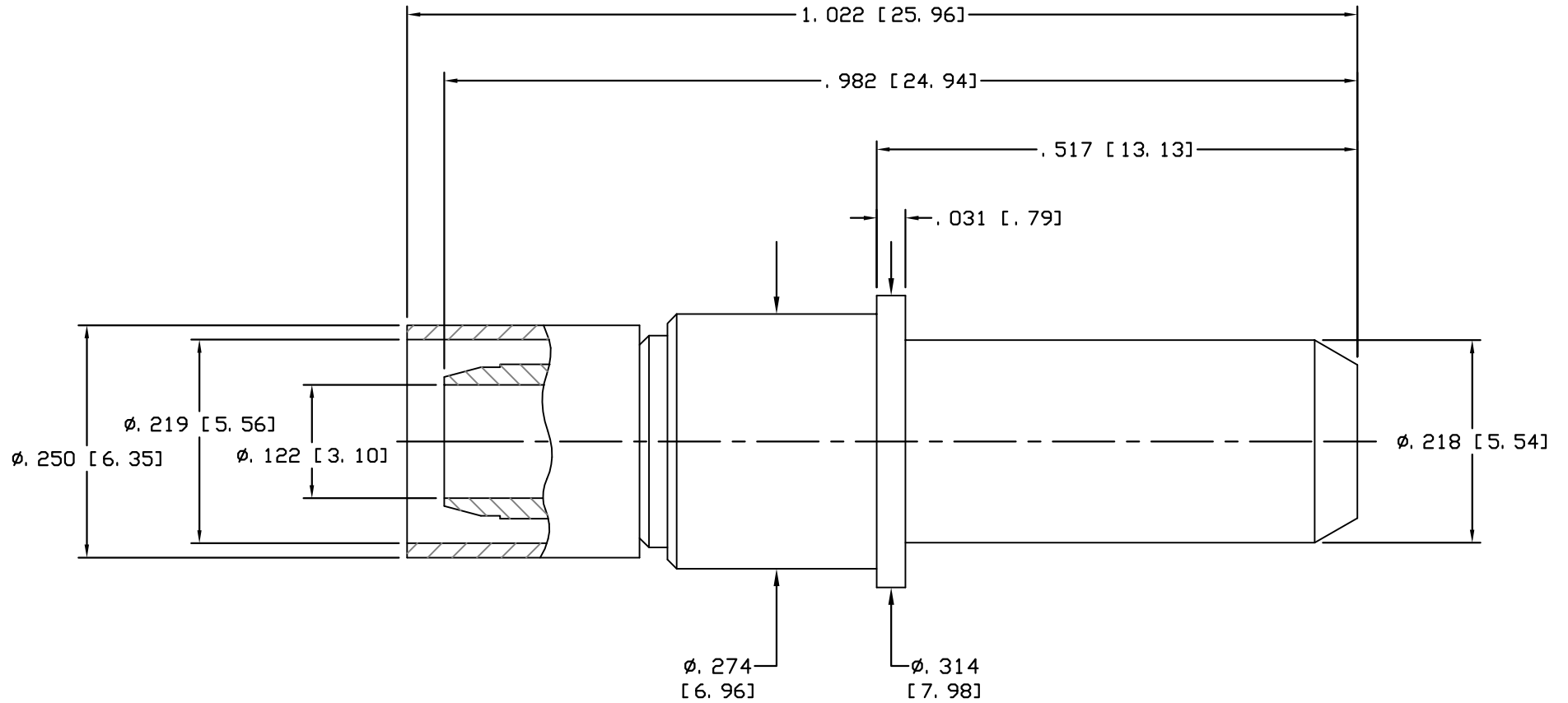


CAD DRAWING - NO MANUAL REVISIONS



**NOTES:**

1. DESIGN AND INTERFACE PER I. D. S. -78.
2. DESIGN TO FIT MIL-C-38999, SERIES I, III & IV HOUSINGS.
3. FERULLE IS SHIPPED LOOSE.
4. ACCOMMODATES SFT-142B OR SIMILAR CABLES.
5. CRIMP USING .213 HEX DIE (M22520/5-02).

