

# INTERNATIONAL STANDARD

# NORME INTERNATIONALE

**Solderless connections –  
Part 6: Insulation piercing connections – General requirements, test methods  
and practical guidance**

**Connexions sans soudure –  
Partie 6: Connexions à percement d'isolant – Exigences générales, méthodes  
d'essai et guide pratique**



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## CONTENTS

FOREWORD.....	5
INTRODUCTION.....	7
1 Scope.....	8
2 Normative references .....	8
3 Terms and definitions .....	9
4 Requirements.....	12
4.1 Workmanship.....	12
4.2 Tools .....	12
5 Pre-requisites for the qualification test schedule.....	12
5.1 Insulation piercing terminations.....	12
5.1.1 Materials .....	12
5.1.2 Dimensions.....	12
5.1.3 Surface finishes.....	13
5.1.4 Design features .....	13
5.2 Insulated conductors.....	13
5.2.1 General .....	13
5.2.2 Materials .....	13
5.2.3 Dimensions.....	13
5.2.4 Surface finishes.....	13
5.2.5 Insulation.....	13
5.3 Insulation piercing connections .....	14
6 Testing.....	14
6.1 Overview.....	14
6.2 General.....	14
6.3 Standard conditions for testing.....	14
6.4 Preconditioning .....	14
6.5 Recovery .....	15
6.6 Mounting of the specimen .....	15
7 Tests.....	15
7.1 General examination.....	15
7.2 Mechanical tests.....	15
7.2.1 Tensile strength.....	15
7.2.2 Bending of the wire/cable .....	15
7.2.3 Vibration.....	17
7.3 Electrical tests .....	18
7.3.1 General .....	18
7.3.2 Contact resistance.....	18
7.3.3 Electrical load and temperature .....	20
7.4 Climatic tests .....	20
7.4.1 General .....	20
7.4.2 Rapid change of temperature.....	21
7.4.3 Climatic sequence .....	21
7.4.4 Flowing mixed gas corrosion test.....	21
7.4.5 Damp heat cyclic .....	21
8 Test schedules .....	22
8.1 General.....	22

8.1.1	Overview .....	22
8.1.2	Insulation piercing connections with terminations suitable for a range of wire diameters .....	22
8.1.3	Multipole components .....	22
8.2	Qualification test schedule .....	23
8.2.1	General .....	23
8.2.2	Initial examination.....	23
8.2.3	Testing of insulation piercing connections.....	23
8.3	Application test schedule .....	25
8.3.1	General .....	25
8.3.2	Initial examination.....	25
8.3.3	Testing of insulation piercing connections.....	25
8.4	Flow charts .....	26
Annex A (informative)	Practical guidance.....	29
A.1	General information on insulation piercing terminations .....	29
A.2	Current-carrying capacity .....	29
A.3	Tool information.....	29
A.4	Termination information .....	30
A.4.1	General .....	30
A.4.2	Materials .....	31
A.4.3	Surface finishes.....	31
A.4.4	Dimensions.....	31
A.5	Conductor information.....	31
A.5.1	General .....	31
A.5.2	Material .....	31
A.5.3	Dimensions.....	31
A.5.4	Surface finishes.....	31
A.5.5	Insulation.....	31
A.5.6	Stripping information for cables (cords) and wires.....	31
A.6	Connection information .....	32
A.7	Axial load.....	33
Bibliography	.....	34
Figure 1	– Example of an integrated insulation piercing connection (one connection shown).....	10
Figure 2	– Example of an insulation piercing connection with insulated flat conductor.....	11
Figure 3	– Example of an insulation piercing connection in a barrel with stranded wires .....	11
Figure 4	– Test arrangement, bending of single wire .....	16
Figure 5	– Test arrangement, bending of flat conductor, flat flexible circuitry .....	17
Figure 6	– Test arrangement, vibration .....	17
Figure 7	– Test arrangement, contact resistance (measuring method for tinsel wire, flat conductor, flat flexible circuitry).....	19
Figure 8	– Test arrangement, contact resistance (measuring method for stranded wires).....	19
Figure 9	– Qualification test schedule (see 8.2) .....	27
Figure 10	– Application test schedule (see 8.3).....	28
Figure A.1	– Example of an insulation piercing termination as an integral part of a component.....	30

Figure A.2 – Example of an insulation piercing termination for flat conductor ..... 30

Figure A.3 – Example of an insulation piercing termination for stranded wires ..... 30

Figure A.4 – Examples of round, flat and flat oval sheath cable ..... 32

Figure A.5 – Example of a flexible circuitry ..... 32

Figure A.6 – Example of an integrated insulation piercing connection ..... 32

Figure A.7 – Example of an integrated insulation piercing connection in a barrel with  
stranded wires ..... 33

  

Table 1 – Vibration, preferred test severities ..... 18

Table 2 – Contact resistance of insulation piercing connections, maximum permitted  
values ..... 20

Table 3 – Number of specimens required ..... 22

Table 4 – Qualification test schedule – Test group A ..... 23

Table 5 – Qualification test schedule – Test group B ..... 23

Table 6 – Qualification test schedule – Test group C ..... 24

Table 7 – Qualification test schedule – Test group D ..... 25

Table 8 – Application test schedule – Test group 1 ..... 26

Table 9 – Application test schedule – Test group 2 ..... 26

Table A.1 – Axial load F ..... 33

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**SOLDERLESS CONNECTIONS –****Part 6: Insulation piercing connections –  
General requirements, test methods and practical guidance**

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IEC 60352-6 has been prepared by subcommittee 48B: Electrical connectors, of IEC technical committee 48: Electrical connectors and mechanical structures for electrical and electronic equipment. It is an International Standard.

