

METAL STRIP SURFACE CONDITIONS AND REQUIREMENTS

1.0 SCOPE

This Specification defines numerous surface conditions potentially affecting the integrity of the contact interface and the ready acceptance of electro-deposited coatings. This specification is to be utilized when evaluating Metal Strip surfaces.

2.0 PURPOSE

The purpose of this Specification is to establish and define criteria describing the character of a typical Metal Strip surface. This specification is to be integrated into the Metal Strip supplier’s inspection plan for determining acceptability of the surface produced.

3.0 ORDER OF PRECEDENCE

This defines the priority order that should be followed when reviewing attributes and requirements of metal strip:

1. Molex Purchase Order
2. Packaging Specifications
3. Molex (Individual) Metal Strip Specification (i.e. Part Number Specification)
4. Molex Material Alloy Specification (i.e. 2090580050 – Molex Material Specification – C70250 Metal Alloy Strips)
5. Surface (2090580044) and Geometric (2090580043) Global Engineering Specifications

4.0 REFERENCE DOCUMENTS:

- Plating Specification for Pre-Plated Tin Strip Surfaces: 2090580041 (Cosmetic/Terminal definition)
- ASTM B820: Standard Test Method for Bend Test for Determining the Formability of Copper and Copper Alloy Strips
- Supplier Requirement Manual ID# 2156750001

For all geometric and dimensional requirements, please refer to *2090580043: Geometric Conditions and Tolerances for Metal Strips*.

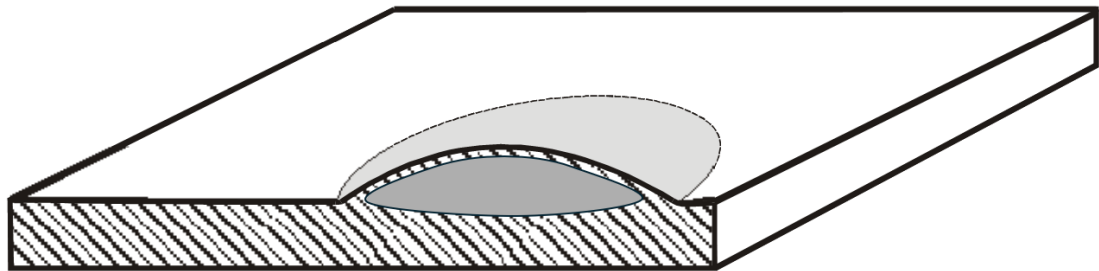
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| CHANGE NO. | | 849682 | | | | | |
| REVISED BY | ELIJAH RESNICK | DATE | 2026/04/15 | DOC TYPE | DOC TYPE DESCRIPTION | DOC PART | SERIES |
| REV APPR BY | DANIEL MOLLA | DATE | 2026/04/15 | QMD | ENGINEERING STANDARD | 000 | 209058 |
| INITIAL RELEASE | | | | CUSTOMER | DOCUMENT NUMBER | REVISION | SHEET |
| INITIAL DRWN | L. WOJNICZKSAMIEC | DATE | 2008/05/05 | MOLEX INTERNAL | 2090580044 | A | 1 OF 11 |
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5.0 DEFINITIONS

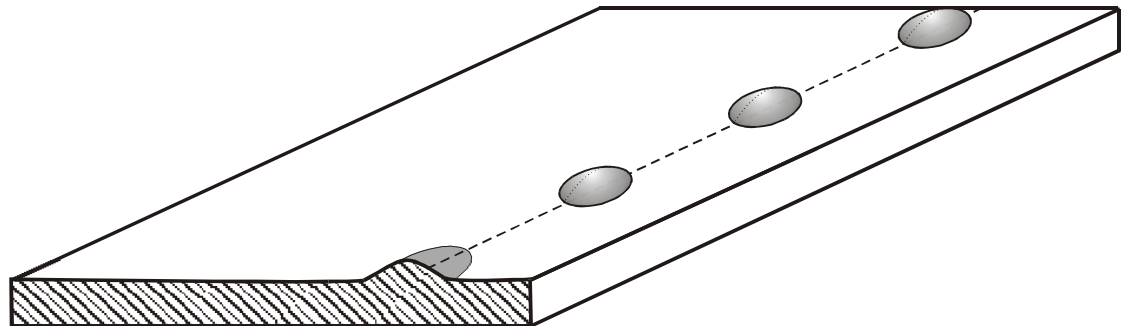
5.1 BLISTER

A raised portion of the strip that may appear round or elongated, typically caused by subcutaneous expanding gas near the surface, allowing the material to internally delaminate.



