak voltage: 10 kV d.c. with ripple

Typical peak current: 0,1 A

 du/dt : up to 1 000 V/ μ s

b) Examples for power electronics

Typical peak voltages: 60 V to 100 V

Typical peak currents: 40 A to 100 A

 du/dt : 1 V/ μ s to 20 V/ μ s

Frequencies: 50 Hz to 20 kHz

Reactive power: up to 500 var

c) Example for d.c.-d.c. convertors

Typical peak voltage: 30 V

Typical peak current: 6 A

 du/dt : 600 V/ μ s

Frequency: up to 20 kHz

d) Examples for switch-mode power supplies

Typical peak voltages: 15 V to 400 V

Typical peak currents: 2 A to 10 A

Frequencies: 100 Hz to 40 kHz

e) Examples for lasers and pulse light sources

Typical peak voltages: 1 kV to 3 kV

Typical peak current: 1 000 A

 du/dt : about 500 V/ μ s

Frequencies: 1 kHz to 5 kHz

E.3 Effect of inductance on pulse testing

Proposed pulse test methods are likely to consist of test circuits involving repetitive charge and discharge of capacitors in resistive circuits. This will result in conventional exponential current and voltage characteristics.

In many applications, however, inductive effects are of considerable importance and have a major influence on the suitability of the capacitor for the application.

These are particularly important at high values of du/dt . If the conditions for critical damping exist ($R^2 = 4 \times L/C$), the effect is a minor modification of the shape of the charge or discharge curve which will have little effect on the severity of the test.

If, however, $R^2 < 4 \times L/C$, there can be overshoot with or without damped oscillations.

These can result in overstress and increased power dissipation.

IECNORM.COM : Click to view the full PDF of IEC 60384-1:2016 RLV

Annex F

(informative)

Guidance for the extension of endurance tests on fixed capacitors

F.1 Overview

The regular repetition of endurance tests under the quality conformance inspection within a quality system offers the opportunity to collect not only their results for the certified test records (CTR), but to accumulate them, wherever possible, for the evaluation of reliability data. As the usual duration of endurance tests on capacitors is 1 000 h or 2 000 h, interested parties may wish to extend these tests to evaluate the long-term behaviour of the components concerned and to improve the base for the reliability evaluation. In the following, guidance is given for the performance and evaluation of such extended endurance tests.

F.2 Guidelines

The following guidelines apply.

- a) Test conditions should preferably be the same as for the standard endurance test. If, for any good reason, different test conditions are chosen, they should be clearly indicated.
- b) For final measurements, the same characteristic should be measured as for the standard endurance test.
- c) The preferred duration for such extended endurance tests is 8 000 h.
- d) The extended test is for information only on long-term behaviour and reliability. The measured values are therefore noted for variable analyses or other reliability evaluation without being linked to the failure criteria as specified.
- e) Intermediate measurements (between 2 000 h and 8 000 h) may be made.
- f) If agreed between the parties concerned, the results of the test may be included in the certified test record (CTR) of released lots.
- g) The “translation” of the results of accumulated tests into reliability data is normally the responsibility of the manufacturer. If somebody else wants to use these accumulated test results for his own reliability evaluation, an appropriate acceleration factor for the components concerned shall be taken into account.

Annex G

(normative)

Damp heat, steady state with voltage applied, for metallized film capacitors only

G.1 Overview

For corrosion sensitivity detection of the metallization of the dielectric film an additional test for damp heat, steady state test with applied voltage shall be carried out.

The deviation of the average capacitance values of the test group with, and the test group without voltage, indicates a possible corrosion of the metallization.

G.2 Test procedure

The damp heat, steady state test shall be carried out with applied a.c. or d.c. voltage, depending on the specified rated voltage of the capacitors.

The damp heat, steady state test with applied voltage shall be carried out on an additional test group. The specimens for both test groups with and without voltage can only be prepared by the manufacturer of the components, who will take care that the specimen for both groups are produced with identical materials and in identical production processes. The number of specimens for an additional test group with voltage is the same as the number for the test group without voltage.

IECNORM.COM : Click to view the full text of IEC 60384-1:2016 RLV

Annex H (normative)

Accelerated damp heat, steady state, for multilayer ceramic capacitors only

H.1 Mounting of capacitors

The capacitors shall be mounted so that each capacitor is connected in series with a resistor. Half of the capacitors shall be connected in series with resistors of $100\text{ k}\Omega \pm 10\%$ and half in series with resistors of $6,8\text{ k}\Omega \pm 10\%$.

H.2 Initial measurement

The capacitors, mounted as in Clause H.1, shall be measured for insulation resistance with a voltage of $1,5\text{ V} \pm 0,1\text{ V}$ applied across the capacitor and resistor in series.

The insulation resistance shall meet the requirements given in the relevant specification.

H.3 Test procedure

The capacitors with associated resistors shall be subjected to conditioning at $(85 \pm 2)^\circ\text{C}$, $(85 \pm 3)\%$ RH for a duration to be specified in the relevant specification. Those capacitors connected to $100\text{ k}\Omega$ resistors shall have a voltage of $(1,5 \pm 0,1)\text{ V}$ applied, and those connected to $6,8\text{ k}\Omega$ resistors shall have $(50 \pm 0,1)\text{ V}$ or U_R applied, whichever is the lower. In both cases the voltage shall be applied across the capacitor/resistor combination.

Care shall be taken to avoid condensation of water on to the capacitors or substrates. Condensation may happen if the door is opened during the test before the humidity is lowered.

H.4 Recovery

The applied voltage shall be disconnected and the capacitors and resistors shall be removed from the test chamber and allowed to recover for 4 h to 24 h in standard atmospheric conditions for testing.

H.5 Final inspection, measurements and requirements

The capacitors, mounted as in accordance with Clause H.1, shall be measured for insulation resistance as in Clause H.2 above.

The insulation resistance shall be greater than 0,1 times the initial limit.

Annex Q (informative)

Quality assessment procedures

Q.1 General

Q.1.1 Scope of this annex

This generic specification and related sectional and detail specifications can be used for the purpose of a full quality assessment system. The following types of approval are provided.

- a) Qualification Approval (QA) is applicable to an identified component or range of components manufactured to similar design and production processes, for which a detail specification exists. Such a detail specification shall be based on this generic specification and a relevant sectional specification and shall give provisions for a QA.

QA is granted to a manufacturer according to the provisions of Clause Q.2 when it has been established that the components meet the requirements of the detail specification.

The test schedules prescribed in the detail specification for the initial product qualification approval and for the product quality conformance inspections apply directly to the component or range to be qualified.

- b) Capability Approval (CA) is applicable to an identified component manufacturing process and set of design rules for which an applicable sectional specification exists. Such a sectional specification shall be based on this generic specification and shall give provisions for a CA.

CA is granted to a manufacturer according to the provisions of Clause Q.3 when it has been established that his capability for manufacturing processes and quality control methods covering a specific component technology meet the requirements of the relevant specifications.

There are different detail specifications used under CA. At least one detail specification is released for the Capability Qualifying Components (CQC), identifying the component's purpose and prescribing the relevant tests and requirements. Other detail specifications are released for the deliverable components and thus may cover standard catalogue components or customer specific components.

- c) Technology Approval (TA) is appropriate when the complete technological process (design, process realization, product manufacture, test and shipment) covers the qualification aspects common to all components determined by the technology. It incorporates the most recent principles and techniques in quality management and provides for the use of statistical methods and tools, continuous improvement and procedural flexibility.

TA is applicable to an identified electronic component manufacturing activity for which a Technology Approval Schedule (TAS) exists.

TA is granted to a manufacturer according to the provisions of Clause Q.4, when it has been demonstrated that the quality management system established for his electronic component manufacturing activity complies with the contents of his/her Technology Approval Declaration Document (TADD), and meets the requirements of the TAS.

The identification of an electronic component manufacturing activity shall be based on component(s) or range(s) of components manufactured to similar design and production processes, for which detail specification(s) exist(s). Such detail specification(s) shall be based on this generic specification and relevant sectional specification(s) and shall give relevant provisions for a technology approval. Such applied detail specifications are to be referenced in the TA.

A prerequisite for obtaining any of these approvals is that a manufacturer has obtained the approval of manufacturer in accordance with the provisions of the relevant certification body.

Q.1.2 Quality assessment definitions

Q.1.2.1 Primary stage of manufacture

The primary stage of manufacture shall be specified in the sectional specification.

Examples of the primary stage of manufacture are:

- For film capacitors:
the winding of the capacitor element or the equivalent operation.
- For ceramic capacitors:
the first common firing of the dielectric-electrode assembly.
- For electrolytic capacitors:
the capacitor manufacturer's evaluation of the formed anode foil.

Q.1.2.2 Structurally similar components

The grouping of structurally similar components for the initial product qualification approval testing or for the product quality conformance testing under QA, CA or TA shall be prescribed in the relevant sectional specification.

Q.1.2.3 Assessment level

An assessment level prescribes the severity of the test schedules, the sampling plans and the number of permissible non-conforming items in each test group. Assessment levels EZ and DZ meet the requirements of the zero defect approach and align the assessment procedures and levels with the current industry practices, e.g. by setting the number of permitted non-conformities (acceptance number) to zero. The sectional specifications shall prescribe the requirements to the test schedules for use in all related detail specifications.

NOTE 1 A variety of assessment levels existed historically, e.g. with different numbers of permissible non-conformities per test. Only the assessment levels EZ and DZ are used in recent specifications.

The sampling plans and inspection levels for assessment levels EZ and DZ shall be selected from those given in IEC 61193-2, except for those elements of the test schedule which are based on fixed sample sizes, irrespective of the size of the lot being inspected.

NOTE 2 The assessment of a quality level close or equal to zero defects by sampling only would lead to an unreasonable increase of inspection efforts. Hence, zero acceptance number sampling plans can only apply to the inspection of products that are manufactured under suitable process control with the target of a zero-defect quality level before sampling inspection.

Q.1.2.4 Failure rate level determination (if applied)

The determination of failure rate level and certification shall be described in the relevant specification.

Q.1.3 Rework

Rework is the rectification of a processing error by means not differing from those used in the current process, or by an explicitly permitted rework process prior to release of the component.

Rework shall not be carried out if prohibited by the relevant sectional or detail specification.

Applicable rework procedures shall be permitted by the relevant sectional or detail specification and shall be fully described in the relevant documentation produced by the manufacturer. All rework shall be carried out under supervision of the Designated Management Representative (DMR) prior to the formation of the inspection lot offered for inspection to the requirements of the detail specification.

Q.1.4 Alternative test methods

The test and measurement methods given by the relevant specification are intended to unify test and measurement procedures. They are not necessarily the only methods which can be used except when specifically designated as referee or reference methods.

An approved manufacturer shall demonstrate to the Certification Body (CB) that any alternative method he uses will give results equivalent to those obtained by the specified method.

In case of dispute, the specified methods take precedence over any alternative method.

Q.1.5 Certified test records of released lots

When certified test records are prescribed in the relevant specification and are requested by a customer, the following information shall be given as a minimum.

- a) Attributes information (that is the number of components tested and the number of non-conforming components) for tests in the sub-groups covered by periodic inspection without reference to the parameter for which rejection was made.
- b) Variables information (that is average and range for the change in capacitance and number of tested components) for periodic tests specified in the relevant sectional specification.

NOTE Under CA a certified test record refers only to tests carried out on capability qualifying components.

Q.1.6 Unchecked parameters

Only those parameters of a component which have been specified in the detail specification and which were subject to testing shall be assumed to be within the specified limits. It cannot be assumed that any unspecified parameter will remain unchanged from one component to another.

A new, more extensive specification shall be used if control of any additional parameter is required. Then the additional test method shall be fully described with specification of sampling plans, inspection levels and requirements and applied in a relevant test schedule.

Q.1.7 Delayed delivery

Components are considered to meet the stated requirements for a period of two years after manufacture and lot release when stored under appropriate conditions, unless otherwise specified in the relevant specification.

Components held for a period exceeding that retention period shall prior to delivery be re-examined for solderability and for electrical characteristics as prescribed in the relevant specification. The sampling and procedure applied for re-examination shall be approved by the Certification Body (CB).

Components are qualified for another retention period, if all relevant requirements were met in the re-examination.

Q.1.8 Repair

Repair consists of rendering an approved component usable which has been damaged or has become defective after its release.

Components which have been repaired shall not be released under any specified quality assessment system.

Q.1.9 Registration of approvals

Approvals shall be based on a published detail specification complying with this generic specification and a relevant sectional specification.

The achieved approvals shall be entered in a relevant and published Register of Approvals, e.g. in the approvals section “online certificates” of the website www.iecq.org. Such entries shall contain all necessary details on the approval, including the applied specifications and the scope of the approval, e.g. designation, variant(s) and range(s) of the approved component(s).

Q.1.10 Manufacture outside the geographical limits

See the requirements of the specified quality assessment system (if any).

Q.2 Qualification approval (QA) procedures

Q.2.1 Eligibility for qualification approval

A qualification approval may be granted to a manufacturer holding a manufacturer's approval.

A component is eligible for QA if the manufacturing process, including the prescribed primary stage of manufacture, is carried out under direct supervision of the relevant Designated Management Representative (DMR).

