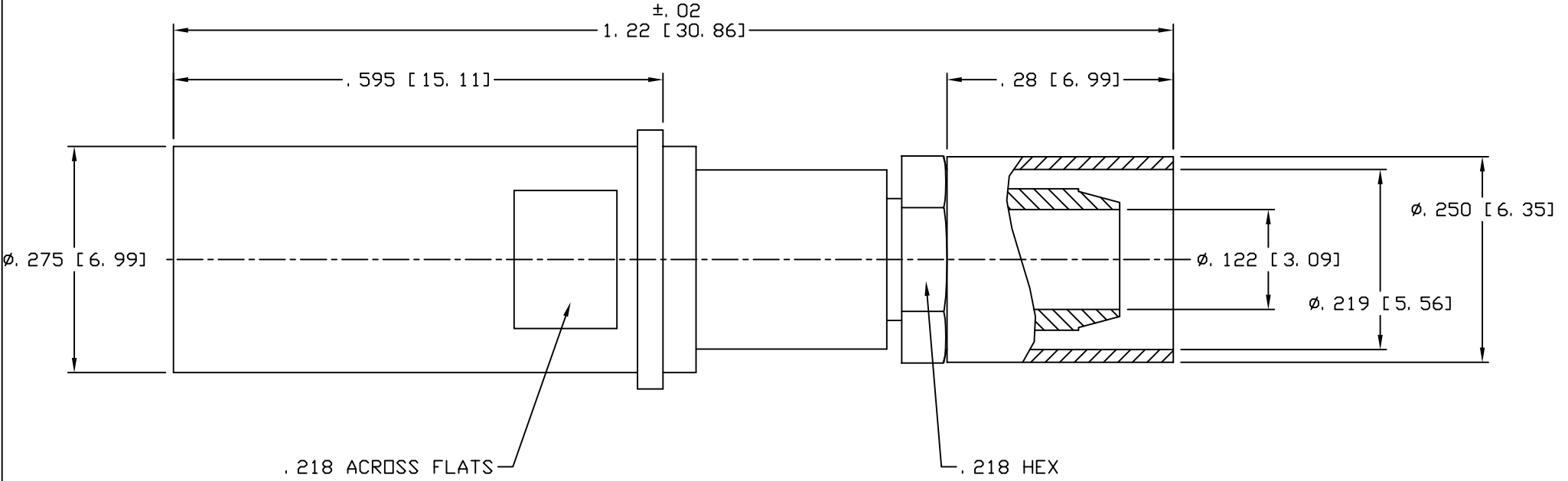
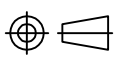


CAD DRAWING - NO MANUAL REVISIONS



**NOTES:**

1. FOR USE IN ARINC 600 CONNECTOR PER MIL-C-83527/3 AND INSERT PER MIL-STD-1842, 11-20T4 OR 11-20T6.
2. INSERTION/WITHDRAWAL TOOL T 0617 REQUIRED TO INSERT AND REMOVE CONTACT FROM HOUSING.
3. ACCOMMODATES RG-55A, RG-142, RG-223 AND TIMES AA-6597 CABLES.
4. CRIMP USING .213 HEX DIE ( M22520/5-05 ).
5. DESIGN AND INTERFACE PER I. D. S. -68.

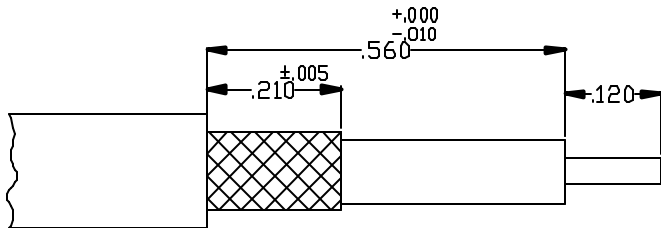
E	PER ECN 9688	12/09/08	JEM	<b>PALCO CONNECTOR</b> 22 GREAT HILL RD., NAUGATUCK, CT 06770 UNLESS OTHERWISE SPECIFIED, PALCO WORKMANSHIP STANDARDS APPLY TOLERANCES ON: DECIMALS: XX ±.01 .XXX ±.005 ANGLES ±1/2° 32' DIMENSIONS IN INCHES OR (METRIC) DO NOT SCALE PRINTS	DRAWN JEM	CHECKED HN	ENGINEER JEM	APPROVED HN	FSCM 58167
D	PER ECN 8031	06/16/05	JM		 DESCRIPTION PKZ, STR. RECT. CRIMP TYPE FOR ARINC				
C	PER ECN 3826	04/09/97	HN			DATE 02/28/95	DRAWING NO. 68-1080-1201	PLATING OPT. A, B, C, D	
B	PER ECN 3655	11/18/96	HN						
A	RELEASED	02/28/95	HN						
REV.	DESCRIPTION	DATE	APPR.	EPR 5919					

