

A	PER ECN 11591	02/20/13	JEM
REV.	DESCRIPTION	DATE	APPR.


PALCO CONNECTOR

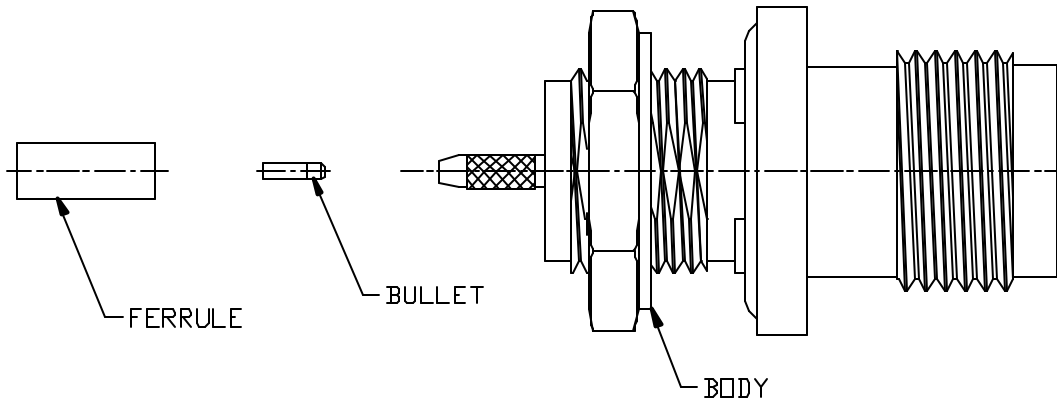
22 GREAT HILL RD., NAUGATUCK, CT 06770

UNLESS OTHERWISE SPECIFIED, PALCO WORKMANSHIP STANDARDS APPLY
 TOLERANCES IN: DECIMALS: XX ± .01 .XXX ± .005 ANGLES ±1/2° 32'
 DIMENSIONS IN INCHES OR (METRIC) DO NOT SCALE PRINTS

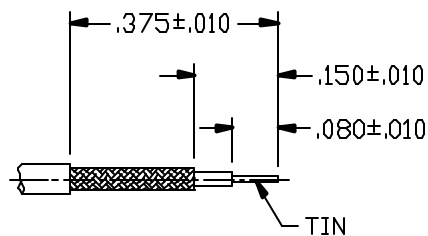
CATALOG ITEM

DRAWN JEM	CHECKED JEM	ENGINEER JEM	APPROVED JEM	FSCM 58167
		DESCRIPTION TNC WATERPROOF FRONT MOUNT BULKHEAD JACK		
DATE 12/3/12	DRAWING NO. 41-1969-0290		PLATING OPT. N	

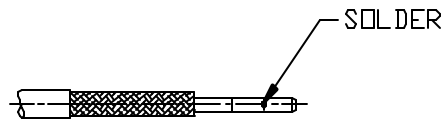
CABLE ASSEMBLY PROCEDURE			REV	DESCRIPTION	DATE	APPR
P/N	41-1969-0290		01	PRELIMINARY	12/5/12	JEM
PAGE 1 OF 1	DATE: 12/5/12		A	PER ECN 11591	02/20/13	JEM
DRAWN: JEM	APPROVED: JEM					
FOR USE WITH HIROSE 1.13mm CABLE		22 GREAT HILL ROAD, NAUGATUCK, CT. 06770		PHONE: (203) 729-9090		FAX: (203) 723-1794



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



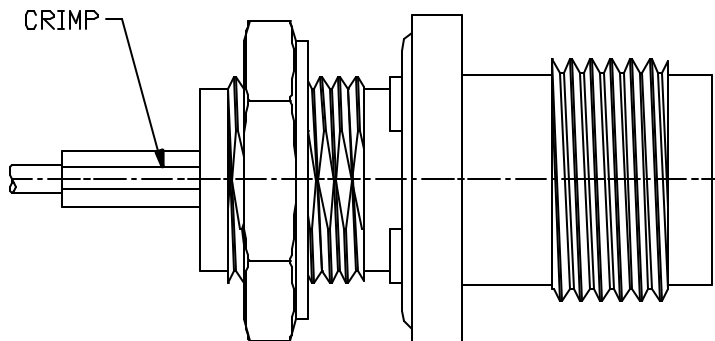
STEP 2
SLIDE BULLET ONTO CENTER
CONDUCTOR. SOLDER BULLET
TO CENTER CONDUCTOR. CLEAN
SOLDER JOINT.




