



- NOTES:
- PRODUCTION TESTS:
    - LEAK TEST: 1000 PSI (AIR), NO BUBBLES 30 SECONDS MINIMUM.
    - HYPOT 1000 VDC 100 MEGOHMS MINIMUM 0.01 SECONDS MINIMUM WIRE TO WIRE.
  - FIVE RANDOMLY SELECTED UNITS OF EACH PRODUCTION LOT SHALL BE THERMALLY CYCLED A MINIMUM OF 20 CYCLES FROM -40 TO 170 °C, WITH A MINIMUM OF 30 MINUTES OF DWELL AT EACH TEMPERATURE EXTREME. THE TEST UNITS WILL THEN BE LEAK TESTED AT 170 ± 5 °C IN INCREMENTS OF 250 PSI FROM 1000 TO 2500 PSI, FOR 30 SECONDS MINIMUM AT EACH PRESSURE. THESE TEST UNITS WILL BE SCRAPPED.
  - ALL "PRODUCTION TESTS" ARE PERFORMED AT ROOM TEMPERATURE.
  - ALL PARTS MUST PASS ALL "PRODUCTION TESTS".
  - NO VOIDS ARE ACCEPTABLE ON O-RING SEALING SURFACES, VOIDS SMALLER THAN Ø0.035 ARE ACCEPTABLE ON ALL OTHER SURFACES.
  - ENVIRONMENTAL SPECIFICATIONS (REFERENCE)
    - OPERATING TEMPERATURE -40 °C TO 170 °C.
    - STORAGE TEMPERATURE -40 °C TO 170 °C.
  - REF-PARTS ARE DEFLASHED ON PARTING LINE +0.005 [.13] MAXIMUM.
  - IT IS ACCEPTABLE FOR RETAINED ENDS (SLUGS) TO BE LOST DURING HANDLING.
  - 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.

ITEM	QTY	PART NUMBER	DESCRIPTION
8	1	EE18 WHT	WIRE 18EE MIL-W-16878/5 .015 19/#30
7	1	EE18 WHT/BLUE	WIRE 18EE MIL-W-16878/5 .015 19/#30
6	1	1381-1098	RING BACKUP .410 ID SCARF CUT TEFLON
5	A/R	PAVE-Seal 200UL94	EPOXY BLACK
4	A/R	PARKER O-LUBE	LUBRICANT O-RING BARIUM BASED
3	2	-012 VITON GF	O-RING -012 VITON 75 -8782
2	1	RW200E-1/4-0-SP	TUBING VITON HEAT SHRINK 1/4" BLACK
1	1	M27500-18LE2S09	CABLE 2/C EE#18AWG TEFLON WHITE 1000V

**PAVE technology co.**

2751 Thunderhawk Court  
Dayton, OH 45414-3445  
U.S.A.  
tel (937) 890-1100  
fax (937) 8905165  
www.pavetechnologyco.com

DESCRIPTION  
SP8C-E-200UL94-2-TEE18-1-34

PART NUMBER  
**3485**

MATERIAL NOTED

REVISION LEVEL  
F

PROJECTION

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