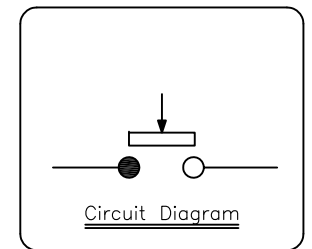
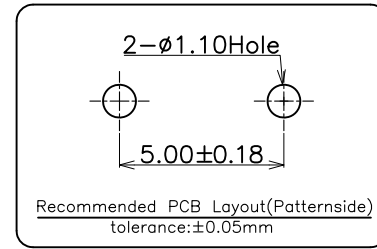
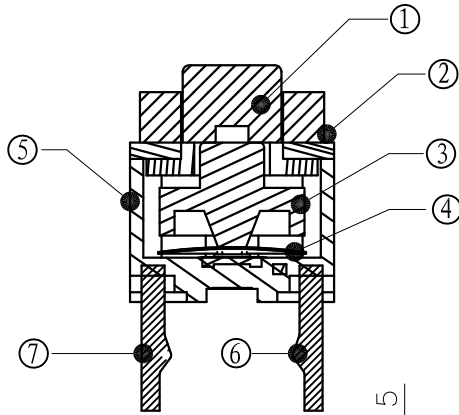
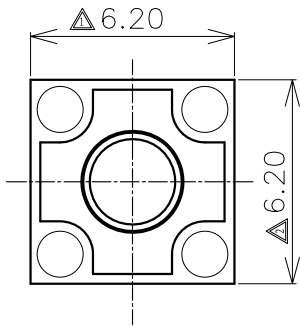
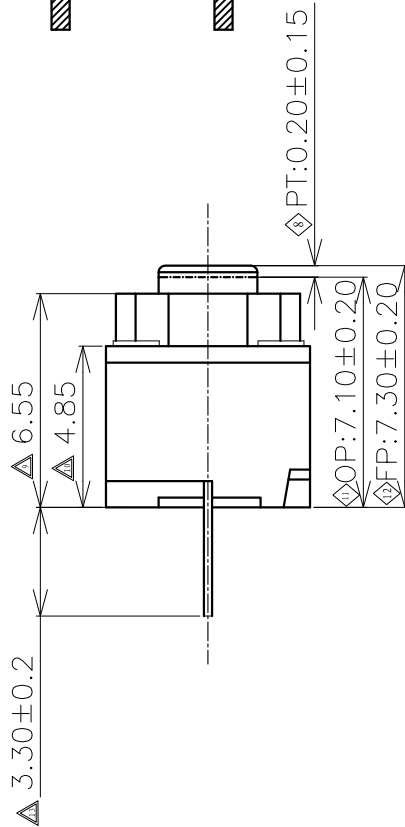
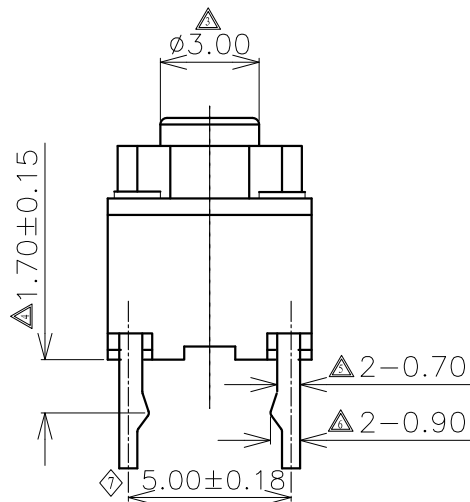


成品检验图面



备注:

- 1. 额定值:DC12伏 50mA
- 2. 接触阻抗:100mΩ Max
- 3. 绝缘阻抗:100MΩ Min (DC250V)
- 4. 耐高压:AC250伏 (50-60Hz)持续 1 分钟
- 5. 操作力:70±10gf (1/N)
- 6. 操作行程:0.20±0.15
- 7. 手感率 (CR): 20%-40% (OF-CF) / OF*100%
(LH756003客户测试机筛选25%-40%)
(其他客户测试机筛选22%-40%)
- 8. 机械寿命:300万次以上



