

RELEASABLE, REPEATABLE ELECTRICAL CONNECTION EMPLOYING COMPRESSION

CROSS REFERENCE TO RELATED APPLICATION

5 Copending and coassigned U. S. Patent Application Serial No. (TUC920010002) filed on even date herewith relates to alternative media devices mounted in portable data storage type cartridges, and a transfer station for providing data transfer with respect to such portable data storage cartridges.

TECHNICAL FIELD

10 This invention relates to electrical interconnection apparatus, and, more particularly, to electrical interconnection apparatus for the transfer of data to and from a portable agent, and for the transfer of low voltage power.

BACKGROUND ART

15 Data storage cartridges typically comprise a data storage media, such as magnetic tape, which are inserted into a separate data storage drive so that data may be read and/or written on the data storage media. Such cartridges are convenient means of storing large quantities of data which are accessed occasionally. They are particularly useful in automated data storage libraries
20 which can contain large numbers of the cartridges on storage shelves and employ a robot accessor to access a cartridge when needed and deliver the cartridge to a data storage drive.

 The typical portable cartridge presently employs a data storage media, such as a length of magnetic tape, which must be open or openable when inserted in a fixed data storage drive to allow the data storage drive to read and/or write data on the media.

25 An inhibitor to the use of any direct data transfer to portable cartridges, instead of to the media which is stored in the cartridge, has been the problem of the interconnection. Detachable data storage devices are known, for example, in U.S. Patent Re. 34,369, or Japanese Patent 7-220464, which employ pluggable connectors. Pluggable connectors typically employ pins and receptacles which wipe against each other as they are plugged and unplugged, thereby cleaning
30 the connectors. However, the wiping action also limits the ability to unplug and replug the connectors, often to 10-15 times, thereby preventing their use for portable cartridges. U.S. Patent 5,970,030 shows that data storage drives may be exchanged, employing low insertion force

connectors which require a complex connect/disconnect mechanism. Such connectors are not practical for portable cartridges.

DISCLOSURE OF THE INVENTION

5 Hence, an object of the present invention is to provide an electrical connection allowing direct data transfer to portable cartridges.

 Another object of the present invention is to provide an electrical connection which is releasable, and which connection is repeatable.

 A transfer station is provided for releasably, repeatably electrically coupling with respect
10 to a portable cartridge. A substrate is mounted in the portable cartridge, the substrate having a plurality of electrical contacts on a facing surface thereof, and the portable cartridge is capable of being engaged by a loader. In the transfer station, a matching circuitized flexible substrate is provided having electrical contacts on a facing surface thereof, the electrical contacts arranged to match the portable cartridge electrical contacts when in a face-to-face relationship. An
15 elastomeric compression element, which has a plurality of protruding compression members, is positioned at a rear surface of the matching circuitized flexible substrate with the protruding compression members facing and in contact with the rear surface, such that individual compression members are registered with corresponding individual electrical contacts. Elongated electrical contacts are registered with two adjacent individual compression members.
20 A reference plate supports the elastomeric compression element. A loader engages the portable cartridge, registering the cartridge substrate electrical contacts in face-to-face relation with the matching circuitized flexible substrate electrical contacts, and exerting a force on the portable cartridge normal to the facing surface of the matching circuitized flexible substrate. The normal force causes the portable cartridge substrate to compress the elastomeric compression element
25 between the matching circuitized flexible substrate and the reference plate to create non-wiping contact between the electrical contacts of the portable cartridge substrate and the electrical contacts of the matching circuitized flexible substrate, thereby forming a releasable, repeatable electrical connection therebetween.

 A portable cartridge is provided for mating with a transfer station having a data transfer
30 interface with electrical contacts on a compression element and having a cartridge loader. The cartridge comprises a data handling agent, such as an encased, self-contained, magnetic data storage drive. In accordance with the present invention, the cartridge comprises a substantially

flat substrate having electrical contacts on a facing surface thereof, the electrical contacts arranged to match the transfer station data transfer interface electrical contacts when in a face-to-face relationship. The substantially flat substrate is coupled to the data handling agent. A cartridge shell supports the data handling agent and the substantially flat substrate. The cartridge shell has at least one engagement surface, such as notches and alignment holes, for engagement by the cartridge loader in the transfer station, whereby the cartridge loader may engage the cartridge, register the cartridge electrical contacts in face-to-face relation with the transfer station data transfer interface electrical contacts, and exert a force on the cartridge normal to the facing surface of the transfer station data transfer interface to cause the portable cartridge substrate to compress the compression element to create non-wiping contact between the electrical contacts of the portable cartridge substrate and the transfer station data transfer interface facing surface, and forming a releasable, repeatable electrical connection therebetween.

For a fuller understanding of the present invention, reference should be made to the following detailed description taken in conjunction with the accompanying drawings.

BRIEF DESCRIPTION OF DRAWINGS

FIG. 1 is an isometric view of a portable data storage cartridge containing a data storage device in accordance with the present invention;

FIG. 2 is an exploded view of an example of a portable data storage cartridge of FIG. 1 containing an encased magnetic data storage drive;

FIG. 3 is a plan view of the portable data storage cartridge of FIG. 2;

FIG. 4 is a plan view illustration of a flex cable of the portable data storage cartridge of FIG. 2;

FIGS. 5A and 5B are respective top and cross-section views of a backing plate of the portable data storage cartridge of FIG. 2;

FIG. 6 is an isometric view of the bottom half of the cartridge shell of FIG. 2, with the backing plate of FIGS. 5A and 5B;

FIG. 7 is a partially cut away isometric view of the portable data storage cartridge of FIG. 2 illustrating the flex cable of FIG. 4;

FIG. 8 is an isometric view of an automated data storage library for storing, transporting, and providing data transfer with respect to portable data storage cartridges of FIG. 1;

FIG. 9 is an isometric view of a transfer station for providing data transfer with respect to the portable data storage cartridge of FIG. 1 and for differentiating the portable data storage cartridge of FIG. 1 from a tape cartridge;

FIG. 10 is an alternative isometric view of the transfer station of FIG. 9, with a loaded
5 portable data storage cartridge of FIG. 1;

FIGS. 11A and 11A are top view illustrations of an optical source mounted on a top plate of the transfer station of FIG. 10 for detecting, respectively, the portable data storage cartridge of FIG. 1 and a tape cartridge;

FIG. 12 is a plan view illustration of an example of a PCB mounting optical receivers for
10 sensing the optical sources of FIGS. 11A and 11B;