5.2 BUMP

A raised portion of the strip that may take many geometric shapes, typically caused by a damaged finishing work roll (roll bang), where the bump takes the shape of the damaged roll portion and repeats at a distance as defined by the roll circumference.

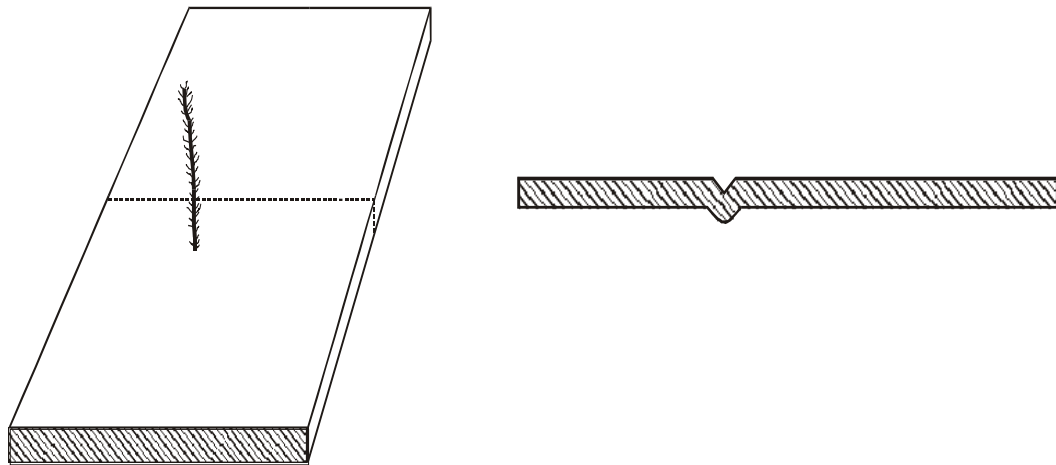


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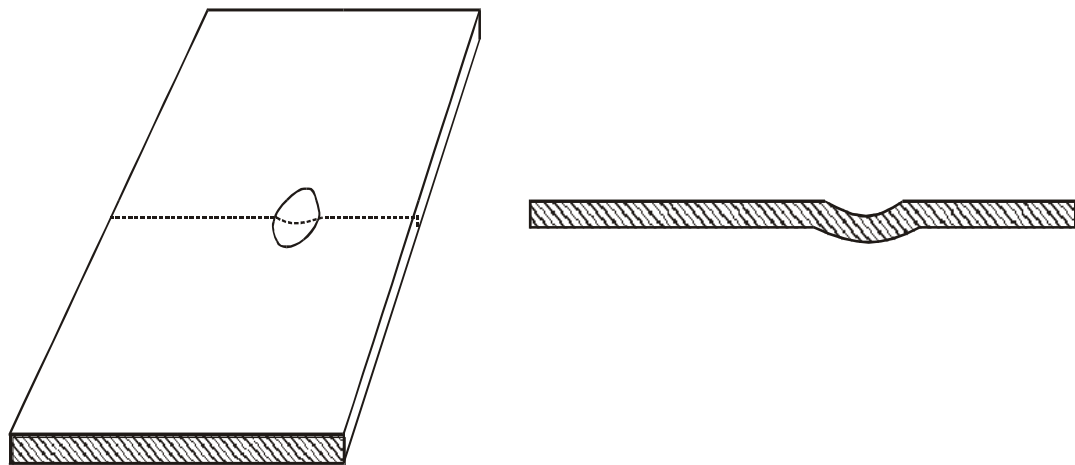
5.3 CREASE

An elongated indentation or fold, which can occur at various stages of strip processing including the folding or rolling of an edge in slitting or winding.



5.4 DENT

Depression of the surface typically associated with a protrusion on the opposite side.