STEP 3
SLIDE FERRULE ONTO CABLE.
FLARE BRAID BY ROTATING
CABLE DIELECTRIC.



STEP 4
INSERT CABLE INTO BODY
UNTIL CABLE BOTTOMS.
SLIDE FERRULE UP UNTIL
IT BOTTOM ON SHOULDER.
CRIMP USING .081 HEX
DIE (DANIELS Y1547P).



INTERFACE DESIGN STANDARD		 22 GREAT HILL ROAD, NAUGATUCK, CT. 06770 PHONE: (203) 729-9090 FAX: (203) 723-1794	REV	DESCRIPTION	DATE	APPR
IDS-41			A	PER ECN 5421	03/21/00	HN
PAGE 1 OF 3	DATE: 02/28/94		B	PER ECN 7427	05/07/04	JM
DRAWN: EK	APPROVED: JEM		C	PER ECN 9024	08/06/07	JEM
		D	PER ECN 10095	11/30/09	JEM	

DESCRIPTION: TNC SERIES

MECHANICAL

MATERIALS

BODIES, FITTINGS, MALE CONTACTS - BRASS PER ASTM-B-16.
 INSULATORS - TEFLON (PTFE) PER ASTM-D-1457.
 CONTACTS, FEMALE AND OUTER - BERYLLIUM COPPER PER ASTM-B-196.
 GASKETS - SILICONE RUBBER PER ZZ-R-765.

FINISHES (ADD LETTER TO END OF PART NUMBER)

BODIES, OUTER CONTACTS, FITTINGS - SILVER PER QQ-S-365 (S SUFFIX)
 NICKEL - PER QQ-N-290 (N SUFFIX)
 CONTACTS - GOLD PLATED .000050 MIN. PER MIL-G-45204 OVER
 .00010 MIN. OF COPPER PER MIL-C-14550.
 OTHER METAL PARTS - SILVER OR NICKEL PLATED TO MEET THE ENVIRONMENTAL
 REQUIREMENTS.

MATING CHARACTERISTICS

PER MIL-C-39012.
 FORCE TO ENGAGE /DISENGAGE- TORQUE - 2 IN-LBS. MAX.
 COUPLING NUT RETENTION - AXIAL FORCE 100 LBS. MIN.,
 TORQUE - 15 IN-LBS. MIN.
 DURABILITY: 500 CYCLES PER MIL-C-39012.