FIG. 13 is an isometric illustration of a compression member, reference plate, support member and clamps of the transfer station of FIG. 9;

FIG. 14 is a plan view illustration of a flex cable of the transfer station of FIG. 9;

FIG. 15 is a cross section illustration of compression member, reference plate, support
15 member and clamps of FIG. 13, with the flex cable of FIG. 14;

FIG. 16 is a circuit diagram illustrating an electrostatic discharge (ESD) path of the transfer station of FIG. 9 and of a portable data storage cartridge of FIG. 1;

FIG. 17 is a side view cut away illustration of the transfer station of FIG. 9 illustrating the loading mechanism in an unloaded position;

FIG. 18 is a cut away illustration of the transfer station of FIG. 9 and of a portable data
20 storage cartridge of FIG. 1 with the loading mechanism in an unloaded position;

FIG. 19 is a side view cut away illustration of the transfer station of FIG. 9 illustrating the loading mechanism in a loaded position;

FIG. 20 is a cut away illustration of the transfer station of FIG. 9 and of a portable data
25 storage cartridge of FIG. 1 with the loading mechanism in a loaded position;

FIG. 21 is a circuit diagram illustrating a power transfer interface of the transfer station of FIG. 9 and of a portable data storage cartridge of FIG. 1;

FIG. 22 is a diagrammatic illustration of a portable data storage cartridge of FIG. 1 containing a non-volatile solid state memory assembly; and

FIG. 23 is a diagrammatic illustration of a portable data storage cartridge of FIG. 1
30 containing an optical disk drive assembly.

BEST MODE FOR CARRYING OUT THE DESCRIPTION

This invention is described in preferred embodiments in the following description with reference to the Figures, in which like numbers represent the same or similar elements. While this invention is described in terms of the best mode for achieving this invention's objectives, it will be appreciated by those skilled in the art that variations may be accomplished in view of these teachings without deviating from the spirit or scope of the invention.

Referring to FIG. 1, a data storage cartridge **40** is provided having a cartridge shell **41** comprising a substantially identical exterior dimensional form factor as a tape cartridge with its leader block. The data storage cartridge comprises a blocking portion **42** to differentiate identification of the data storage cartridge **40** from a tape cartridge. In one aspect, the blocking portion **42** is opaque to optically block an optical source from a corresponding sensor, whereas the prior art leader block hole will transmit an optical beam, thereby differentiating the data storage cartridge **40** from a tape cartridge. Alternatively, or additionally, an opaque blocking portion **43** may be located on the opposite side of the data storage cartridge **40**. In another aspect, a blocking portion **44** is located at a side of the location of the leader block hole at which the threading pin of a tape drive begins engagement of a tape cartridge, and thereby prevents engagement of the data storage cartridge and provides differentiated identification of the portable data storage cartridge.

A notch **45**, similar to the notch of a tape cartridge, is provided to interlock with a holder in a storage shelf of an automated data storage library which tends to hold the data storage cartridge in position in the shelf.

As will be discussed, the cartridge shell **41** mounts a data handling agent, such as a data storage device, therein. Also as will be discussed, an external data transfer interface electrical connector **48** is provided, incorporating a substrate **50**, having electrical contacts **51** on a facing surface of the substrate. The electrical contacts **51** are coupled to the data handling agent, and are arranged to match electrical contacts of a transfer station, when in a face-to-face relationship.

Alignment, or registration, holes **55** and **56** are provided and mate with corresponding alignment pins of the transfer station to laterally align and register the data transfer interface of the portable cartridge **40** with a data transfer interface of the transfer station.

An exploded view of an example of a portable data storage cartridge **40** of FIG. 1 is illustrated in FIG. 2, and a plan view is illustrated in FIG. 3, and contains an encased, self-contained and operational magnetic data storage drive **60**. An example of an encased, self-

contained, magnetic data storage drive of the desired form factor to fit within the cartridge shell 41 comprises the IBM Travelstar 2.5 inch series of magnetic data storage drives. Specifically, FIGS. 2 and 3 illustrate the bottom half 46 of the cartridge shell 41.

Referring to FIGS. 1-3, in one aspect, notches 58 and 59 are provided to allow a loader of the transfer station to engage the portable data storage cartridge 40 and to force the electrical contacts 51 of the data transfer interface electrical connector 48 into non-wiping contact with matching electrical contacts of the transfer station.

In another aspect, a shock mount 62 supports and mounts the data storage device within the cartridge shell 41. Specifically, FIGS. 2 and 3 illustrate the bottom half 63 of the shock mount 62. The shock mount 62 is arranged to insure that the data storage device is fully separated from and isolated from potential mechanical contact with the cartridge shell or the data transfer interface electrical connector 48. Referring additionally to FIG. 4, a flex cable 65 both provides the electrical contacts 51 at a substrate 71 and interconnects the data storage device and the external data transfer interface 48, while also isolating mechanical contact between the data storage device and the cartridge shell 41, thereby further insuring the full separation and mechanical isolation of the data storage device, such as the encased magnetic disk drive assembly 60, from the cartridge shell 41. As the result, the data storage device is protected from rough handling and is able to withstand the dropping of the cartridge, or misplacement the cartridge such that it is handled roughly, either through actions of a robot accessor or through manual handling.

With respect to this aspect of the present invention, the cartridge shell 41, shock mount 62, data transfer interface 48, and flex cable 65 may comprise any configuration suitable for supporting a particular data storage device, while isolating mechanical contact between the data storage device and the cartridge shell. Specifically, the cartridge shell 41 may comprise an exterior dimensional form factor differing from that of a tape cartridge with a leader block.

The data storage device 60 is preferably encased, self-contained and operational, comprising both the necessary mechanical and electronic components. In the context of an encased magnetic disk drive assembly, the assembly comprises at least one rotatable disk, a motor for rotating the disk(s), at least one head, an actuator and servo system for seeking and tracking, and addressing, motor control, and data handling electronics for reading and writing data, and for communicating at the data transfer interface, for example, employing an industry

standard format, such as IDE, SCSI or PCI. Thus, the device does not have to be opened to provide data transfer.

Referring additionally to FIGS. 5A, 5B, 6 and 7, a substantially flat backing plate 70 is provided which supports and mounts a termination 71 of the flex cable 65 of FIG. 4, forming the electrical connector 48. The backing plate 70 and flex cable termination 71 snap into slots 73 and 74 in the cartridge shell 41 for mechanical support. The backing plate 70 thus supports and positions the facing surface 50 of the flex cable 65 to form the external data transfer interface electrical connector. FIG. 7 also illustrates the top half 72 of the shock mount 62 and the top half 75 of the cartridge shell 41.

