

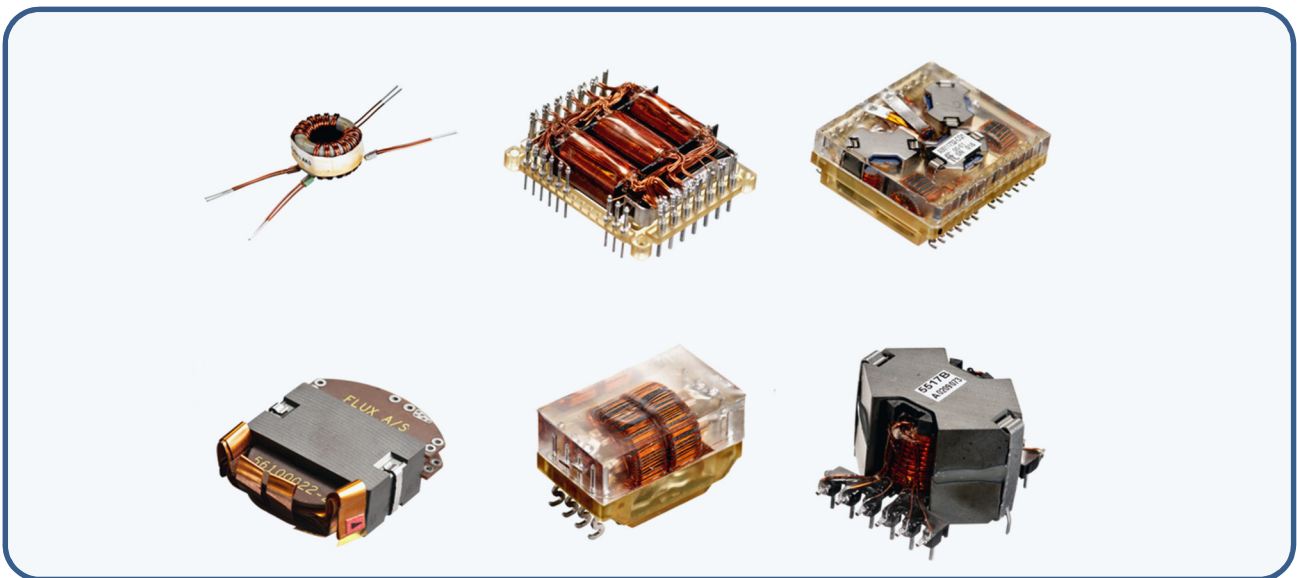
Test Supplement: **ESCC Delta Test**

Document: 08699017

Issue: 1

Date: 09th December 2019

Page: 1 of 23



Author

Michael D. Simpson

Sales Manager (Space)

Lars A. Gregersen

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1. INTRODUCTION

This document details the Delta testing of Flux A/S components requested in line with TFQ.

2. REFERENCE DOCUMENTS

Ref.	Document	Title
RD1	MIL-PRF-27	General Specification for Transformers and Inductors
RD2	MIL-STD-981	Design, Manufacturing and Quality Standards for Custom Electromagnetic Devices for Space Applications
RD3	FT 08690020	Generic Specification Magnetic Components for Space Applications
RD4	MAGN-SP-0114-CRS	Technical Specification
RD5	L253-PWR-TO-250-36	Coupled inductor drawing
RD6	CRS-EPT-04003	Generic Specification for Magnetic Components Procurement

3. UNITS UNDER TEST

Sample Ref	FT Number	Description
S8	14221029-1-B	Power Transformer
S9	14220152-2-B	Output Inductor GK
S11	14171022-2-B	Transformer RM
S16	14110241-2-B	BOB FTFS POWER TRANSFORM
S17	14110133-5-B	Gate Drive Transformer
S24	12240143-1-B	Coupled Inductor

