

Notes:

76-1080-0670A

- 1) Design and Interface per IDS 76.
- 2) Blindmate RF/Microwave Contact for Standard Density Multiport RF D-Subminiature Connectors.
- 3) Size 8 PkZ<sup>®</sup>, 75 Ohm, 3 GHz Straight Receptacle.
- 4) Crimp/Clamp to RG-179 Cable.
- 5) Crimp Using .128 Hex Die (M22520/5-03).
- 6) Bullet, Crimp Nut, Ferrule, and Spacer Supplied Loose.
- 7) .000050" Min. Gold Over Nickel.

				<b>PALCO CONNECTOR</b> 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 11831	01/03/14	JEM			DESCRIPTION PKZ RECEPTACLE 75 OHMS, CRIMP/CLAMP				
A	PER ECN 11756	08/16/13	JEM							
03	CHANGE DD	04/07/11	JEM		DATE	DRAWING NO.	PLATING OPT.			
02	PRELIMINARY	04/01/11	JEM		04/01/11	76-1080-0670	A, B			
REV.	DESCRIPTION	DATE	APPR.							

CABLE ASSEMBLY PROCEDURE

P/N 76-1080-0670

PAGE 1 OF 1 DATE: 04/01/11

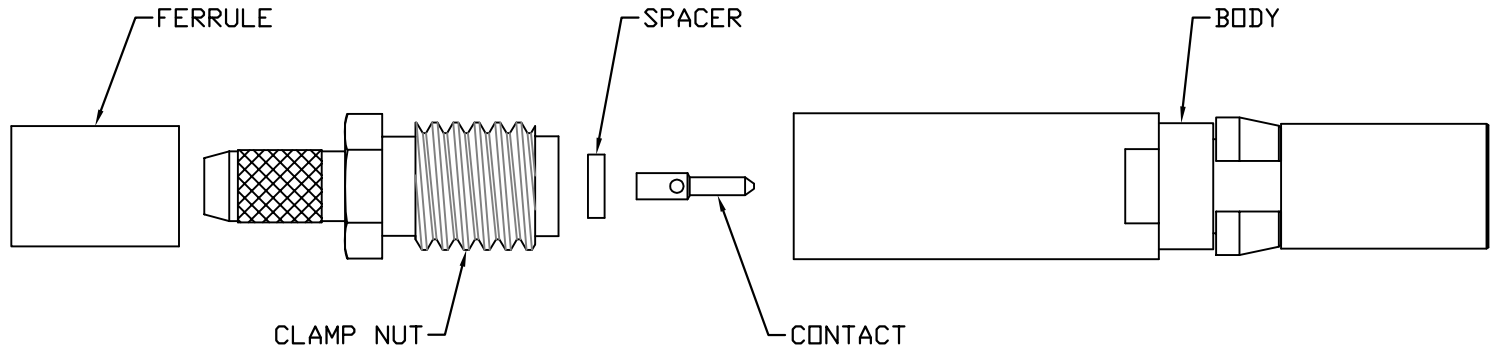
DRAWN: MS APPROVED: JEM

FOR USE WITH RG-179 CABLE

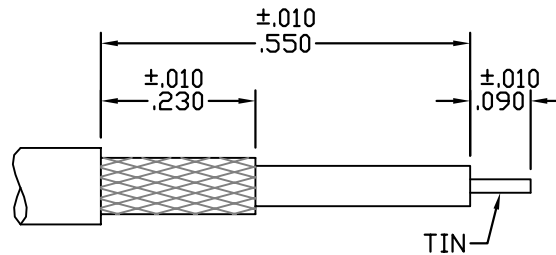
# PALEO CONNECTOR

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

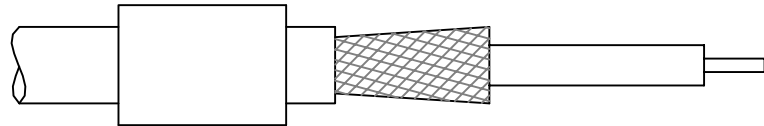
REV	DESCRIPTION	DATE	APPR
02	PRELIMINARY	04/01/11	JEM
03	REVISED	04/08/11	JEM
A	PER ECN 11756	08/21/13	JEM
B	PER ECN 11831	01/03/14	JEM



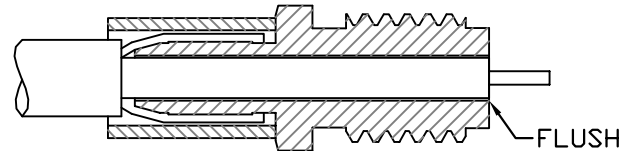
**STEP 1**  
 TRIM CABLE TO DIMENSIONS SHOWN.  
 TIN CENTER CONDUCTOR AND CLEAN  
 SOLDER JOINT.