备注:

◇: 表示重点管控尺寸,一般为功能尺寸,首检及巡检时需量测。
 ▲: 表示次要重点管控尺寸,一般为装配尺寸,首检时需量测。
 1) 重点及次要重点管控尺寸中的序号不可重复,需依次往后增加。若其中有某个尺寸在变更或其它状况下,尺寸消失或不要求管控时,原序号不可再用。有其它尺寸需要增加管控时,序号往后增加。
 2) 版次定义:新开发而未转量产之产品图面版次为A1, A2, A3...
 已转量产之产品图面版次为A, B, C...

自动机物料表	⑥	BWMI62XX-01014	端子	a b	1	H65Y	镀银8-15u"	
	⑤	BZMI62XX-02020CL	单粒基座		1	PA66+GF. 30%	灰色	
	④	BWMI62XX-03005	弹片		1	SUS301-EH	镀银20u"	
	③	BSMI62XX-03011	橡胶垫		1	硅胶	灰色	
	②	BSMI62XX-04008	单粒盖子		1	PBT+GF. 30%	黑色	
	①	BSMI62XX-05017	导芯		1	POM	红色	
(1/N) 序号	物料料号	零件名称	端子编号	用量	材	料	镀层/颜色	备注

手工线物料表	⑥	BWMI62XX-01007	端子	a b	1	H65Y	镀银8-15u"	
	⑤	BZMI62XX-02013CL	双排基座		1	PA66+GF. 30%	灰色	
	④	BWMI62XX-03005	弹片		1	SUS301-EH	镀银20u"	
	③	BSMI62XX-03011	橡胶垫		1	硅胶	灰色	
	②	BSMI62XX-04001	双排盖子		1	PA66+GF. 30%	黑色	
	①	BSMI62XX-05017	导芯		1	POM	红色	
序号	物料料号	零件名称	端子编号	用量	材	料	镀层/颜色	备注

承认	日期	东莞市凯华电子有限公司 DONGGUAN CITY KAIHUA ELECTRONICS CO.,LTD	名称	7.3方形微动圆头红导静音开关									
设计	陈耿		2016.01.11	料号	CMI627301D07								
审核			单位: mm	比例: 1:1	视角								
核准			图号	KHA-MI6273-007	页次 1 OF 1								
未注尺寸公差		<table border="1"> <tr> <td>30 < L</td> <td>± 0.30</td> </tr> <tr> <td>10 < L ≤ 30</td> <td>± 0.20</td> </tr> <tr> <td>5 < L ≤ 10</td> <td>± 0.15</td> </tr> <tr> <td>L ≤ 5</td> <td>± 0.10</td> </tr> </table>	30 < L	± 0.30	10 < L ≤ 30	± 0.20	5 < L ≤ 10	± 0.15	L ≤ 5	± 0.10	角度	± 2°	
30 < L	± 0.30												
10 < L ≤ 30	± 0.20												
5 < L ≤ 10	± 0.15												
L ≤ 5	± 0.10												

ECN号码	版次	日期	说明	变更者	审核
ECN-1905-27	N	2019.05.21	内部操作力加严管控由70±20gf变更70±10gf (1/N)	陈耿	
ECN-1709-14	M	2017.9.19	受控成品图纸和BOM表增加自动组装机物料表 (1/N)	陈耿	
ECN-1706-21	L	2017/06/28	成品手感率CR: 20%-40%, 自动测试机手感率CR加严筛选22%-40% (1/N)	陈耿	