Q.2.2 Application for qualification approval

The manufacturer shall comply with the specified quality assessment system (if any).

Q.2.3 Subcontracting

The relevant specification may restrict subcontracting according to the specified quality assessment system (if any).

If subcontracting of the primary stage of manufacture and/or subsequent stages is employed, it shall be in accordance with the specified quality assessment system (if any).

Q.2.4 Test procedure for the initial product qualification approval

The detail specification shall prescribe the test schedule and the requirements for the initial product qualification approval testing.

The sampling and formation of inspection lots shall be prescribed in the sectional specification or in the detail specification. The sampling plan for the initial product qualification approval testing is based on the fixed sample size procedure, with the number of permissible non-conforming specimen set to zero (e.g. assessment level EZ).

The specimen for an inspection lot shall be collected at random over a short time within an inspection period, not including any major change of the manufacturing process.

Q.2.5 Granting of qualification approval

Qualification approval shall be granted when the procedures in accordance with the specified quality assessment system (if any) have been completed satisfactorily.

Q.2.6 Maintenance of qualification approval

A QA shall be maintained by regular quality conformance inspections in order to demonstrate the compliance with the requirements for quality conformance prescribed in the detail specification.

Q.2.7 Quality conformance inspection

The test schedule and the requirements for the product quality conformance inspection shall be prescribed in the detail specification.

The sampling and formation of inspection lots shall be prescribed in the sectional specification or in the detail specification. The sampling plans and inspection levels shall be selected from those given in IEC 61193-2, for the part of the product quality conformance inspection schedule based on variable sample sizes, as used for the lot-by-lot testing. The sampling plan for the periodic product quality conformance inspection testing is based on the fixed sample size procedure. The number of permissible nonconforming specimen for each test group of both test schedules is set to zero (e.g. assessment level EZ).

The specimen for an inspection lot shall be collected at random over a short time within an inspection period, not including any major change of the manufacturing process.

Utilisation of the switching rule for reduced inspection in Group C of the test schedule is permitted in all subgroups except endurance, unless otherwise prescribed in the relevant specification.

Q.3 Capability approval (CA) procedures

Q.3.1 General

Capability Approval covers a manufacturing process and quality control methods (including design aspects as applicable) for a specific component technology with clearly defined scope and limits of the employed manufacturing capability.

The capability shall be demonstrated on Capability Qualifying Components (CQC), which serve as specimen for initial qualification testing and for subsequent quality conformance inspections. There shall be a detail specification for a CQC, based on this generic specification and on a sectional specification, giving the provisions for a CA.

A detailed Process Control Plan (PCP) shall be used for inspections to be carried out during the manufacturing process applied to the manufacturing of components for release.

There shall be specific detail specifications for standard catalogue components and for customer specific components to be released under capability approval. They shall be based on this generic specification and on the same sectional specification supporting the detail specification for the CQC.

Q.3.2 Eligibility for capability approval

The manufacturer shall comply with the requirements of the specified quality assessment system (if any).

A component manufacturer is eligible for CA if the manufacturing process, including the prescribed primary stage of manufacture, is carried out under direct supervision of the relevant Designated Management Representative (DMR).

Q.3.3 Application for capability approval

The manufacturer shall comply with the requirements of the specified quality assessment system (if any), and with the requirements of the relevant sectional specification.

Q.3.4 Subcontracting

The relevant specification may restrict subcontracting according to the rules of the specified quality assessment system (if any).

If subcontracting of the primary stage of manufacture and/or subsequent stages is employed, it shall be in accordance with the specified quality assessment system (if any).

Q.3.5 Description of the capability

The manufacturer shall describe the capability relevant to the manufacturing technology and range of products involved in a Capability Manual (CM), which shall meet the requirements of the specified quality assessment system (if any). The CM shall state the limits of the covered technology, and design rules, if applicable.

The CM may be subject to confidentiality, hence the manufacturer shall provide an abstract of the description of capability suitable for publication.

Q.3.6 Demonstration and verification of capability

The verification of the claimed capability shall demonstrate compliance with the contents of the CM and utilize Capability Qualifying Components (CQC) and the Process Control Plan (PCP), as required by the specified quality assessment system (if any).

The CQCs shall be used to demonstrate the limits of capability and compliance with the relevant detail specification.

Q.3.7 Granting of capability approval

Capability approval shall be granted when the procedures in accordance with the specified quality assessment system (if any) have been completed satisfactorily and the requirements of the relevant sectional specification have been met.

Q.3.8 Maintenance of capability approval

A Capability Approval shall be maintained according to the specified quality assessment system (if any) and to the respective descriptions of the CM by regular quality conformance inspections on the CQCs in order to demonstrate the compliance with the requirements for quality conformance prescribed in the relevant detail specification.

Q.3.9 Quality conformance inspection

Quality conformance inspections shall be executed according to the provisions of the specified quality assessment system (if any) and to the respective descriptions of the CM.

The test schedule and the requirements for the quality conformance inspection shall be prescribed in the relevant detail specification(s) for deliverable components, e.g. the specific detail specifications for standard catalogue components or for customer specific components.

The sampling and formation of inspection lots shall be prescribed in the sectional specification or in the detail specification. The sampling plans and inspection levels shall be selected from those given in IEC 61193-2, except for those elements of the test schedule which are based on fixed sample sizes.

The specimen for an inspection lot shall be collected at random over a short time within an inspection period, not including any major change of the manufacturing process.

Q.4 Technology approval (TA) procedure

Q.4.1 General

Technology Approval is a method of approving a complete technological process covering the approval aspects common to all products as determined by the technology under consideration. It extends the existing suite of approval concepts (QA and CA) by adding the following principles as mandatory aspects:

- a) a formal system for quality management, actively involving all employees in the commitment to quality;
- b) use of in-process control methods, for example, SPC, to be defined in a Technology Approval Schedule (TAS);
- c) a strategy for continuous quality improvement;
- d) monitoring the overall technologies and operations associated with the design and manufacturing processes as well as the components themselves;
- e) procedural flexibility due to the underlying quality assurance management system and market sector requirements;
- f) acceptance of a manufacturer's operational documentation to provide means for rapid approval or extension of approval.

Q.4.2 Eligibility for technology approval

A TA may be granted to a manufacturer holding an Approval of Manufacturer to the specified quality assessment system (if any).

Prerequisite to a TA is a Technology Approval Schedule (TAS) covering the entire scope of technology for which approval is intended, written according to the requirements of the specified quality assessment system (if any).

Q.4.3 Application of technology approval

The procedure and requirements for an application for TA are given in the specified quality assessment system (if any).

Q.4.4 Subcontracting

The TAS or the relevant specification may restrict subcontracting according to the rules of the specified quality assessment system (if any).

Q.4.5 Description of technology

The manufacturer shall describe the implementation of the TAS in his organisation in a Technology Approval Declaration Document (TADD) which shall meet the requirements of the specified quality assessment system (if any). The TADD shall describe the relevant scope of technology and relate to, but not exceed the range of activities covered by the TAS.

Q.4.6 Demonstration and verification of the technology

For verification of the operational and technological processes, the manufacturer shall demonstrate compliance with the contents of the TADD, as required in the specified quality assessment system (if any).

For manufacturing verification, characterisation and evaluation of process performance shall be performed on components, for which a detail specification exists. Such detail specification

shall be based on this generic specification and a sectional specification and shall give provisions for a TA.

Q.4.7 Granting of technology approval

TA shall be granted by the Certification Body (CB) when the requirements of the specified quality assessment system (if any) have been met.

Q.4.8 Maintenance of technology approval

A TA shall be maintained according to the provisions of the specified quality assessment system (if any).

Q.4.9 Quality conformance inspection

The quality conformance inspection shall be carried out in accordance with the relevant TAS.

The quality conformance inspection of the manufacturing shall be performed on components for which a detail specification has been registered in the TADD. The test schedule and the requirements for the quality conformance inspection shall be prescribed in the detail specification.

The sampling and formation of inspection lots shall be prescribed in the sectional specification or in the detail specification. The sampling plans and inspection levels shall be selected from those given in IEC 61193-2, except for those elements of the test schedule which are based on fixed sample sizes.

The specimen for an inspection lot shall be collected at random over a short time within an inspection period, not including any major change of the manufacturing process.

Utilisation of the switching rule for reduced inspection in Group C of the test schedule is permitted in all subgroups except endurance, unless otherwise prescribed in the relevant specification.

Bibliography

IEC 60384-2, *Fixed capacitors for use in electronic equipment – Part 2: Sectional specification – Fixed metallized polyethylene terephthalate film dielectric d.c. capacitors*

IEC 60384-3, *Fixed capacitors for use in electronic equipment – Part 3: Sectional specification – Surface mount fixed tantalum electrolytic capacitors with manganese dioxide solid electrolyte*

IEC 60384-3-1, *Fixed capacitors for use in electronic equipment – Part 3-1: Blank detail specification: Surface mount fixed tantalum electrolytic capacitors with manganese dioxide solid electrolyte – Assessment level EZ*

IEC 60384-3-101, *Fixed capacitors for use in electronic equipment – Part 3-101: Detail specification – Fixed tantalum chip capacitors for surface mounting with solid electrolyte and porous anode, style I – Assessment level E*

IEC 60384-26, *Fixed capacitors for use in electronic equipment – Part 26: Sectional specification – Fixed aluminium electrolytic capacitors with conductive polymer solid electrolyte*

IEC 60410, *Sampling plans and procedures for inspection by attributes*

IEC 60469:2013, *Transitions, pulses and related waveforms – Terms, definitions and algorithms*

ISO 9000, *Quality management systems – Fundamentals and vocabulary*

SOMMAIRE

AVANT-PROPOS.....	93
INTRODUCTION.....	95
1 Généralités.....	97
1.1 Domaine d'application	97
1.2 Références normatives.....	97
2 Données techniques	99
2.1 Symboles, unités et abréviations	99
2.1.1 Généralités	99
2.1.2 Symboles littéraux.....	99
2.1.3 Abréviations.....	100
2.2 Termes et définitions.....	100
2.3 Valeurs préférentielles et exigences techniques supplémentaires.....	105
2.3.1 Généralités	105
2.3.2 Valeurs préférentielles de la capacité nominale	105
2.3.3 Valeurs préférentielles de la tension assignée	105
2.3.4 Charge assignée en alternatif.....	105
2.3.5 Charge assignée en impulsions.....	106
2.3.6 Tension corrigée en fonction de la température.....	106
2.4 Marquage	107
2.4.1 Généralités	107
2.4.2 Codage.....	107
3 Procédures d'assurance de la qualité.....	107
4 Essais et procédures de mesure	108
4.1 Généralités	109
4.2 Conditions atmosphériques normalisées	109
4.2.1 Conditions atmosphériques normalisées d'essai	109
4.2.2 Conditions de reprise	109
4.2.3 Conditions d'arbitrage	110
4.2.4 Conditions de référence	110
4.3 Séchage	110
4.4 Examen visuel et contrôle des dimensions.....	110
4.4.1 Examen visuel	110
4.4.2 Dimensions (calibrage).....	110
4.4.3 Dimensions (détail)	111
4.5 Résistance d'isolement.....	111
4.5.1 Préconditionnement	111
4.5.2 Conditions de mesure	111
4.5.3 Points d'essai	111
4.5.4 Méthodes d'essai	112
4.5.5 Compensation de température.....	112
4.5.6 Conditions devant être indiquées dans la spécification applicable	112
4.6 Tension de tenue	114
4.6.1 Généralités	114
4.6.2 Circuit d'essai (pour l'essai entre sorties).....	114
4.6.3 Essai	115
4.6.4 Exigences.....	116

4.6.5	Conditions devant être indiquées dans la spécification applicable	116
4.7	Capacité	117
4.7.1	Fréquence de mesure et tension de mesure	117
4.7.2	Équipement de mesure	117
4.7.3	Conditions devant être indiquées dans la spécification applicable	117
4.8	Tangente de l'angle de perte et résistance-série équivalente (RSE)	117
4.8.1	Tangente de l'angle de perte	117
4.8.2	Résistance-série équivalente (RSE)	118
4.9	Courant de fuite	118
4.9.1	Préconditionnement	118
4.9.2	Méthode d'essai	118
4.9.3	Source d'alimentation	118
4.9.4	Exactitude de mesure	118
4.9.5	Circuit d'essai	118
4.9.6	Conditions devant être indiquées dans la spécification applicable	119
4.10	Impédance	119
4.11	Inductance et fréquence de résonance propre	120
4.11.1	Fréquence de résonance propre (f_r)	120
4.11.2	Inductance	123
4.11.3	Conditions devant être indiquées dans la spécification applicable	123
4.12	Sortie de l'armature extérieure	123
4.13	Robustesse des sorties	124
4.13.1	Généralités	124
4.13.2	Essai U_{a1} – Traction	124
4.13.3	Essai U_b – Pliage (sur la moitié de l'échantillon)	125
4.13.4	Essai U_c – Torsion (autre moitié de l'échantillon)	125
4.13.5	Essai U_d – Couple	125
4.13.6	Examen visuel	125
4.14	Résistance à la chaleur de brasage	125
4.14.1	Préconditionnement et mesurage initial	125
4.14.2	Procédure d'essai	125
4.14.3	Reprise	126
4.14.4	Inspection finale, mesurage et exigences	126
4.15	Brasabilité	126
4.15.1	Généralités	126
4.15.2	Préconditionnement	126
4.15.3	Procédure d'essai	126
4.15.4	Inspection finale, mesurages et exigences	127
4.16	Variations rapides de température	127
4.16.1	Mesurage initial	127
4.16.2	Procédure d'essai	127
4.16.3	Inspection finale, mesurages et exigences	127
4.17	Vibrations	127
4.17.1	Mesurage initial	127
4.17.2	Procédure d'essai	127
4.17.3	Essai électrique (mesurage intermédiaire)	127
4.17.4	Inspection finale, mesurages et exigences	128
4.18	Secousses (chocs répétitifs)	128
4.18.1	Mesurage initial	128