Table 3-1a - RM topology

Sample Ref	FT Number	Description
S3	14260122-1-B	Transformer E30-T-5780
S10	14210148-2-B	Transformer
S23	12260014-2-B	EFD Inductor

Table 3-1b - EFD topology

Sample Ref	FT Number	Description
S18	14011001-5-B	Balun Transformer Parylene Coated

Table 3-1c - Double Aperture Cores topology

Sample Ref	FT Number	Description
S5	14240255-2-B	Transformer, T207-CMF-TO-250-8
S6	14231004-1-B	Transformer assembly
S7	14230080-1-B	Transformer EFD-3032
S12	14141010-1-B	Preregulator Current Sensor
S13	14121023-2-B	BDR Current Sense Transformer
S14	14120075-3-B	CSO-COME COMMAND TRANSFORMER
S15	14111002-2-B	Current Trafo 1:1:100:100
S20	12401014-2-B	Input Differential Filter
S21	12311053-1-B	Coupled Inductor
S22	12311036-1-B	Buck Converter Inductor
S25	12181014-1-B	Inductor 195µH 1.9A
S26	12171025-4-B	Filter Inductor



S27	12141088-2-B	Input Inductor
S28	12141060-1-B	Inductor
S29	12141041-4-B	CM Choke
S30	12121111-4-B	COIL R10 RA.1401.104.13Z Issue 04
S31	12111034-1-B	I_MEAS
S32	12071003-1-B	Toroidal Inductor
S33	12050016-1-B	Common Mode Choke 2x109.8μH
S34	12041025-2-B	DM Choke 200nH 9,1Adc
S35	12031029-1-B	DM Inductor 2
S36	12021032-1-B	Filter Choke
S37	12011025-1-B	Input filter choke 58uH 0,1A
S40	12021008-1-B	Inductor 102L375

Table 3-1d - Toroidal topology

Sample Ref	FT Number	Description
S38	12001201-1-B	RF Filter

Table 3-1e - Aircoils topology

Sample Ref	FT Number	Description
S1	14280056-1-B	IM2 In 68V- 71V, Out 8.5V / 13.5A
S2	14271044-1-B	IM In 100V Out 2.5V 18A
S4	14271043-2-B	IM In 50 V Out 7.75 V 25 A

Table 3-1f - Integrated Magnetics topology

Sample Ref	FT Number	Description
S39	12000096-1-B	Amobead 3-2-3W

Table 3-1g - Ammobead topology

Sample Ref	FT Number	Description
S19	12800014-1-B	FLUX SMT Series 1280 - EP5 Inductor

Table 3-1h - Mini SMT EFD



4. ADDITIONAL TESTING

4.1 Thermal Shock

Thermal shock shall be performed using an environmental chamber. The following test conditions shall be used.

Parameter	Requirement
Minimum temperature	- 55°C ±3°C
Maximum temperature	+120°C ±3°C
Transition temperature	Room Temperature
Dwell time at min. and max. temperature	30 min.
Dwell time at transition temperature	4 min.
Transfer time	< 5 min.
Number of cycles	100

The first five cycles shall run continuously. After five cycles, the test may be interrupted after the completion of any full cycle, and the components allowed to return to ambient room temperature before testing is resumed.

4.1.1 Thermal shock requirement

The components shall be examined for evidence of leakage and other visible damage according to MIL-PRF-27^(RD1) section 3.24.

4.2 Dielectric Withstanding Voltage

Atmospheric pressure is applicable both components.

4.2.1 Dielectric withstanding voltage method

The dielectric withstanding voltage test, serves to determine whether insulating materials and spacing between different parts in the magnetic component are adequate.

The test consists of the application of a DC voltage higher than rated voltage for a specific time between mutually insulated portions of a component part or between insulated portions and ground.

The test shall be applied between each winding and shield, and all of the other windings and shields connected to the core (if accessible). Alternatively the test shall be applied between each winding and shield, and each of the other windings, shields and core (if accessible).

