

CABLE ASSEMBLY PROCEDURE

P/N 26-008X-0670

PAGE 1 OF 1 DATE: 08/18/99

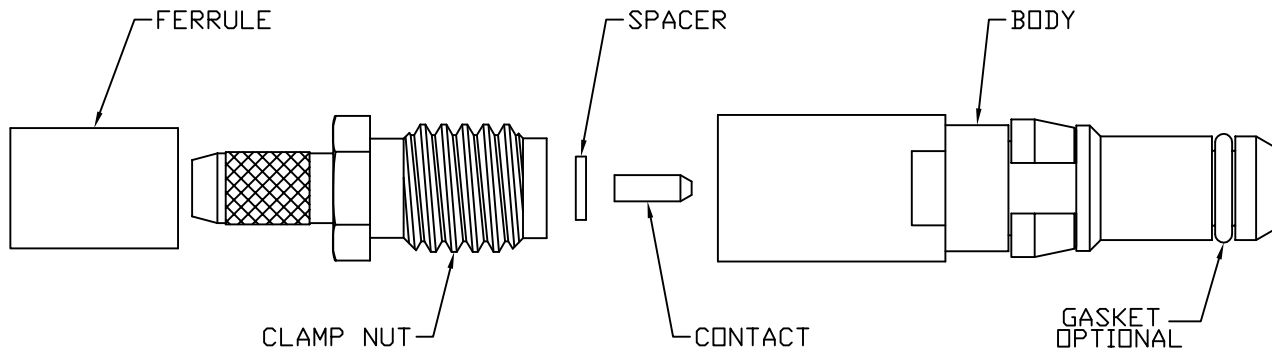
DRAWN: EK APPROVED: JEM

FOR USE WITH RG-316 CABLE

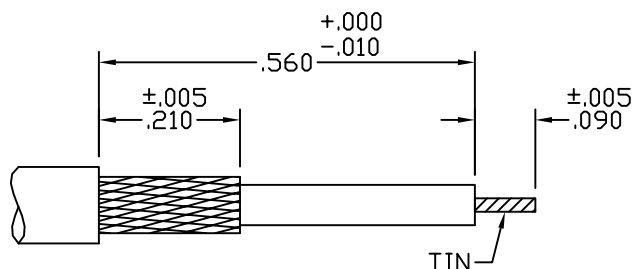
PALEO CONNECTOR

22 GREAT HILL ROAD, NAUGATUCK, CT. 06770
 PHONE: (203) 729-9090 FAX: (203) 723-1794

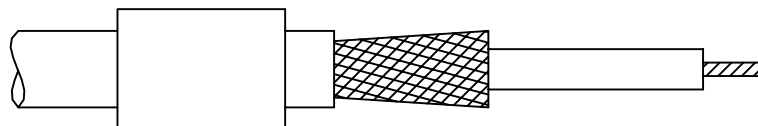
REV	DESCRIPTION	DATE	APPR
N	PER ECN 7705	11/19/04	JEM
D	PER ECN 10128	12/15/09	JEM
P	PER ECN 10292	04/20/10	JEM
R	PER ECN 10690	11/08/10	JEM



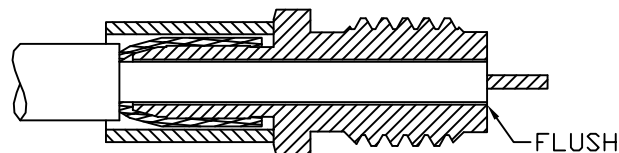
STEP 1
 TRIM CABLE TO DIMENSIONS SHOWN.
 TIN CENTER CONDUCTOR AND CLEAN
 SOLDER JOINT.



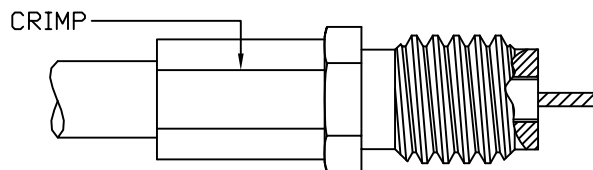
STEP 2
 SLIDE FERRULE OVER CABLE
 AND FLAIR BRAID BY ROTATING
 DIELECTRIC.



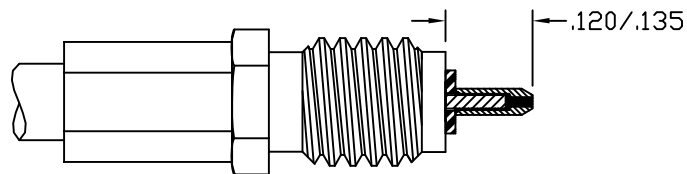
STEP 3
 INSERT THE BARREL OF THE CRIMP NUT BETWEEN
 THE BRAID AND DIELECTRIC, POSITIONED SO THAT
 THE END OF THE CABLE DIELECTRIC IS FLUSH
 WITH THE END OF THE CRIMP NUT.