The flex cable 65 comprises a plurality of lands coupled to the electrical contacts 51 of the facing surface 50 at the termination 71, and are coupled to the data storage device, such as encased magnetic data storage drive 60, for example, at a connector 76 at the rear to provide the above described mechanical isolation.

In one embodiment, the electrical contacts 51 of the substantially flat substrate facing surface 50 comprise pads containing gold for providing gold contact surfaces. For example, the contacts comprise copper pads on which are plated a diffusion barrier, such as nickel, and Type II gold pads plated on the diffusion barrier, but which are plated to a thickness greater than standard. As an example, the thickness of the gold pads is substantially 100 micro inches. As defined by those of skill in the art, a plating of about 8 micro inches is considered a "flash", about 15 micro inches is considered "adequate", and about 30 micro inches is considered "standard". The diffusion barrier is preferably plated to a thickness greater than 50 micro inches. Type II gold pads are also referred to as "hard gold" by those of skill in the art, and comprises a defined set of alloys. Preferably, the gold pads are electrolytically plated.

In an alternative embodiment, other materials having characteristics similar to gold may be employed for the electrical contacts 51, such as palladium or palladium-nickel. Pads containing palladium forming the electrical contacts may have a gold "flash" layer.

In a preferred embodiment, the electrical contacts 51 are substantially flat, having substantially flat contact surfaces on the pads. Electrical contact physics defines that the actual contact is made via small microstructure high spots on the contact surface, referred to as "aspirates", distributed throughout the contact interface, even though the contact surface is substantially flat.

As an alternative embodiment, the electrical contacts **51** may comprise shaped contacts having shaped surfaces on the pads. In "Hertzian" theory, shaping the surfaces tends to concentrate contact force in small contact area. The shaping may be achieved by plating or material removal, and may assume various shapes, referred to as, e.g., dimple, crowned, hertzian stress dot, flat on sphere, dendrite, crossed cylinders, sphere on cup, or sculptured.

Further, at least one of the electrical contacts **51** of the substantially flat substrate facing surface comprises an elongated contact, as will be discussed.

As illustrated by the cross section shown in FIG. **5B**, the backing plate **70** is in the general form of an "H" beam, with a front portion **77** supporting and positioning the flex cable termination **71**, and a rear portion **78** which provides structural strength. As will be discussed, the data storage cartridge **40**, when loaded into the transfer station, will be subjected to considerable force in a direction normal to the facing surface **50**, for example, over 10 pounds, to effect the non-wiping contact with the transfer station data transfer interface, requiring that the backing plate have considerable structural strength, for example, comprising a hard, durable plastic. Examples of plastics having good structural strength comprise "Ryton", a polyphenylene sulphide resin from Phillips 66; "Ultem", a polyetherimide resin from GE, and "Lexan", a polycarbonate from GE.

In another aspect, the alignment, or registration, holes **55** and **56** are provided in the substantially flat backing plate **70** in close proximity to the substantially flat substrate **50**. The substrate **50** of the flex cable termination **71** is aligned with respect to the backing plate **70** at the time of assembly by use of a probe inserted through holes **80** and **81** of the termination **71** and into holes **82** and **83**, respectively, of the backing plate **70**. Thus, the substantially flat substrate facing surface **50** is aligned with respect to the backing plate **70** and the alignment or registration holes **55** and **56** therein. The alignment holes are arranged for mating with corresponding transfer station alignment pins to register the external data transfer interface electrical connector **48** with respect to the transfer station.

The flex cable **65**, in addition to coupling with the data handling agent, or data storage device, to provide data transfer with the contacted transfer station, is coupled to a power input of the data handling agent to provide power from the transfer station to the data handling agent.

In another aspect, when registered and aligned with the transfer station, the backing plate **70** is in contact with the alignment pins at holes **55** and/or **56**. The backing plate **70** comprises a semiconductive plastic material having electrical resistivity. In one example, the material has

sufficient embedded carbon to provide the electrical resistivity, comprising 10%-30% carbon filled plastic. As an alternative, the backing plate **70** comprises two plates, one plate comprising the “H” beam, and the other plate, preferably in front of the “H” beam, and with the alignment holes, comprising a carbon filled semiconductive member. The backing plate is electrically coupled to the data storage device by means of land **85** of flex cable **65**, to a ground thereof, thereby forming an electrostatic discharge path from the data storage device to the backing plate and through the electrically semiconductive material to the alignment pins of the transfer station, which are electrically grounded, as will be discussed. Any of the above discussed plastics may be carbon filled and employed as the backing plate **70** or as the carbon filled one of two plates. A specific example of a carbon filled plastic comprises a 20% carbon filled polycarbonate, called “Stat-Kon DC-1004-FR”.

FIG. **8** illustrates an automated data storage library **90** for storing, transporting, and providing data transfer with respect to tape cartridges **10** and portable data storage cartridges **40** of FIG. **1**. The library **90** comprises at least one, and preferably a plurality of, data storage drives **92** for reading and/or writing data on data storage media, such as the tape cartridges **10**. Additionally, the library comprises at least one, and preferably a plurality of, transfer stations **93** for providing data transfer with respect to the data storage cartridges **40**. Both the tape cartridges **10** and the data storage cartridges **40** are stored in storage shelves **95**. The various cartridges may be stored in a segregated manner or may be stored randomly throughout the storage shelves. A typical automated data storage library also comprises one or more input/output stations **97** at which a cartridge may be received or delivered. A robot accessor **98**, including a gripper **99**, grips and transports a selected cartridge **10** or **40** amongst a storage shelf **95**, an input/output station **97**, a transfer station **93** and/or a data storage drive **92**. The automated data storage library robot accessor may also include a media sensor **96**. The media sensor **96** may comprise a label reader, such as a bar code scanner, or a reading system, such as a smart card or RF (radio frequency) reader, or other similar type of system, which is able to identify the cartridge, such as by means of its volume serial number, or VOLSER. As one example, the VOLSER may comprise a label placed on the cartridge which is read by a bar code reader. As another example, the VOLSER may be recorded in an RF chip in the cartridge which is read by an RF receiver.

FIGS. **9-20** illustrate an embodiment of a transfer station **100** and various components. The transfer station may be employed on a stand-alone basis, or may comprise a transfer station **93** of the automated data storage library **90** of FIG. **8**.