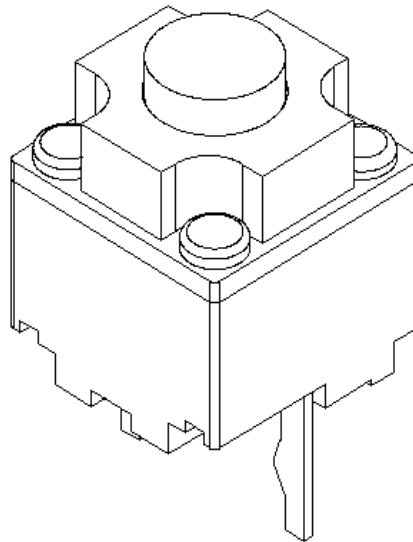
凱華電子
KAIHUA EEELETRONICS

Document Number:

KH-PS1607-38

产品规格书

Product Specification



P/N: CMI627301D07			Title : Micro Switch		
Rev.	ECN	Release and Revision Description:	Prepared By/Date:	Checked By/Date:	Approved By/Date:
A	—	New releasing 初版发行	陈耿/2015/11/15	吕攀豪/2015/11/16	陈军/2015/11/16
B	—	Revise format 修订格式	陈耿/2016/12/7	吕攀豪/2016/12/7	易平/2016/12/7



P/N: CMI627301D07	DOC. No.: KH-PS1607-38	Rev.: B	Page: 2/11
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1. Scope/范围:

This Product Specification covers the requirement of Micro switch on product performance, test methods and quality assurance provisions.
本规格书内容涵盖微动开关产品的要求，包括性能指标、测试方法及质量保证方面等。

2. Product Application/产品应用:

The Switch is applied in all types of Computer mouse. Please let us know before using any of the products in the application not described above.
该微动开关产品适用于所有类型的电脑鼠标，如果用于本文中未提及的领域请在使用前告知。

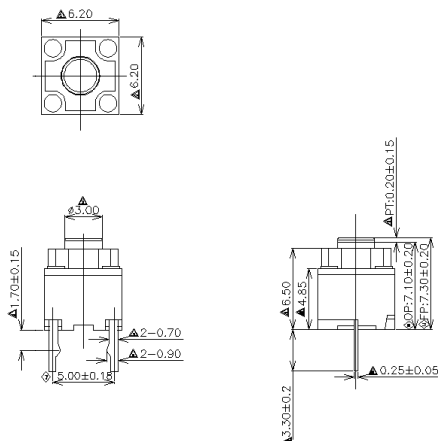
3. Technology Parameters/技术参数:

Ambient Humidity 工作湿度:	45~85% R.H.;
Operating Temperature Range 使用温度范围:	-10℃~+70℃;
Storage Temperature Range 保存温度范围:	-20℃~+80℃;
Normal Condition:	
Ambient temperature 环境温度:	20±5℃
Relative humidity 相对湿度:	65%±5% R.H.;
Air pressure 气压:	86~101KPa;
Contact Resistance 接触阻抗:	100 mΩ Max;
Operation Force 操作力:	70±10gf;
Solder Ability 可焊性:	245±5℃,3±0.5s;
Withstand Soldering Temperature 耐焊接热:	260±5℃,3±0.5s;

4. Ratings/额定性能要求:

Rating 额定负荷:	DC12V / 50mA;
Insulation Resistance 绝缘电阻:	≥100MΩ/ DC 250V;
Withstand Voltage 耐电压:	AC 250V 1 Minute;
Mechanical Life 机械寿命:	3,000,000 Cycles .