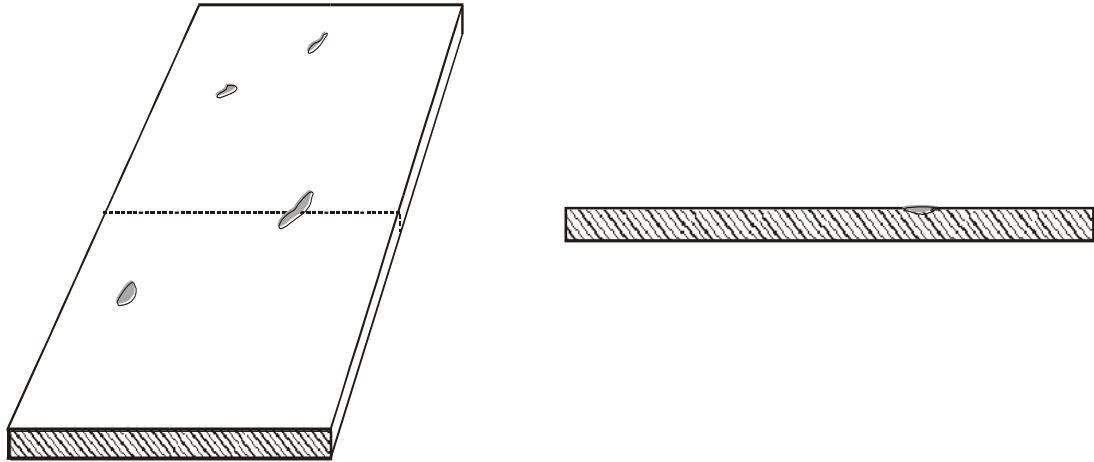


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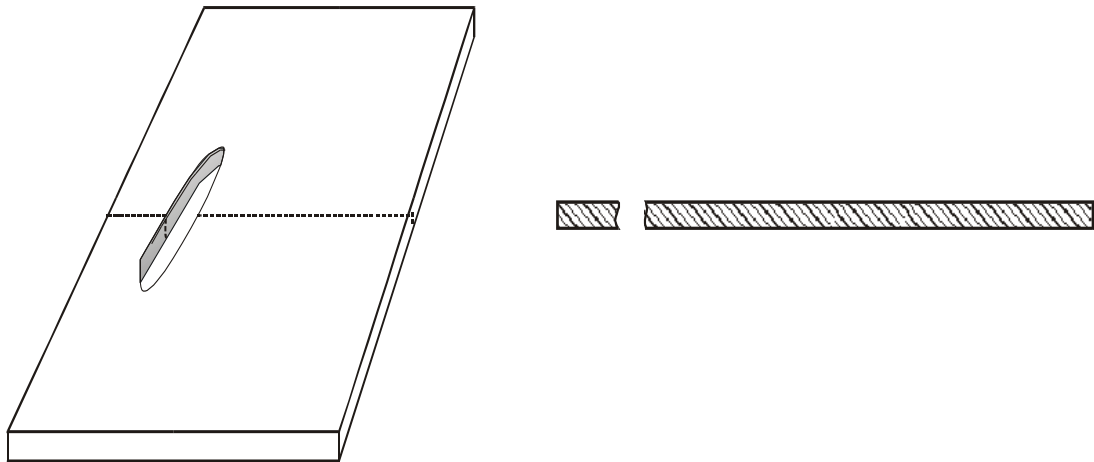
5.5 FOREIGN MATERIAL

The bonding of particulates on the strip's surface (surface contamination.)



5.6 HOLES

Voids appearing through the cross-section of the material thickness.

