

# INTERNATIONAL STANDARD

## NORME INTERNATIONALE

---

**Solderless connections –  
Part 3: Accessible insulation displacement (ID) connections – General  
requirements, test methods and practical guidance**

**Connexions sans soudure –  
Partie 3: Connexions autodénudantes accessibles – Règles générales, méthodes  
d'essai et guide pratique**





## THIS PUBLICATION IS COPYRIGHT PROTECTED

Copyright © 2020 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.

Droits de reproduction réservés. Sauf indication contraire, aucune partie de cette publication ne peut être reproduite ni utilisée sous quelque forme que ce soit et par aucun procédé, électronique ou mécanique, y compris la photocopie et les microfilms, sans l'accord écrit de l'IEC ou du Comité national de l'IEC du pays du demandeur. Si vous avez des questions sur le copyright de l'IEC ou si vous désirez obtenir des droits supplémentaires sur cette publication, utilisez les coordonnées ci-après ou contactez le Comité national de l'IEC de votre pays de résidence.

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

Tel.: +41 22 919 02 11  
[info@iec.ch](mailto:info@iec.ch)  
[www.iec.ch](http://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 corrigendum or an amendment might have been published.

#### IEC publications search - [webstore.iec.ch/advsearchform](http://webstore.iec.ch/advsearchform)

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 It also gives information on projects, replaced and withdrawn publications.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](http://webstore.iec.ch/justpublished)

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

#### IEC Customer Service Centre - [webstore.iec.ch/csc](http://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: [sales@iec.ch](mailto:sales@iec.ch).

#### Electropedia - [www.electropedia.org](http://www.electropedia.org)

The world's leading online dictionary on electrotechnology, containing more than 22 000 terminological entries in English and French, with equivalent terms in 16 additional languages. Also known as the International Electrotechnical Vocabulary (IEV) online.

#### IEC Glossary - [std.iec.ch/glossary](http://std.iec.ch/glossary)

67 000 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.

### A propos de l'IEC

La Commission Electrotechnique Internationale (IEC) est la première organisation mondiale qui élabore et publie des Normes internationales pour tout ce qui a trait à l'électricité, à l'électronique et aux technologies apparentées.

### A propos des publications IEC

Le contenu technique des publications IEC est constamment revu. Veuillez vous assurer que vous possédez l'édition la plus récente, un corrigendum ou amendement peut avoir été publié.

#### Recherche de publications IEC -

[webstore.iec.ch/advsearchform](http://webstore.iec.ch/advsearchform)

La recherche avancée permet de trouver des publications IEC en utilisant différents critères (numéro de référence, texte, comité d'études,...). Elle donne aussi des informations sur les projets et les publications remplacées ou retirées.

#### IEC Just Published - [webstore.iec.ch/justpublished](http://webstore.iec.ch/justpublished)

Restez informé sur les nouvelles publications IEC. Just Published détaille les nouvelles publications parues. Disponible en ligne et une fois par mois par email.

#### Service Clients - [webstore.iec.ch/csc](http://webstore.iec.ch/csc)

Si vous désirez nous donner des commentaires sur cette publication ou si vous avez des questions contactez-nous: [sales@iec.ch](mailto:sales@iec.ch).

#### Electropedia - [www.electropedia.org](http://www.electropedia.org)

Le premier dictionnaire d'électrotechnologie en ligne au monde, avec plus de 22 000 articles terminologiques en anglais et en français, ainsi que les termes équivalents dans 16 langues additionnelles. Egalement appelé Vocabulaire Electrotechnique International (IEV) en ligne.

#### Glossaire IEC - [std.iec.ch/glossary](http://std.iec.ch/glossary)

67 000 entrées terminologiques électrotechniques, en anglais et en français, extraites des articles Termes et Définitions des publications IEC parues depuis 2002. Plus certaines entrées antérieures extraites des publications des CE 37, 77, 86 et CISPR de l'IEC.

# INTERNATIONAL STANDARD

# NORME INTERNATIONALE

---

## **Solderless connections –**

### **Part 3: Accessible insulation displacement (ID) connections – General requirements, test methods and practical guidance**

## **Connexions sans soudure –**

### **Partie 3: Connexions autodénudantes accessibles – Règles générales, méthodes d'essai et guide pratique**

INTERNATIONAL  
ELECTROTECHNICAL  
COMMISSION

COMMISSION  
ELECTROTECHNIQUE  
INTERNATIONALE

---

ICS 29.120.20

ISBN 978-2-8322-8086-7

**Warning! Make sure that you obtained this publication from an authorized distributor.  
Attention! Veuillez vous assurer que vous avez obtenu cette publication via un distributeur agréé.**

