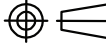


NOTES:

1. DESIGN AND INTERFACE PER I. D. S. -78.
2. DESIGN TO FIT MIL-C-38999 SERIES I, III & IV, (SIZE 8 CAVITY).
3. CRIMP NUT & FERRULE SHIPPED LOOSE.
4. ACCOMMODATES SFT-142B OR SIMILAR CABLES.
5. CRIMP USING .213 HEX DIE (M22520/5-05).

				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 MS	CHECKED JEM	ENGINEER MS	APPROVED JEM	FSCM 58167
B	PER ECN 11642	04/17/13	JEM		 DESCRIPTION PKZ RECEPTACLE CRIMP/CLAMP TYPE				
A	PER ECN 10901	03/22/11	JEM		DATE 09/23/10	DRAWING NO. 78-1080-2203	PLATING OPT. A, B, C, D		
REV.	DESCRIPTION	DATE	APPR.		EPR 9832j				

CABLE ASSEMBLY PROCEDURE

P/N 78-1080-2203

PAGE 1 OF 1 DATE: 09/23/10

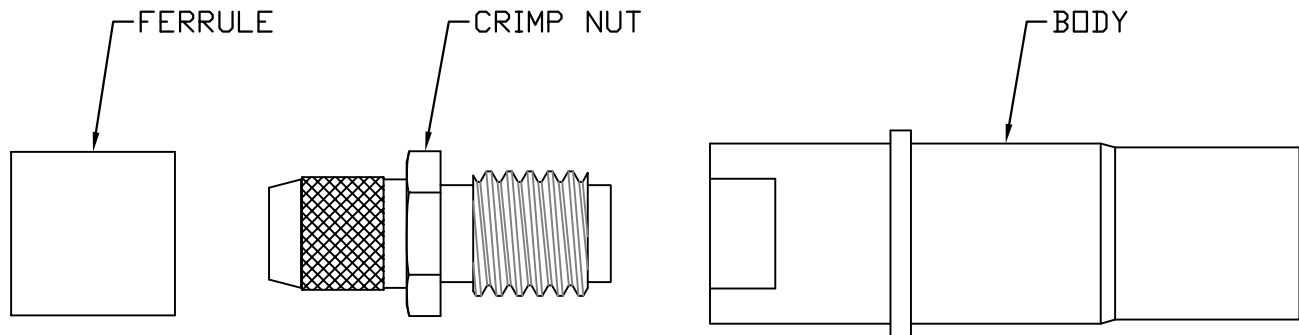
DRAWN: MS APPROVED: JEM

FOR USE WITH SFT-142B CABLE

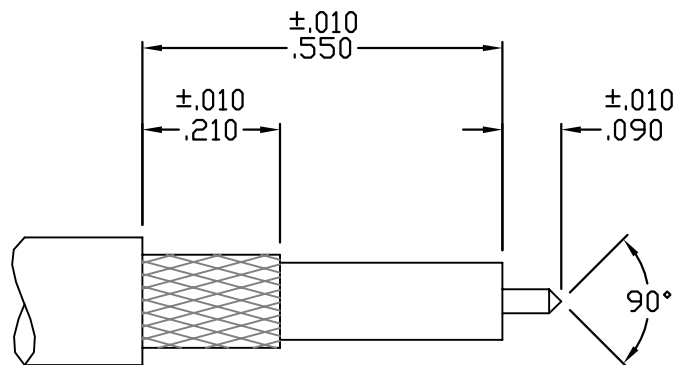
PALEO
CONNECTOR

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

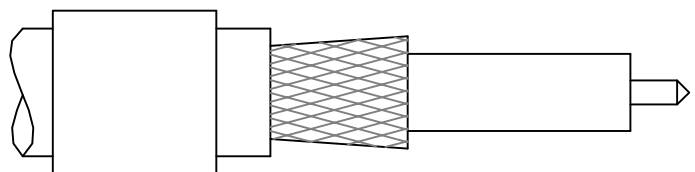
REV	DESCRIPTION	DATE	APPR
A	PER ECN 10901	03/22/11	JEM
B	PER ECN 11642	04/17/11	JEM



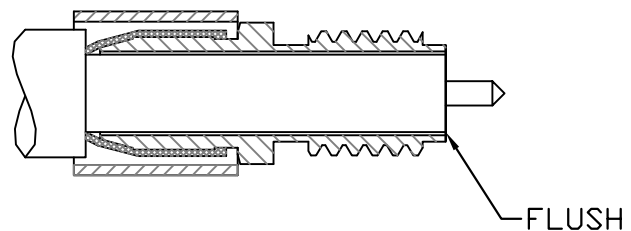
STEP 1
STRIP CABLE TO DIMENSIONS SHOWN, POINT CENTER CONDUCTOR.