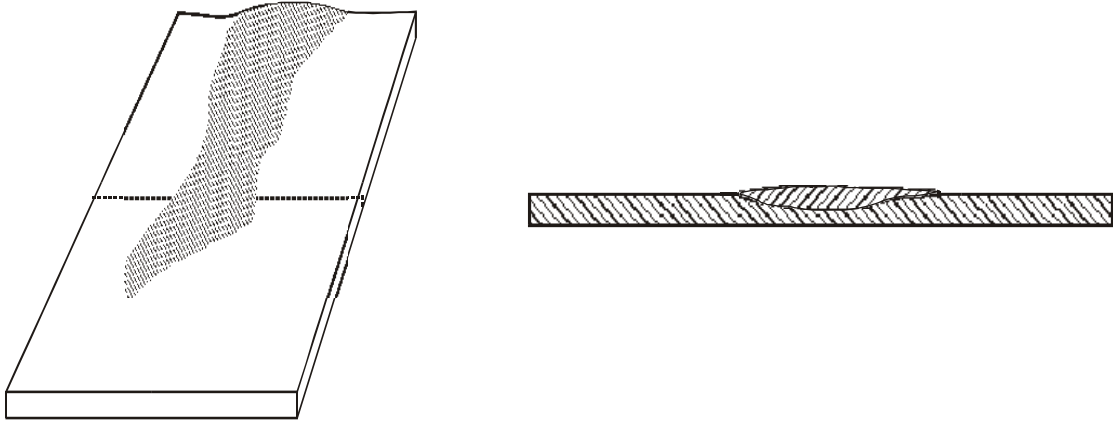


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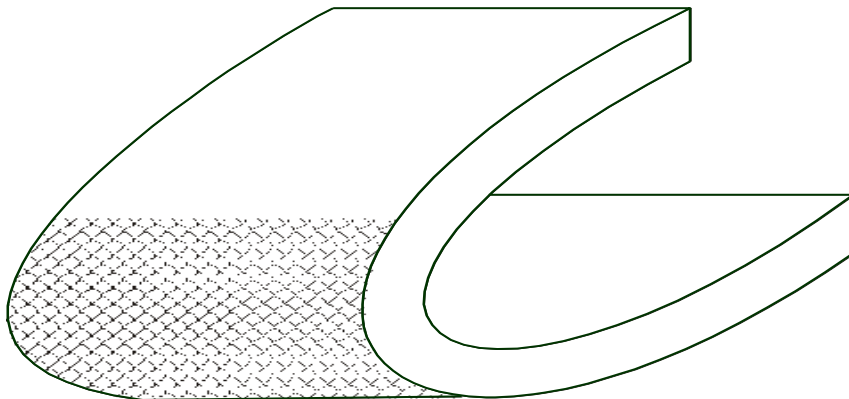
5.7 LAMINATIONS

A surface event where the material is attached at one end and bonded at the other end, causing an area of weakness that may peel, delaminate, or initiate material failure under a mechanical load. If not attached at either end, the observation is to be categorized as foreign material.



5.8 ORANGE PEELED SURFACE

An observed surface characteristic, which is generated from the required bending of the metal strip in the forming process. This is a condition that is pre-controlled by specifying the Ready-to-Finish grain size referenced in accordance to the Order of Precedence (see 3.0). Therefore, inspection of this characteristic is facilitated at the supplier's site when certifying specified bend requirements.



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Orange peel in the bending area can also be known as roping and is a limit condition which is generally deemed acceptable by Molex standards if no cracks can be observed. Surface critical conditions determined by cosmetic requirements where such a condition would be deemed unacceptable must be documented under the respective material specification. This requirement is agreeable with ASTM B820.

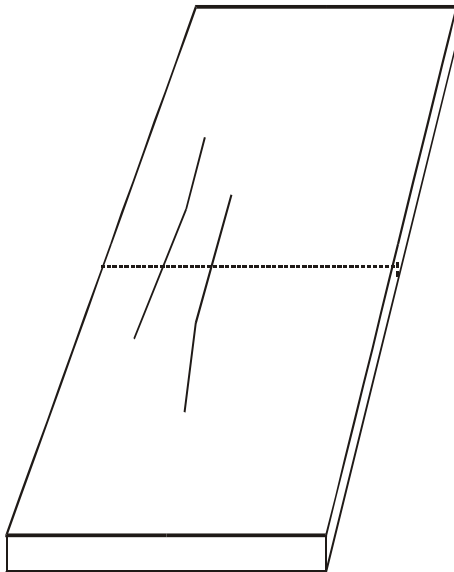


"Accepted", heavy orange peel, no cracks

Rank 3 – Bendability outer surface condition minimal requirement when testing formability at 90° and 180° bends. See Molex Alloy Standards.

5.9 SCRATCH

An elongated break in the surface caused by mechanical damage. The surface is broken open and a depression is formed.