ELECTRICALS

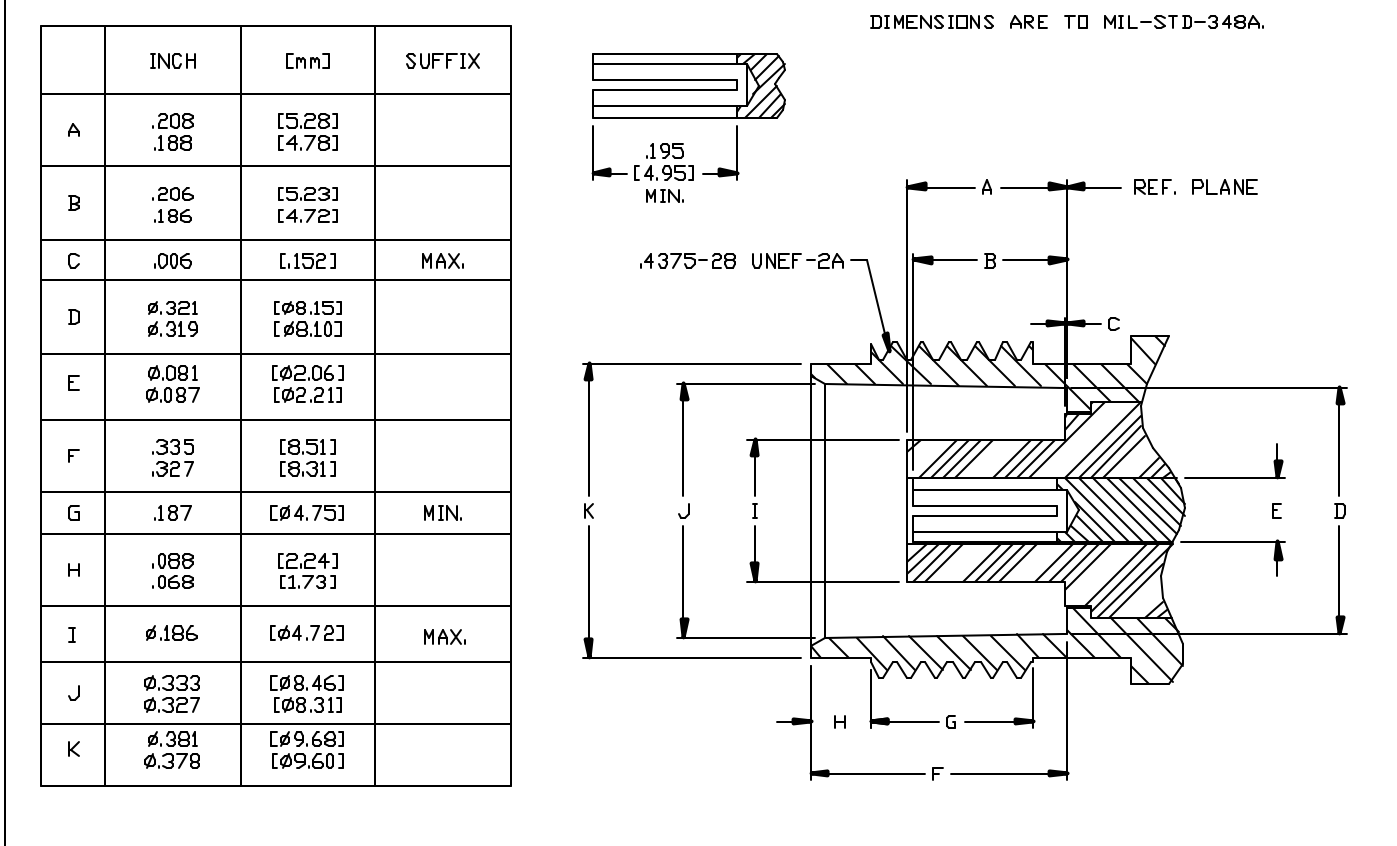
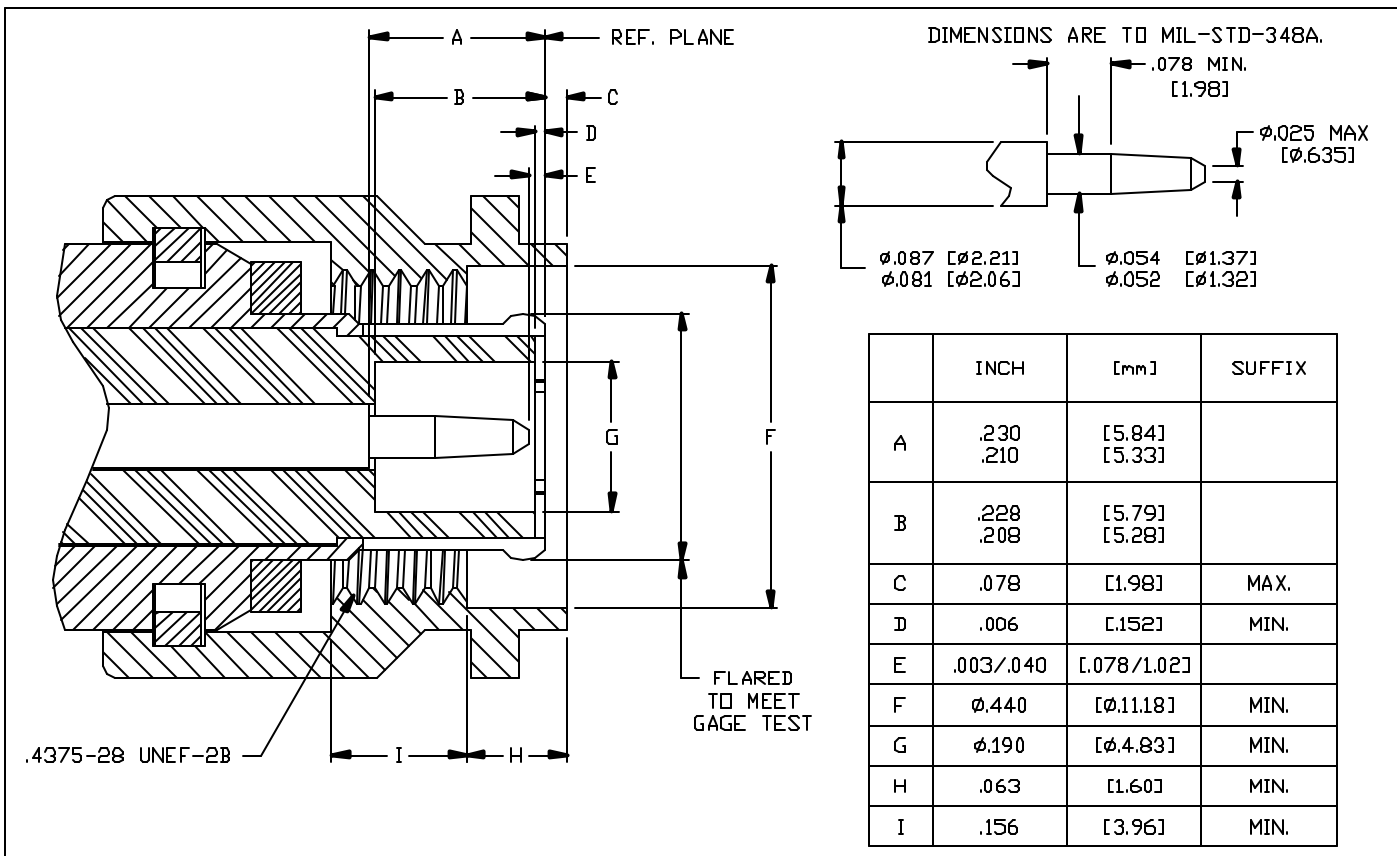
IMPEDANCE: 50 OHMS.
 FREQUENCY RANGE: DC TO 11 GHz (CONNECTOR PERFORMANCE ONLY;
 DEPENDENT OF CABLE).
 INSULATION RESISTANCE: 5000 MEGOHMS, MIN..
 TEMPERATURE RATING: -65°C TO +165°C.
 DWV: 1500 VOLTS AT SEA LEVEL.
 CONTACT RESISTANCE: CENTER CONTACT - 1.5 MILLIOHMS;
 OUTER CONTACT - 0.2 MILLIOHMS.
 VSWR: 1.30 MAX.
 R.F. LEAKAGE: -60 dB MIN. FROM 2 TO 3 GHz.
 INSERTION LOSS: 0.18 dB MAX. AT 9 GHz.

ENVIRONMENTAL

VIBRATION: MIL-STD-202, METHOD 204, TEST CONDITION B.
 SHOCK: MIL-STD-202, METHOD 213, TEST CONDITION B.
 THERMAL SHOCK: MIL-STD-202, METHOD 107, TEST CONDITION B @ 85°C.
 CORROSION: MIL-STD-202, METHOD 101, TEST CONDITION B.
 MOISTURE RESISTANCE: MIL-STD-202, METHOD 106,
 NO MEASUREMENT AT HIGH HUMIDITY.

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DIMENSIONS ARE TO MIL-STD-348A.