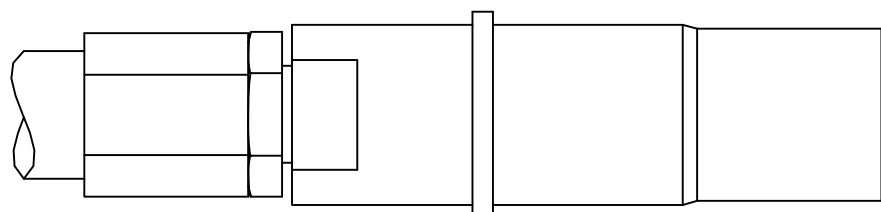
STEP 2
SLIDE FERULE OVER CABLE. LIFT UP OUTER BRAID, DO NOT BRUSH UP THE STRANDS LONGITUDINALLY. CUT THE TAPE, BRING OUTER BRAID BACK. FLAIR INNER AND OUTER BRAID BY ROTATING DIELECTRIC.



STEP 3
SLIDE CRIMP NUT OVER CABLE DIELECTRIC AND UNDER BRAID, BE SURE CRIMP NUT IS FLUSH WITH CABLE DIELECTRIC. SLIDE FERRULE UP AGAINST SHOULDER OF CRIMP NUT AND CRIMP USING .213 HEX DIE (M2520/5-05).



STEP 4
INSERT PREPARED CABLE ASSEMBLY INTO BACK OF BODY AND TORQUE CRIMP NUT TO 7-10 INCH-LBS.



INTERFACE DESIGN STANDARD		PALEC CONNECTOR	REV	DESCRIPTION	DATE	APPR
IDS-78			B	PER ECN 5123	06/29/99	HN
PAGE 1 OF 2	DATE: 06/16/98		C	PER ECN 9935	05/22/09	JEM
DRAWN: JEM	APPROVED: HN		D	PER ECN 10145	01/20/10	JEM
		22 GREAT HILL ROAD, NAUGATUCK, CT. 06770				
		PHONE: (203) 729-9090 FAX: (203) 723-1794				

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:
 GOLD 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

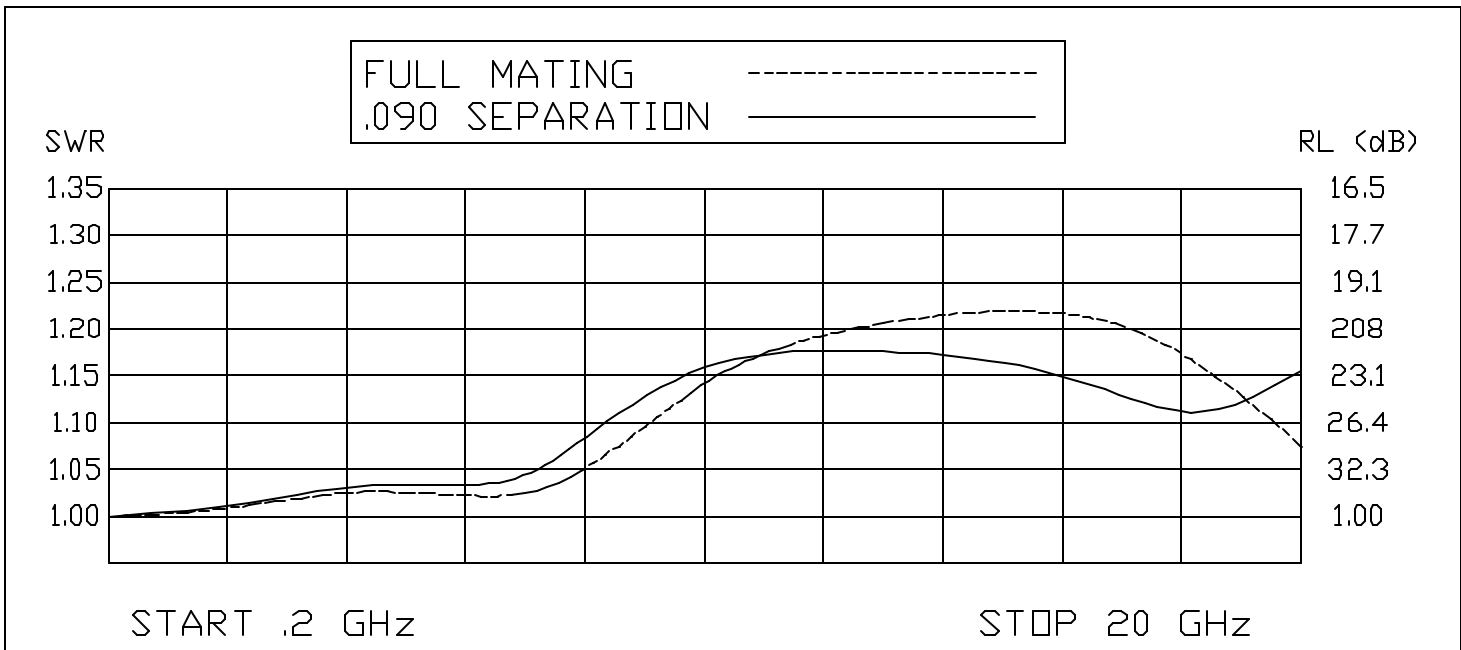
OUTER BODIES _____ 3 LBS MAX. INSERTION.
 2 OZ. MIN. WITHDRAWL.
 CENTER CONTACTS _____ 32 OZ. MAX. INSERTION.
 .5 OZ. MIN. WITHDRAWL.
 HOUSING RETENTION _____ 12 LBS. MIN.
 AXIAL MATING TOLERANCE _____ .090

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.
 INSERTION LOSS: .06 √(F/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
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