Atmospheric pressure applies

<i>Voltage</i>	<i>500 V DC</i>
<i>Max. Current</i>	<i>0.10 mA ± 0.02 mA</i>
<i>Ramp Time</i>	<i>Max. 1 s</i>
<i>Dwell Time</i>	<i>Min. 60 s</i>

4.2.2 Dielectric withstanding voltage requirements

During and post test the magnetic device shall be inspected for evidence of arcing, flashover, breakdown of insulation, and damage in accordance with MIL-PRF-27^(RD1), section 4.7.9.1.



4.3 Electrical Characteristics

During the tests, the item shall preferably be mounted in a fixture, assuring that the item will not be damaged during the test. The connections must not affect the solderability of the pin or the wire.

4.3.1 Electrical characteristics method – Final measurements

The Main Inductance shall be measured and recorded.

4.4 Visual Inspection

4.4.1 Visual inspection method

Visual inspection shall be aided by magnification appropriate to the size of inspection item, between 4x to 10x magnifications. Additional magnification shall be used to resolve suspected anomalies or defects.

4.4.2 Visual inspection requirements

The components shall be examined to verify that the materials, external design and construction, physical dimensions, marking and workmanship are in accordance with the requirements defined in the relevant procedures



5. TEST FLOW

Group and Test		Sample	Method (Paragraph)	Requirement (Paragraph)
		1		
No subgroups	Visual Inspection	✓	4.4.1	4.4.2
	Thermal Shock	✓	4.1.1	4.1.2
	Dielectric Withstanding Voltage	✓	4.2.1	4.2.1
	Electrical characteristics (room temperature)	✓	4.3.1	4.3.2
	Visual Inspection	✓	4.4.1	4.4.2
Sample Size = 1			Failures Allowed = 0	

Table 5-1 Test Flow

6. ACCEPT / REJECT CRITERIA

Sample units that do not fulfil the requirements for any one or more tests are to be removed and are considered not acceptable. If, however, the cause of the failure can be identified as bad workmanship, wrong handling or similar reasons and is clearly not related to the general performance of material, process or topology, the sample can be considered as acceptable.

7. REPORTING

Reporting shall be in English writing.



8. TESTSHEETS

8.1 14280056-1-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance μH	INSUL.2 MOhm	
CONDITIONS	§4.4	§4.1	§4.2	V=100mV f=100kHz LB2	V=500V	§4.4
LIMITS		100 Cycles	60s	High		
				Low 14,3	Low 5000	
S/N N/A	✓	✓	✓	14,56	✓	✓

8.2 14271044-1-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance μH	INSUL.2 MOhm	
CONDITIONS	§4.4	§4.1	§4.2	V=30mV f=100kHz LB2	V=500V	§4.4
LIMITS		100 Cycles	60s	High		
				Low 5,90	Low 5000	
S/N 051	✓	✓	✓	6,49	✓	✓

8.3 14260122-1-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance μH	INSUL.2 MOhm	
CONDITIONS	§4.4	§4.1	§4.2	V=0.250V f=100kHz N1	V=500V	§4.4
LIMITS		100 Cycles	60s	High 180,4		
				Low 147,6	Low 5000	
S/N 124	✓	✓	✓	164,1	✓	✓

8.4 14271043-2-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance μH		
CONDITIONS	§4.4	§4.1	§4.2	V=30Mv f=100kHz lb2		§4.4
LIMITS		100 Cycles	60s	High		
				Low 4,15		
S/N 136	✓	✓	✓	4,49	✓	✓



8.5 14240255-2-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance μH	INSUL.2 MOhm	
CONDITIONS	§4.4	§4.1	§4.2	V=0.250V f=10kHz		§4.4
LIMITS		100 Cycles	60s	High 1383,5	Low 300	
				Low 756,6		
S/N 056	✓	✓	✓	959,0	✓	✓

