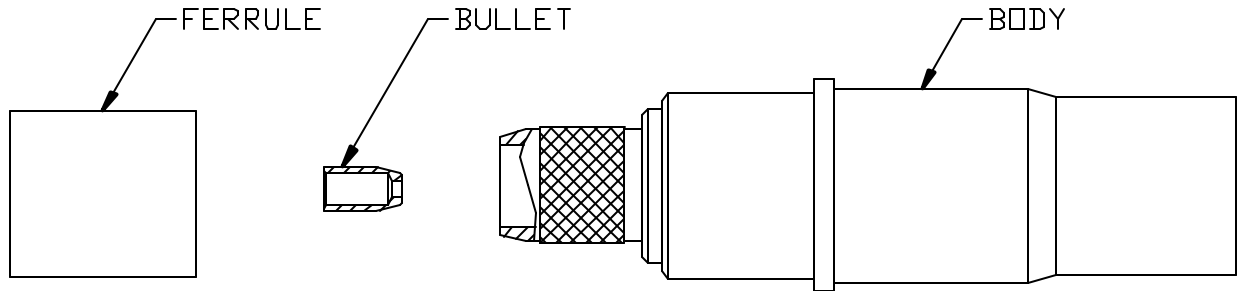


NOTES:

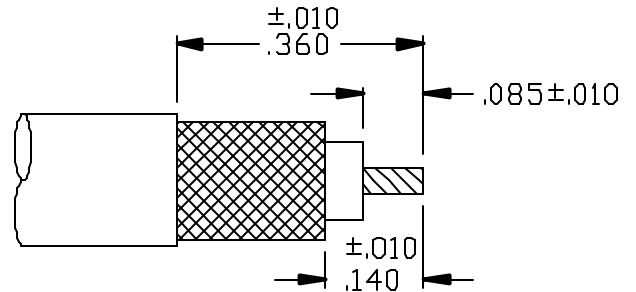
1. DESIGN AND INTERFACE PER I. D. S. -78.
2. DESIGN TO FIT MIL-C-38999, SERIES I, III & IV (SIZE 8 CAVITY).
3. BULLET & FERRULE SHIPPED LOOSE.
4. ACCOMMODATES RG-400 OR SIMILAR CABLES.
5. CRIMP USING A .213 HEX DIE SET Y-197 M22520/5-05.

|      |              |          |       |   |              |  |                             |                            |               |
|------|--------------|----------|-------|---|--------------|--|-----------------------------|----------------------------|---------------|
|      |              |          |       | <b>PALCO CONNECTOR</b><br>22 GREAT HILL RD., NAUGATUCK, CT 06770<br>UNLESS OTHERWISE SPECIFIED, PALCO WORKMANSHIP STANDARDS APPLY<br>TOLERANCES ON: DECIMALS: XX ±.01 .XXX ±.005 ANGLES ±1/2° 32'<br>DIMENSIONS IN INCHES OR (METRIC) DO NOT SCALE PRINTS | DRAWN<br>JSV | CHECKED<br>HN                            | ENGINEER<br>JV              | APPROVED<br>HN             | FSCM<br>58167 |
| D    | PER ECN 9680 | 12/08/08 | JEN   |   |              | DESCRIPTION PKZ RECEPTACLE<br>CRIMP TYPE |                             |                            |               |
| C    | PER ECN 6604 | 05/07/02 | HN    |   |              | DATE<br>12/12/01                         | DRAWING NO.<br>78-1080-1203 | PLATING OPT.<br>A, B, C, D |               |
| B    | PER ECN 6516 | 3/25/02  | HN    |   |              |  |                             |                            |               |
| A    | PER ECN 6420 | 12/12/01 | HN    |   |              |  |                             |                            |               |
| REV. | DESCRIPTION  | DATE     | APPR. | EPR 2484;   |              |  |                             |                            |               |

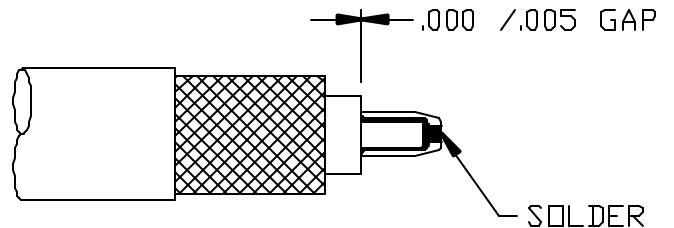
|                           |                |  |     |              |          |      |
|---------------------------|----------------|--|-----|--------------|----------|------|
| CABLE ASSEMBLY PROCEDURE  |                | <br>22 GREAT HILL ROAD, NAUGATUCK, CT. 06770<br>PHONE: (203) 729-9090 FAX: (203) 723-1794 | REV | DESCRIPTION  | DATE     | APPR |
| P/N 78-1080-1203          |                |  | B   | PER ECN 6516 | 3/25/02  | HN   |
| PAGE 1 OF 1               | DATE: 12/12/01 |  | C   | PER ECN 6604 | 5/06/02  | HN   |
| DRAWN: JSV                | APPROVED: HN   |  | D   | PER ECN 9680 | 12/08/08 | JEM  |
| FOR USE WITH RG-400 CABLE |                |  |     |              |          |      |



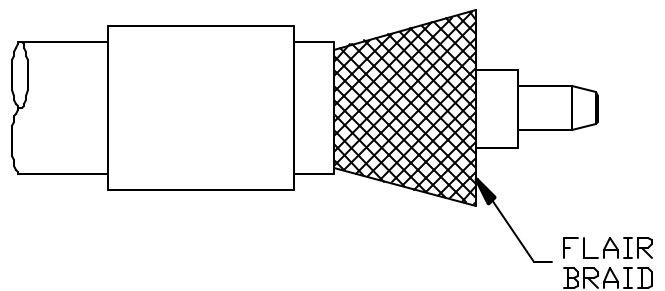
STEP 1  
TRIM CABLE TO DIMENSIONS SHOWN.



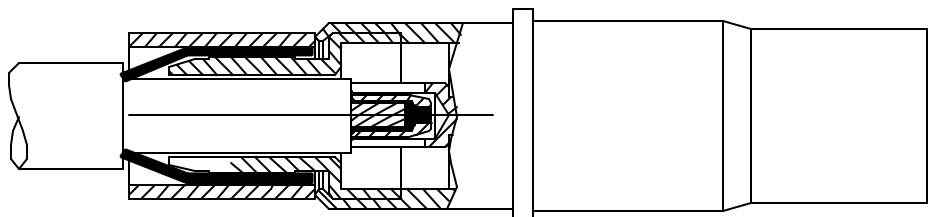
STEP 2  
TIN CABLE CENTER CONDUCTOR.  
SOLDER BULLET ONTO CENTER CONTACT.  
CLEAN SOLDER JOINT.



STEP 3  
SLIDE FERRULE OVER CABLE AND  
FLAIR BRAID BY ROTATING THE  
CABLE DIELECTRIC.



STEP 4  
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

