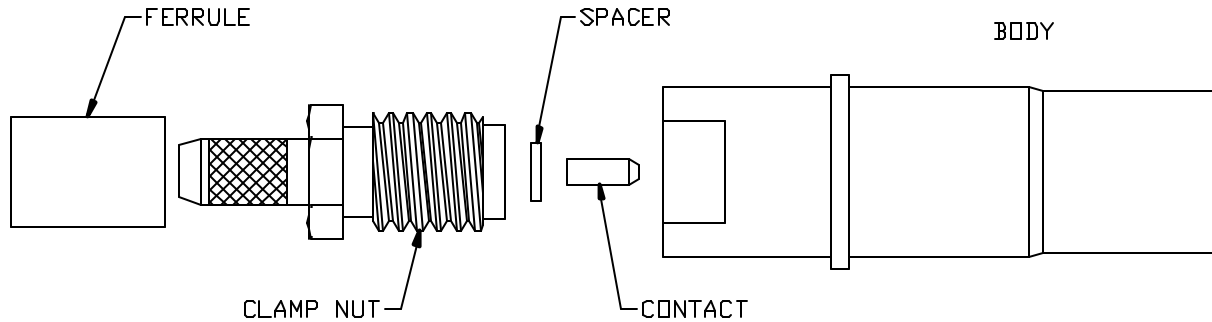


NOTES:

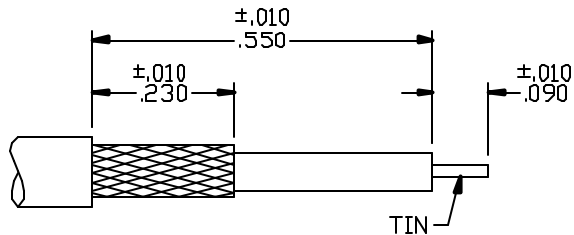
1. DESIGN AND INTERFACE PER I. D. S. -78.
2. DESIGN TO FIT MIL-C-38999, <SIZE 8 CAVITY>.
3. BULLET, CRIMP NUT, FERRULE & SPACER SHIPPED LOOSE.
4. ACCOMMODATES RD-316 OR SIMILAR CABLES.
5. CRIMP USING .151 HEX DIE (M22520/5-37).

				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 YT	CHECKED HN	ENGINEER YT	APPROVED HN	FSCM 58167
C	PER ECN 10471	07/20/10	JEM			DESCRIPTION PKZ RECEPTACLE CRIMP/CLAMP TYPE			
B	PER ECN 9678	12/09/09	JEM						
A	REL. ECN 6620	05/16/02	HN		DATE 05/16/02	DRAWING NO. 78-1080-2670		PLATING OPT. A, B, C, D	
REV.	DESCRIPTION	DATE	APPR.		EPR 9864; CATALOG ITEM				

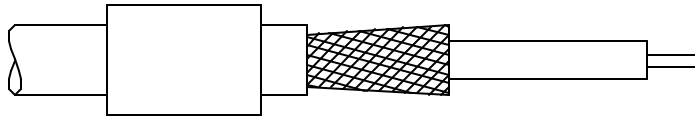
CABLE ASSEMBLY PROCEDURE		 22 GREAT HILL ROAD, NAUGATUCK, CT. 06770 PHONE: (203) 729-9090 FAX: (203) 723-1794	REV	DESCRIPTION	DATE	APPR
P/N	78-1080-2670		A	REL. ECN 6620	05/16/02	HN
PAGE 1 OF 1	DATE: 05/16/02		B	PER ECN 9678	12/08/08	JEM
DRAWN: YT	APPROVED: HN		C	PER ECN 10471	07/20/10	JEM
FOR USE WITH RD-316 CABLE						



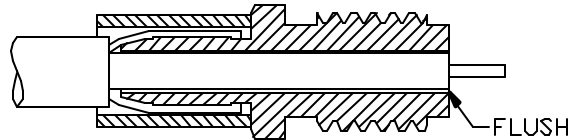
STEP 1
 TRIM CABLE TO DIMENSIONS SHOWN.
 TIN CENTER CONDUCTOR AND CLEAN
 SOLDER JOINT.



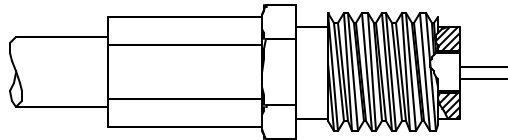
STEP 2
 SLIDE FERRULE OVER CABLE
 AND FLAIR BRAID BY ROTATING
 DIELECTRIC.