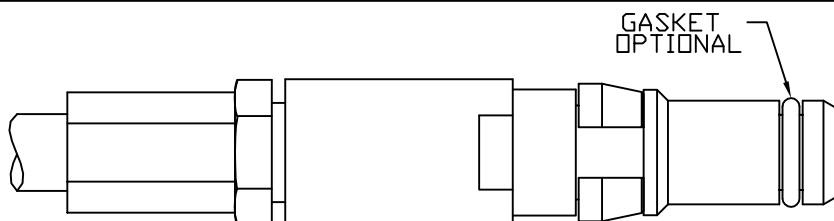
STEP 4
 SLIDE THE FERRULE AGAINST THE SHOULDER
 OF THE CRIMP NUT AND CRIMP USING .128 HEX
 DIE (M22520/5-03).



STEP 5
 PLACE THE SPACER AGAINST THE CRIMP
 NUT. SLIDE THE BULLET OVER THE CENTER
 CONDUCTOR. USING RESISTANCE SOLDERING
 TWEEZERS, APPLY HEAT TO THE BULLET
 TO REFLOW THE SOLDER, CLEAN SOLDER JOINT.



STEP 6
 THREAD CONNECTOR BODY ONTO
 THE CRIMP NUT ASSEMBLY,
 TIGHTEN TO 7-10 IN-LBS.



INTERFACE DESIGN STANDARD		PALEO CONNECTOR	REV	DESCRIPTION	DATE	APPR
IDS-26			D	PER ECN 6752	10/24/02	HN
PAGE 1 OF 2	DATE: 02/28/94		E	PER ECN 7265	01/27/04	HN
DRAWN: JEM	APPROVED: HN	22 GREAT HILL ROAD, NAUGATUCK, CT. 06770 PHONE: (203) 729-9090 FAX: (203) 723-1794	F	PER ECN 9935	05/22/09	JEM
			G	PER ECN 10145	01/20/10	JEM

DESCRIPTION: 26 SERIES, SIZE 8 PkZ®

MECHANICAL

MATERIALS

BODIES:

PLUG BODIES - BRASS PER ASTM B 16.
RECEPTACLE BODIES - BRASS PER ASTM B 16.

PLATING:

GOLD PER MIL-G-45204.
COPPER PER MIL-C-14550.
NICKEL PER QQ-N-290.

INSULATORS - VIRGIN TEFLON (PTFE) PER ASTM D 1710 AND ASTM D 1457.
RETAINING RING - BERYLLIUM COPPER PER ASTM B 196.
MALE CONTACT - BERYLLIUM COPPER PER ASTM B 197.
FEMALE CONTACTS - BERYLLIUM COPPER PER ASTM B 197.
WEATHER SEAL GASKET (OPTIONAL) - SILICONE RUBBER PER ZZ-R-765.
EMI GASKET - BERYLLIUM COPPER ASTM B 196.

FINISHES (ADD LETTER TO END OF PART NUMBER)

"A" - .000050 MIN. GOLD OVER NICKEL
"B" - .000030 MIN. GOLD OVER NICKEL
"C" - .000050 MIN. GOLD OVER COPPER
"D" - .000030 MIN. GOLD OVER COPPER

MATING CHARACTERISTICS

OUTER BODIES _____ 3 LBS MAX. INSERTION.
2 OZ. MIN. WITHDRAWAL.
CENTER CONTACTS _____ 32 OZ. MAX. INSERTION.
.5 OZ. MIN. WITHDRAWAL.
HOUSING RETENTION _____ 12 LBS. MIN.
AXIAL MATING TOLERANCE _____ .090

ELECTRICALS

FREQUENCY RANGE: DC TO 32 GHz.
VOLTAGE RATING STRAIGHT: 1000 VRMS.
VOLTAGE RATING ANGLED: 800 VRMS.
CURRENT RATING: 5 AMPS.
INSULATION RESISTANCE: 2000 MEGOHMS MIN.
INSERTION LOSS: .06 $\sqrt{f(\text{GHz})}$ dB

