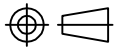


NOTES:

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 RD-316 OR SIMILAR CABLES.
5. CRIMP USING .151 HEX DIE (M22520/5-37).

E	PER ECN 11753	08/15/13	JEM	<p>PALCO CONNECTOR</p> <p>22 GREAT HILL RD., NAUGATUCK, CT 06770</p> <p>UNLESS OTHERWISE SPECIFIED, PALCO WORKMANSHIP STANDARDS APPLY</p> <p>TOLERANCES ON: DECIMALS: XX ±.01 .XXX ±.005 ANGLES ±1/2° 32'</p> <p>DIMENSIONS IN INCHES OR (METRIC) DO NOT SCALE PRINTS</p>	DRAWN	CHECKED	ENGINEER	APPROVED	FSCM	
D	PER ECN 10666	11/01/10	JEM		YT	HN	YT	HN	58167	
C	PER ECN 10124	12/10/09	JEM		 DESCRIPTION PkZ PLUG CRIMP/CLAMP					
B	PER ECN 6696	08/02/02	HN							
A	REL. ECN 6620	05/16/02	HN		DATE	DRAWING NO.	PLATING OPT.			
REV.	DESCRIPTION	DATE	APPR.	05/16/02	78-0080-2670	A, B, C, D				

CABLE ASSEMBLY PROCEDURE

P/N 78-0080-2670

PAGE 1 OF 1 DATE: 05/16/02

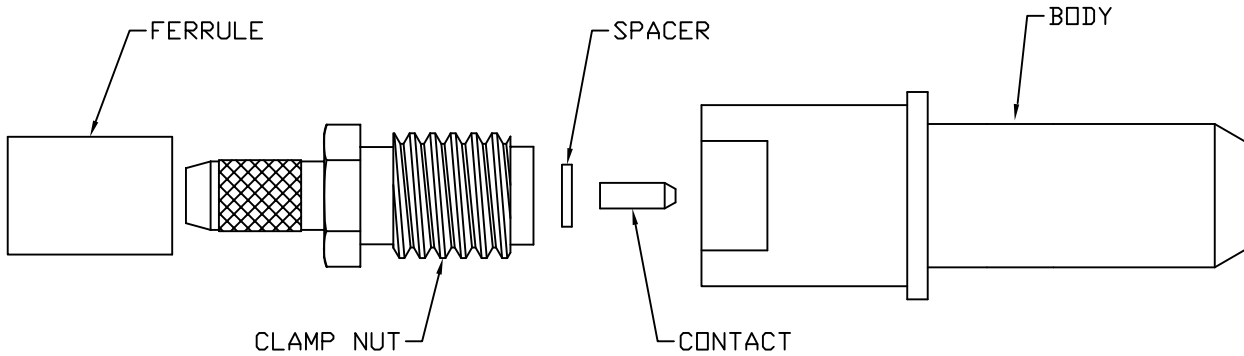
DRAWN: YT APPROVED: HN

FOR USE WITH RD-316 CABLE

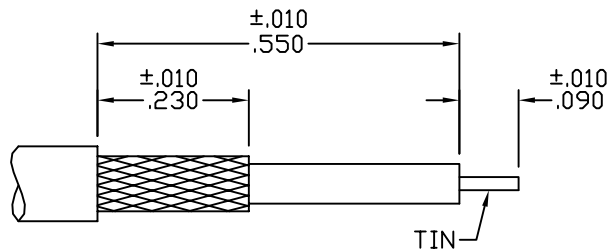
PALCO
CONNECTOR

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

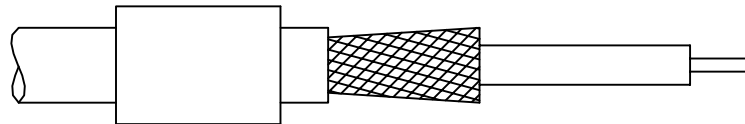
REV	DESCRIPTION	DATE	APPR
B	PER ECN 6696	08/02/02	HN
C	PER ECN 10124	12/10/09	JEM
D	PER ECN 10666	11/01/10	JEM
E	PER ECN 11753	08/15/13	JEM



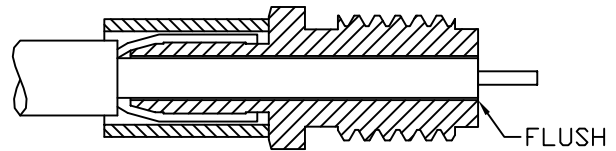
STEP 1
TRIM CABLE TO DIMENSIONS SHOWN.
TIN CENTER CONDUCTOR AND CLEAN
SOLDER JOINT.



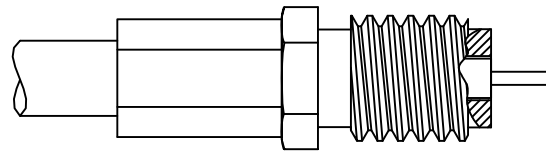
STEP 2
SLIDE FERRULE OVER CABLE
AND FLAIR BRAID BY ROTATING
DIELECTRIC.



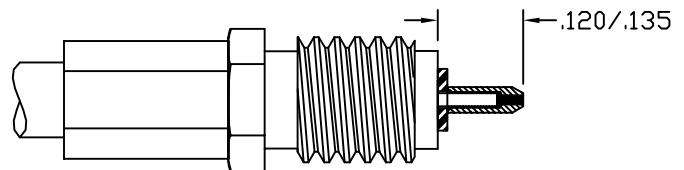
STEP 3
INSERT THE BARREL OF THE CRIMP NUT
BETWEEN THE BRAID AND DIELECTRIC,
POSITIONED SO THAT THE END OF
THE CABLE DIELECTRIC IS FLUSH
WITH THE END OF THE CRIMP NUT.



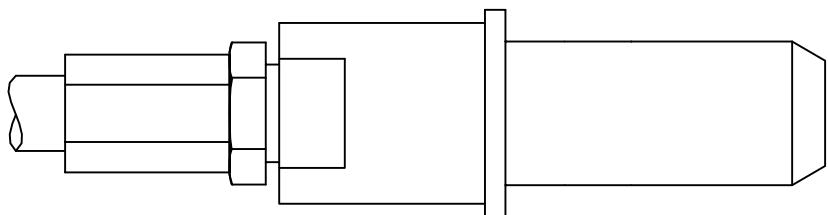
STEP 4
SLIDE THE FERRULE AGAINST THE
SHOULDER OF THE CRIMP NUT AND
CRIMP USING .151 HEX DIE (M22520/5-37).



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 2 OF 2	DATE: 06/16/98
DRAWN: JEM	APPROVED: HN

PALEO
CONNECTOR

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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[®] SIZE 8, FOR MIL-C-38999