8.6 14231004-1-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance μH	INSUL.2 MOhm	
CONDITIONS	§4.4	§4.1	§4.2	V=0.250V f=100kHz N3		§4.4
LIMITS		100 Cycles	60s	High 162,6	Low 5000	
				Low 93,4		
S/N 013	✓	✓	✓	120,0	✓	✓

8.7 14230080-1-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance μH	INSUL.2 MOhm	
CONDITIONS	§4.4	§4.1	§4.2	V=0.150V f=125KHz NP1		§4.4
LIMITS		100 Cycles	60s	High 10,56	Low 500	
				Low 8,64		
S/N 111	✓	✓	✓	10,00	✓	✓

8.8 14221029-1-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance μH	INSUL.2 MOhm	
CONDITIONS	§4.4	§4.1	§4.2	V=0.100V f=100kHz N1		§4.4
LIMITS		100 Cycles	60s	High 431,6	Low 100	
				Low 232		
S/N 023	✓	✓	✓	326,3	✓	✓



8.9 14220152-2-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance μH	INSUL.2 MOhm	
CONDITIONS	§4.4	§4.1	§4.2	V=10mV f=10kHz N1		§4.4
LIMITS		100 Cycles	60s	High 54,4	Low 100	
S/N 072	✓	✓	✓	50,6		✓

8.10 14210148-2-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance μH	INSUL.2 MOhm	
CONDITIONS	§4.4	§4.1	§4.2	V=0.100V f=150kHz		§4.4
LIMITS		100 Cycles	60s	High 45,0	Low 500	
S/N 046	✓	✓	✓	40,7		✓

8.11 14171022-2-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance μH	INSUL.2 MOhm	
CONDITIONS	§4.4	§4.1	§4.2	V=0.250V f=100kHz N1		§4.4
LIMITS		100 Cycles	60s	High 18139	Low 5000	
S/N 017	✓	✓	✓	14374		✓

8.12 14141010-1-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance mH	INSUL.2 MOhm	
CONDITIONS	§4.4	§4.1	§4.2	V=0.250V f=100kHz N3-4		§4.4
LIMITS		100 Cycles	60s	High 1,45	Low 5000	
S/N 050	✓	✓	✓	1,172		✓



8.13 14121023-2-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance mH	INSUL.2 MOhm	
CONDITIONS	§4.4	§4.1	§4.2	V=0.250V f=100kHz N1	V=500V	§4.4
LIMITS		100 Cycles	60s	High 22,00 Low 13,20	Low 10	
S/N	✓	✓	✓	17,2	✓	✓

8.14 14120075-3-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance µH	INSUL.2 MOhm	
CONDITIONS	§4.4	§4.1	§4.2	V=10mV f=10kHz N1	V=500V	§4.4
LIMITS		100 Cycles	60s	High 1,61 Low 0,87	Low 100	
S/N 088	✓	✓	✓	1,23	✓	✓

8.15 14111002-2-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance mH	INSUL.2 MOhm	
CONDITIONS	§4.4	§4.1	§4.2	V=0.250V f=100kHz N3	V=500V	§4.4
LIMITS		100 Cycles	60s	High 16,00 Low 10,20	Low 5000	
S/N 049	✓	✓	✓	12,47	✓	✓

8.16 14110241-2-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance µH	INSUL.2 MOhm	
CONDITIONS	§4.4	§4.1	§4.2	V=0.010V f=100kHz Npri	V=500V	§4.4
LIMITS		100 Cycles	60s	High 26,8 Low 24,2	Low 10000	
S/N 024	✓	✓	✓	25,6	✓	✓



8.17 14110133-5-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance μH	INSUL.2 MOhm	
CONDITIONS	§4.4	§4.1	§4.2	V=0.050V f=10kHz N1		§4.4
LIMITS		100 Cycles	60s	High 2700	Low 5000	
S/N 534	✓	✓	✓	1844	✓	✓