In one aspect, referring to FIGS. 9-12, the transfer station **100** is arranged to provide data transfer with respect to portable data storage cartridges **40** of FIG. 1, where the portable data storage cartridge has generally an exterior dimensional form factor of a tape cartridge **10** having a leader block. As discussed above, the leader block comprises a hole therethrough for engagement by a threading pin. Also as discussed above, the portable data storage cartridge **40** comprises a blocking portion, such as the blocking portion **42**, of the cartridge shell **41**, which is opaque.

The transfer station **100** comprises a receiver **103** for receiving the portable data storage cartridge. The cartridge may be received manually, or may be received from the robot accessor of the automated data storage library **90** of FIG. 8, or may be received from an automated cartridge loader (ACL) as is known to those of skill in the art.

Optical sources **105** and **106** are mounted at openings **107** and **108** of a top plate **109** of the transfer station. Sensors **115** and **116** are mounted on a printed circuit board (PCB) **118** for sensing the optical sources **105** and **106**, respectively. The optical sources **105** and **106** preferably comprise an infrared source, such as an LED optical source, which is focused, providing a focused beam directed toward the respective sensor **115** and **116**, which preferably comprise infrared optical sensors.

Optical source **105** and corresponding sensor **115** are located near a receiving slot **120** of the transfer station into which the cartridge is inserted. Thus, as the cartridge, whether it is a tape cartridge **10** or a portable data storage cartridge **40**, the cartridge interrupts the beam, such that the sensor **115** detects that a cartridge is being inserted into the receiver **103**. Stops **121** and **122** are provided at the end of travel of receiver **103**, and comprise the point at which the cartridge is fully received into the transfer station.

Optical source **106** is located at, and directed toward the location of the leader block hole **19** of a tape cartridge **10** and the location of the blocking portion **42** of a portable data storage cartridge **40** when a cartridge is at the end of travel in the receiver. The corresponding sensor **116** is positioned at the location of the leader block hole and blocking portion at the opposite side of the cartridge from the optical source **106**. The sensor **116** may be enabled by the sensor **115**, and senses the blockage of the optical source **106** by a cartridge shell blocking portion, thereby identifying the differentiated identification of the data storage cartridge, and indicating the presence of the portable data storage cartridge **40** at the end of travel in the receiver **103**. Sensor **116** will therefore enable the transfer station to load the portable data storage cartridge **40**. If the

beam is not blocked, such that sensor **116** continues to detect the beam from the optical source **106**, either the cartridge has not been fully inserted into the receiver **103**, or the cartridge is a tape cartridge **10**, and the beam is received through the leader block hole **19**. In this situation, there is an error, and the transfer station will not proceed.

5 As is understood by those of skill in the art, one or both source **105**, **106** and corresponding sensor **115**, **116** may be reversed, the source located on the PCB **118**, and the sensor on the top plate **109**. Also as is understood by those of skill in the art, alternative locations intermediate the PCB and on the top plate may also be employed for mounting the sources and sensors.

10 Referring to FIGS. **9** and **13-15**, in another aspect, a data transfer interface electrical connector **130** of the transfer station **100** is illustrated for mating with the external data transfer interface electrical connector **48** of the portable data storage cartridge **40**, of FIGS. **1-7**. The transfer station **100** releasably, repeatably provides an electrical coupling with respect to the cartridge external data transfer interface, which comprises a substrate **71** having a plurality of
15 substantially flat electrical contacts **51** on a substantially flat facing surface **50** thereof, the substrate mounted in a portable cartridge **40** capable of being engaged by a loader.

The electrical connector **130** comprises an elastomeric compression element **132** having a plurality of protruding compression members **133** supported by a reference plate **134**. Preferably, the compression element is fixed to the reference plate **134**. As examples, the compression
20 element may be cemented, bonded, or vulcanized to the reference plate. The compression element is positioned at a rear surface **135** of a matching circuitized flexible substrate **136**, which preferably comprises a termination of a flex cable **138**. The matching circuitized flexible substrate **136** has electrical contacts **141** on a facing surface **140** thereof, the electrical contacts **141** arranged to match the portable cartridge electrical contacts **51** when in a face-to-face
25 relationship. The protruding compression members **133** of the compression element **132** are facing and in contact with the rear surface **135**, such that the individual compression members **133** are registered with the corresponding individual electrical contacts **141**.

The compression element **132** is generally of the type described in U.S. Patents 4,902,234; 5,059,129; 5,873,740; or 5,947,750.

30 At least ones of the electrical contacts **141** of the matching circuitized flexible substrate **136** of flex cable **138**, and corresponding ones of the electrical contacts **51** of the substantially flat substrate facing surface **50** of the flex cable **65** of FIG. **4**, comprise elongated contacts, the

contacts **141** each registering with two adjacent individual compression members **133** of the elastomeric compression element **132**. In this manner, the elongated contacts comprise redundant contacts over two compression members, and have matching contact surfaces which are at least twice as great in surface area as a single contact of the size of a single compression member.

Thus, in the electrical connector **130**, the circuitized flexible substrate **136** is positioned on the elastomeric compression element **132** such that a rear surface of the substrate is in contact with the compression members **133**, and the elongated contacts **141** on the facing surface **140** of the substrate are registered with two adjacent individual compression members **133**. Further, in the electrical connector **48**, when the substrate **71** is registered in face-to-face relation with the facing surface **140** of the mating electrical connector **130**, the elongated contacts **51** are each positioned to overlie two adjacent individual compression members **133**, and with the elongated electrical contacts **51** in releasable contact with corresponding elongated contacts **141**.

The elongated contacts **51**, **141** registering with two adjacent compression members **133** provide redundant contacts with independent normal force generation. Specifically, each adjacent compression member provides the contact normal force to a discrete region of the elongated pad, and the ability of each region to make reliable contact can be considered independent and therefore redundant. For well designed electrical contacts operating at an intrinsic failure rate (FR), the effect of adding redundant contacts is to reduce the overall contact failure rate. The effective failure rate (EFR) for multiple contacts in parallel can be estimated by dividing the failure rate (FR) by the number of contacts in parallel. Specifically, $(EFR) = (FR) / (\# \text{ of contacts in parallel})$. Thus, as shown by the equation, the additional of a second, redundant contact reduces the effective failure rate of a contact by about $\frac{1}{2}$.