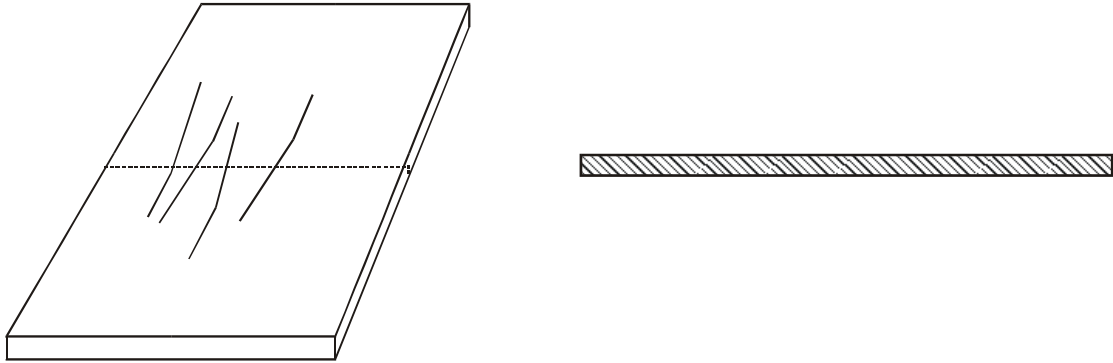


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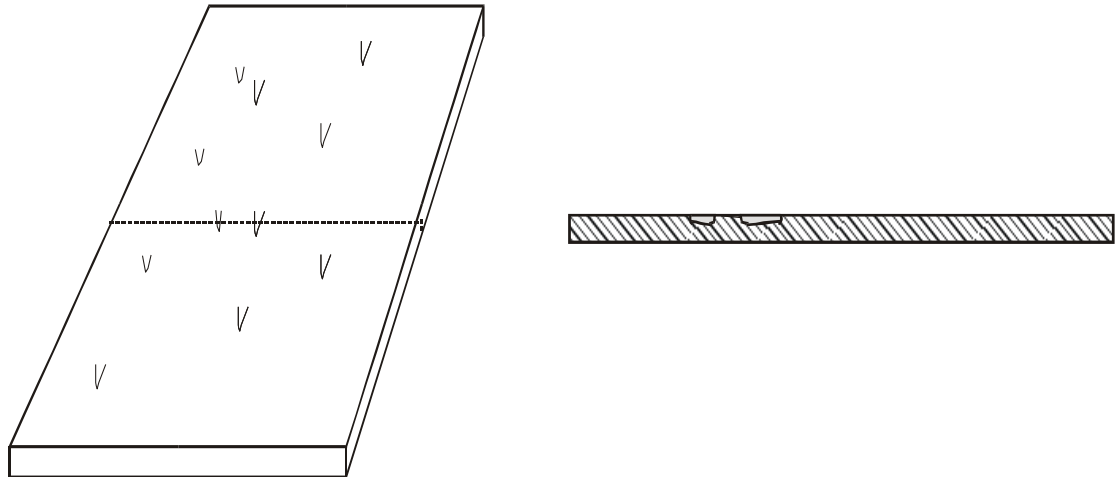
5.10 STRIATIONS

A group of linear observations made on the surface of the strip, sometimes caused by the finish roll grind or a linear burnish mark. The characteristic of striations is that they do not break the surface in cross-section and are not feelable.



5.11 SLIVERS

Sometimes reported as miniature laminations, a sliver will emerge from the surface, when the material is bent in a tight 1 r/t 180° radius bend, or the surface has tape applied and the tape is subsequently removed, pulling the sliver up for observation. Slivers are typically caused by subcutaneous (subsurface) structure anomalies that fail in rolling, or significant rolling reduction applied to a previously mechanically damaged surface.

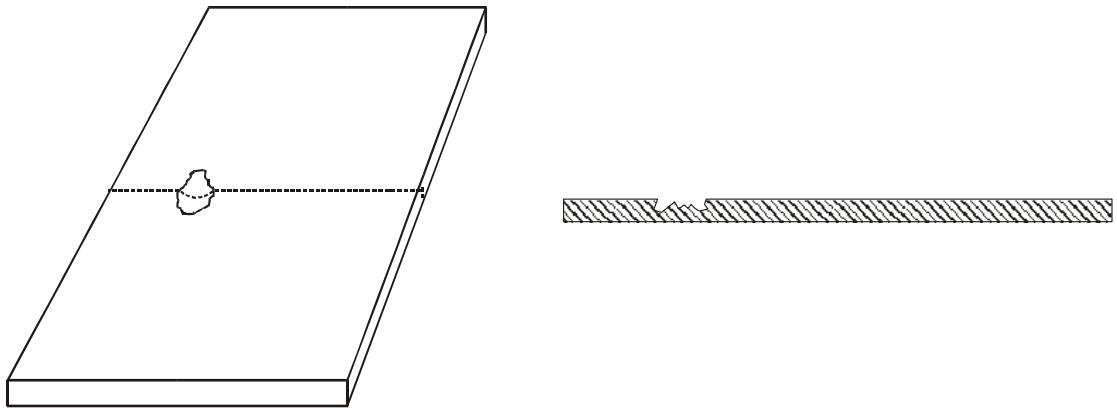


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5.12 PITS

A depression in the material surface caused by (mechanical) embossing or corrosion.



