



- NOTES:
1. LEAK TEST: "X" PRESSURE, NO BUBBLES "Y" SECONDS MINIMUM, SEE TABLE. A GREEN PAINT DOT INDICATES THE PART HAS PASSED THE TEST.
  2. HYPOT 630 VDC 500 MΩ MINIMUM 0.01 SEC MINIMUM WIRE TO WIRE.
  3. VALIDATION TESTING FOR 2491 ONLY:
    - A) 30 POUND PULL TEST ON CONDUCTORS OF WIRES (FORCE TO BE EQUALLY DISTRIBUTED AMONG THE WIRES, WITH THE HOUSING HELD STATIONARY)
    - B) THERMAL CYCLE 0°F TO 200°F [-18°C TO 93°C], 3 CYCLES, 1 HOUR HOLD AT EACH TEMPERATURE EXTREME, THEN
    - C) SUBMERGE FOR A MINIMUM OF 3 HOURS "ATMOSPHERE" SIDE UNDER 10 FEET OF SALT WATER, 5-8% SALT SOLUTION, THEN
    - D) HYPOT 50 VDC 5 MΩ 0.01 SEC MINIMUM.
 [NOTE: VALIDATION TEST PIECE WILL HAVE AT LEAST 10 FEET OF WIRE ON THE ATMOSPHERE SIDE, NOT 20.98 INCHES.]
  4. ALL TESTS ARE PERFORMED AT ROOM TEMPERATURE.
  5. ALL PARTS MUST PASS ALL TESTS.
  6. WIRE COLOR POSITIONING IS VARIABLE
  7. WIRES ARE NOT REQUIRED TO BEND SHARPLY AT EPOXY SEAL SURFACE.
  8. NO COSMETIC SURFACE VOIDS ARE ACCEPTABLE ON O-RING SEALING SURFACES, COSMETIC SURFACE VOIDS SMALLER THAN 0.035 [0.89] ARE ACCEPTABLE ON ALL OTHER SURFACES.
  9. DIMENSION IS OVER-ALL-LENGTH EXCLUDING OVERFILL ON ATMOSPHERE SIDE OF HOUSING.
  10. REF-OPERATING TEMPERATURE -20°C TO 125°C.
  11. REF-PARTS ARE DEFLASHED ON PARTING LINE +0.005 [0.13] MAXIMUM.
  12. DIMENSIONS ARE INCHES [millimeters].
  13. PAVE-SEAL CAN BE A BI-DIRECTIONAL HERMETIC SEAL FOR VACUUM AND MOST PRESSURES. FOR PRESSURES ABOVE 150 PSI (10 BAR), CHECK WITH SALES ENGINEERING.

PAVE#	"A"	"B"	DESCRIPTION	"X"	"Y"
2491	20.98±.25 [533±6.4]	7.40±.25 [188±6.4]	SPF12-E-150-6-TZZ18-533-188mm	80 PSI (5.5 BAR)	90
2491-1	19.69 MIN [500 MIN]	19.69 MIN [500 MIN]	SPF12-E-150-6-TZZ18-500-500mm	15 BAR (217 PSI)	30

11	1	RR 5100-75-HST	RETAINING RING EXTERNAL .750SS
10	A/R	PAVE-Seal 150	EPOXY BLACK
9	1	TZZ18 ORG	WIRE 18TZZ XL-ETFE .015 WALL 7/#26
8	1	TZZ18 BRN	WIRE 18TZZ XL-ETFE .015 WALL 7/#26
7	1	TZZ18 PUR	WIRE 18TZZ XL-ETFE .015 WALL 7/#26
6	1	TZZ18 BLU	WIRE 18TZZ XL-ETFE .015 WALL 7/#26
5	1	TZ18 RED /16	WIRE 18 TEFZEL MIL-W-22759/16-18 19/#30
4	1	TZ18 BLK /16	WIRE 18 TEFZEL MIL-W-22759/16-18 19/#30
3	A/R	PARKER O-LUBE	LUBRICANT O-RING BARIUM-BASED
2	1	-016 VITON	O-RING -016 VITON 75
1	1	0130	HOUSING SPF12-E
ITEM	QTY	PART#	DESCRIPTION

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ALL DIMENSIONS AND TOLERANCES APPLY TO FINISHED PART IN INCHES  
 ALLOWABLE TOLERANCES UNLESS SPECIFIED OTHERWISE: NONE +/-0.5  
 .X DECIMAL +/- 0.1 .XX DECIMAL +/- 0.02 .XXX DECIMAL +/-0.005  
 ANGLES +/- 1 DEG SURFACE FINISH 128 microinch RMS

DESCRIPTION **PAVE-Seal® Cable Harnesses**  
 \*SEE TABLE  
 PART NUMBER **2491\***  
 REVISION LEVEL **N**  
 PROJECTION