4.18.2	Procédure d'essai	128
4.18.3	Inspection finale, mesurages et exigences	128
4.19	Chocs	128
4.19.1	Mesurage initial	128
4.19.2	Procédure d'essai	128
4.19.3	Inspection finale, mesurages et exigences	128
4.20	Étanchéité des boîtiers	128
4.21	Séquence climatique	129
4.21.1	Généralités	129
4.21.2	Mesurages initiaux	129
4.21.3	Chaleur sèche	129
4.21.4	Chaleur humide, cyclique, essai Db, premier cycle	129
4.21.5	Froid	129
4.21.6	Basse pression atmosphérique	129
4.21.7	Chaleur humide, cyclique, essai Db, cycles restants	130
4.21.8	Mesurages finaux	130
4.22	Chaleur humide, essai continu	130
4.22.1	Mesurage initial	130
4.22.2	Procédure d'essai	130
4.22.3	Inspection finale, mesurages et exigences	131
4.23	Endurance	131
4.23.1	Mesurages initiaux	131
4.23.2	Procédure d'essai	131
4.23.3	Conditions devant être indiquées dans la spécification applicable	131
4.23.4	Tension d'essai	131
4.23.5	Positionnement dans la chambre d'essai	132
4.23.6	Reprise	132
4.23.7	Inspection finale, mesurages et exigences	133
4.24	Variation de la capacité avec la température	133
4.24.1	Méthode statique	133
4.24.2	Méthode dynamique	134
4.24.3	Méthodes de calcul	134
4.25	Stockage	135
4.25.1	Stockage à haute température	135
4.25.2	Stockage à basse température	135
4.26	Surtension	136
4.26.1	Mesurage initial	136
4.26.2	Procédure d'essai	136
4.26.3	Inspection finale, mesurages et exigences	137
4.26.4	Informations devant être données dans la spécification particulière applicable	137
4.27	Essais de charge et de décharge et essai de courant d'appel	137
4.27.1	Mesurage initial	137
4.27.2	Procédure d'essai	138
4.27.3	Charge et décharge	138
4.27.4	Courant d'appel	139
4.27.5	Inspection finale, mesurages et exigences	139
4.28	Décharge de pression (pour les condensateurs électrolytiques en aluminium)	139
4.28.1	Généralités	139

4.28.2	Essai en courant alternatif.....	139
4.28.3	Essai en courant continu	139
4.28.4	Essai pneumatique.....	139
4.28.5	Inspection finale, mesurages et exigences.....	139
4.29	Caractéristiques à haute et basse températures.....	140
4.29.1	Procédure d'essai	140
4.29.2	Exigences	140
4.30	Essai de stabilité thermique.....	140
4.31	Résistance au solvant des composants.....	140
4.31.1	Mesurages initiaux	140
4.31.2	Procédure d'essai	140
4.31.3	Inspection finale, mesurages et exigences.....	141
4.32	Résistance au solvant du marquage	141
4.32.1	Procédure d'essai	141
4.32.2	Inspection finale, mesurages et exigences.....	141
4.33	Montage (pour les condensateurs pour montage en surface uniquement)	141
4.33.1	Substrat.....	141
4.33.2	Brasage à la vague	141
4.33.3	Brasage par fusion.....	142
4.34	Essai de cisaillement.....	144
4.34.1	Procédure d'essai	144
4.34.2	Inspection finale, mesurages et exigences.....	144
4.35	Essai de pliage du substrat	144
4.35.1	Procédure d'essai	144
4.35.2	Reprise.....	145
4.35.3	Inspection et exigences finales.....	145
4.36	Absorption diélectrique.....	145
4.36.1	Procédure d'essai	145
4.36.2	Exigences	146
4.37	Essai continu de chaleur humide accéléré	146
4.37.1	Mesurages initiaux	146
4.37.2	Méthodes d'essai	146
4.37.3	Procédures d'essai.....	146
4.37.4	Inspection finale, mesurages et exigences.....	146
4.38	Inflammabilité passive	146
4.38.1	Procédure d'essai	146
4.38.2	Inspection finale, mesurages et exigences.....	147
4.39	Essai aux surintensités.....	147
4.39.1	Mesurages initiaux	147
4.39.2	Procédure d'essai	147
4.39.3	Exigences pour le circuit de charge	148
4.39.4	Éléments non conformes	148
4.40	Surtension transitoire (pour condensateurs électrolytiques en aluminium à électrolyte non solide)	148
4.40.1	Mesurage initial	148
4.40.2	Procédure d'essai	149
4.40.3	Inspection finale, mesurages et exigences.....	150
4.40.4	Conditions devant être indiquées dans la spécification applicable	150
4.41	Essai sur le développement des trichites	150

4.41.1	Généralités	150
4.41.2	Préparation des éprouvettes.....	151
4.41.3	Mesurage initial	151
4.41.4	Procédures d'essai.....	151
4.41.5	Sévérités des essais	151
4.41.6	Inspection finale, mesurages et exigences.....	151
Annexe A (informative) Interprétation des plans d'échantillonnage et des procédures tels qu'ils sont décrits dans l'IEC 60410 et destinés à être utilisés dans les systèmes d'assurance de la qualité		152
Annexe B (informative) Règles pour la préparation des spécifications particulières pour des condensateurs et des résistances pour équipements électroniques, destinés à être utilisés dans les systèmes d'assurance de la qualité		153
B.1	Élaboration	153
B.2	Norme de référence	153
B.3	Diffusion	153
Annexe C (informative) Disposition de la première page d'une spécification PCP/CQC.....		154
Annexe D (informative) Exigences pour le rapport d'essai d'agrément de savoir-faire		155
D.1	Généralités	155
D.2	Exigences	155
D.3	Résumé des informations sur les essais (pour chaque CQC).....	155
D.4	Enregistrement de mesure.....	155
Annexe E (informative) Guide pour l'essai en impulsion des condensateurs		156
E.1	Présentation	156
E.2	Conditions typiques en impulsions pour les condensateurs	156
E.3	Influence de l'inductance sur les essais en impulsions	157
Annexe F (informative) Lignes directrices pour l'extension des essais d'endurance sur les condensateurs fixes		159
F.1	Présentation	159
F.2	Lignes directrices	159
Annexe G (normative) Essai continu de chaleur humide avec application de tension, pour les condensateurs à film métallisé uniquement		160
G.1	Présentation	160
G.2	Procédure d'essai	160
Annexe H (normative) Essai continu de chaleur humide accéléré, pour les condensateurs céramiques multicouches uniquement.....		161
H.1	Montage des condensateurs	161
H.2	Mesurage initial.....	161
H.3	Procédure d'essai	161
H.4	Reprise.....	161
H.5	Inspection finale, mesurages et exigences	161
Annexe Q (informative) Procédures d'assurance de la qualité		162
Q.1	Généralités	162
Q.1.1	Domaine d'application de la présente annexe	162
Q.1.2	Définitions de l'assurance de la qualité	163
Q.1.3	Reprise.....	164
Q.1.4	Autres méthodes d'essai	164
Q.1.5	Rapports certifiés d'essais des lots acceptés	164
Q.1.6	Paramètres non vérifiés	164
Q.1.7	Livraison différée	165

Q.1.8	Réparation	165
Q.1.9	Registre des agréments	165
Q.1.10	Fabrication hors des limites géographiques	165
Q.2	Procédures d'homologation (QA)	165
Q.2.1	Aptitude à l'homologation	165
Q.2.2	Demande d'homologation	165
Q.2.3	Sous-traitance	165
Q.2.4	Procédure d'essai pour l'homologation initiale des produits	166
Q.2.5	Octroi de l'homologation	166
Q.2.6	Maintien de l'homologation	166
Q.2.7	Contrôle de conformité de la qualité	166
Q.3	Procédures d'agrément de savoir-faire	166
Q.3.1	Généralités	166
Q.3.2	Aptitude à l'agrément de savoir-faire	167
Q.3.3	Demande d'agrément de savoir-faire	167
Q.3.4	Sous-traitance	167
Q.3.5	Description du savoir-faire	167
Q.3.6	Démonstration et vérification de savoir-faire	167
Q.3.7	Octroi de l'agrément de savoir-faire	168
Q.3.8	Maintien de l'agrément de savoir-faire	168
Q.3.9	Contrôle de conformité de la qualité	168
Q.4	Procédure d'agrément de technologie	168
Q.4.1	Généralités	168
Q.4.2	Aptitude à l'agrément de technologie	169
Q.4.3	Demande d'agrément de technologie	169
Q.4.4	Sous-traitance	169
Q.4.5	Description de la technologie	169
Q.4.6	Démonstration et vérification de la technologie	169
Q.4.7	Octroi d'agrément de technologie	169
Q.4.8	Maintien d'agrément de technologie	169
Q.4.9	Contrôle de conformité de la qualité	169
Bibliographie		171
Figure 1	– Puissance réactive en fonction de la fréquence	106
Figure 2	– Relation entre la plage des températures de catégorie et la tension appliquée	107
Figure 3	– Circuit d'essai de tension de tenue	114
Figure 4	– Schéma de principe du circuit de mesure de l'impédance	119
Figure 5	– Disposition de montage des condensateurs	121
Figure 6	– Disposition de montage des condensateurs	121
Figure 7	– Schéma typique d'un ondemètre-oscillateur à absorption	122
Figure 8	– Schéma de principe du circuit de mesure	123
Figure 9	– Circuit d'essai	124
Figure 10	– Circuit d'essai pour les condensateurs électrolytiques	132
Figure 11	– Circuit à relais	136
Figure 12	– Circuit à thyristors	136
Figure 13	– Forme d'onde de la tension aux bornes du condensateur	137

Figure 14 – Forme d’onde de la tension et du courant.....	138
Figure 15 – Substrat approprié pour les essais mécaniques.....	143
Figure 16 – Substrat approprié pour les essais électriques	144
Figure 17 – Essai aux surintensités.....	148
Figure 18 – Circuit d’essai de la surtension transitoire	149
Figure 19 – Forme d’onde de la tension.....	150
Tableau 1 – Conditions d’arbitrage.....	110
Tableau 2 – Mesurage de la résistance d’isolement.....	111
Tableau 3 – Points de mesure.....	113
Tableau 4 – Force de traction.....	124
Tableau 5 – Couple.....	125
Tableau 6 – Nombre de cycles	130
Tableau 7 – Sévérités et exigences.....	147

IECNORM.COM : Click to view the full PDF of IEC 60384-1:2016 RLV

COMMISSION ÉLECTROTECHNIQUE INTERNATIONALE

**CONDENSATEURS FIXES UTILISÉS
DANS LES ÉQUIPEMENTS ÉLECTRONIQUES –****Partie 1: Spécification générique****AVANT-PROPOS**

- 1) La Commission Electrotechnique Internationale (IEC) est une organisation mondiale de normalisation composée de l'ensemble des comités électrotechniques nationaux (Comités nationaux de l'IEC). L'IEC a pour objet de favoriser la coopération internationale pour toutes les questions de normalisation dans les domaines de l'électricité et de l'électronique. A cet effet, l'IEC – entre autres activités – publie des Normes internationales, des Spécifications techniques, des Rapports techniques, des Spécifications accessibles au public (PAS) et des Guides (ci-après dénommés "Publication(s) de l'IEC"). Leur élaboration est confiée à des comités d'études, aux travaux desquels tout Comité national intéressé par le sujet traité peut participer. Les organisations internationales, gouvernementales et non gouvernementales, en liaison avec l'IEC, participent également aux travaux. L'IEC collabore étroitement avec l'Organisation Internationale de Normalisation (ISO), selon des conditions fixées par accord entre les deux organisations.
- 2) Les décisions ou accords officiels de l'IEC concernant les questions techniques représentent, dans la mesure du possible, un accord international sur les sujets étudiés, étant donné que les Comités nationaux de l'IEC intéressés sont représentés dans chaque comité d'études.
- 3) Les Publications de l'IEC se présentent sous la forme de recommandations internationales et sont agréées comme telles par les Comités nationaux de l'IEC. Tous les efforts raisonnables sont entrepris afin que l'IEC s'assure de l'exactitude du contenu technique de ses publications; l'IEC ne peut pas être tenue responsable de l'éventuelle mauvaise utilisation ou interprétation qui en est faite par un quelconque utilisateur final.
- 4) Dans le but d'encourager l'uniformité internationale, les Comités nationaux de l'IEC s'engagent, dans toute la mesure possible, à appliquer de façon transparente les Publications de l'IEC dans leurs publications nationales et régionales. Toutes divergences entre toutes Publications de l'IEC et toutes publications nationales ou régionales correspondantes doivent être indiquées en termes clairs dans ces dernières.
- 5) L'IEC elle-même ne fournit aucune attestation de conformité. Des organismes de certification indépendants fournissent des services d'évaluation de conformité et, dans certains secteurs, accèdent aux marques de conformité de l'IEC. L'IEC n'est responsable d'aucun des services effectués par les organismes de certification indépendants.
- 6) Tous les utilisateurs doivent s'assurer qu'ils sont en possession de la dernière édition de cette publication.
- 7) Aucune responsabilité ne doit être imputée à l'IEC, à ses administrateurs, employés, auxiliaires ou mandataires, y compris ses experts particuliers et les membres de ses comités d'études et des Comités nationaux de l'IEC, pour tout préjudice causé en cas de dommages corporels et matériels, ou de tout autre dommage de quelque nature que ce soit, directe ou indirecte, ou pour supporter les coûts (y compris les frais de justice) et les dépenses découlant de la publication ou de l'utilisation de cette Publication de l'IEC ou de toute autre Publication de l'IEC, ou au crédit qui lui est accordé.
- 8) L'attention est attirée sur les références normatives citées dans cette publication. L'utilisation de publications référencées est obligatoire pour une application correcte de la présente publication.
- 9) L'attention est attirée sur le fait que certains des éléments de la présente Publication de l'IEC peuvent faire l'objet de droits de brevet. L'IEC ne saurait être tenue pour responsable de ne pas avoir identifié de tels droits de brevets et de ne pas avoir signalé leur existence.