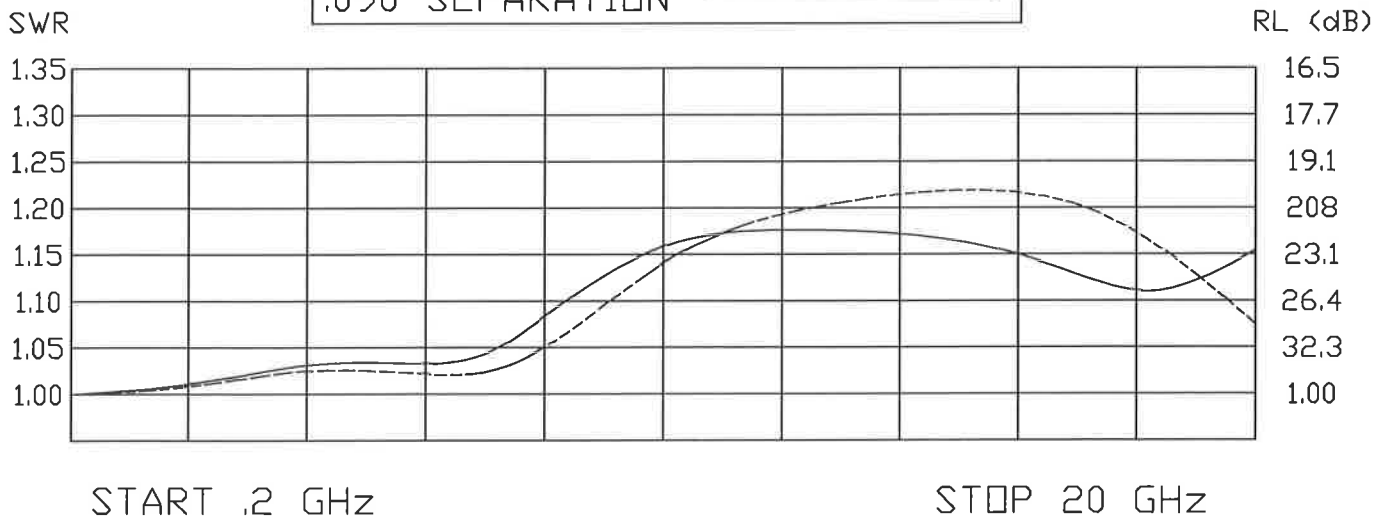
CONTACT RESISTANCE: CENTER CONTACT 5 MILLIOHMS
CONTACT RESISTANCE: OUTER CONTACT 3 MILLIOHMS
VSWR: 1.08 + .009(f) GHz., RG-402 CABLE.
1.15 + .02 (f) GHz., RG-174 & RG-316 CABLES.
1.15 + .01 (f) GHz., RG-142, 223, 303 & 400 CABLES.

ENVIRONMENTAL

OPERATING TEMPERATURE: -65°C to +165°C
VIBRATION: MIL-STD-202, METHOD 204, TEST CONDITION D.
SHOCK: MIL-STD-202, METHOD 213, TEST CONDITION I.
SALT SPRAY: MIL-STD-1344, METHOD 1001, CONDITION B.
DURABILITY: 500 CYCLES.

THERMAL SHOCK: MIL-STD-202, METHOD 107, TEST CONDITION B, EXCEPT HIGH TEMPERATURE SHALL BE +85°C.
MOISTURE RESISTANCE: MIL-STD-202, METHOD 106.
NO MEASUREMENT AT HIGH HUMIDITY. INSULATION RESISTANCE 2000 MEGOHMS AFTER HUMIDITY.

FULL MATING _____
.090 SEPARATION _____



INTERFACE DESIGN STANDARD	
IDS-26	
PAGE 2 OF 2	DATE: 06/28/94
DRAWN: JEM	APPROVED: HN

PALEO
CONNECTOR

22 GREAT HILL ROAD, NAUGATUCK, CT. 06770
PHONE: (203) 729-9090 FAX: (203) 723-1794

REV	DESCRIPTION	DATE	APPR
D	PER ECN 6752	10/24/02	HN
E	PER ECN 7625	01/27/04	HN
F	PER ECN 9935	05/22/09	JEM
G	PER ECN 10145	01/20/10	JEM

DESCRIPTION: 26 SERIES, PKZ® SIZE 8

	INCH	[mm]	SUFFIX
A	.250	[6.35]	MIN.
B	ϕ $\frac{.153}{.156}$	$\frac{[3.89]}{[3.96]}$	
C	$\frac{.126}{.132}$	$\frac{[3.20]}{[3.35]}$	MIN.
D	ϕ .206	[5.23]	

PLUG

	INCH	[mm]	SUFFIX
A	.245	[6.22]	MIN.
B	$\frac{.143}{.147}$	$\frac{[3.63]}{[3.73]}$	
C	ϕ .206	[5.23]	
D	ϕ $\frac{.0395}{.0410}$	$\frac{[1.00]}{[1.04]}$	
E	ϕ .157	[3.99]	MIN.

RECEPTACLE