5.13 MICRO TEARS

A condition caused by incorrect processing parameters in the rolling mill process causing microscopic tears that can entrap contaminants yielding difficulties in plating.

5.14 CHATTER MARKS

A surface condition caused by a rolling process where the material being rolled is “skidding” in the roll bite yielding an observable wavy condition observed without magnification.

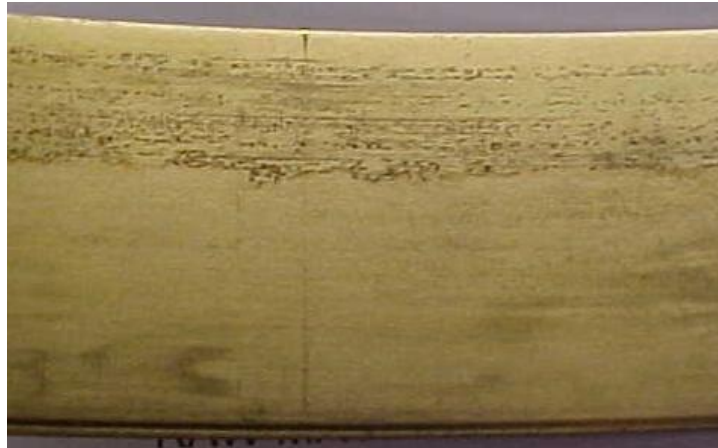


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5.15 SURFACE CONTAMINATION

Contaminants that may not cause discoloration but affect the ready acceptance of Electro-deposited coatings or negatively affect the stamping process. The following are the more common types of surface contaminants:



- 5.15.1** Silicone compounds such as maintenance spray.
- 5.15.2** Stain discoloration of the material's surface with respect to contamination (e.g. water, organic decomposition, foreign material, etc).
- 5.15.3** Non-sulfur oils such as mineral oils used in rolling.
- 5.15.4** Water-soluble roll coolants such as 3-8% fat based roll oils.
- 5.15.5** Benzotriazole compounds to prevent environmental staining.
- 5.15.6** Embedded carbonaceous material such as burnt roll oils after annealing.
- 5.15.7** "Oil Free Surface Condition": This condition is required when an application of contact lubrication is to be applied to plated surfaces. "Oil Free Surface Condition" refers to no intentional oil application after the final mill cleaning operation. After the plating application there is to be no use of any slitting oils or anti-fret lubricant and the processing equipment subsequent to the plating operation requires a Line Clearance procedure. This procedure requires a wipe down of contact points on the processing equipment that could inadvertently contaminate the material strip surface with processing oils.

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5.16 TOLERANCES ON SURFACE ROUGHNESS FOR BARE & PRE-PLATED STRIPS

The test protocol for Surface Roughness is derived through data capture parameters defined in *ISO 21920-3:2021(E)*:

- For an Acceptance Criterium of Non-Periodic Profiles of upper tolerance R_a values within the 0.1 – 2.0 μm range, Setting Class Sc3:
 - Profile L-filter nesting index N_{lc} (Cut-Off λ_c), mm: 0.8
 - Evaluation Length l_e , mm: 4.0
 - Maximum sampling distance d_x , μm : 0.5
 - * Maximum nominal tip radius r_{tip} , μm : 2.0

Orientation of measurement must occur in the transverse direction to rolling; 90° off the rolling direction.

*: *If using stylus profilometer.*

Unless superseded by special requirements listed in documents of greater precedence (ref. Section 3.0 *Order of Precedence*), general surface roughness requirements are as follows:

1. Gold Plated applications: $R_a \leq 0.15$ microns
2. Non Gold-Plated applications:
 - Thickness ≤ 0.5 mm: $R_a \leq 0.20$ microns
 - Thickness > 0.5 mm: $R_a \leq 0.25$ microns
3. When plating is not specified, a maximum surface roughness of $R_a \leq 0.15$ microns applies