La Norme internationale IEC 60384-1 a été établie par le comité d'études 40 de l'IEC: Condensateurs et résistances pour équipements électroniques.

Cette cinquième édition annule et remplace la troisième édition parue en 2008. Cette édition constitue une révision technique, incluant des révisions mineures des tableaux, des valeurs et des références.

Cette édition inclut les modifications techniques majeures suivantes par rapport à l'édition précédente:

- INTRODUCTION ajoutée;
- 4.41 Essai sur le développement des trichites ajouté;
- Annexe Q entièrement restructurée.

Le texte de cette norme est issu des documents suivants:

FDIS	Rapport de vote
40/2420/FDIS	40/2444/RVD

Le rapport de vote indiqué dans le tableau ci-dessus donne toute information sur le vote ayant abouti à l'approbation de cette norme.

Une liste de toutes les parties de la série IEC 60384, publiées sous le titre général *Condensateurs fixes utilisés dans les équipements électroniques*, peut être consultée sur le site web de l'IEC.

Cette publication a été rédigée selon les Directives ISO/IEC, Partie 2.

Le comité a décidé que le contenu de cette publication ne sera pas modifié avant la date de stabilité indiquée sur le site web de l'IEC sous "<http://webstore.iec.ch>" dans les données relatives à la publication recherchée. À cette date, la publication sera

- reconduite,
- supprimée,
- remplacée par une édition révisée, ou
- amendée.

IECNORM.COM : Click to view the full PDF of IEC 60384-1:2016 RLV

INTRODUCTION

Le système de spécifications pour des condensateurs fixes utilisés dans des équipements électroniques est structuré dans un système hiérarchique constitué des types suivants de spécifications.

Spécification générique

La spécification générique couvre tous les sujets, principalement les sujets communs à la famille de condensateurs fixes utilisés dans des équipements électroniques, tels que la terminologie, les méthodes de mesure et les essais. Lorsque des conditions ou des paramètres relatifs aux exigences spécifiques à la sous-famille particulière ou au type particulier de condensateur fixe sont exigés, de telles exigences doivent être données par une des spécifications subordonnées.

Pour le domaine d'application des condensateurs fixes, la référence numérique de la spécification générique est l'IEC 60384-1.

Spécification intermédiaire

Les spécifications intermédiaires couvrent tous les sujets s'ajoutant à ceux indiqués dans la spécification générique et qui sont spécifiques à un sous-groupe défini de condensateurs fixes. Ces sujets sont normalement les valeurs préférentielles des dimensions et des caractéristiques, les méthodes d'essai supplémentaires et les exigences applicables aux méthodes d'essai données dans la spécification générique, les exigences relatives à l'échantillonnage et à la préparation des éprouvettes, les sévérités d'essai recommandées et les critères d'acceptation préférentiels. La spécification intermédiaire présente également la structure et le domaine d'application des programmes d'essai qui doivent être appliqués dans toutes les spécifications particulières subordonnées.

Pour le domaine d'application des condensateurs fixes, les références numériques aux spécifications intermédiaires vont de l'IEC 60384-2 pour les condensateurs à film de polyester à actuellement l'IEC 60384-26 pour les condensateurs électrolytiques en aluminium à électrolyte solide en polymère conducteur. La variété de spécifications intermédiaires peut être adaptée aux différentes technologies de condensateurs fixes.

Spécification particulière

Les spécifications particulières donnent, directement ou en faisant référence à d'autres spécifications, toutes les informations nécessaires pour décrire complètement un type et une plage donnés de condensateurs fixes, y compris les exigences relatives à toutes les valeurs des dimensions et des caractéristiques. Elles donnent également toutes les informations exigées pour l'assurance de la qualité du type et de la plage de condensateurs fixes couverts dans un système approprié d'assurance de la qualité, y compris les exigences relatives à toutes les sévérités d'essai et à tous les critères d'acceptation appliqués, et les programmes d'essai réalisés.

Les spécifications particulières peuvent être soit des spécifications du système IEC, soit une autre spécification liée à l'IEC, soit une spécification du fabricant ou de l'utilisateur. Pour le domaine d'application des condensateurs fixes, les références numériques aux spécifications particulières sont par exemple l'IEC 60384-3-101, pour une spécification particulière se rapportant à la spécification intermédiaire IEC 60384-3 et à la spécification particulière cadre auxiliaire IEC 60384-3-1.

Spécification particulière cadre

Dans le système hiérarchique de spécifications, une spécification intermédiaire est complétée par une ou plusieurs spécifications particulières cadres utilisées pour assurer une

présentation uniforme des spécifications particulières. La spécification particulière cadre fournit au rédacteur des spécifications un modèle de disposition à adopter et un modèle d'informations à fournir, ainsi que des lignes directrices pour la préparation de spécifications particulières en respectant les exigences des spécifications génériques ou intermédiaires supérieures. Les spécifications particulières cadres ne sont pas considérées comme des spécifications applicables parce qu'elles ne décrivent pas de composants particuliers.

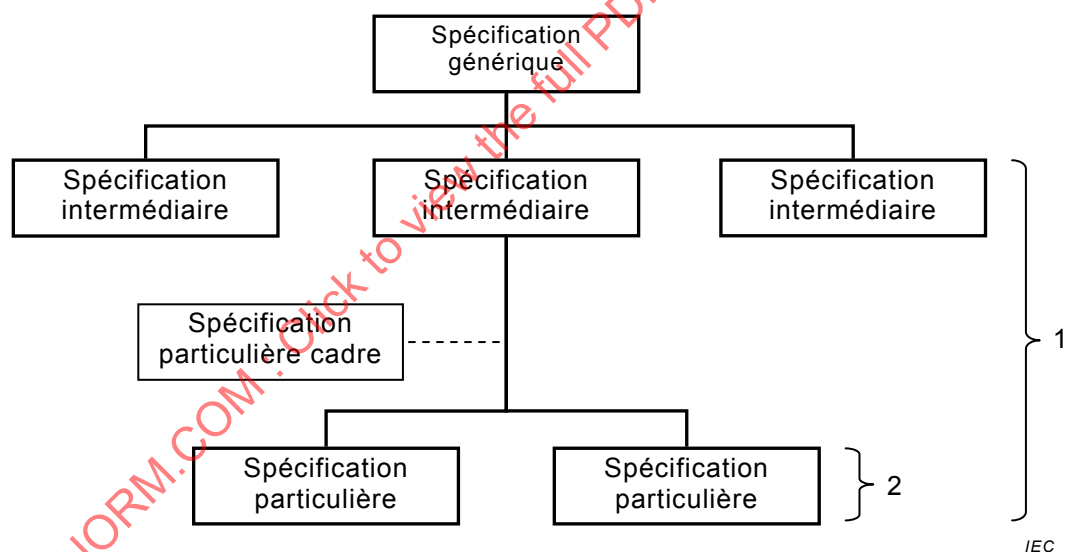
La présence d'un système de spécifications hiérarchiques établi, avec des spécifications particulières cadres, permet de préparer des spécifications particulières même en dehors du comité d'études de l'IEC concerné.

Pour le domaine d'application des condensateurs fixes, les références numériques aux spécifications particulières cadres sont par exemple l'IEC 60384-3-1, pour une spécification particulière cadre se rapportant à la spécification intermédiaire IEC 60384-3.

Spécification applicable

Dans ce système, le terme «spécification applicable» porte sur des spécifications subordonnées contenant des exigences spécifiques, le cas échéant.

N'importe quelle spécification générique ou intermédiaire peut utiliser un résumé et des références universelles à des spécifications subordonnées de n'importe quel niveau hiérarchique en utilisant l'expression «spécification applicable».



IEC

Légende

- 1 Indique la plage de "Spécifications applicables" pour la spécification générique supérieure, le cas échéant.
- 2 Indique la plage de "Spécifications applicables" pour la spécification intermédiaire supérieure, le cas échéant.

CONDENSATEURS FIXES UTILISÉS DANS LES ÉQUIPEMENTS ÉLECTRONIQUES –

Partie 1: Spécification générique

1 Généralités

1.1 Domaine d'application

La présente partie de l'IEC 60384 est une spécification générique qui s'applique aux condensateurs fixes utilisés dans les équipements électroniques.

Elle établit des définitions, des procédures de contrôle et des méthodes d'essai normalisées à utiliser dans les spécifications intermédiaires et particulières des composants électroniques, pour les systèmes d'assurance de la qualité ou pour tout autre usage.

1.2 Références normatives

Les documents suivants sont cités en référence de manière normative, en intégralité ou en partie, dans le présent document et sont indispensables pour son application. Pour les références datées, seule l'édition citée s'applique. Pour les références non datées, la dernière édition du document de référence s'applique (y compris les éventuels amendements).

IEC 60027 (toutes les parties), *Symboles littéraux à utiliser en électrotechnique*

IEC 60050 (toutes les parties), *Vocabulaire Électrotechnique International*

IEC 60062, *Codes de marquage des résistances et des condensateurs*

IEC 60063, *Séries de valeurs normales pour résistances et condensateurs*

IEC 60068-1:2013, *Essais d'environnement – Partie 1: Généralités et lignes directrices*

IEC 60068-2-1:2007, *Essais d'environnement – Partie 2-1: Essais – Essai A: Froid*

IEC 60068-2-2:2007, *Essais d'environnement – Partie 2-2: Essais – Essai B: Chaleur sèche*

IEC 60068-2-6:2007, *Essais d'environnement – Partie 2-6: Essais – Essai Fc: Vibrations (sinusoïdales)*

IEC 60068-2-13:1983, *Essais d'environnement – Partie 2-13: Essais – Essai M: Basse pression atmosphérique*

IEC 60068-2-14:2009, *Essais d'environnement – Partie 2-14: Essais – Essai N: Variation de température*

IEC 60068-2-17:1994, *Essais d'environnement – Partie 2-17: Essais – Essai Q: Étanchéité*

IEC 60068-2-20:2008, *Essais d'environnement – Partie 2-20: Essais – Essai T: Méthodes d'essai de la brasabilité et de la résistance à la chaleur de brasage des dispositifs à broches*

IEC 60068-2-21:2006, *Essais d'environnement – Partie 2-21: Essais – Essai U: Robustesse des sorties et des dispositifs de montage incorporés*

IEC 60068-2-27:2008, *Essais d'environnement – Partie 2-27: Essais – Essai Ea et guide: Chocs*

IEC 60068-2-30:2005, *Essais d'environnement – Partie 2-30: Essais – Essai Db: Essai cyclique de chaleur humide (cycle de 12 h + 12 h)*

IEC 60068-2-45:1980, *Essais fondamentaux climatiques et de robustesse mécanique – Partie 2-45: Essais – Essai XA et guide: Immersion dans les solvants de nettoyage*
IEC 60068-2-45:1980/AMD1:1993

IEC 60068-2-54:2006, *Essais d'environnement – Partie 2-54: Essais – Essai Ta: Essai de la soudabilité des composants électroniques à l'aide de la méthode de la balance de mouillage*

IEC 60068-2-58:2015, *Essais d'environnement – Partie 2-58: Essais – Essai Td: Méthodes d'essai de la soudabilité, résistance de la métallisation à la dissolution et résistance à la chaleur de brasage des composants pour montage en surface (CMS)*

IEC 60068-2-67:1995, *Essais d'environnement – Partie 2-67: Essais – Essai Cy: Essai continu de chaleur humide, essai accéléré applicable en premier lieu aux composants*

IEC 60068-2-69:2007, *Essais d'environnement – Partie 2-69: Essais – Essai Te: Essai de brasabilité des composants électroniques pour les composants de montage en surface (CMS) par la méthode de la balance de mouillage*

IEC 60068-2-78:2012, *Essais d'environnement – Partie 2-78: Essais – Essai Cab: Chaleur humide, essai continu*

IEC 60068-2-82:2007, *Essais d'environnement – Partie 2-82: Essais – Essai XW1: Méthodes de vérification des trichites pour les composants électroniques et électriques*

IEC 60294, *Mesure des dimensions d'un composant cylindrique à sorties axiales*

IEC 60617, *Symboles graphiques pour schémas*

IEC 60695-11-5:2004, *Essais relatifs aux risques du feu – Partie 11-5: Flamme d'essai – Méthode d'essai au brûleur-aiguille – Appareillage, dispositif d'essai de vérification et lignes directrices*

IEC 60717, *Méthode pour la détermination de l'encombrement des condensateurs et résistances à sorties unilatérales*

IEC 61193-2, *Quality assessment systems – Part 2: Selection and use of sampling plans for inspection of electronic components and packages* (disponible en anglais seulement)

IEC 61249-2-7:2002, *Matériaux pour circuits imprimés et autres structures d'interconnexion – Partie 2-7: Matériaux de base renforcés, plaqués et non plaqués – Feuille stratifiée tissée de verre E avec de la résine époxyde, d'inflammabilité définie (essai de combustion verticale), plaquée cuivre*

ISO 3, *Nombres normaux – Séries de nombres normaux*

ISO 80000-1, *Grandeurs et unités – Partie 1: Généralités*

2 Données techniques

2.1 Symboles, unités et abréviations

2.1.1 Généralités

Il convient que les unités, les symboles graphiques et les symboles littéraux proviennent, dans la mesure du possible, des publications suivantes:

- IEC 60027 (série);
- IEC 60050 (série);
- IEC 60617;
- ISO 80000-1.