5. Profile Dimensions /外形尺寸:





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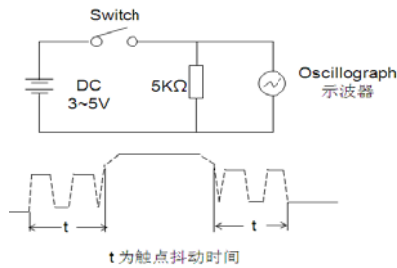
6. Electrical Performance/电气性能:

Item 项目	Description 项目描述	Test Condition 测试条件	Requirement 规格要求
6.1	Contact Resistance 接触电阻	<p>Static load: (Operation force)x2, which is applied on the center of Switch stem. 静态负载: 动作力的 2 倍, 施加在手柄中心.</p> <p>Measurement tool: Contact resistance Meter. 测量工具: 微电流接触电阻计(1KHz, 20mV,5~50mA)</p> <p>在低电流 ($\leq 100\text{mA}$) 条件下测试. Measured at low current (100mA or less).</p>	<p>100mΩ Max 100mΩ 以下</p>
6.2	Insulation Resistance 绝缘电阻	<p>Apply a Voltage of DC 250 V for 1 minute, according to the below method. (1) Between terminals. (2) Between terminal and Body.</p> <p>输入 250V DC 电压 1 分钟, 按如下接触方法测试: (1) 端子与端子之间. (2) 端子与外壳之间.</p>	<p>100MΩ Min 100 兆欧以上</p>
6.3	Dielectric withstanding voltage 耐电压	<p>Apply a Voltage of AC 250 V (50~60Hz) for 1 minute, according to the below method. (1) Between terminals. (2) Between terminal and Body.</p> <p>输入 250V AC 电压 1 分钟, 按如下接触方法测试: (1) 端子与端子之间. (2) 端子与外壳之间.</p>	<p>No evidence of breakdown 无瞬断、击穿等破坏.</p>
6.4	Bouncing 触点抖动	<p>Operation speed: 3~4 times/s 操作速度: 每秒 3~4 次</p> <p>Slightly push the center of stem by 3~4 times/s, to test the bounce at "ON" and "OFF" 以每秒 3~4 次的速度, 轻轻在手柄中心加力, 在"导通"与"瞬断"间测试.</p> <p>Oscillo scope 示波器 Switch Bouncing Test Circuit 抖动测定回路.</p>	<p>Before Life cycle: On: 5ms MAX,5 毫秒以下 Off: 5ms MAX,5 毫秒以下</p> <p>After Life cycle: On: 10ms MAX,10 毫秒以下 Off: 10ms MAX,10 毫秒以下</p>

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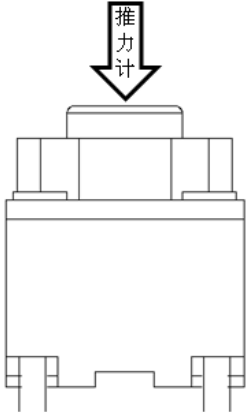
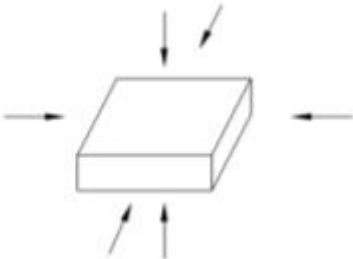
触点抖动用图:



7. Mechanical Performance/机械性能:

Item 项目	Description 项目描述	Test Condition 测试条件	Requirement 规格要求
7.1	The load curve 荷重曲线	<p>Place the vertical direction of switch operation and gradually increase the load applied to the center of the stem until it stop. 开关的动作方向为垂直放置，向手柄中心逐渐施加负荷直到停止。</p>	See page 10 见第 10 页
7.2	Movement Characteristic 动作特征	<p>Place the vertical direction of switch operation and gradually increase the load applied to the center of the stem until it stop. 开关的动作方向为垂直放置，向手柄中心逐渐施加负荷直到停止。</p>	See page 10 见第 10 页



