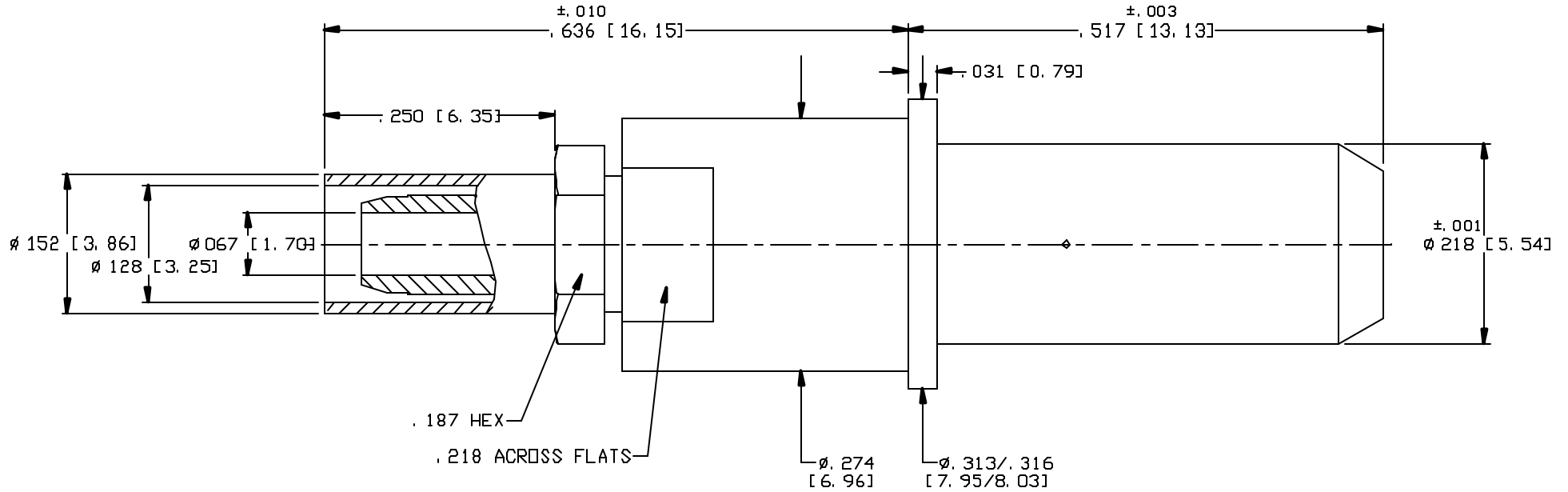
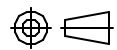


CAD DRAWING - NO MANUAL REVISIONS



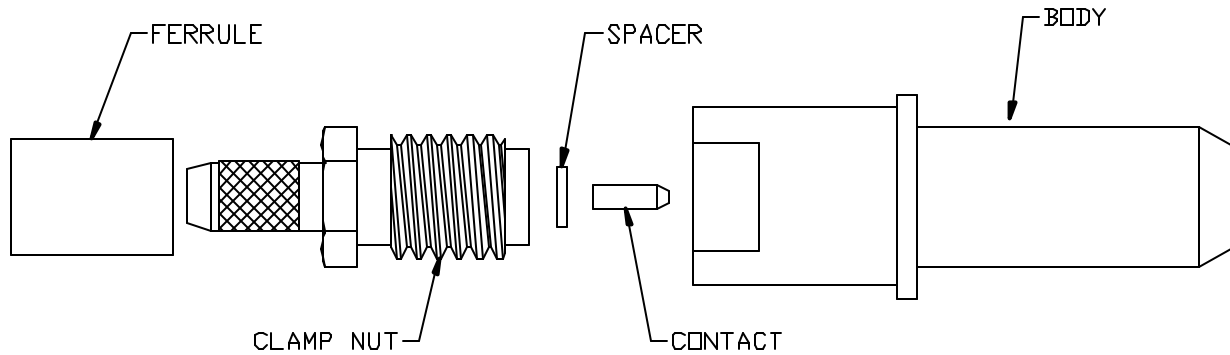
NOTES:

1. DESIGN AND INTERFACE PER I. D. S. -78.
2. DESIGN TO FIT MIL-C-38999 HOUSING, (SIZE 8 CAVITY).
3. BULLET, FERRULE, CRIMP NUT & SPACER SHIPPED LOOSE.
4. ACCOMMODATES M17/113-RG316 OR SIMILAR CABLES.
5. CRIMP USING .128 HEX DIE (M22520/5-03).