Si d'autres rubriques sont exigées, il convient qu'elles soient établies conformément aux principes énoncés dans les publications référencées ci-dessus.

2.1.2 Symboles littéraux

C_N	Capacité nominale
DA	Dielectric Absorption (absorption diélectrique)
du/dt	Capacité à supporter des impulsions
f_r	Fréquence de résonance propre
I_{leak}	Courant de fuite
k_0	Caractéristiques des impulsions maximales admissibles
L	Inductance propre
R_{INS}	Résistance d'isolement
T_A	Température de catégorie inférieure
$\tan \delta$	Tangente de l'angle de perte
T_B	Température de catégorie supérieure
T_C	Température de catégorie
T_{op}	Température de fonctionnement
T_R	Température assignée
U_C	Tension de catégorie
U_{op}	Tension de fonctionnement
U_R	Tension assignée
U_{RS}	Surtension
Z	Impédance

α Coefficient de température de la capacité

$\tau = C_N \times R_{INS}$ Constante de temps

2.1.3 Abréviations

CA Agrément de savoir-faire (*Capability Approval*)

CB Organisme de certification (*Certification Body*)

CQC Composants pour agrément de savoir-faire (*Capability Qualifying Components*)

DMR Responsable désigné (*Designated Management Representative*)

RSE Résistance-Série Équivalente

IPA Alcool isopropylique (*Isopropyl alcohol*)

PCP Plan de Contrôle de Processus

QA Homologation (*Qualifying Approval*)

CMS Composant pour Montage en Surface

TA Agrément de technologie (*Technology Approval*)

TADD Document de déclaration d'agrément de technologie (*Technology Approval Declaration Document*)

2.2 Termes et définitions

Pour les besoins du présent document, les termes et définitions suivants s'appliquent.

NOTE Dans la version anglaise, les termes sont énumérés par ordre alphabétique.

2.2.1

condensateur pour courant alternatif

condensateur conçu essentiellement pour fonctionner sous des tensions alternatives

2.2.2

condensateur bipolaire

<condensateur électrolytique> condensateur prévu pour supporter une tension alternative et/ou une inversion de la polarité de la tension continue appliquée

2.2.3

catégorie d'inflammabilité passive

catégorie indiquant la durée maximale d'inflammation autorisée après une durée d'application de flamme spécifiée

2.2.4

plage des températures de catégorie

plage des températures ambiantes pour laquelle le condensateur a été conçu pour fonctionner de manière continue

Note 1 à l'article: La plage des températures est limitée par la température de catégorie inférieure et la température de catégorie supérieure (voir 2.2.10 et 2.2.41).

2.2.5**tension de catégorie** U_C

tension maximale pouvant être appliquée de manière continue à un condensateur utilisé à sa température de catégorie supérieure (2.2.41)

2.2.6**condensateur pour courant continu**

condensateur conçu essentiellement pour fonctionner sous des tensions continues

Note 1 à l'article: Il peut ne pas convenir pour une utilisation sur des sources de courant alternatif.

2.2.7**famille**

<composants électroniques> groupe de composants qui présentent principalement un attribut physique particulier et/ou réalisent une fonction définie

2.2.8**classe**

terme servant à préciser des caractéristiques générales complémentaires concernant l'application projetée du composant

2.2.9**condensateur isolé**

condensateur dont toutes les bornes d'une section peuvent être portées à un potentiel différent (mais non inférieur à la tension assignée) de celui de toute surface conductrice avec laquelle le boîtier est susceptible d'entrer en contact en utilisation normale

2.2.10**température de catégorie inférieure**

température ambiante minimale pour laquelle un condensateur a été conçu en vue d'un fonctionnement permanent

2.2.11**température maximale de stockage**

température ambiante maximale que le condensateur supporte sans dommage en conditions de non-fonctionnement

2.2.12**température maximale d'un condensateur**

température du point le plus chaud de la surface externe

Note 1 à l'article: Les bornes sont considérées comme faisant partie de la surface externe.

2.2.13**température minimale de stockage**

température ambiante minimale que le condensateur supporte sans dommage en conditions de non-fonctionnement

2.2.14**température minimale d'un condensateur**

température du point le plus froid de la surface externe

Note 1 à l'article: Les bornes sont considérées comme faisant partie de la surface externe.

2.2.15**capacité nominale** C_N

valeur de capacité pour laquelle a été conçu le condensateur et qui est habituellement marquée sur celui-ci

2.2.16

inflammabilité passive

aptitude d'un condensateur à brûler avec une flamme par suite de l'application d'une source de chaleur externe

2.2.17

condensateur polarisé

<condensateur électrolytique> condensateur conçu pour être utilisé sous une tension unidirectionnelle reliée conformément à la polarité indiquée

2.2.18

condensateur pour impulsions

condensateur pour utilisation avec des impulsions de courant ou de tension

Note 1 à l'article: Les définitions de l'IEC 60469 s'appliquent.

2.2.19

circuit équivalent en impulsion d'un condensateur

circuit équivalent d'un condensateur composé d'un condensateur idéal en série avec l'inductance parasite et la résistance série équivalente (RSE)

Note 1 à l'article: Pour le fonctionnement en impulsion, la résistance série équivalente sera similaire, mais non identique à la RSE mesurée sous une tension sinusoïdale. La RSE en impulsions dépend des fréquences harmoniques contenues dans l'impulsion et de la variation des pertes selon la fréquence.

2.2.20

charge assignée en alternatif

charge alternative sinusoïdale maximale qui peut être appliquée en permanence aux bornes d'un condensateur à toute température comprise entre la température de catégorie inférieure (2.2.10) et la température assignée (2.2.24)

2.2.21

charge assignée en impulsions

charge maximale en impulsions qui peut être appliquée aux bornes d'un condensateur à une certaine fréquence de répétition des impulsions à toute température comprise entre la température de catégorie inférieure (2.2.10) et la température assignée (2.2.24)

2.2.22

courant ondulé assigné

valeur efficace du courant alternatif maximal admissible d'une fréquence spécifiée, sous lequel le condensateur peut fonctionner de façon permanente à une température spécifiée

Note 1 à l'article: Dans la mesure où le courant ondulé générera une tension ondulée à travers le condensateur, il convient que la somme de la tension continue et de la valeur de crête de la tension alternative appliquée au condensateur ne dépasse pas la tension assignée ou, selon le cas, la tension corrigée en fonction de la température.

2.2.23

tension ondulée assignée

valeur efficace de la tension alternative maximale admissible d'une fréquence spécifiée superposée à la tension continue à laquelle le condensateur peut fonctionner de façon permanente à une température spécifiée

Note 1 à l'article: Il convient que la somme de la tension continue et de la valeur de crête de la tension alternative appliquées au condensateur ne dépasse pas la tension assignée ou, selon le cas, la tension corrigée en fonction de la température.

2.2.24

température assignée

température ambiante maximale à laquelle la tension assignée peut être appliquée de manière continue

2.2.25**tension assignée** U_R **2.2.25.1****tension continue assignée**

tension continue maximale pouvant être appliquée en permanence à un condensateur utilisé à la température assignée (2.2.24)

Note 1 à l'article: La tension continue maximale est la somme de la tension continue et de la valeur de crête de la tension alternative ou de la valeur de crête de la tension d'impulsion appliquées au condensateur.

2.2.25.2**tension alternative assignée**

tension alternative efficace maximale pouvant être appliquée en permanence à un condensateur utilisé à la température assignée (2.2.24) et à une fréquence donnée

2.2.25.3**tension assignée en impulsions**

valeur de crête de la tension d'impulsion dans une forme d'onde d'impulsion donnée, pouvant être appliquée en permanence à un condensateur utilisé à la température assignée (2.2.24)

2.2.26**tension inverse**

<condensateur polarisé> tension appliquée aux bornes du condensateur dans le sens inverse de polarité

Note 1 à l'article: La tension inverse s'applique aux condensateurs polarisés uniquement.

2.2.27**autocicatrisation**

processus par lequel les propriétés électriques d'un condensateur sont, après une perforation locale du diélectrique, rapidement et essentiellement rétablies aux valeurs existant avant la perforation

2.2.28**modèle**

subdivision d'un type (2.2.39), généralement basée sur des facteurs dimensionnels, qui peut inclure plusieurs variantes, généralement d'ordre mécanique

2.2.29**sous-famille**

<composants électroniques> groupe de composants d'une famille (2.2.7), fabriqués par des méthodes technologiques similaires

2.2.30**condensateur pour montage en surface**

condensateur fixe dont les petites dimensions et la nature ou la forme des bornes rendent approprié son montage dans des circuits hybrides et en surface des cartes imprimées

2.2.31**rapport de surtension**

quotient de la tension instantanée maximale qui peut être appliquée aux bornes du condensateur, pour une durée spécifiée, à toute température à l'intérieur de la plage des températures de catégorie (2.2.4) par, selon le cas, la tension assignée (2.2.25) ou la tension corrigée en fonction de la température (2.2.36)

2.2.32**tangente de l'angle de pertes** **$\tan \delta$**

rapport de la perte de puissance du condensateur à la puissance réactive du condensateur, lorsqu'une tension sinusoïdale de fréquence spécifiée est appliquée à ses bornes

2.2.33**caractéristiques capacité/température**

variation maximale de capacité qui se produit sur une plage donnée de températures à l'intérieur de la plage des températures de catégorie (2.2.4) du condensateur

Note 1 à l'article: Cette caractéristique s'applique principalement aux condensateurs dont les variations de capacité en fonction de la température, variations linéaires ou non linéaires, ne peuvent pas être exprimées avec précision et certitude.

Note 2 à l'article: Cette caractéristique s'exprime normalement en pourcentage de la valeur de capacité à la température de référence de 20 °C.

2.2.34**coefficient de température de la capacité** **α**

rapport de la variation de capacité, mesurée aux extrémités d'une plage spécifiée de températures, à la variation de température la provoquant

Note 1 à l'article: Cette propriété s'applique aux condensateurs dont les variations de capacité en fonction de la température sont linéaires ou approximativement linéaires, et peut être énoncée avec une certaine précision.

Note 2 à l'article: Ce coefficient s'exprime normalement en millionièmes par Kelvin ($10^{-6}/K$).

2.2.35**dérive de capacité après cycle thermique**

variation irréversible maximale de capacité observée à la température ambiante pendant ou après l'exécution d'un nombre spécifié de cycles de température

Note 1 à l'article: Cette propriété s'applique aux condensateurs dont les variations de capacité en fonction de la température sont linéaires ou approximativement linéaires, et peut être énoncée avec une certaine précision.

Note 2 à l'article: Cette dérive s'exprime généralement en pourcentage de la valeur de capacité à la température de référence, laquelle est normalement de 20 °C.

2.2.36**tension corrigée en fonction de la température**

tension maximale pouvant être appliquée de façon permanente aux bornes d'un condensateur à toute température comprise entre la température assignée (2.2.24) et la température de catégorie supérieure (2.2.41)

Note 1 à l'article: Se reporter à 2.3.6.

2.2.37**échauffement**

élévation de la température du condensateur par rapport à la température ambiante résultant des pertes internes dues au fonctionnement sous tension alternative, en impulsions ou dans des conditions de charge/décharge

2.2.38**constante de temps** **τ**

produit de la résistance d'isolement par la capacité

Note 1 à l'article: La constante de temps s'exprime normalement en secondes.

2.2.39**type**

ensemble de composants de conception et de techniques de fabrication identiques, permettant de les prendre en compte soit en vue de procéder à une homologation, soit dans le cadre d'un contrôle de la conformité de la qualité

Note 1 à l'article: Ces composants font généralement l'objet d'une seule spécification particulière.