**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<sub>v</sub>  
 DIMENSIONS IN INCHES OR (METRIC) DO NOT SCALE PRINTS

DRAWN  
MS

CHECKED  
JEM

ENGINEER  
MS

APPROVED  
JEM

FSCM  
58167



DESCRIPTION  
PKZ PLUG  
CRIMP TYPE

DATE  
09/23/10

DRAWING NO.  
78-0080-2203

PLATING OPT.  
A, B, C, D

REV.	DESCRIPTION	DATE	APPR.
B	PER ECN 11642	04/17/13	JEM
A	PER ECN 10901	03/22/11	JEM

CABLE ASSEMBLY PROCEDURE

P/N 78-0080-2203

PAGE 1 OF 1 DATE: 09/23/10

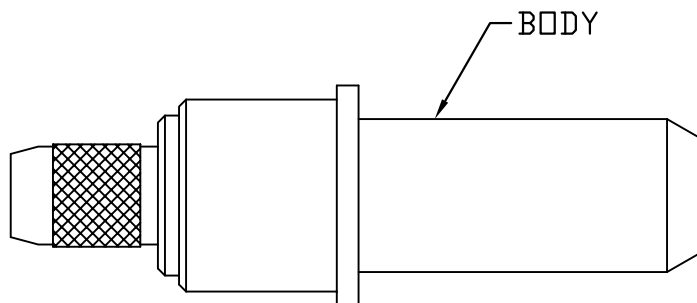
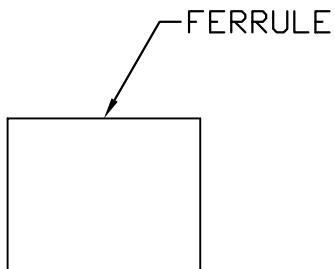
DRAWN: MS APPROVED: JEM

FOR USE WITH SFT-142B CABLE

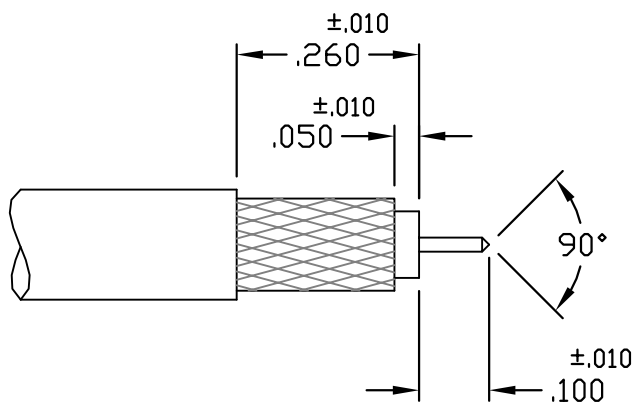
**PALEO**  
CONNECTOR

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

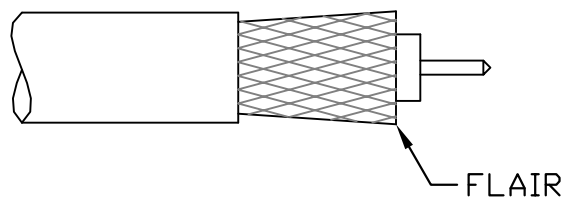
REV	DESCRIPTION	DATE	APPR
A	PER ECN 10901	03/22/11	JEM
B	PER ECN 11642	04/17/11	JEM



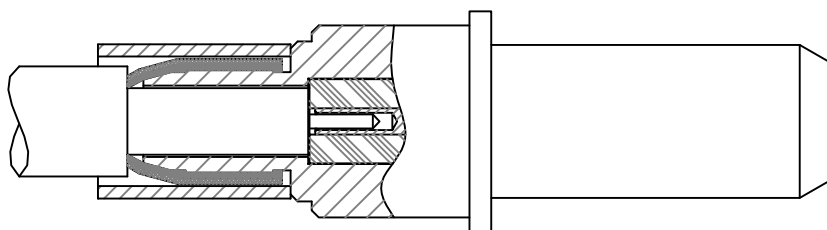
STEP 1  
TRIM CABLE TO DIMENSIONS  
SHOWN. POINT CENTER CONDUCTOR.



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



STEP 3  
SLIDE CABLE INTO BACK  
OF CONNECTOR UNTIL  
CABLE BOTTOMS. SLIDE  
FERRULE INTO POSITION  
AND CRIMP USING A .213  
HEX DIE (M22520/5-05).





INTERFACE DESIGN STANDARD	
IDS-78	
PAGE 2 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, PKZ<sup>®</sup> SIZE 8, FOR MIL-C-38999