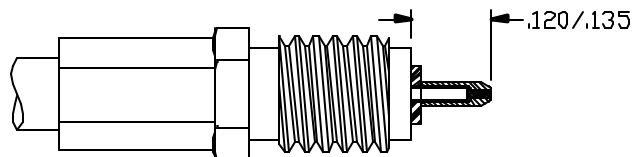
STEP 3
 INSERT THE BARREL OF THE CRIMP NUT BETWEEN
 THE BRAID AND DIELECTRIC, POSITIONED SO THAT
 THE END OF THE CABLE DIELECTRIC IS FLUSH
 WITH THE END OF THE CRIMP NUT.



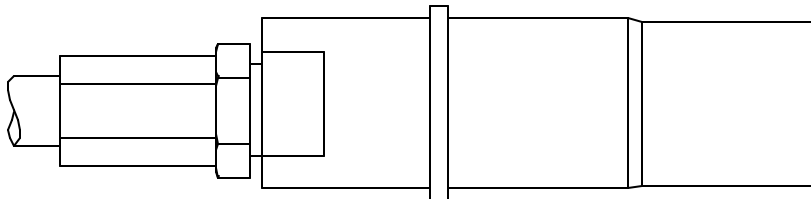
STEP 4
 SLIDE THE FERRULE AGAINST THE SHOULDER
 OF THE CRIMP NUT AND CRIMP USING .151 HEX
 DIE (M22520/5-37).



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



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.
 INSERSION LOSS: .06 $\sqrt{f(\text{GHz})}$ dB

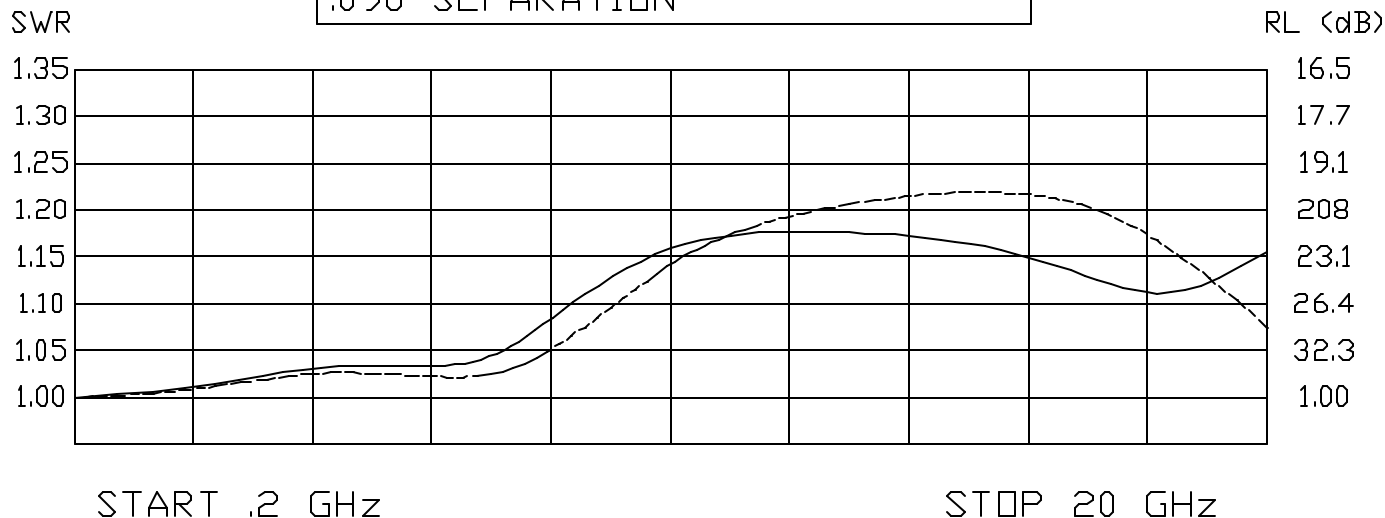
CONTACT RESISTANCE: CENTER CONTACT 5 MILLIOHMS
 CONTACT RESISTANCE: OUTER CONTACT 3 MILLIOHMS
 VSWR: 1.08 + .009(f) GHz., RG-402 CABLE.
 1.15 + .02 (F) GHz., RG-174 & RG-316 CABLES.
 1.15 + .01 (F) GHz., RG-142, 223, 303 & 400 CABLES.

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.

FULL MATING -----
 .090 SEPARATION _____



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
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