7.3	Static Strength 静止强度	<p>A static load of 0.5 Kgf shall be applied in the direction of button operation for a period of 60 seconds. 在手柄动作方向施加 0.5kgf 的静负荷 60 秒, 然后测试参数.</p> 	No damage (Electrical and mechanical) 电气和机械性能正常.
7.4	Stem Pull Strength 手柄拉拔强度	<p>Break by a pull force applied opposite to the direction of stem operation. 在推柄动作方向反向垂直施加拉力, 使其破坏的程度.</p>	500gf Min
7.5	Shock 机械冲击	<p>Measured by according to the below condition: (1) Acceleration: 80g 加速度: 80g (2) Cycles of test: 3 cycles each in 6 directions, for a total of 18 cycles. 试验次数: 每个方向 3 次, 6 个方向共 18 次.</p> 	Shall meet No.6, 7.1, 7.2. 满足 6, 7.1, 7.2 要求.



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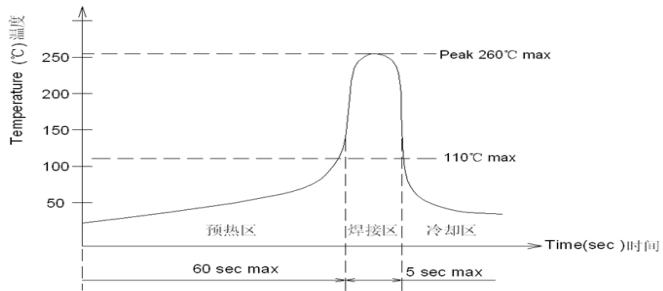
7.6	Life Test 寿命测试	<p>(1) Weight:150gf 砝码: 150gf</p> <p>(2) Operation speed: 2~3cycles/s 操作速度: 2~3 次/秒</p> <p>(3) Push force: Maximum value of operation force. 按压力: 操作力规格值的上限.</p> <p>(4) Cycles: 3,000,000 times Min 操作次数: 300 万次以上</p>	<p>Contact resistance: 10000m Ω Max 接触电阻: 10000 毫欧以下</p> <p>Bouncing: 10ms Max 触点抖动: 10 毫秒以下</p> <p>Operation force: Variation rate within ±30%</p> <p>操作力的变化范围在 初始值的±30%以内.</p>
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8. Environmental Performance/环境性能:

Item 项目	Description 项目描述	Test Condition 测试条件	Requirement 规格要求
8.1	Cold test 耐寒性	<p>(1) Temperature : - 20±2℃ 温度: - 20±2℃</p> <p>(2) Duration of test: 96h 持续时间: 96 小时</p> <p>(3) Take off a drop water 去掉水珠</p> <p>(4) Standard conditions after test : 1h 试验后的放置条件: 1 小时</p>	<p>Contact resistance: 200m Ω Max Shall meet : No. 6.2 to 6.4 No. 7.1 to 7.2 接触电阻 200m Ω 以下</p> <p>满足: No. 6.2 to 6.4 No. 7.1 to 7.2</p>
8.2	Heat test 耐热性	<p>(1) Temperature : 80±2℃ 温度: 80±2℃</p> <p>(2) Duration of test: 96h 持续时间: 96 小时</p> <p>(3) Take off a drop water 去掉水珠</p> <p>(4) Standard conditions after test : 1h 试验后的放置条件: 1 小时</p>	<p>Contact resistance: 200m Ω Max Shall meet : No. 6.2 to 6.4 No. 7.1 to 7.2 接触电阻 200m Ω 以下</p> <p>满足: No. 6.2 to 6.4 No. 7.1 to 7.2</p>

