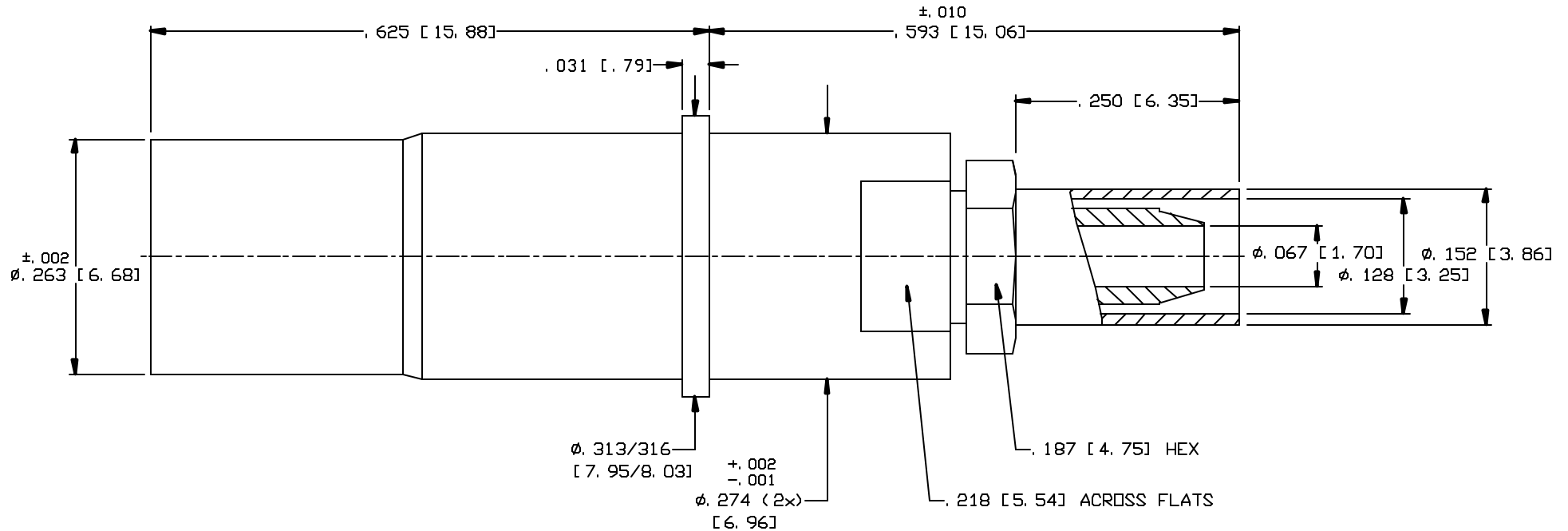


CAD DRAWING - NO MANUAL REVISIONS

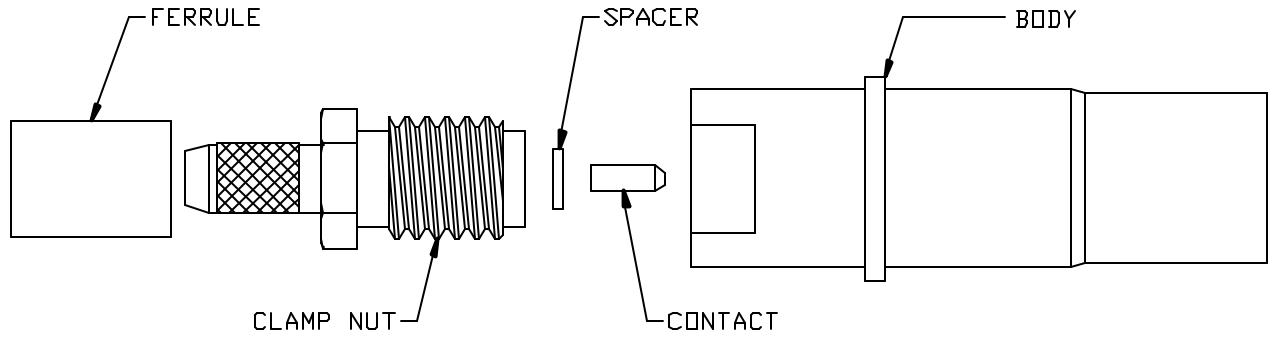


NOTES:

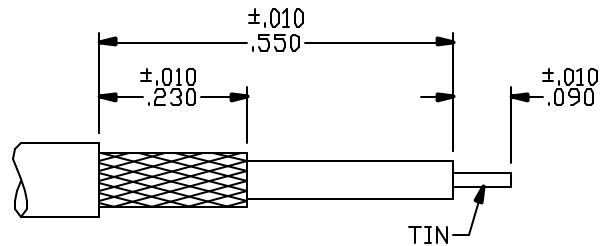
1. DESIGN AND INTERFACE PER I. D. S. -78.
2. DESIGN TO FIT MIL-C-38999, (SIZE 8 CAVITY).
3. BULLET, CRIMP NUT, FERRULE & SPACER SHIPPED LOOSE.
4. ACCOMMODATES M17/113-RG316 OR SIMILAR CABLES.
5. CRIMP USING .128 HEX DIE (M22520/5-03).

				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 JEM	CHECKED HN	ENGINEER JEM	APPROVED HN	FSCM 58167
D	PER ECN 10928	04/11/11	JEM			DESCRIPTION: PKZ RECEPTACLE CRIMP/CLAMP TYPE			
C	PER ECN 9681	12/08/08	JEM			DATE 05/13/98	DRAWING NO. 78-1080-0670	PLATING OPT. A, B, C, D	
B	PER ECN 7110	07/22/03	HN						
A	REL. ECN 5658	05/13/98	HN						
REV.	DESCRIPTION	DATE	APPR.	CATALOG ITEM					

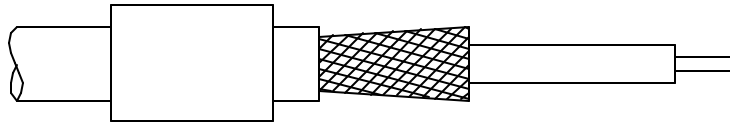
CABLE ASSEMBLY PROCEDURE		PALEO CONNECTOR 22 GREAT HILL ROAD, NAUGATUCK, CT. 06770 PHONE: (203) 729-9090 FAX: (203) 723-1794	REV	DESCRIPTION	DATE	APPR
P/N	78-1080-0670		B	PER ECN 7110	07/22/03	HN
PAGE 1 OF 1	DATE: 07/22/03		C	PER ECN 9681	12/08/08	JEM
DRAWN: YT	APPROVED: HN		D	PER ECN 10928	04/11/11	JEM
FOR USE WITH M17/113-RG316 CABLE						



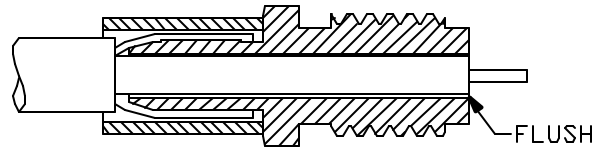
STEP 1
 TRIM CABLE TO DIMENSIONS SHOWN.
 TIN CENTER CONDUCTOR AND CLEAN
 SOLDER JOINT.



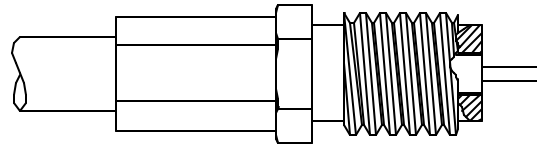
STEP 2
 SLIDE FERRULE OVER CABLE
 AND FLAIR BRAID BY ROTATING
 DIELECTRIC.



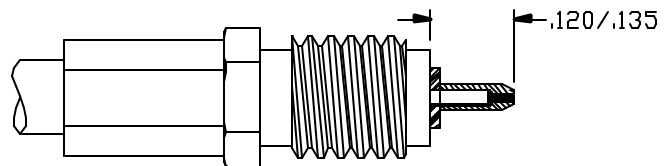
STEP 3
 INSERT THE BARREL OF THE CRIMP NUT BETWEEN
 THE BRAID AND DIELECTRIC, POSITIONED SO THAT
 THE END OF THE CABLE DIELECTRIC IS FLUSH
 WITH THE END OF THE CRIMP NUT.