## CONTENTS

FOREWORD .....	5
INTRODUCTION .....	7
1 Scope .....	9
2 Normative references .....	9
3 Terms and definitions .....	10
4 Workmanship .....	13
5 Prerequisites for basic test schedule .....	13
5.1 General .....	13
5.2 Prerequisites for accessible ID terminations .....	14
5.2.1 Accessible ID termination materials .....	14
5.2.2 Accessible ID termination dimensions .....	14
5.2.3 Accessible ID termination surface finishes .....	14
5.2.4 Accessible ID termination design features .....	14
5.3 Prerequisites for wires and conductors .....	14
5.3.1 Wires and conductors .....	14
5.3.2 Wire insulation .....	15
5.4 Accessible insulation displacement connections (accessible ID connections) .....	15
6 Testing .....	15
6.1 Introduction .....	15
6.2 General .....	15
6.3 Standard conditions for testing .....	16
6.4 Preconditioning .....	16
6.5 Recovery .....	16
6.6 Mounting of specimen .....	16
7 Tests .....	16
7.1 General examination .....	16
7.2 Mechanical tests .....	17
7.2.1 Transverse extraction force .....	17
7.2.2 Bending of the wire .....	18
7.2.3 Vibration .....	19
7.2.4 Repeated connection and disconnection, reusable accessible ID terminations .....	20
7.3 Electrical tests .....	20
7.3.1 General .....	20
7.3.2 Contact resistance .....	21
7.3.3 Electrical load and temperature .....	22
7.4 Climatic tests .....	22
7.4.1 General .....	22
7.4.2 Rapid change of temperature .....	22
7.4.3 Climatic sequence .....	22
7.4.4 Flowing mixed gas corrosion test .....	22
7.4.5 Damp heat, cyclic .....	23
8 Test schedules .....	23
8.1 General .....	23
8.1.1 Overview .....	23

8.1.2	ID connections with terminations suitable for a range of wire diameters	23
8.1.3	Multipole connectors	23
8.2	Basic test schedule	24
8.2.1	Généralités	24
8.2.2	Initial examination	24
8.2.3	Testing of accessible ID connections	24
8.3	Full test schedule	26
8.3.1	General	26
8.3.2	Initial examination	26
8.3.3	Testing of accessible ID connections	26
8.4	Flow charts	29
Annex A (informative)	Practical guidance	32
A.1	General information on accessible ID connections	32
A.1.1	General	32
A.1.2	Advantages of accessible ID connections	32
A.2	Current-carrying capacity	33
A.3	Tool information	33
A.3.1	Wire insertion tool	33
A.3.2	Wire extraction tool	33
A.3.3	Combination tool	33
A.4	Termination information	33
A.4.1	General	33
A.4.2	Design features	34
A.4.3	Materials	34
A.4.4	Surface finishes	34
A.5	Wire information	34
A.5.1	Type	34
A.5.2	Dimensions	34
A.5.3	Surface finishes	34
A.5.4	Insulation	34
A.6	Connection information	35
Annex B (informative)	Application examples	37
B.1	Examples for good IDCs or negative results (see Figure B.1 to Figure B.7)	37
B.2	Examples for good transversal micro section or negative results	39
Bibliography		40
Figure 1	– Example of accessible and non-accessible insulation displacement connection	7
Figure 2	– Insulation displacement connection	11
Figure 3	– Slot	12
Figure 4	– Beam	13
Figure 5	– Test arrangement, transverse extraction force	17
Figure 6	– Test arrangement, bending of the wire	18
Figure 7	– Test arrangement, vibration	19
Figure 8	– Test arrangement, contact resistance	21
Figure 9	– Basic test schedule (see 8.2)	30
Figure 10	– Full test schedule (see 8.3)	31

Figure A.1 – Example of a single-type accessible ID termination with a solid round conductor..... 36

Figure B.1 – Example of correct and acceptable ID connections ..... 37

Figure B.2 – Examples for good IDCs or negative results..... 37

Figure B.3 – Faulty IDC: damaged contacts ..... 38

Figure B.4 – Requirements for open-ended IDCs ..... 38

Figure B.5 – Faulty IDC: damaged wire..... 38

Figure B.6 – IDC: Wire position..... 39

Figure B.7 – IDC: transversal micro section ..... 39

Table 1 – Minimum transverse extraction force ..... 18

Table 2 – Vibration, preferred test severities ..... 19

Table 3 – Contact resistance of accessible ID connections, maximum permitted values ..... 21