6 INSPECTION METHODS AND REQUIREMENTS

| DEF. NO. | CONDITION | INSPECTION METHOD | REQUIREMENT |
|----------|-----------------------|------------------------|---|
| 5.1 | Blister | Visual or CCD Camera | None allowed |
| 5.2 | Bump | Visual or CCD Camera | * Within thickness tolerance, 300mm cut length, cut width = 4 – 50 mm |
| 5.3 | Crease | Visual or CCD Camera | None Allowed |
| 5.4 | Dent | Visual or CCD Camera | None Allowed |
| 5.5 | Foreign Material | Visual or CCD Camera | None Allowed |
| 5.6 | Holes | Visual or CCD Camera | None Allowed |
| 5.7 | Lamination | Visual or CCD Camera | None Allowed |
| 5.8 | Orange Peel | Visual or bend test | No roping or as agreed by Molex Eng. |
| 5.9 | Scratch | Visual or CCD Camera | No "feelable" scratches Using finger nail |
| 5.10 | Striations | Visual or CCD Camera | * "Non-feelable" allowed |
| 5.11 | Slivers | Bend or tape test | None Allowed |
| 5.12 | Pits | Visual or CCD Camera | None Allowed |
| 5.13 | Micro Tears | Visual or 100x, sample | None Allowed |
| 5.14 | Chatter Marks | Visual | None Allowed |
| 5.15 | Surface Contamination | See 5.15.1 - 5.15.7 | |
| 5.15.1 | Silicone | Monitor process inputs | None Allowed |
| 5.15.2 | Stain Discoloration | Visual or CCD Camera | None Allowed |
| 5.15.3 | Non-Sulfur Oils | Monitor process inputs | Light coat as agreed by Molex plan |
| 5.15.4 | Water soluble Oils | Monitor process inputs | Wiped dry or as agreed by Molex plan |
| 5.15.5 | Benzotriazole | Monitor process inputs | No spots on surface allowed |
| 5.15.6 | Embedded Carbon | Visual or CCD Camera | None Allowed |
| 5.15.7 | Oil Free Surface | Process Control Plan | Process Instruction |

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***NOTE: IF MOLEX COSMETIC APPEARANCE (REF. PLATING STANDARD: 2090580041 – TERMINAL AND COSMETIC CLASSIFICATIONS) CRITERIA DICTATE THAT STRIATIONS AND BUMPS ARE UNACCEPTABLE, THEN THE MOLEX RECEIVING ENTITY MUST IDENTIFY THE REQUIREMENT ON THE INDIVIDUAL STRIP SPECIFICATION. ACCEPTANCE CRITERIA WILL BE ESTABLISHED DURING SUPPLIER CONTRACT REVIEW. VISUAL INSPECTION AT 3X MAXIMUM.**

6.1 PERFORMANCE REQUIREMENTS

This standard does not presume to be an all-inclusive list of conditions affecting material performance. However, this standard is considered to be a living document capturing defined conditions that are known to affect the Molex process. Therefore, in the event of processing issues that are not documented within this standard, the Molex facility and supplier will work together in a problem-solving environment to resolve and document the issues to their mutual satisfaction.

6.2 QUALITY / PERFORMANCE CONTINUITY

As referred to in 6.1 of this standard, an inclusive list of all conditions affecting the Molex process is not possible. Therefore, when the supplier has established a process that has been judged acceptable by a Molex facility, it shall not be changed without the consent of that Molex facility. It is the supplier’s responsibility to recognize these process changes through the current quality techniques available. Reference “6.2 Supplier Request for Change” in the Supplier Requirement Manual – 2156750001, available in SupplierNet at the date of revision.

7 SUMMARY OF CHANGES

Document ID# Change from **ES-40000-5007** → **2090580044**.

Appendix A – “Descriptive Examination for Slivers” has been removed.

Appendix B – “Process Change Notification” guideline has been removed, please instead refer to Molex’s Supplier Requirement Manual – 2156750001.

Appendix C – “Acceptability Criteria for Preplated Strip Surfaces” has been reallocated to Plating Specification for Pre-Plated Tin Strip Surfaces – 2090580041.

Appendix D – “Tolerances for Metal Strips” has been moved to 2090580043: Geometric Conditions and Tolerances for Metal Strips.

Adjustment of *Inspection Methods and Requirements* Table (Section 6) as previous version was slightly out of order.

Converted all remaining Imperial to Metric Units.

Changes to *3.0 Order of Precedence*:

- Addition of *Packaging Specifications*.
- Reclassification of “Global Specifications” item #5.

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