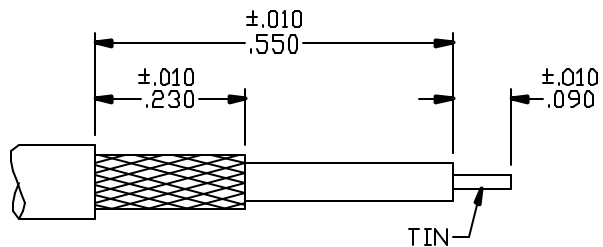
E	PER ECN 10962	05/17/11	JEM	PALCO CONNECTOR 22 GREAT HILL RD., NAUGATUCK, CT 06770 UNLESS OTHERWISE SPECIFIED, PALCO WORKMANSHIP STANDARDS APPLY TOLERANCES ON: DECIMALS: XX ±.01 .XXX ±.005 ANGLES ±1/2° 32' DIMENSIONS IN INCHES OR (METRIC) DO NOT SCALE PRINTS	DRAWN	CHECKED	ENGINEER	APPROVED	FSCM
D	PER ECN 10125	12/10/09	JEM		JEM	HN	JEM	HN	58167
C	PER ECN 6696	08/02/02	HN		 DESCRIPTION PKZ PLUG CRIMP/CLAMP				
B	PER ECN 6614	5/14/02	HN						
A	REL. ECN 4640	08/17/98	HN		DATE	DRAWING NO.	PLATING OPT.		
REV.	DESCRIPTION	DATE	APPR.	EPR 10176 MOTOROLA	08/17/98	78-0080-0670	A, B, C, D		

THE INFORMATION IN THIS DOCUMENT IS CONFIDENTIAL AND PROPRIETARY AND MAY NOT BE USED FOR ANY PURPOSE WITHOUT THE WRITTEN CONSENT OF PALCO.

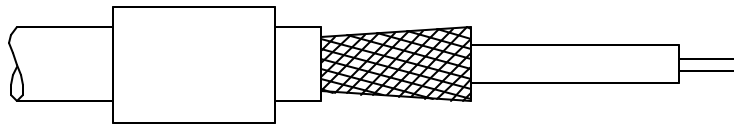
CABLE ASSEMBLY PROCEDURE		<p style="text-align: center;">PALEO</p> <p style="text-align: center;">CONNECTOR</p> <p>22 GREAT HILL ROAD, NAUGATUCK, CT. 06770 PHONE: (203) 729-9090 FAX: (203) 723-1794</p>	REV	DESCRIPTION	DATE	APPR
P/N	78-0080-0670		B	PER ECN 6614	05/14/02	HN
PAGE 1 OF 1	DATE: 08/17/98		C	PER ECN 6696	08/02/02	HN
DRAWN: JEM	APPROVED: HN		D	PER ECN 10125	12/10/09	JEM
FOR USE WITH M17/113-RG316 CABLE			E	PER ECN 10962	05/17/11	JEM



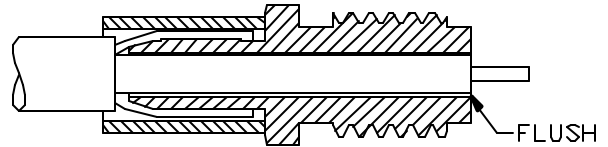
STEP 1
TRIM CABLE TO DIMENSIONS SHOWN.
TIN CENTER CONDUCTOR AND CLEAN
SOLDER JOINT.



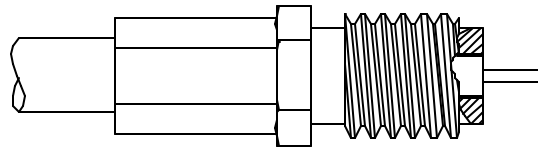
STEP 2
SLIDE FERRULE OVER CABLE
AND FLAIR BRAID BY ROTATING
DIELECTRIC.



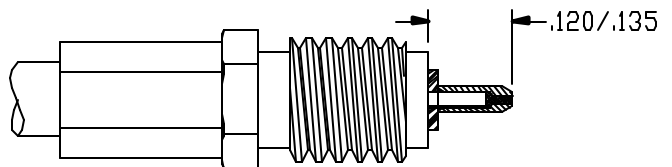
STEP 3
INSERT THE BARREL OF THE CRIMP NUT BETWEEN
THE BRAID AND DIELECTRIC, POSITIONED SO THAT
THE END OF THE CABLE DIELECTRIC IS FLUSH
WITH THE END OF THE CRIMP NUT.