The effect of redundant contacts on the plug dependent failure rate, or the ability of a contact to make electrical contact during first plugging follows a similar equation. Therefore, two contacts in parallel provide a higher probability of successfully plugging an electrical connector, and, hence, the data handling device.

As with respect to the electrical contacts **51** of flex cable **65** of FIG. 4, the electrical contacts **141** of the substantially flat substrate facing surface **140** may comprise pads containing gold, and preferably comprise copper pads on which are plated a diffusion barrier, such as nickel, and Type II, or "hard", gold pads plated on the diffusion barrier, but which are plated to a thickness greater than standard, for example, to a thickness of substantially 100 micro inches.

The diffusion barrier is preferably plated to a thickness greater than 50 micro inches. Preferably, the gold pads are electrolytically plated.

The electrical contacts **141** may also alternatively comprise other materials, such as pads containing palladium, such as palladium or palladium-nickel, and may have a gold “flash” layer.

5 The electrical contacts **141** preferably are substantially flat, having substantially flat contact surfaces on the pads. Alternatively, the electrical contacts **141** may comprise shaped contacts having shaped surfaces on the pads, as discussed above.

10 The flex cable **138** comprises a plurality of lands coupled to the electrical contacts **141** of the facing surface **140** at the termination **136**, and are coupled to the PCB **118** of FIG. **12** at connector **145** at termination **146** of the flex cable.

15 In another aspect, alignment, or registration, holes **155** and **156** are provided in close proximity to the electrical contacts **141**. The flex cable termination **136** is aligned and the electrical contacts **141** registered with respect to the compression members **133** at the time of assembly by use of a probe inserted through holes **157** and **158** of the termination **136** and into
20 holes **155** and **156**, respectively, and the flex cable termination is tightened to a predetermined amount at the compression members. As will be discussed, the matching circuitized flexible substrate **136** is tightened only sufficiently to attain registration, while issuing from the elastomeric compression element **132** without an immediate change in direction, and subsequently forming a gradual curve **160**, **161** in a direction normal to the facing surface **140**.
25 Then, clamps **162** and **163** are bolted into place to hold the circuitized flexible substrate in place. In the illustrated example, clamp **162** holds the flex cable at tail **164**, and clamp **163** holds the flex cable **138**. As will be discussed, when the external interface of the portable data storage cartridge is registered with the matching circuitized flexible substrate electrical contacts **141**, a loader exerts a force on the portable cartridge normal to the facing surface **140**, compressing the
30 elastomeric compression element **132** between the matching circuitized flexible substrate **136** and the reference plate **134**. The arrangement of the matching circuitized flexible substrate **136** to issue from the elastomeric compression element **132** without an immediate change in direction and subsequently form the gradual curve **160**, **161** in a direction normal to the facing surface **140**, allows the substrate to move freely in the normal direction without pulling in the lateral direction.
This creates a non-wiping contact between the electrical contacts **51** of the portable cartridge substrate **50** of FIG. **1** and the electrical contacts **141** of the matching circuitized flexible substrate **136**, thereby forming a releasable, repeatable electrical connection therebetween.

In another aspect, referring additionally to FIG. 18, the transfer station 100 additionally comprises alignment pins 165 and 166 for mating with respective registration holes 55 and 56 of the portable data storage cartridge 40 of FIG. 1 to register the external data transfer interface electrical connector 48 with the station data transfer electrical connector interface 130. Both alignment pins are aligned substantially normal to the facing surface 140 of the matching circuitized flexible substrate 136, and are tapered at the ends 167 and 168, respectively, to a rounded point in the direction of the portable cartridge substrate 50 to orient the portable cartridge substrate and gradually laterally align the portable cartridge substrate and the matching circuitized flexible substrate 136. To prevent tolerance buildup between the alignment pins and the respective registration holes, alignment pin 165 is preferably cylindrical, the same as the corresponding registration hole 55, and of a slightly lesser diameter. As an example, the alignment pin may have a diameter 5% less than that of the registration hole. However, alignment pin 166 is instead a non-round pin, such as a "diamond" pin, as is known to those of skill in the art, and is substantially narrower than pin 165, but of the same height. Thus, the external interface electrical connector 48 of the portable data storage cartridge 40 is properly registered in the vertical direction at both ends by the alignment pins and is properly registered in the horizontal direction by the alignment pin 165.

In another aspect, referring to FIGS. 15 and 20, the facing surface 140 of the matching circuitized flexible substrate is oriented parallel to gravity, and the cartridge loader is oriented to provide the "normal" force orthogonal to gravity, to minimize debris deposition on the facing surface 140.

In another aspect, and additionally referring to FIG. 16, when registered and aligned with the transfer station, the backing plate 70 of the portable data storage cartridge 40 of FIGS. 6 and 7 is in contact with the alignment pins 165 and 166 at registration holes 55 and/or 56. As discussed above, the backing plate 70, and therefore the registration holes 55 and 56 are electrically coupled to the data storage device, such as magnetic data storage drive 60, by means of land 85 of the flex cable, to a ground thereof, thereby forming an electrostatic discharge path from the data storage device to the backing plate and through the electrically semiconductive material to the alignment pins. The data storage device, since it is within a portable data storage cartridge, is not externally grounded and, as such, comprises an electrostatic source in the cartridge. The alignment pins 165 and 166 are conductive and coupled to a ground path 169, via

support member **170**, thereby forming an electrostatic discharge path from the registration holes **55** and **56** of the portable data storage cartridge **40** to the ground path **169**.

Referring to FIGS. **10** and **17-20**, a loader of the transfer station **100** is illustrated which loads the portable data storage cartridge, exerting a force normal to the facing surface **140** of the flex cable **138** of FIG. **15**. FIGS. **17** and **18** illustrate a cartridge **40** at the end of travel in the receiver **103** at the stops (only stop **122** is shown), and before the cartridge is loaded. FIGS. **10**, **19** and **20** illustrate a cartridge that has been loaded. FIG. **20** also illustrates the flex cable **138** as arranged to loop over and outside the mechanism of the transfer station **100** to the PCB **118**, thereby both allowing ease of assembly and of replacement of both the PCB and the flex cable.