Note 2 à l'article: Des composants décrits dans plusieurs spécifications particulières peuvent, dans certains cas, être considérés comme appartenant à un même type.

2.2.40**condensateur non isolé**

condensateur dont au moins une des bornes d'une section ne peut pas être portée à un potentiel différent (mais non inférieur à la tension assignée) de celui de toute surface conductrice avec laquelle le boîtier est susceptible d'entrer en contact en utilisation normale

2.2.41**température de catégorie supérieure**

température ambiante maximale pour laquelle un condensateur a été conçu pour fonctionner de manière continue

2.2.42**dommage visible**

dommage visible susceptible de réduire l'aptitude du condensateur à l'emploi pour lequel il a été prévu

2.3 Valeurs préférentielles et exigences techniques supplémentaires**2.3.1 Généralités**

Chaque spécification intermédiaire doit spécifier les valeurs préférentielles appropriées à la sous-famille; pour la capacité nominale, voir aussi 2.3.2.

2.3.2 Valeurs préférentielles de la capacité nominale

Les valeurs préférentielles de la capacité nominale doivent être prises dans les séries spécifiées dans l'IEC 60063.

2.3.3 Valeurs préférentielles de la tension assignée

Les valeurs préférentielles de la tension assignée sont les valeurs de la série R10 de l'ISO 3: 1,0 – 1,25 – 1,6 – 2,0 – 2,5 – 3,15 – 4,0 – 5,0 – 6,3 – 8,0 et leurs multiples décimaux ($\times 10^n$, n : nombre entier).

2.3.4 Charge assignée en alternatif

La charge assignée en alternatif peut s'exprimer comme étant:

- a) une tension alternative assignée aux basses fréquences;
- b) un courant alternatif assigné aux fréquences élevées;
- c) une puissance réactive assignée aux fréquences intermédiaires (var).

Ceci est présenté à la Figure 1.

Pour un type particulier de condensateur, il peut être nécessaire de spécifier une ou plusieurs des caractéristiques ci-dessus.

Les condensateurs couverts par le domaine d'application de la présente norme ont normalement une puissance réactive inférieure à 500 var à une fréquence comprise entre

50 Hz et 60 Hz. Les fréquences basses peuvent être 50 Hz à 60 Hz, 100 Hz à 120 Hz ou 400 Hz. Les tensions efficaces peuvent atteindre 600 V à une fréquence comprise entre 50 Hz et 60 Hz. Cependant, il peut être exigé que des condensateurs pour filtres, pour circuits d'émetteur ou de convertisseur fonctionnent dans une large plage de fréquences sous une puissance allant jusqu'à 10 kvar aux plus hautes fréquences avec des tensions efficaces jusqu'à 1 000 V.

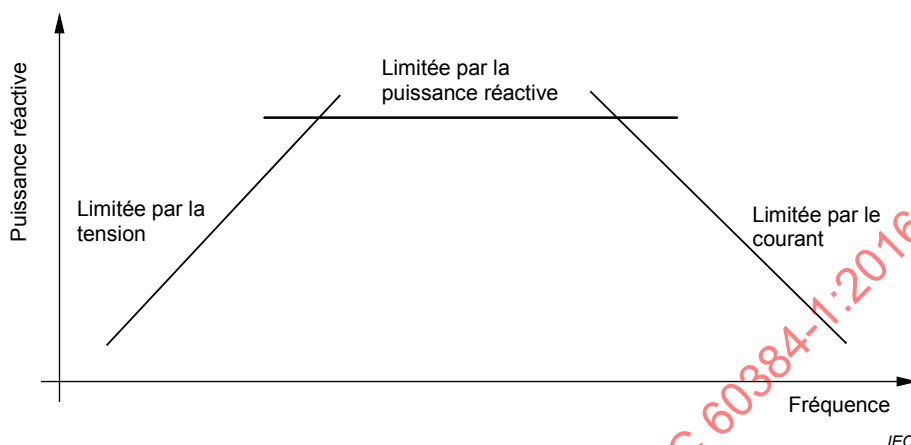


Figure 1 – Puissance réactive en fonction de la fréquence

2.3.5 Charge assignée en impulsions

La charge assignée en impulsions peut s'exprimer par les paramètres a) et b) et un ou plusieurs des autres paramètres ci-après :

- a) courant de crête par μF ou du/dt ($\text{V}/\mu\text{s}$);
- b) durées relatives des périodes de charge et de décharge;
- c) courant;
- d) tension de crête;
- e) tension inverse de crête;
- f) fréquence de répétition des impulsions;
- g) puissance active maximale.

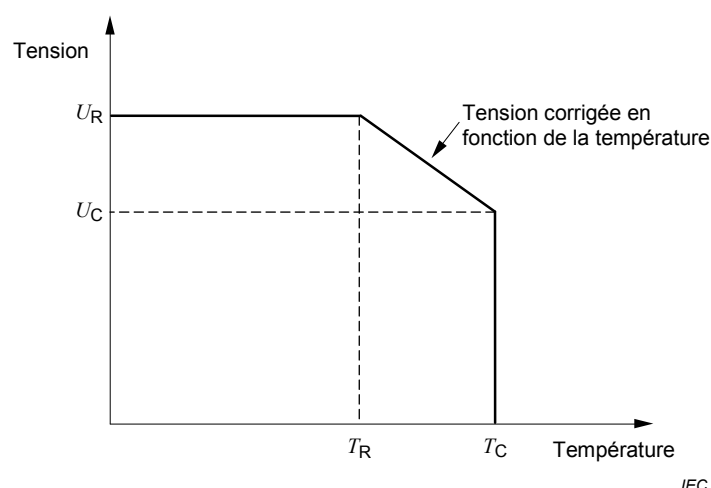
Ces paramètres sont fixés pour des impulsions périodiques.

Dans le cas d'impulsions intermittentes, il convient de spécifier le cycle de service. Dans le cas d'impulsions aléatoires, il convient de fixer le nombre total d'impulsions attendues pendant une période donnée.

Il convient de calculer le courant efficace en impulsions conformément au 3.2.17.5 de l'IEC 60469:2013. Dans le cas d'impulsions intermittentes ou aléatoires, il convient de choisir l'intervalle de temps de façon qu'il corresponde à l'échauffement maximal.

2.3.6 Tension corrigée en fonction de la température

Il convient que les informations sur la dépendance entre tension et température à des températures comprises entre la température assignée et la température de catégorie supérieure soient données, le cas échéant, dans la spécification applicable (voir Figure 2).



Légende

- U_R est la tension assignée
 U_C est la tension de catégorie
 T_R est la température assignée
 T_C est la température de catégorie

Figure 2 – Relation entre la plage des températures de catégorie et la tension appliquée

2.4 Marquage

2.4.1 Généralités

La spécification intermédiaire doit indiquer les critères d'identification et les autres informations devant être portées sur le condensateur et/ou l'emballage.

L'ordre de priorité du marquage des petits condensateurs doit être spécifié.

2.4.2 Codage

Lorsqu'un code est utilisé pour le marquage de la valeur de la capacité, de la tolérance ou de la date de fabrication, le code employé doit être choisi parmi ceux donnés dans l'IEC 60062.

3 Procédures d'assurance de la qualité

Voir l'Annexe Q.

4 Essais et procédures de mesure

Informations générales sur les essais et procédures de mesure	Para- graphe
Généralités	4.1
Conditions atmosphériques normalisées	4.2
Séchage	4.3
Stockage	4.25
Montage (pour les condensateurs pour montage en surface uniquement)	4.33
Essais et mesurages électriques	
Résistance d'isolement	4.5
Tension de tenue	4.6
Capacité	4.7
Tangente de l'angle de perte et résistance-série équivalente (RSE)	4.8
Courant de fuite	4.9
Impédance	4.10
Inductance et fréquence de résonance propre	4.11
Variation de la capacité avec la température	4.24
Surtension	4.26
Essai aux surintensités	4.39
Essais de charge et décharge et de courant d'appel	4.27
Absorption diélectrique	4.36
Surtension transitoire (pour condensateurs électrolytiques en aluminium à électrolyte non solide)	4.40
Essais et mesurages mécaniques	
Examen visuel et contrôle des dimensions	4.4
Sortie de l'armature extérieure	4.12
Robustesse des sorties	4.13
Vibrations	4.17
Secousses (chocs répétitifs)	4.18
Chocs	4.19
Étanchéité des boîtiers	4.20
Essai de cisaillement	4.34
Essai de pliage du substrat	4.35
Essais d'environnement et climatiques	
Variations rapides de température	4.16
Séquence climatique	4.21
Chaleur humide, essai continu	4.22
Endurance	4.23
Caractéristiques à haute et basse températures	4.29
Essai de stabilité thermique	4.30
Essai continu de chaleur humide accéléré	4.37
Essais relatifs à l'assemblage des composants	
Résistance à la chaleur de brasage	4.14
Brasabilité	4.15
Résistance au solvant des composants	4.31
Résistance au solvant du marquage	4.32
Essai sur le développement des trichites	4.41
Essai relatif à la sécurité	
Décharge de pression (pour les condensateurs électrolytiques en aluminium)	4.28
Inflammabilité passive	4.38

4.1 Généralités

La spécification intermédiaire et/ou la spécification particulière cadre doivent indiquer les essais à effectuer, les mesurages à effectuer avant et après chaque essai ou chaque sous-groupe d'essais et l'ordre dans lequel ces essais doivent être effectués. Les étapes de chaque essai doivent être effectuées dans l'ordre indiqué. Les conditions de mesure doivent être les mêmes pour les mesurages initiaux et finaux.

Si les spécifications nationales d'un système d'assurance de la qualité incluent des méthodes différentes de celles indiquées dans les spécifications ci-dessus, elles doivent être décrites de façon détaillée.

Les limites données dans toutes les spécifications sont des limites absolues. Le principe prévoyant la prise en compte de l'incertitude de mesure doit être appliqué.

4.2 Conditions atmosphériques normalisées

4.2.1 Conditions atmosphériques normalisées d'essai

Sauf spécification contraire, tous les essais et mesurages doivent être effectués dans les conditions atmosphériques normalisées d'essai fixées au 4.3 de l'IEC 60068-1:2013.

- température: 15 °C à 35 °C;
- humidité relative: 25 % à 75 %;
- pression atmosphérique: 86 kPa à 106 kPa.

Avant les mesurages, le condensateur doit être stocké à la température de mesure pendant un temps suffisant pour lui permettre d'atteindre cette température en tout point. La période spécifiée pour la reprise à la fin d'un essai est normalement suffisante.

Lorsque des mesurages sont effectués à une température différente de la température spécifiée, les résultats doivent, si nécessaire, être corrigés pour la température spécifiée. La température ambiante pendant les mesurages doit être indiquée dans le rapport d'essai. En cas de conflit, les mesurages doivent être répétés en utilisant une des températures d'arbitrage (conformément à 4.2.3) et d'autres conditions précisées dans la présente norme.

Lorsque des essais sont effectués en séquence, les mesurages finaux d'un essai peuvent être pris comme mesurages initiaux de l'essai suivant.

Pendant les mesurages, le condensateur ne doit pas être exposé aux courants d'air, au rayonnement solaire direct ou à d'autres influences susceptibles d'introduire des erreurs.

4.2.2 Conditions de reprise

Sauf spécification contraire, la reprise doit s'effectuer dans les conditions atmosphériques normalisées d'essai (4.2.1).

S'il est nécessaire de procéder à la reprise dans des conditions bien contrôlées, les conditions de reprise contrôlées du 4.4.2 de l'IEC 60068-1:2013 doivent être utilisées.

Sauf indication contraire donnée dans la spécification applicable, une durée de 1 h à 2 h doit être utilisée.

La définition de la reprise est telle que donnée au 3.4 de l'IEC 60068-1:2013, et elle est davantage restreinte pour les condensateurs, comme suit:

Lorsqu'une période de reprise est spécifiée comme étant, par exemple, de 1 h à 2 h, ceci signifie que le mesurage (ou autre action ultérieure) sur un lot de condensateurs peut débuter après 1 h et doit être terminé avant 2 h à partir du début de la période de reprise.

La méthode préférentielle pour spécifier une période de reprise se présente sous la forme "x h à y h".

4.2.3 Conditions d'arbitrage

Pour les besoins d'arbitrage, une des conditions atmosphériques normalisées pour les essais d'arbitrage du 4.2 de l'IEC 60068-1:2013, présentées dans le Tableau 1 ci-dessous, doit être choisie.

Tableau 1 – Conditions d'arbitrage

Température	Humidité relative	Pression atmosphérique
°C	%	kPa
20 ± 1	63 à 67	86 à 106
23 ± 1	48 à 52	86 à 106
25 ± 1	48 à 52	86 à 106
27 ± 1	63 à 67	86 à 106

4.2.4 Conditions de référence

Pour les références, les conditions atmosphériques normalisées de référence du 4.1 de l'IEC 60068-1:2013 s'appliquent:

- température: 20 °C;
- pression atmosphérique: 101,3 kPa.