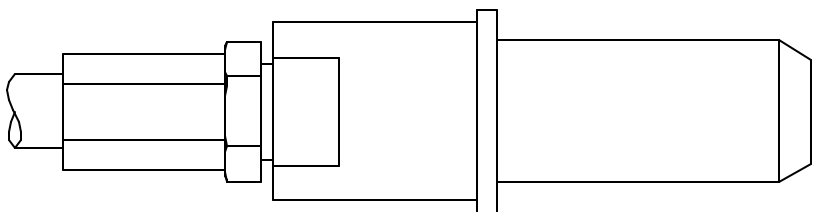
STEP 4
SLIDE THE FERRULE AGAINST THE SHOULDER
OF THE CRIMP NUT AND CRIMP USING .128 HEX
DIE (M22520/5-03).



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	
IDS-78	
PAGE 1 OF 2	DATE: 06/16/98
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 5123	06/29/99	HN
C	PER ECN 9935	05/22/09	JEM
D	PER ECN 10145	01/20/10	JEM

DESCRIPTION: 78 SERIES, SIZE 8 PKZ® , FOR MIL-C-38999

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.
GROUNDING RING - BERYLLIUM COPPER PER 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

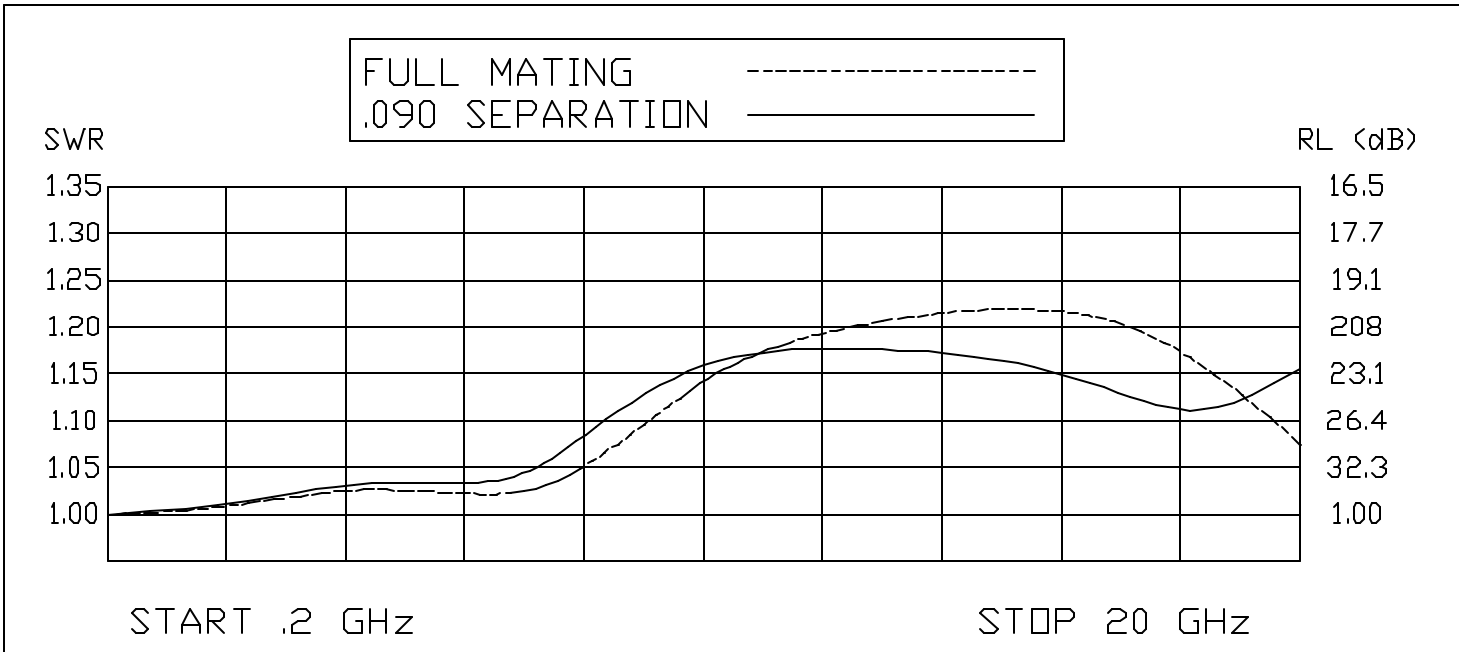
FREQUENCY RANGE: DC TO 32 GHz.
VOLTAGE RATING STRAIGHT: 1000 VRMS.
VOLTAGE RATING ANGLED: 800 VRMS.
CURRENT RATING: 5 AMPS.
INSULATION RESISTANCE: 2000 MEGOHMS MIN.
INSERION LOSS: $.06 \sqrt{f(\text{GHz})}$ dB

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: MEL-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.



INTERFACE DESIGN STANDARD	
IDS-78	
PAGE 2 OF 2	DATE: 06/16/98
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PALEO
CONNECTOR

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

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