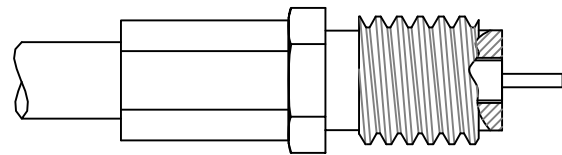
**STEP 2**  
 SLIDE FERRULE OVER CABLE  
 AND FLAIR BRAID BY ROTATING  
 DIELECTRIC.



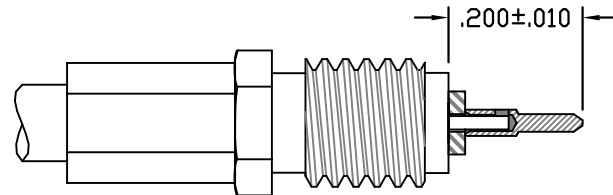
**STEP 3**  
 INSERT THE BARREL OF THE CRIMP NUT BETWEEN  
 THE BRAID AND DIELECTRIC, POSITIONED SO THAT  
 THE END OF THE CABLE DIELECTRIC IS FLUSH  
 WITH THE END OF THE CRIMP NUT.



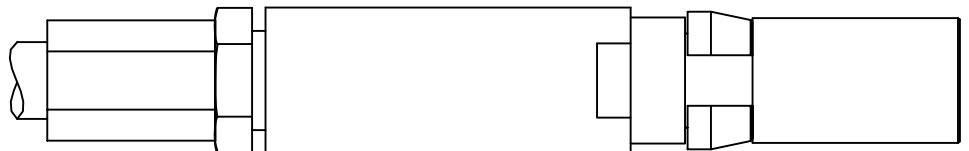
**STEP 4**  
 SLIDE THE FERRULE AGAINST THE SHOULDER  
 OF THE CRIMP NUT AND CRIMP USING .128 HEX  
 DIE (M22520/5-03).




**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			REV	DESCRIPTION	DATE	APPR
IDS-76			01	PRELIMINARY	01/07/10	JEM
PAGE 1 OF 1	DATE: 01/07/10					
DRAWN: JEM	APPROVED: JEM					
		22 GREAT HILL ROAD, NAUGATUCK, CT. 06770 PHONE: (203) 729-9090 FAX: (203) 723-1794				

DESCRIPTION: 76 SERIES PkZ®, SIZE 8, 75 OHM MICROWAVE CONTACTS FOR STANDARD DENSITY MULTI-PORT RF D-SUB CONNECTORS

**MECHANICAL**

**MATERIALS**

BODIES:

PLUG BODIES - BRASS PER ASTM B 16.  
RECEPTACLE BODIES - BRASS PER ASTM B 16.

PLATING:

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

INSULATORS - VIRGIN TEFLON (PTFE) PER ASTM D 1710 AND 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.  
WEATHER SEAL GASKET (OPTIONAL) - SILICONE RUBBER PER ZZ-R-765.  
EMI GASKET - BERYLLIUM COPPER PER ASTM B 196.

**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 3 GHz.  
VOLTAGE RATING STRAIGHT: 1000 VRMS.  
VOLTAGE RATING ANGLED: 800 VRMS.  
CURRENT RATING: 5 AMPS.  
INSULATION RESISTANCE: 2000 MEGOHMS MIN.  
INSERTION 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 (75 OHMS) CABLE.  
1.15 + .02 (f) GHz., MINI RG-59 CABLES.  
1.15 + .01 (f) GHz., RG-59 CABLE.

**ENVIRONMENTAL**

OPERATING TEMPERATURE: -65°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.