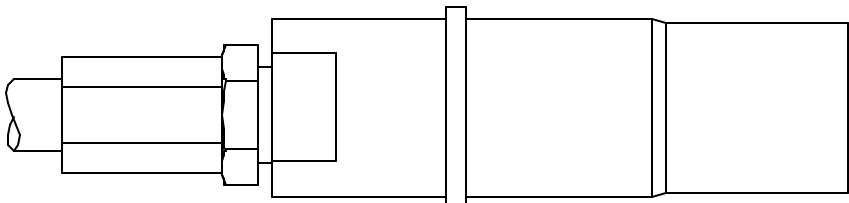
STEP 4
 SLIDE THE FERRULE AGAINST THE SHOULDER
 OF THE CRIMP NUT AND CRIMP USING .128 HEX
 DIE (M22520/5-03).



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.

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.

PLATING:

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

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

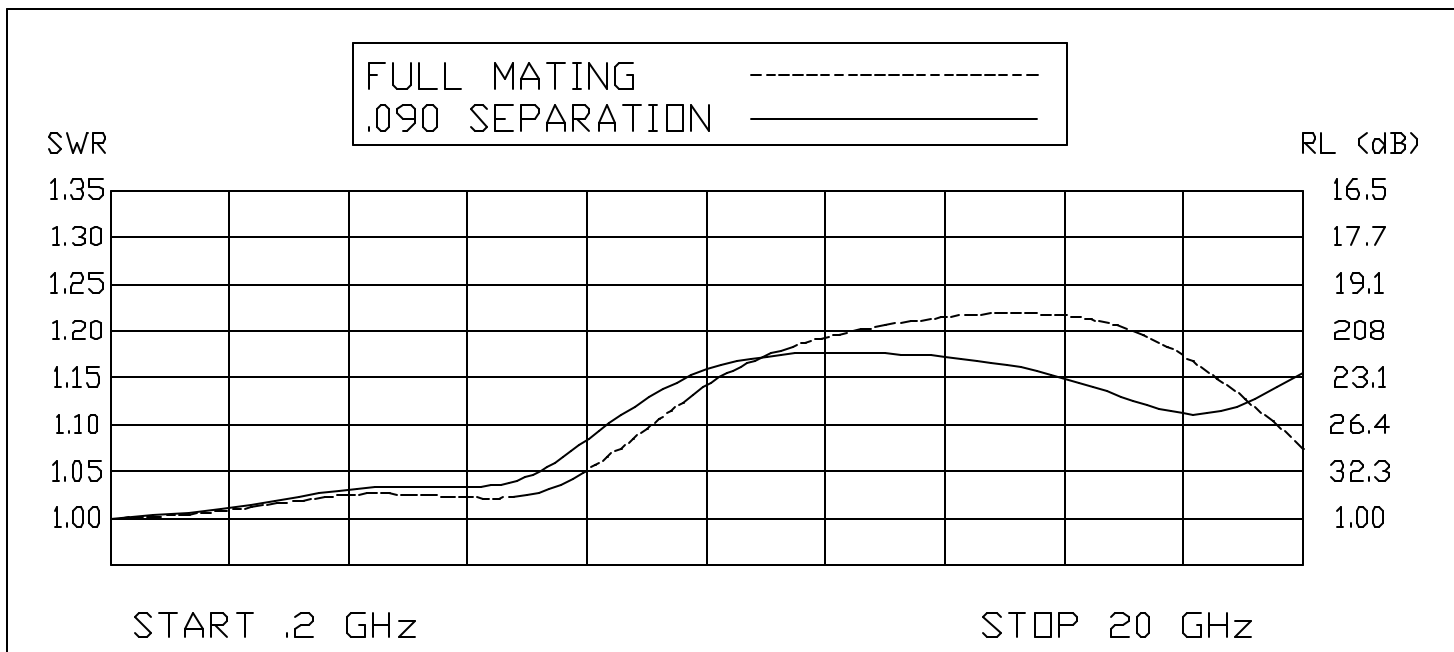
FREQUENCY RANGE: DC TO 32 GHz.
VOLTAGE RATING STRAIGHT: 1000 VRMS.
VOLTAGE RATING ANGLED: 800 VRMS.
CURRENT RATING: 5 AMPS.
INSULATION RESISTANCE: 2000 MEGOHMS MIN.
INSERION LOSS: .06 $\sqrt{f(\text{GHz})}$ dB

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