Table 4 – Number of specimens required ..... 24

Table 5 – Qualification test schedule – Test group 1 ..... 25

Table 6 – Qualification test schedule – Test group 2 ..... 25

Table 7 – Qualification test schedule – Test group 3 ..... 26

Table 8 – Qualification test schedule – Test group A..... 27

Table 9 – Qualification test schedule – Test group B..... 27

Table 10 – Qualification test schedule – Test group C ..... 28

Table 11 – Qualification test schedule – Test group D ..... 29

Table 12 – Qualification test schedule – Test group E..... 29

## INTERNATIONAL ELECTROTECHNICAL COMMISSION

**SOLDERLESS CONNECTIONS –****Part 3: Accessible insulation displacement (ID) connections –  
General requirements, test methods and practical guidance**

## 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 60352-3 has been prepared by subcommittee 48B: Electrical connectors, of IEC technical committee 48: Electrical connectors and mechanical structures for electrical and electronic equipment.

This second edition cancels and replaces the first edition published in 1993. This edition constitutes a technical revision.

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

- a) Subclause 7.2.2: reduce the limit of duration of contact disturbance to 1  $\mu$ s.
- b) Subclause 7.2.3: reduce the limit of duration of contact disturbance to 1  $\mu$ s.
- c) Transferred Clauses 9 to 13 to Annex A (informative).
- d) The figures were revised for clarity.

The text of this International Standard is based on the following documents:

FDIS	Report on voting
48B/2789/FDIS	48B/2802/RVD

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

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

A list of all parts in the IEC 60352 series, published under the general title *Solderless connections*, can be found on the IEC website.

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

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



## INTRODUCTION

The two following parts of IEC 60352 are available on solderless insulation displacement connections:

- Part 3: Accessible insulation displacement connections – General requirements, test methods and practical guidance;
- Part 4: Solderless non-accessible insulation displacement connections – General requirements, test methods and practical guidance.

NOTE In this document the term "insulation displacement" is abbreviated to "ID", for example "ID connection", "ID termination".

Figure 1 illustrates examples of accessible and non-accessible insulation displacement connections that clarify the difference among them.

Part 3 includes requirements and relevant tests (normative) as well as a practical guidance in Annex A (informative) for accessible ID connections.

Two test schedules are provided:

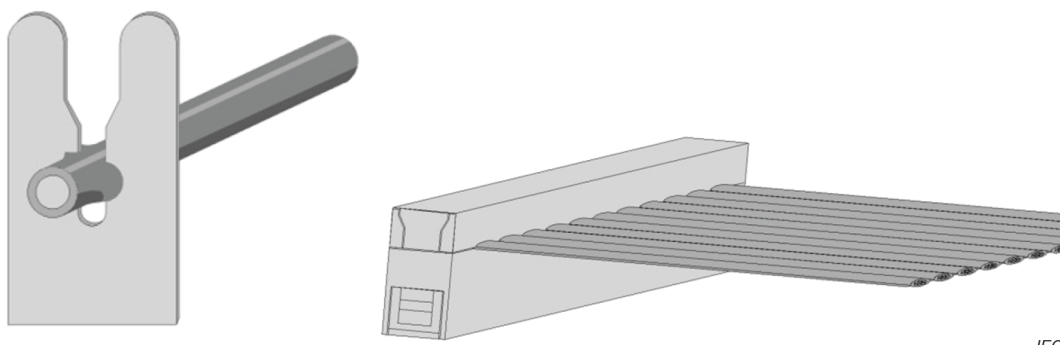
- the basic test schedule which applies to insulation displacement connections which conform to all prerequisites of Clause 5. It is derived from experience with successful applications of such connections;
- the full test schedule which applies to insulation displacement connections which do not fully conform to all prerequisites of Clause 5, for example which are manufactured using materials or finishes not included in Clause 5.

This philosophy permits cost and time effective performance verification using a limited basic test schedule for established insulation displacement connections and an expanded full test schedule for connections requiring more extensive performance validation.

The suitability of the accessible ID connection implies that the specified requirements and tests apply to all factors involved in producing a suitable ID connection, namely:

- the accessible ID termination, which may be part of a single-pole or multipole connector;
- the wire (or range of wires) for which the termination is suitable;
- the tools (if any) required to produce that type of solderless connection.

The practical guidance (informative Annex A) serves as a guideline for the required workmanship. Attention is drawn to the fact that some industries (e.g. automotive, aerospace, nuclear, military) may have specific workmanship standards and/or quality requirements, which are outside the scope of this standard.



IEC

**Figure 1 – Example of accessible and non-accessible insulation displacement connection**

IEC Guide 109 advocates the need to minimise the impact of a product on the natural environment throughout the product life cycle.

It is understood that some of the materials permitted in this document may have a negative environmental impact.

As technological advances lead to acceptable alternatives for these materials, they will be eliminated from the document.