The loading mechanism is initially at an "insert" position with motor **180** having operated through gear train **181** to rotate bell crank **182** toward the front of the transfer station **100**. Bell crank **182** has thus pushed beam **184** toward the front of the transfer station, which pushed arm **185** of receiver **103**, and therefore the receiver **103** towards the front opening **120** of the transfer station. Guides **186** and **187** of the arm **185** ride in slots **188** and **189** of the transfer station and movably support the receiver **103** as it moves forward and backwards. An engagement arm **190** is attached to the receiver **103** at pivot **191**, and includes a guide **192** which moves in slot **195** of the transfer station. As is understood by those of skill in the art, the guides, arms, beams and slots are the same on each side of the receiver **103**. Also as is understood by those of skill in the art, differing arrangements of guides, arms, beams and slots may be employed in accordance with the present invention.

When the receiver **103** is in the "insert" position toward the front opening **120** of the transfer station, slot **195** pulls guide **192** down, away from the receiver **103**. An engagement pin **200** is located on the same shaft as guide **192**, on the opposite side of arm **190**, and protrudes toward the interior of the receiver **103**. Thus, as the guide **192** is pulled down by slot **195**, the engagement pin **200** is also pulled down, out of the interior of the receiver **103**. This allows a portable data storage cartridge to be inserted into the receiver.

The loader is enabled by the sensor **116** of FIG. **12**, which, as discussed above, identifies the differentiated identification of the data storage cartridge, indicating the presence of the portable data storage cartridge **40** at the end of travel in the receiver **103**.

The sensor **116** enables motor **180** to operate through gear train **181** to rotate bell crank **182** away from the front, and toward the rear, of the transfer station **100**. Bell crank **182** thus pulls beam **184** toward the rear of the transfer station, which pulls arm **185** of receiver **103**, and

therefore the receiver **103**, towards the rear of the transfer station. As the receiver **103** is pulled toward the rear of the transfer station, slot **195** elevates guide **192** up, toward the receiver **103**, such that engagement pin **200** is elevated into the receiver **103**, where it engages the portable cartridge **40** of FIG. **1** at notches **58** and **59**. As the receiver continues to be pulled toward the rear of the transfer station, the engagement pins **200** exert a force on the portable cartridge **40** normal to the facing surface **140** of the matching circuitized flexible substrate **136**. First, the alignment pins **165** and **166** engage corresponding holes **55** and **56** of the cartridge to orient the portable cartridge substrate and gradually laterally align the portable cartridge substrate and the matching circuitized flexible substrate **136**, registering the cartridge substrate electrical contacts **51** in face-to-face relation with the matching circuitized flexible substrate electrical contacts **141**. Then the engagement pins exert the normal force on the portable cartridge and cause the portable cartridge substrate **50** (and backing plate **70**) to compress the elastomeric compression element **132** between the matching circuitized flexible substrate **136** and reference plate **134** to create non-wiping contact between the electrical contacts **51** of the portable cartridge substrate **50** and the electrical contacts **141** of the matching circuitized flexible substrate **136**, thereby forming a releasable, repeatable electrical connection therebetween.

As an example, the force generated by the loader may comprise at least 30 grams per compression member, for a total normal force greater than 10 pounds on the cartridge, and compresses the compression element a depth of about .022 inches. In loading the cartridge, the motor **180** rotates bell crank **182** beyond the center of rotation to a stop, at an over-center position, so that the arm tends to be locked in position to prevent inadvertent release of the cartridge. The motor releases the cartridge by rotating back over center and then towards the front opening **120** of the transfer station. Referring to FIGS. **19** and **20**, in one embodiment, bell crank **182** is rotated beyond the center of rotation to a stop **193**. In an alternative embodiment, bell crank **182** is rotated until beam **184** contacts the pivot end of bell crank **182**, such that beam **184** becomes a stop. When against the stop, the bell crank **182** is locked under pressure, providing the normal force to compress the compression element **132**.

Referring to FIGS. **13** and **18**, ribs **202** and **203** are provided at the edges of the compression element **132** to lightly clamp the flex cable substrate **136** of FIG. **14** to help restrain any lateral movement of the flex cable substrate as the individual compression members are compressed under the contacts **141** of the interface.

Surface **171** and **172** straddle the flex cable substrate **136** and butt up to the “H” beam **70** of the cartridge of FIG. **6** or the interface **48** of the cartridge of FIG. **1**, and limit the compression of the compression members along the outer rows as the motor **180** of FIG. **10** rotates bell crank **182** to the loaded position.

5 In another aspect, additionally referring to FIG. **21**, the external data transfer interface electrical connector **48** of the portable data storage cartridge **40**, in addition to coupling with the data handling agent, or data storage device, such as magnetic data storage drive **60**, to provide data transfer with the contacted transfer station **100**, comprises a power transfer interface coupled by one or more lands **209** of the flex cable to a power input **210** of the data handling agent to
10 transfer power from the transfer station **100** to the data handling agent.

In a further aspect, the power transfer interface additionally both verifies electrical contact between the data handling agent and the transfer station before supplying full power, and when applying power, gradually ramps the application of power.

Specifically, a transfer station power supply provides power at input **220** for the cartridge
15 **40**. A trickle circuit **222** limits current flow to output **215**, and to the data handling agent when electrical contact is first made between contacts **141** of the transfer station **100** and contacts **51** of the cartridge **40**. Before contact is made, no current flows, and output **215** is at the same voltage as power input **220**, which voltage is detected by a detector **228**. As soon as contact is made, a small current flows to the data handling agent and back to ground **221**, limited by the trickle
20 circuit **222**, reducing the voltage at output **215**, detected by detector **228**. Thus, detector **228** detects the current flow to the cartridge **40**, thereby verifying electrical contact between the data handling agent and the transfer station.

Once electrical contact is verified, the detector **228** enables ramping circuit **230** to initially operate gate **233** to gate a small amount of power to output **215**, and then gradually
25 ramping gate **233** to ramp up to full power. As the power is ramped up, the voltage at output **215** is increased, and may be detected by detector **228**. Thus, optionally, detector **228** may be employed to detect any problems during application of full power evidenced by a change in voltage at output **215**, and operate ramping circuit **230** to open gate **233**. An example of gate **233** is an FET. Detector **128** also detects “unmating”, or release of the cartridge **40** when the
30 electrical contact is unmade, and operates ramping circuit **230** to open gate **233**. A fusing circuit **234** may be employed to limit transfer of excessive power to the cartridge **40**. The electrical contact verification and the gradual ramping of power insure that the active data handling

element or data storage device in the cartridge **40** is protected from electrical spikes which could otherwise damage the device.