This second edition cancels and replaces the first edition published in 1997. This edition constitutes a technical revision.

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

- a) axial load in 7.2.2 provided in a table in Annex A rather than as percentage of breaking load of the wire;
- b) different approach to measure contact resistance provided in 7.3.2.3.

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

Draft	Report on voting
48B/3001/FDIS	48B/3009/RVD

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

The language used for the development of this International Standard is English.

This document was drafted in accordance with ISO/IEC Directives, Part 2, and developed in accordance with ISO/IEC Directives, Part 1 and ISO/IEC Directives, IEC Supplement, available at [www.iec.ch/members\\_experts/refdocs](http://www.iec.ch/members_experts/refdocs). The main document types developed by IEC are described in greater detail at [www.iec.ch/standardsdev/publications](http://www.iec.ch/standardsdev/publications).

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 [webstore.iec.ch](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

This part of IEC 60352 applies to solderless connections made by insulation piercing (IP) and includes requirements, tests and practical guidance information for such connection technology.

Two test schedules are provided:

- a qualification test schedule that applies to insulation piercing connections which conform to all pre-requisites of Clause 5, which are derived from experience with successful applications of such insulation piercing connections;
- an application test schedule that applies to insulation piercing connections made with suitable IP termination which are integral part of a component and are already fulfilling the pre-requisites of Clause 5.

IEC Guide 109 advocates the need to minimize the impact of a product on the natural environment throughout the product life cycle. IEC 62430 provides principles, requirements and guidance to implement environmentally conscious design.

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 to these materials, they will be eliminated from this document.

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## SOLDERLESS CONNECTIONS –

### Part 6: Insulation piercing connections – General requirements, test methods and practical guidance

#### 1 Scope

This part of IEC 60352 is applicable to insulation piercing connections made with stranded wires and tinsel wires, insulated flat conductors and flat flexible circuitries for use in electrical and electronic equipment.

Information on materials and data from industrial experience is included in addition to the test procedures to provide electrically stable connections under prescribed environmental conditions.

The object of this document is to:

- determine the suitability of insulation piercing connections under specified mechanical, electrical, and atmospheric conditions;
- provide a means of comparing test results when the tools used to make the connections, if any, are of different designs or manufacture.

There are different designs and materials for insulation piercing terminations in use. For this reason, only fundamental parameters of the termination, the performance requirements of the conductor and the complete connection are specified in this document.

#### 2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

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

IEC 60512-1:2018, *Connectors for electrical and electronic equipment – Tests and measurements – Part 1: Generic specification*

IEC 60512-1-1:2002, *Connectors for electronic equipment – Tests and measurements – Part 1-1: General examination – Test 1a: Visual examination*

IEC 60512-1-2:2002, *Connectors for electronic equipment – Tests and measurements – Part 1-2: General examination – Test 1b: Examination of dimension and mass*

IEC 60512-2-1:2002, *Connectors for electronic equipment – Tests and measurements – Part 2-1: Electrical continuity and contact resistance tests – Test 2a: Contact resistance – Millivolt level method*

IEC 60512-2-2:2003, *Connectors for electronic equipment – Tests and measurements – Part 2-2: Electrical continuity and contact resistance tests – Test 2b: Contact resistance – Specified test current method*

IEC 60512-2-5:2003, *Connectors for electronic equipment – Tests and measurements – Part 2-5: Electrical continuity and contact resistance tests – Test 2e: Contact disturbance*

IEC 60512-6-4:2002, *Connectors for electronic equipment – Tests and measurements – Part 6-4: Dynamic stress tests – Test 6d: Vibration (sinusoidal)*

IEC 60512-9-2:2011, *Connectors for electronic equipment – Tests and measurements – Part 9-2: Endurance tests – Test 9b: Electrical load and temperature*

IEC 60512-11-1:2019, *Connectors for electrical and electronic equipment – Tests and measurements – Part 11-1: Climatic tests – Test 11a - Climatic sequence*

IEC 60512-11-4:2002, *Connectors for electronic equipment – Tests and measurements – Part 11-4: Climatic tests – Test 11d: Rapid change of temperature*

IEC 60512-11-7:2003, *Connectors for electronic equipment – Tests and measurements – Part 11-7: Climatic tests – Test 11g: Flowing mixed gas corrosion test*

IEC 60512-11-9:2002, *Connectors for electronic equipment – Tests and measurements – Part 11-9: Climatic tests – Test 11i: Dry heat*

IEC 60512-11-10:2002, *Connectors for electronic equipment – Tests and measurements – Part 11-10: Climatic tests – Test 11j: Cold*

IEC 60512-11-12:2002, *Connectors for electronic equipment – Tests and measurements – Part 11-12: Climatic tests – Test 11m: Damp heat, cyclic*

IEC 60512-16-20:1996, *Electromechanical components for electronic equipment – Basic testing procedures and measuring methods – Part 16: Mechanical tests on contacts and terminations – Section 20: Test 16t: Mechanical strength (wired termination of solderless connections)*

### 3 Terms and definitions

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

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- IEC Electropedia: available at <http://www.electropedia.org/>
- ISO Online browsing platform: available at <http://www.iso.org/obp>

#### 3.1

##### **conductor**

part of the cable or wire intended to carry electric current

Note 1 to entry: The conductor may be

- a) solid – made of a single strand of circular cross-section;
- b) stranded – made of several strands of circular cross-section assembled either by laying up concentrically or by bunching, and without insulation between them.

Note 2 to entry: The properties of the copper are in accordance with IEC 60228.

[SOURCE: IEC 60189-1:2018, 3.1]