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8.3	Temperature cycle 温度循环	<p>(1) Test cycles: 5 cycles 试验周期: 5 个周期</p> <p>(2) Standard condition after test:1h 试验后的放置条件: 1 小时</p> <table border="1" data-bbox="464 490 1066 680"> <thead> <tr> <th></th> <th>Temperature 温度</th> <th>Duration of test 持续时间</th> </tr> </thead> <tbody> <tr> <td rowspan="4">1 cycle 一次循环</td> <td>20±5℃</td> <td>1h</td> </tr> <tr> <td>-20±2℃</td> <td>1h</td> </tr> <tr> <td>20±5℃</td> <td>1h</td> </tr> <tr> <td>80±5℃</td> <td>1h</td> </tr> </tbody> </table>		Temperature 温度	Duration of test 持续时间	1 cycle 一次循环	20±5℃	1h	-20±2℃	1h	20±5℃	1h	80±5℃	1h	<p>Contact resistance: 200mΩ Max Shall meet : No. 6.2 to 6.4 No. 7.1 to 7.2 接触电阻 200mΩ 以下 满足: No. 6.2 to 6.4 No. 7.1 to 7.2</p>
	Temperature 温度	Duration of test 持续时间													
1 cycle 一次循环	20±5℃	1h													
	-20±2℃	1h													
	20±5℃	1h													
	80±5℃	1h													
8.4	Soldering heat test 耐焊接热	<p>Soldering area: T/2 of PWB thickness. (PWB: T=1.6mm) 焊接面积: 印刷基板的 1/2 厚度处</p> <p>Soldering temperature: 260±5℃ 焊接温度: 260±5℃</p> <p>Soldering time: 3±0.5s 焊接时间: 3±0.5 秒</p>	<p>Appearance: No abnormality. 外观无异常</p>												
8.5	Solderability 可焊性	<p>1. Hand soldering 手工焊接: Please practice according to below condition: (1) Soldering Temperature : 350±5℃ 焊接温度: 350±5℃ (2) Continual soldering time: 3±0.5s 连续焊接时间: 3±0.5 秒 (3) Capacity of soldering iron: ≤20w 电烙铁功率: 20 瓦以下</p> <p>2. Automatic PIP soldering 自动波峰焊接: For the product of T/H, according to below condition: 波峰焊温度曲线图(单波峰)</p> 	<p>At least 95% of surface area of immersed portion shall be covered by solder. 侵焊面积大于 95% 以上。</p>												



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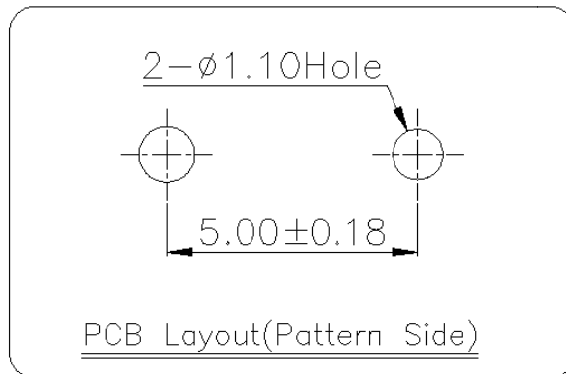
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8.6	Humidity test 耐湿性	<p>(1) Temperature : $60 \pm 2^{\circ}\text{C}$ 温度: $60 \pm 2^{\circ}\text{C}$</p> <p>(2) relative humidity: 90~95% R.H. 相对湿度: 90~95% R.H.</p> <p>(3) Duration of test: 96h 持续时间: 96 小时</p> <p>(4) Take off a drop water 去掉水珠</p> <p>(5) Standard conditions after test: 1h 试验后的放置条件: 1 小时</p>	<p>Contact resistance: $200\text{m}\Omega$ Max</p> <p>Shall meet : No. 6.2 to 6.4 No. 7.1 to 7.2</p> <p>接触电阻 $200\text{m}\Omega$ 以下</p> <p>满足: No. 6.2 to 6.4 No. 7.1 to 7.2</p>
8.7	Withstand K_2S 硫化测试	<p>Apply the following environment to test: 根据下列条件进行测试</p> <p>(1) Temperature: $35 \pm 5^{\circ}\text{C}$ 温度: $35 \pm 5^{\circ}\text{C}$</p> <p>(2) K_2S Density: 2%; 硫化钾浓度: 2%</p> <p>(3) Duration: 2 minute. 持续时间: 2 分钟</p>	<p>Appearance: No corrosion spot, no crack, no base plate naked. 外观: 无腐蚀点, 无裂纹, 无裸露基材.</p> <p>Contact Resistance: $200\text{m}\Omega$ Max 接触电阻: 200 毫欧以下</p>