FIGS. **22** and **23** illustrate portable data storage cartridges containing alternative data handling or data storage devices. FIG. **22** illustrates a portable data storage cartridge **40** of FIG. **1** containing a non-volatile solid state memory assembly **240**. The solid state memory assembly may advantageously comprise an “off the shelf” device, such as are readily available. FIG. **23** illustrates a portable data storage cartridge of FIG. **1** containing an optical disk drive assembly **250**. Currently, commercially available optical disk drives would have to be modified to employ a non-removable optical disk. Other data handling devices may occur to those of skill in the art.

While the preferred embodiments of the present invention have been illustrated in detail, it should be apparent that modifications and adaptations to those embodiments may occur to one skilled in the art without departing from the scope of the present invention as set forth in the following claims.

CLAIMS

We claim:

1. A transfer station (100) for releasably, repeatably electrically coupling with respect to a
5 substrate (50) having a plurality of electrical contacts (51) on a substantially flat facing surface
thereof, said substrate mounted in a portable cartridge (40) capable of being engaged by a loader,
comprising:
 - a matching circuitized flexible substrate (136) having electrical contacts (141) on a facing
surface thereof, said electrical contacts arranged to match said portable cartridge electrical
10 contacts when in a face-to-face relationship;
 - an elastomeric compression element (132) having a plurality of protruding compression
members positioned at a rear surface of said matching circuitized flexible substrate and said
protruding compression members facing and in contact with said rear surface, individual said
compression members registered with corresponding individual said electrical contacts;
 - 15 a reference plate (134) for supporting said elastomeric compression element; and
 - a loader for engaging said portable cartridge, registering said cartridge substrate electrical
contacts in face-to-face relation with said matching circuitized flexible substrate electrical
contacts, and exerting a force on said portable cartridge normal to said facing surface of said
matching circuitized flexible substrate to cause said portable cartridge substrate to compress said
20 elastomeric compression element between said matching circuitized flexible substrate and said
reference plate to create non-wiping contact between said electrical contacts of said portable
cartridge substrate and said electrical contacts of said matching circuitized flexible substrate,
thereby forming a releasable, repeatable electrical connection therebetween.
- 25 2. The transfer station of Claim 1, wherein said electrical contacts of said matching
circuitized flexible substrate comprise pads containing gold.
3. The transfer station of Claim 2, wherein said matching circuitized flexible substrate
comprises copper pads on which are plated a diffusion barrier, and Type II gold pads plated on
30 said diffusion barrier.

4. The transfer station of Claim 3, wherein said gold pads are plated to a thickness greater than standard.

5. The transfer station of Claim 1, wherein said electrical contacts of said matching
5 circuitized flexible substrate comprise pads containing palladium.

6. The transfer station of Claim 2, wherein said cartridge loader is arranged to provide said normal force in the amount of at least 30 grams per individual compression member.

10 7. The transfer station of Claim 1, wherein at least ones of said electrical contacts of said matching circuitized flexible substrate comprise elongated contacts, each registering with two adjacent said individual compression members of said elastomeric compression element.

8. The transfer station of Claim 1, wherein said reference plate is substantially flat,
15 providing substantially uniform support of said elastomeric compression element.

9. The transfer station of Claim 1, additionally comprising alignment pins in close proximity to said elastomeric compression element, said alignment pins aligned substantially normal to said facing surface of said matching circuitized flexible substrate for mating with
20 corresponding alignment holes of said portable cartridge to laterally align said portable cartridge substrate and said matching circuitized flexible substrate.

10. The transfer station of Claim 9, wherein said alignment pins are tapered to a rounded point in the direction of said portable cartridge substrate to orient said portable cartridge substrate
25 and gradually laterally align said portable cartridge substrate and said matching circuitized flexible substrate.

11. The transfer station of Claim 9, wherein said alignment pins extend beyond said matching circuitized flexible substrate a distance sufficient to contact a cartridge failing to have
30 said alignment holes, to protect said matching circuitized flexible substrate from contact with said cartridge.

12. The transfer station of Claim 9, wherein said alignment pins are conductive and coupled to ground to discharge any electrostatic charge at said corresponding alignment holes of said portable cartridge.

5 13. The transfer station of Claim 1, wherein said facing surface of said matching circuitized flexible substrate is oriented parallel to gravity, and said cartridge loader is oriented to provide said force orthogonal to gravity, to minimize debris deposition on said facing surface.

10 14. The transfer station of Claim 1, wherein said matching circuitized flexible substrate comprises a termination of a flex cable.

15 15. The transfer station of Claim 14, wherein said flex cable issues from said elastomeric compression element without an immediate change in direction, and subsequently forming a gradual curve in said normal direction to maintain symmetrical force on said matching circuitized flexible substrate as said elastomeric compression element is compressed.

16. The transfer station of Claim 1, wherein said electrical contacts of said matching circuitized flexible substrate are substantially flat.

20 17. The transfer station of Claim 1, wherein said electrical contacts of said matching circuitized flexible substrate comprise shaped contacts.

25 18. The transfer station of Claim 1, wherein said loader comprises at least one bell crank which rotates to an over-center position, thereby exerting said force on said portable cartridge.

19. An electrical connector, comprising:

an elastomeric compression element having a plurality of protruding compression members; and

30 a circuitized flexible substrate having electrical contacts on a facing surface thereof, at least one of said electrical contacts comprising an elongated contact, said substrate positioned on said elastomeric compression element such that a rear surface thereof is in contact with said protruding compression members, and with individual said electrical contacts registered with

corresponding individual said protruding compression members, and with said at least one elongated contact registered with two adjacent said individual protruding compression members.

20. The electrical connector of Claim **19**, wherein said electrical contacts of said circuitized
5 flexible substrate facing surface comprise pads containing gold.

21. The electrical connector of Claim **20**, wherein said circuitized flexible substrate facing
surface electrical contacts comprise copper pads on which are plated a diffusion barrier, and
Type II gold pads plated on said diffusion barrier.

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22. The electrical connector of Claim **21**, wherein said gold pads are plated to a thickness
greater than standard.

23. The electrical connector of Claim **19**, wherein said electrical contact of said circuitized
15 flexible substrate facing surface comprise pads containing palladium.

24. The electrical connector of Claim **19**, additionally comprising a reference plate
positioned at a rear surface of said elastomeric compression element for supporting said
elastomeric compression element.

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25. The electrical connector of Claim **24**, wherein said reference plate is substantially flat,
providing substantially uniform support of said elastomeric compression element.