4.3 Séchage

Sauf indication contraire dans la spécification applicable, le condensateur doit être conditionné pendant $96 \text{ h} \pm 4 \text{ h}$ par un chauffage dans un four à circulation d'air porté à une température de $55 \text{ °C} \pm 2 \text{ °C}$ et dont l'humidité relative ne dépasse pas 20 %.

Le condensateur doit ensuite être mis à refroidir dans un dessiccateur contenant un dessiccant approprié, tel que de l'alumine activée ou du gel de silice, et doit y être maintenu depuis la sortie du four jusqu'au début des essais spécifiés.

4.4 Examen visuel et contrôle des dimensions

4.4.1 Examen visuel

L'examen visuel doit montrer que l'état de la pièce, l'exécution et la finition sont satisfaisants (voir 2.2.42).

Le marquage doit être lisible à l'examen visuel et doit être conforme aux exigences de la spécification particulière.

4.4.2 Dimensions (calibrage)

Les dimensions indiquées dans la spécification particulière, appropriées au calibrage, doivent être vérifiées, et elles doivent être conformes aux valeurs précisées dans la spécification particulière.

Lorsque cela est applicable, les mesurages doivent être effectués conformément à l'IEC 60294 ou à l'IEC 60717.

4.4.3 Dimensions (détail)

Toutes les dimensions précisées dans la spécification particulière doivent être vérifiées et doivent être conformes aux valeurs indiquées.

4.5 Résistance d'isolement

4.5.1 Préconditionnement

Avant d'effectuer ce mesurage, les condensateurs doivent être complètement déchargés.

4.5.2 Conditions de mesure

Sauf indication contraire dans la spécification applicable, la résistance d'isolement doit être mesurée sous la tension spécifiée dans le Tableau 2.

La résistance d'isolement doit être mesurée après que la tension a été appliquée pendant $60 \text{ s} \pm 5 \text{ s}$, sauf indication contraire dans la spécification particulière.

Tableau 2 – Mesurage de la résistance d'isolement

Caractéristiques assignées de tension du condensateur V	Tension de mesure V
U_R ou $U_c < 10$	U_R ou $U_c \pm 10 \%$
$10 \leq U_R$ ou $U_c < 100$	10 ± 1^a
$100 \leq U_R$ ou $U_c < 500$	100 ± 15
$500 \leq U_R$ ou U_c	500 ± 50
^a Lorsqu'il peut être démontré que la tension n'a pas d'influence sur le résultat de la mesure, ou qu'une relation connue existe, les mesurages peuvent être effectués à des tensions pouvant atteindre, selon le cas, la tension assignée ou la tension de catégorie. En cas de litige, la tension de 10 V doit être utilisée, sauf indication contraire dans la spécification intermédiaire.	

U_R est la tension assignée utilisée pour définir la tension de mesure à utiliser dans des conditions atmosphériques normalisées d'essai.

U_c est la tension de catégorie utilisée pour définir la tension de mesure à utiliser lorsque l'essai est effectué à la température de catégorie supérieure.

4.5.3 Points d'essai

La résistance d'isolement doit être mesurée entre les points de mesure définis au Tableau 3, indiqués dans la spécification applicable.

L'essai A, entre sorties, s'applique à tous les condensateurs, isolés et non isolés.

L'essai B, isolation interne, s'applique aux condensateurs isolés en boîtier métallique non isolé et aux condensateurs multiples isolés et non isolés.

L'essai C, isolation externe, s'applique aux condensateurs isolés en boîtier non métallique ou en boîtier métallique isolé. Pour cet essai, la tension de mesure doit être appliquée en utilisant l'une des trois méthodes suivantes, comme cela est indiqué dans la spécification applicable.

4.5.4 Méthodes d'essai

4.5.4.1 Méthode de la feuille métallique

Une feuille métallique doit être enroulée étroitement autour du corps du condensateur.

Pour les condensateurs à sorties axiales, cette feuille doit dépasser d'au moins 5 mm à chaque extrémité, à condition qu'un espace minimal de 1 mm puisse être maintenu entre la feuille métallique et les sorties. Si cet espace minimal ne peut être assuré, la dimension de la feuille doit être réduite d'autant qu'il sera nécessaire pour ménager un espace de 1 mm.

Pour les condensateurs à sorties unilatérales, une distance minimale de 1 mm doit être maintenue entre le bord de la feuille et chaque sortie.

4.5.4.2 Méthode pour les condensateurs comportant des dispositifs de montage

Le condensateur doit être monté de façon normale sur une plaque métallique dépassant d'au moins 12,7 mm, dans toutes les directions, la face de montage du condensateur.

4.5.4.3 Méthode du bloc métallique en V

Le condensateur doit être calé dans le fond d'un bloc métallique en V ouvert à 90° de dimensions telles que le corps du condensateur ne dépasse pas les extrémités du bloc.

La force appliquée pour caler le condensateur doit être telle qu'elle garantisse un contact adéquat entre le condensateur et le bloc.

Le condensateur doit être placé conformément aux dispositions suivantes:

- a) condensateurs cylindriques: le condensateur doit être placé dans le bloc de telle sorte que la sortie la plus éloignée de l'axe du condensateur soit au plus près de l'une des faces du bloc;
- b) condensateurs rectangulaires: le condensateur doit être placé dans le bloc de telle sorte que la sortie la plus proche du bord du condensateur soit au plus près de l'une des faces du bloc.

Pour les condensateurs cylindriques et rectangulaires à sorties axiales, tout décentrement éventuel des sorties au point où elles sortent du corps du condensateur doit être ignoré.

4.5.5 Compensation de température

Lorsque cela est indiqué dans la spécification particulière, la température à laquelle le mesurage est réalisé doit être notée. Si cette température diffère de 20 °C, une correction doit être apportée à la valeur mesurée en multipliant la valeur par le facteur de correction approprié indiqué dans la spécification intermédiaire.

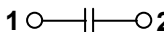
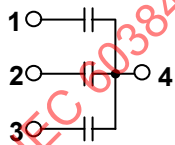
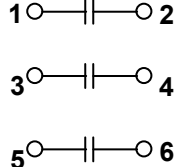
4.5.6 Conditions devant être indiquées dans la spécification applicable

La spécification applicable doit indiquer:

- a) les points de mesure et la tension de mesure correspondant à chacun de ces points;
- b) la méthode d'application de la tension (l'une de celles décrites en 4.5.4);
- c) le temps d'électrification, s'il est différent de 1 min;

- d) toute précaution spéciale à prendre pendant les mesurages;
- e) tous les facteurs de correction exigés pour les mesurages à l'intérieur de la plage des températures couverte par les conditions atmosphériques normalisées d'essai;
- f) la température de mesure, si elle est différente des conditions atmosphériques normalisées d'essai;
- g) la valeur minimale de la résistance d'isolement pour les différents points de mesure (voir le Tableau 3).

Tableau 3 – Points de mesure

Essai	Applicabilité:	1: Condensateurs simples	2: Condensateurs multiples dont tous les éléments ont une sortie commune	3: Condensateurs multiples dont les éléments n'ont pas de sortie commune
		par exemple 	par exemple 	par exemple 
A. Entre sorties ^a	Tous condensateurs	1a: Entre sorties (1-2)	2a: Entre la sortie commune et chacune des autres sorties (1-4, 2-4, 3-4)	3a: Entre les sorties de chaque élément (1-2, 3-4, 5-6)
B. Isolation interne	Condensateurs simples et multiples isolés en boîtier métallique non isolé (1b, 2b, 3b)	1b: Entre les sorties reliées entre elles et le boîtier [(1 à 2)- boîtier]	2b: Entre toutes les sorties reliées entre elles et le boîtier [(1 à 4)- boîtier]	3b: Entre toutes les sorties reliées entre elles et le boîtier [(1 à 6)- boîtier]
	Condensateurs multiples isolés et non isolés (2c et 3c)		2c: Entre la sortie non commune de chaque élément et toutes les autres sorties reliées entre elles par exemple [2-(1, 3, 4)]	3c: Entre les sorties de chacun des éléments pris deux à deux, les deux sorties de chaque élément étant reliées entre elles par exemple [(1 à 2)-(3 à 6)]
C. Isolation externe	Condensateurs isolés en boîtier non métallique ou en boîtier métallique isolé	1c: Entre les deux sorties reliées entre elles et, selon le cas, la feuille métallique, la plaque métallique ou le bloc métallique en V	2d: [(1 à 4)- gabarit métallique]	3d: [(1 à 6)- gabarit métallique]
		[(1 à 2)- gabarit métallique]	Entre toutes les sorties reliées entre elles et, selon le cas: la feuille métallique, la plaque métallique ou le bloc métallique en V	
^a Lorsqu'un condensateur a plus de deux sorties, les points de mesure sont les deux sorties isolées l'une de l'autre par l'élément diélectrique du condensateur. Par exemple, pour un condensateur de traversée coaxiale, il convient que les points de mesure soient l'une des sorties reliées au conducteur central et au boîtier métallique coaxial ou à la face de montage.				

4.6 Tension de tenue

4.6.1 Généralités

L'essai spécifié ci-après est un essai en courant continu. Lorsqu'un essai en courant alternatif est appliqué, le circuit d'essai doit être indiqué dans la spécification applicable.

4.6.2 Circuit d'essai (pour l'essai entre sorties)

Les éléments du circuit d'essai doivent être tels que les conditions concernant les courants de charge et de décharge et la constante de temps à la charge, indiqués dans la spécification applicable, soient maintenues.

La Figure 3 spécifie les caractéristiques d'un circuit d'essai approprié.

La résistance du voltmètre ne doit pas être inférieure à 10 000 Ω/V .

La résistance R_1 comprend la résistance interne de la source de tension.

Les résistances R_1 et R_2 doivent avoir une valeur suffisante pour limiter le courant de charge et de décharge à la valeur indiquée dans la spécification applicable.

La capacité du condensateur C_1 doit être au moins dix fois plus grande que la capacité du condensateur en essai.

Le cas échéant, la constante de temps $R_1 \times (C_X + C_1)$ doit être inférieure ou égale à la valeur indiquée dans la spécification applicable.

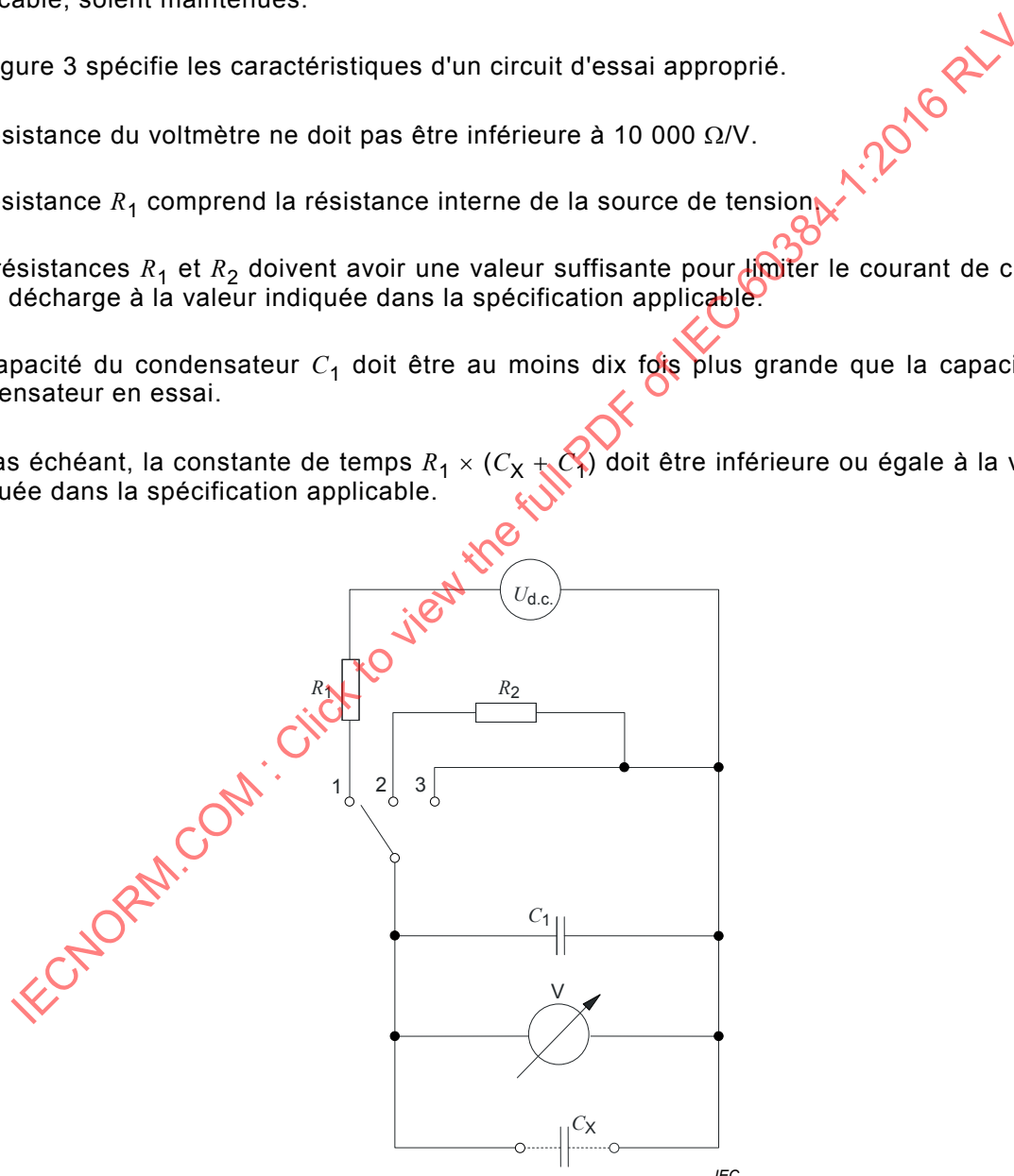


Figure 3 – Circuit d'essai de tension de tenue

Le condensateur C_1 peut être omis pour l'essai de certains types de condensateurs. Il convient que cela soit fixé dans la spécification intermédiaire.