9. Recommended PCB Layout 推荐的 PCB 安装焊盘规格:

(Top View)

(Single face board T=1.6mm)



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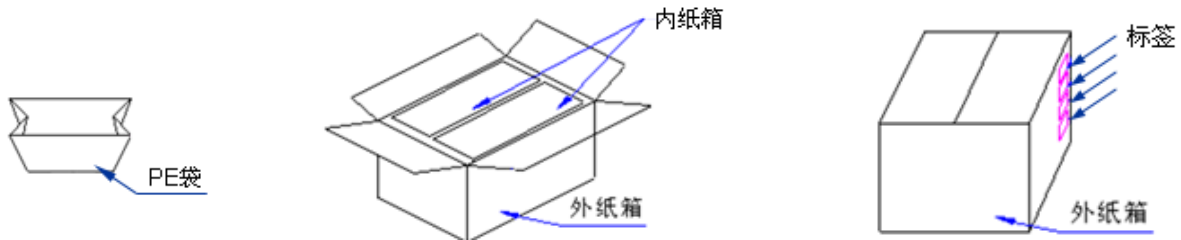
10. Operation (FP/OP/PT/OT /MD/OF/CF/CR) Movement Characteristic 动作特征:

Parameter	Unit	Specification	Remark
FP	mm	7.30±0.20	
OP	mm	7.10±0.20	
PT	mm	0.20±0.15	
OT	mm	0.2	min
MD	mm	0.12	max
OF	gf	70±10	
CF	gf	30	min
CR	%	25%-40%	

11. Packaging 包装:

Packaging type: 1000 PCS/Pe bag / 2000 PCS/inner carton / 20000 PCS/outer cartons .

包装方式: 1000Pcs/PE 袋./2000Pcs/内纸箱/ 20000Pcs/外纸箱



12. Precaution 注意事项:

12.1 Immersion Soldering condition 浸焊条件

ITEM 项目	CONDITION 条件
Preheat temperature 预热温度	110°C Max (Ambient temperature of soldering surface of P.W.B) 110°C 以下(印刷基板焊锡面周围的温度)
Preheat time 预热时间	60s, Max 60 秒以内`
Area of flux 助焊剂面积	1/2 Max of PWB Thickness 印刷基板厚度的 1/2 以内
Temperature of solder 焊锡温度	260±5°C 260±5°C
Time of immersion 浸焊时间	Within 5s 5 秒以内
Number of soldering 焊接次数	2time Max (But should down heat of the first soldering) 2 次以内
Printed wiring board 印刷基板	Single side copper-clad laminates 单面铜箔



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- (1) After switches were soldered, please be careful not to clean switches with solvent
开关浸焊后,注意不要用溶剂清洗.
- (2) Under the condition of using soldering iron, soldering temperature shall be 350°C max within 3 sec.
在使用烙铁的情况下,焊锡温度应在350°C以下,焊接时间3秒以内.

12.2 Notes 注意点:

- (1) Please be cautious not to give excessive static load or shock to switches.
注意不要施加超负荷的压力或晃动开关.
- (2) Please be careful not to stack up P. W. B. after switches were soldered.
开关焊接以后,印刷基板注意不要叠放.
- (3) Preservation under high temperature and high humidity or corrosive gas should be avoided Especially. When you need to preserve for a long period, do not open the carton.
保管时尤其应注意避开高湿高温和有腐蚀性气体的环境. 如需长时间保存,请不要打开包装箱.
- (4) Products meet the ROHS & REACH environmental management substances control standards
产品满足 **ROHS & REACH** 环境管理物质管制标准