8.18 14011001-5-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance nH	INSUL.2 MOhm	
CONDITIONS	§4.4	§4.1	§4.2	I=100mA f=300kHz N1-2		§4.4
LIMITS		100 Cycles	60s	High 165	Low 500	
S/N N/A	✓	✓	✓	153	✓	✓

8.19 12800014-1-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance μH	INSUL.2 MOhm	
CONDITIONS	§4.4	§4.1	§4.2	V=0.010V f=300kHz N1		§4.4
LIMITS		100 Cycles	60s	High 0,157	Low 5000	
S/N 017	✓	✓	✓	0,156	✓	✓

8.20 12401014-2-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance μH	INSUL.2 MOhm	
CONDITIONS	§4.4	§4.1	§4.2	V=0.250V f=100kHz N1		§4.4
LIMITS		100 Cycles	60s	High 20,35	Low 5000	
S/N 343	✓	✓	✓	17,54	✓	✓



8.21 12311053-1-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance μH	INSUL.2 MOhm	
CONDITIONS	§4.4	§4.1	§4.2	V=0.250V f=100kHz N1	V=500V	§4.4
LIMITS		100 Cycles	60s	High 13,9 Low 8,9	Low 5000	
S/N 002	✓	✓	✓	10,17	✓	✓

8.22 12311036-1-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance μH	INSUL.2 MOhm	
CONDITIONS	§4.4	§4.1	§4.2	V=0.250V f=100kHz N1	V=500V	§4.4
LIMITS		100 Cycles	60s	High 160,5 Low 138,0	Low 5000	
S/N 109	✓	✓	✓	149,9	✓	✓

8.23 12260014-2-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance μH	INSUL.2 MOhm	
CONDITIONS	§4.4	§4.1	§4.2	V=0.100V f=131kHz Ns	V=500V	§4.4
LIMITS		100 Cycles	60s	High 11,30 Low 9,20	Low 500	
S/N 041	✓	✓	✓	10,36	✓	✓

8.24 12240143-1-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance μH	INSUL.2 MOhm	
CONDITIONS	§4.4	§4.1	§4.2	V=0.250V f=100kHz N1	V=500V	§4.4
LIMITS		100 Cycles	60s	High 17,60 Low 15,30	Low 5000	
S/N 009	✓	✓	✓	16,05	✓	✓



8.25 12181014-1-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance μH	INSUL.2 MOhm	
CONDITIONS	§4.4	§4.1	§4.2	V=0.300V f=100kHz N1	V=500V	§4.4
LIMITS		100 Cycles	60s	High 214,9 Low 175,9	Low 500	
S/N 143	✓	✓	✓	190,1	✓	✓

8.26 12171025-4-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance μH	INSUL.2 MOhm	
CONDITIONS	§4.4	§4.1	§4.2	V=0.030V f=100kHz N1-2	V=500V	§4.4
LIMITS		100 Cycles	60s	High 1,428 Low 1,037	Low 5000	
S/N 126	✓	✓	✓	1,221	✓	✓

8.27 12141088-2-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance μH	INSUL.2 MOhm	
CONDITIONS	§4.4	§4.1	§4.2	V=0.250V f=100kHz N1-2	V=500V	§4.4
LIMITS		100 Cycles	60s	High 285 Low 233	Low 5000	
S/N 047	✓	✓	✓	263	✓	✓

8.28 12141060-1-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance μH	INSUL.2 MOhm	
CONDITIONS	§4.4	§4.1	§4.2	V=0.250V f=100kHz N1-2	V=500V	§4.4
LIMITS		100 Cycles	60s	High 544 Low 445	Low 5000	
S/N 022	✓	✓	✓	492	✓	✓



8.29 12141041-4-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance μH	INSUL.2 MOhm	
CONDITIONS	§4.4	§4.1	§4.2	V=0.10V f=100kHz N ₁₋₂	V=500V	§4.4
LIMITS		100 Cycles	60s	High 2,152 Low 1,156	Low 500	
S/N 237	✓	✓	✓	1,613	✓	✓