4.6.3 Essai

4.6.3.1 Généralités

L'essai comprend, selon le cas, une ou plusieurs parties, conformément au Tableau 3 et aux exigences de la spécification applicable.

L'application répétée de l'essai de tension de tenue peut endommager le condensateur de façon irréversible, et il convient de l'éviter dans la mesure du possible.

4.6.3.2 Essai A – Entre sorties

4.6.3.2.1 Points d'essai

La tension d'essai est appliquée aux points 1a, 2a, 3a du Tableau 3, selon les exigences de la spécification applicable.

4.6.3.2.2 Procédure

Le commutateur étant placé en position 2, relier les deux bornes représentées à la Figure 3 à une source de tension continue réglable de puissance suffisante et réglée à la valeur de la tension d'essai exigée.

Relier le condensateur à soumettre aux essais (C_X) au circuit d'essai, comme indiqué sur la Figure 3.

Placer le commutateur en position 1 de façon à charger les condensateurs C_1 et C_X à travers R_1 .

Le commutateur reste dans cette position pendant le temps spécifié après que la tension d'essai a été atteinte.

Décharger les condensateurs C_1 et C_X à travers R_2 en plaçant le commutateur en position 2. Dès que le voltmètre est revenu à zéro, mettre les condensateurs en court-circuit en plaçant le commutateur en position 3 et déconnecter le condensateur C_X .

4.6.3.3 Essai B – Isolation interne

4.6.3.3.1 Points d'essai

La tension d'essai est appliquée aux points 1b, 2b, 2c, 3b, 3c du Tableau 3, selon les exigences de la spécification applicable.

4.6.3.3.2 Procédure

La tension d'essai spécifiée est appliquée instantanément à travers la résistance interne de l'alimentation pendant le temps indiqué dans la spécification applicable. Pour le point 2c, utiliser le circuit d'essai et la procédure indiquée pour l'essai entre sorties (4.6.2 et 4.6.3.2).

4.6.3.4 Essai C – Isolation externe (applicable uniquement aux condensateurs isolés dans un boîtier non métallique ou dans un boîtier métallique isolé)

4.6.3.4.1 Points d'essai

La tension d'essai est appliquée aux points 1c, 2d ou 3d en utilisant, pour l'application de la tension, l'une des trois méthodes suivantes, selon les exigences de la spécification applicable.

4.6.3.4.2 Méthode de la feuille métallique

Une feuille métallique doit être enroulée étroitement autour du corps du condensateur.

Pour les condensateurs à sorties axiales, cette feuille doit dépasser d'au moins 5 mm à chaque extrémité, à condition qu'un espace minimal de 1 mm/kV puisse être maintenu entre la feuille métallique et les sorties. Si cet espace ne peut être maintenu, le dépassement de la feuille doit être réduit autant qu'il est nécessaire pour établir l'espace de 1 mm/kV de tension d'essai.

Pour les condensateurs à sorties unilatérales, une distance minimale de 1 mm/kV doit être maintenue entre le bord de la feuille et chaque sortie.

En aucun cas, la distance entre la feuille et les sorties ne doit être inférieure à 1 mm.

4.6.3.4.3 Méthode pour les condensateurs comportant des dispositifs de montage

Le condensateur doit être monté de façon normale sur une plaque métallique dépassant d'au moins 12,7 mm, dans toutes les directions, la face de montage du condensateur.

4.6.3.4.4 Méthode du bloc métallique en V

Le condensateur doit être calé dans le fond d'un bloc métallique en V ouvert à 90° de dimensions telles que le corps du condensateur ne dépasse pas les extrémités du bloc.

La force appliquée pour caler le condensateur doit être telle qu'elle assure un contact adéquat entre le condensateur et le bloc.

Le condensateur doit être placé conformément aux dispositions suivantes:

- a) condensateurs cylindriques: le condensateur doit être placé dans le bloc de telle sorte que la sortie la plus éloignée de l'axe du condensateur soit au plus près de l'une des faces du bloc;
- b) condensateurs rectangulaires: le condensateur doit être placé dans le bloc de telle sorte que la sortie la plus proche du bord du condensateur soit au plus près de l'une des faces du bloc.

Pour les condensateurs cylindriques et rectangulaires à sorties axiales, tout décentrement éventuel de la sortie au point où elle sort du corps du condensateur doit être ignoré.

4.6.3.4.5 Procédure

La tension d'essai spécifiée est appliquée instantanément à travers la résistance interne de la source d'alimentation et pendant le temps indiqué dans la spécification applicable.

4.6.4 Exigences

Pour chacun des points d'essai spécifiés, il ne doit y avoir aucun signe de claquage ni de contournement pendant la période d'essai.

4.6.5 Conditions devant être indiquées dans la spécification applicable

La spécification applicable doit indiquer:

- a) les points d'essai (voir Tableau 3) et la tension d'essai correspondant à chacun de ces points;
- b) pour l'essai d'isolation externe (essai C), la méthode d'application de la tension d'essai (l'une de celles décrites en 4.6.3.4);
- c) la durée d'application de la tension;
- d) le courant maximal de charge et de décharge;
- e) le cas échéant, la valeur maximale de la constante de temps à la charge ($R_1 \times (C_1 + C_X)$).

4.7 Capacité

4.7.1 Fréquence de mesure et tension de mesure

Sauf indication contraire dans la spécification applicable, la capacité doit être mesurée à l'une des fréquences suivantes:

- condensateurs électrolytiques: 100 Hz à 120 Hz
- autres condensateurs: $C_N \leq 1 \text{ nF}$: 100 kHz, 1 MHz ou 10 MHz
(la référence doit être 1 MHz)
- $1 \text{ nF} < C_N \leq 10 \text{ }\mu\text{F}$: 1 kHz ou 10 kHz
(la référence doit être 1 kHz)
- $C_N > 10 \text{ }\mu\text{F}$: 50 Hz (60 Hz) ou 100 Hz (120 Hz)

La tolérance sur toutes les fréquences dans le cadre des mesurages ne doit pas dépasser $\pm 20 \%$.

Sauf indication contraire dans la spécification applicable, la tension de mesure ne doit pas être supérieure à 3 % d' U_R ou 5 V, selon la plus faible des deux valeurs.

4.7.2 Équipement de mesure

L'exactitude de l'équipement de mesure doit être telle que l'erreur n'excède pas:

- a) pour les mesures absolues de capacité: 10 % de la tolérance de capacité ou 2 % de la mesure absolue, la plus petite de ces deux valeurs étant applicable;
- b) pour les mesures de variation de capacité: 10 % de la variation maximale de capacité spécifiée.

Dans aucun des deux cas a) et b) ci-dessus, il n'est nécessaire que l'exactitude soit meilleure que l'erreur absolue minimale de mesure (par exemple 0,5 pF) indiquée dans la spécification applicable.

4.7.3 Conditions devant être indiquées dans la spécification applicable

La spécification applicable doit indiquer:

- a) la température de mesure si elle diffère des conditions atmosphériques normalisées d'essai;
- b) les fréquences de mesure et la plage de capacité auxquelles elles s'appliquent, si elles sont différentes de celles qui sont spécifiées en 4.7.1;
- c) l'erreur absolue de mesure, lorsque cela est applicable (par exemple 0,5 pF);
- d) la tension de mesure, si elle diffère de celle qui est spécifiée en 4.7.1;
- e) le cas échéant, la tension de polarisation appliquée.

4.8 Tangente de l'angle de perte et résistance-série équivalente (RSE)

4.8.1 Tangente de l'angle de perte

4.8.1.1 Fréquence de mesure

La tangente de l'angle de perte doit être mesurée dans les mêmes conditions que celles indiquées pour le mesurage de la capacité à une ou plusieurs fréquences prises dans la liste de 4.7.1 et précisées dans la spécification applicable.

4.8.1.2 Exactitude de mesure

Sauf indication contraire dans la spécification intermédiaire, la méthode de mesure doit être telle que l'erreur ne dépasse pas 10 % de la valeur spécifiée ou 0,000 3, selon la plus grande des deux valeurs.

4.8.2 Résistance-série équivalente (RSE)

4.8.2.1 Fréquence de mesure

Sauf indication contraire dans la spécification applicable, la résistance-série équivalente doit être mesurée à l'une des fréquences suivantes:

50 Hz, 60 Hz, 100 Hz, 120 Hz, 1 kHz, 10 kHz, 100 kHz, 1 MHz et 10 MHz.

4.8.2.2 Exactitude de mesure

Sauf indication contraire dans la spécification applicable, l'exactitude de l'équipement de mesure doit être telle que l'erreur ne dépasse pas 10 % de l'exigence.

4.8.2.3 Conditions devant être indiquées dans la spécification applicable

La spécification applicable doit indiquer

- a) la fréquence de mesure;
- b) l'erreur absolue de mesure;
- c) la tension de mesure, si différente de celle spécifiée en 4.7.1;
- d) la tension de polarisation appliquée, si applicable;
- e) la température à laquelle les mesurages doivent être effectués, si différente de celle des conditions atmosphériques normalisées d'essai.

4.9 Courant de fuite

4.9.1 Préconditionnement

Avant d'effectuer ce mesurage, les condensateurs doivent être complètement déchargés.

4.9.2 Méthode d'essai

Le courant de fuite doit être mesuré, sauf indication contraire dans la spécification applicable, sous la tension continue (U_R ou U_C) appropriée à la température de l'essai, après une période d'électrisation ne dépassant pas 5 min. Il n'est pas nécessaire d'appliquer la tension pendant la totalité des 5 min si le courant de fuite spécifié est atteint dans un temps plus court.

4.9.3 Source d'alimentation

Dans le cadre d'un essai, une source d'alimentation stable telle qu'une alimentation stabilisée doit être utilisée.

4.9.4 Exactitude de mesure

L'erreur de mesure ne doit pas être supérieure à ± 5 % ou 0,1 μA , selon la plus grande des deux valeurs.

4.9.5 Circuit d'essai

Lorsque la spécification applicable le précise, une résistance de protection de 1 000 Ω doit être placée en série avec le condensateur pour limiter le courant de charge.

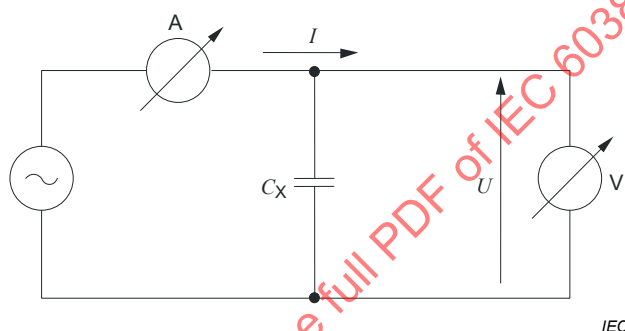
4.9.6 Conditions devant être indiquées dans la spécification applicable

La spécification applicable doit indiquer:

- la limite du courant de fuite à la température de référence de 20 °C, et à d'autres températures spécifiées;
- si nécessaire, le facteur de correction, lorsque les mesurages sont effectués à une température située dans la plage des températures correspondant aux conditions atmosphériques normalisées d'essai, mais différente de 20 °C;
- le temps d'électrisation, s'il diffère de 5 min;
- si une résistance de protection de 1 000 Ω doit ou ne doit pas être placée en série avec le condensateur pour limiter le courant de charge, comme cela est défini en 4.9.5.

4.10 Impédance

L'impédance doit être mesurée par la méthode utilisant un voltmètre et un ampèremètre, conformément au circuit de la Figure 4, ou circuit équivalent.



Légende

C_X	capacité de l'éprouvette
U	tension de mesure
I	courant de mesure
A	ampèremètre
V	voltmètre

Figure 4 – Schéma de principe du circuit de mesure de l'impédance

L'impédance Z_X du condensateur C_X est donnée par $Z_X = \frac{U}{I}$.

La fréquence de la tension de mesure doit être de préférence choisie parmi les valeurs suivantes:

50 Hz, 60 Hz, 100 Hz, 120 Hz, 1 kHz, 10 kHz, 100 kHz, 1 MHz et 10 MHz.

Sauf indication contraire dans la spécification applicable, l'exactitude de l'équipement de mesure doit être telle que l'erreur ne dépasse pas 10 % de l'exigence.

Aux fréquences supérieures à 120 Hz, des précautions sont nécessaires pour éviter des erreurs survenant du fait de courants vagabonds. Il convient que le courant traversant le condensateur soit limité, de telle sorte que le résultat de mesure ne soit pas modifié de façon significative par l'échauffement du condensateur.