26. The electrical connector of Claim **24**, for mating with a mating electrical connector,
25 additionally comprising a loader for engaging said mating electrical connector and exerting a
force on said mating electrical connector normal to said facing surface of said circuitized flexible
substrate to cause said mating electrical connector to compress said elastomeric compression
element between said circuitized flexible substrate rear surface and said reference plate.

30 27. The electrical connector of Claim **26**, wherein said loader is arranged to provide said
normal force in the amount of at least 30 grams per individual compression member.

28. The electrical connector of Claim **19**, additionally comprising alignment pins in close proximity to said elastomeric compression element, said alignment pins aligned substantially normal to said facing surface of said circuitized flexible substrate for mating with corresponding alignment holes of a mating electrical connector to laterally align said mating electrical connector and said circuitized flexible substrate facing surface.

29. The electrical connector of Claim **27**, wherein said alignment pins are conductive and coupled to ground to discharge any electrostatic charge at said corresponding alignment holes of said mating electrical connector.

30. The electrical connector of Claim **19**, wherein said facing surface of said circuitized flexible substrate is oriented parallel to gravity to minimize debris deposition on said facing surface.

31. The electrical connector of Claim **19**, wherein said circuitized flexible substrate comprises a termination of flex cable.

32. The electrical connector of Claim **31**, wherein said flex cable issues from said elastomeric compression element without an immediate change in direction, and subsequently forming a gradual curve in said normal direction to maintain symmetrical force on said flex cable at said facing surface upon compression of said elastomeric compression element.

33. The electrical connector of Claim **19**, wherein at least one of said electrical contacts of said facing surface is coupled to a source of data, and wherein at least another of said electrical contacts of said facing surface is coupled to a power supply.

34. The electrical connector of Claim **19**, wherein said at least one elongated electrical contact of said circuitized flexible substrate is substantially flat.

35. The electrical connector of Claim **19**, wherein said at least one elongated electrical contact of said circuitized flexible substrate comprises a shaped contact.

36. A portable cartridge for mating with a transfer station, said transfer station having a data transfer interface with electrical contacts on a compression element and having a cartridge loader, said cartridge comprising:

a data handling agent;

5 a substrate having electrical contacts on a substantially flat facing surface thereof, said electrical contacts arranged to match said transfer station data transfer interface electrical contacts when in a face-to-face relationship, said substantially flat substrate coupled to said data handling agent; and

a cartridge shell supporting said data handling agent and said substantially flat substrate,
10 said cartridge shell having at least one engagement surface for engagement by said cartridge loader in said transfer station, whereby said cartridge loader may engage said cartridge, register said cartridge electrical contacts in face-to-face relation with said transfer station data transfer interface electrical contacts, and exert a force on said cartridge normal to said facing surface of said transfer station data transfer interface to cause said portable cartridge substrate to compress
15 said compression element to create non-wiping contact between said electrical contacts of said portable cartridge substrate and said transfer station data transfer interface facing surface, and forming a releasable, repeatable electrical connection therebetween.

37. The portable cartridge of Claim **36**, wherein said electrical contacts of said substantially
20 flat substrate facing surface comprise pads containing gold.

38. The portable cartridge of Claim **37**, wherein said substantially flat substrate facing surface electrical contacts comprise copper pads on which are plated a diffusion barrier, and Type II gold pads plated on said diffusion barrier.

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39. The portable cartridge of Claim **38**, wherein said gold pads are plated to a thickness greater than standard.

40. The portable cartridge of Claim **36**, wherein said electrical contacts of said substantially
30 flat substrate facing surface comprise pads containing palladium.

41. The portable cartridge of Claim 36, wherein at least ones of said electrical contacts of said substantially flat substrate facing surface comprise elongated contacts.

42. The portable cartridge of Claim 36, wherein said transfer station additionally comprises alignment pins, said portable cartridge additionally comprising alignment holes in close proximity to said substantially flat substrate, said alignment holes arranged for mating with corresponding said transfer station alignment pins to laterally align said portable cartridge substrate and said transfer station data transfer interface facing surface.

43. The portable cartridge of Claim 36, wherein said substantially flat substrate comprises: a backing plate; and a termination of a flex cable mounted on said backing plate, and forming said substantially flat facing surface, said flex cable coupled to said data handling agent.

44. The portable cartridge of Claim 43, wherein said flex cable comprises a plurality of lands coupled to said flat electrical contacts of said facing surface at said termination, and wherein said flex cable is also coupled to a power input of said data handling agent to provide power from said transfer station to said data handling agent.

45. The portable cartridge of Claim 36, wherein said electrical contacts of said substantially flat substrate facing surface are substantially flat.

46. The portable cartridge of Claim 36, wherein said electrical contacts of said substantially flat substrate facing surface comprise shaped contacts.

47. A matching electrical connector for mating with an electrical connector having electrical contacts on a facing surface of a substrate, said substrate overlying protruding compression members of a compression element, said matching electrical connector comprising:

a substrate having a substantially flat facing surface thereof; and

5 a plurality of electrical contacts on said substantially flat facing surface of said substrate, at least one of said electrical contacts comprising an elongated contact which, when said substrate is registered in face-to-face relation with said mating electrical connector facing surface, is positioned to overlie two adjacent said individual protruding compression members of said mating electrical connector compression element.

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48. The matching electrical connector of Claim 47, wherein said electrical contacts comprise pads containing gold.

49. The matching electrical connector of Claim 48, wherein said electrical contacts comprise
15 copper pads on which are plated a diffusion barrier, and Type II gold pads plated on said diffusion barrier.

50. The matching electrical connector of Claim 49, wherein said gold pads are plated to a thickness greater than standard.

20

51. The matching electrical connector of Claim 47, wherein said electrical contacts comprise pads containing palladium.

52. The matching electrical connector of Claim 47, wherein said substrate comprises:

25

a backing plate; and

a termination of a flex cable mounted on said backing plate, and forming said substantially flat facing surface.

53. The matching electrical connector of Claim 52, wherein said backing plate is arranged to
30 support said flex cable termination and to transmit an applied force to said flex cable termination, when registered in said face-to-face relation, to thereby exert said applied force toward said mating electrical connector facing surface.

54. The matching electrical connector of Claim 47, wherein said substrate is arranged, when registered in said face-to-face relation, to exert an applied force toward said mating electrical connector facing surface.

5

55. The matching electrical connector of Claim 47, wherein said at least one elongated electrical contact is substantially flat.

56. The matching electrical connector of Claim 47, wherein said at least one elongated

10 electrical contact comprises a shaped contact.