CABLE ASSEMBLY PROCEDURE	
P/N	68-1080-1201 A/B/C/D
PAGE 1 OF 1	DATE: 2/12/97
DRAWN: IY	APPROVED: HN
FOR USE WITH RG-55A, 142, 223 CABLE	

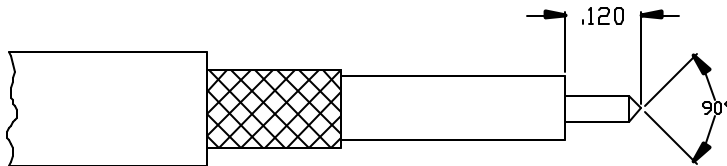
**PALEO**  
**CONNECTOR**

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

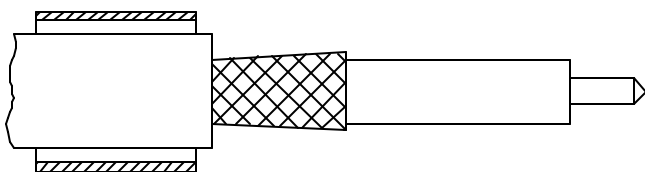
REV	DESCRIPTION	DATE	APPR
C	PER ECN 3826	04/09/97	HN
D	PER ECN 8031	06/16/05	JM
E	PER ECN 9688	12/09/08	JEM



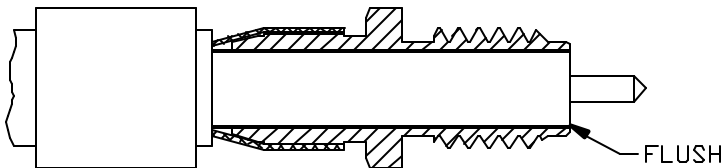
STEP 1.  
STRIP CABLE TO DIMENSIONS SHOWN.



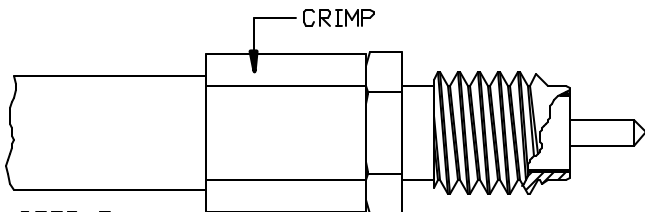
STEP 2.  
TRIM CABLE TO NEW DIMENSIONS.  
POINT CENTER CONDUCTOR AS SHOWN.



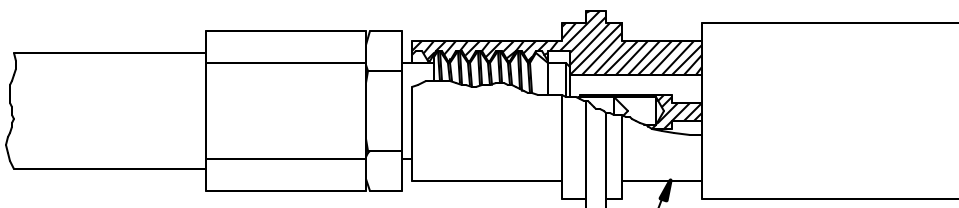
STEP 3.  
SLIDE FERRULE OVER CABLE. FLARE BRAID BY ROTATING DIELECTRIC.



STEP 4.  
INSERT THE BARREL OF THE CRIMP NUT BETWEEN THE CABLE BRAID AND DIELECTRIC.  
POSITION SO THAT THE END OF THE CABLE DIELECTRIC IS FLUSH WITH THE END OF  
CRIMP NUT.



STEP 5.  
SLIDE FERRULE AGAINST SHOULDER AND CRIMP USING .213 HEX DIE(M22520/5-05) AND Y-197 DIE SET.



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

INTERFACE DESIGN STANDARD	
IDS-68	
PAGE 1 OF 2	DATE: 06/29/99
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
B	PER ECN 9588	10/27/08	HN
C	PER ECN 9935	05/22/09	JEM
D	PER ECN 10145	01/20/10	JEM
E	PER ECN 11479	10/19/12	JEM

DESCRIPTION: 68 SERIES, SIZE 8 PKZ®, FOR ARINC

**MECHANICAL**

**MATERIALS**

**BODIES:**

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

**PLATING:**

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

INSULATORS - TEFLON (PTFE) PER 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. WITHDRAWL.  
CENTER CONTACTS \_\_\_\_\_ 32 OZ. MAX. INSERTION.  
.5 OZ. MIN. WITHDRAWL.  
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.  
INSERION 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: -55°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.