8.30 12121111-4-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance μH	INSUL.2 MOhm	
CONDITIONS	§4.4	§4.1	§4.2	V=0.010V f=10kHz N ₁₋₂	V=500V	§4.4
LIMITS		100 Cycles	60s	High 53,17 Low 24,54	Low 5000	
S/N 445	✓	✓	✓	40,16	✓	✓

8.31 12111034-1-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance mH	INSUL.2 MOhm	
CONDITIONS	§4.4	§4.1	§4.2	V=0.250V f=100kHz N ₁₋₂	V=500V	§4.4
LIMITS		100 Cycles	60s	High 11,44 Low 9,36	Low 5000	
S/N	✓	✓	✓	10,59	✓	✓

8.32 12071003-1-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance μH	INSUL.2 MOhm	
CONDITIONS	§4.4	§4.1	§4.2	V=0.050V f=10kHz N ₁₋₂	V=500V	§4.4
LIMITS		100 Cycles	60s	High 12,77 Low 10,03	Low 5000	
S/N 056	✓	✓	✓	10,96	✓	✓



8.33 12050016-1-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance μH	INSUL.2 MOhm	
CONDITIONS	§4.4	§4.1	§4.2	V=300mV f=100kHz N ₁₋₂		§4.4
LIMITS		100 Cycles	60s	High 142,7	Low 5000	
S/N 227	✓	✓	✓	116,6	✓	✓

8.34 12041025-2-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance nH	INSUL.2 MOhm	
CONDITIONS	§4.4	§4.1	§4.2	V=10mV f=300kHz N ₁₋₂		§4.4
LIMITS		100 Cycles	60s	High 230,00	Low 5000	
S/N 336	✓	✓	✓	201,09	✓	✓

8.35 12031029-1-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance μH	INSUL.2 MOhm	
CONDITIONS	§4.4	§4.1	§4.2	V=0.250V f=100kHz N ₁₋₂		§4.4
LIMITS		100 Cycles	60s	High 14,4	Low 5000	
S/N 021	✓	✓	✓	13,0	✓	✓

8.36 12021032-1-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance μH	INSUL.2 MOhm	
CONDITIONS	§4.4	§4.1	§4.2	V=10mV f=300kHz N _{1a1-2}		§4.4
LIMITS		100 Cycles	60s	High 0,1770	Low 5000	
S/N 032	✓	✓	✓	0,1678	✓	✓



8.37 12011025-1-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance μH		
CONDITIONS	§4.4	§4.1	§4.2	V=0.050V f=30kHz N ₁₋₂		§4.4
LIMITS		100 Cycles	60s	High	63,8	
				Low	52,2	
S/N 032	✓	✓	✓	57,1		✓

8.38 12001201-1-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance μH		
CONDITIONS	§4.4	§4.1	§4.2	V=0.250V f=100kHz N ₁₋₂		§4.4
LIMITS		100 Cycles	60s	High	0,968	
				Low	0,792	
S/N 135	✓	✓	✓	0,829		✓

8.39 12000096-1-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Saturation Time μH		
CONDITIONS	§4.4	§4.1	§4.2	V _{peak} =1,0V		§4.4
LIMITS		100 Cycles	60s	High	1,4	
				Low	0,99	
S/N N/A	✓	✓	✓	1,15		✓

8.40 12021008-1-B

	Visual Inspection	Thermal Shocks	DWV	Electrical Characteristics		Visual Inspection
				Inductance μH		
CONDITIONS	§4.4	§4.1	§4.2	V=0.1V f=100kHz N ₁₋₂		§4.4
LIMITS		100 Cycles	60s	High	3,78	
				Low	3,22	
S/N A495	✓	✓	✓	3,39		✓