



**NOTES:**

1. 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.
2. 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 2500PSI, FOR 30 SECONDS MINIMUM AT EACH PRESSURE. THESE TEST UNITS WILL BE SCRAPPED.
3. ALL "PRODUCTION TESTS" ARE PERFORMED AT ROOM TEMPERATURE.
4. ALL PARTS MUST PASS ALL "PRODUCTION TESTS".
5. NO VOIDS ARE ACCEPTABLE ON O-RING SEALING SURFACES, VOIDS SMALLER THAN Ø0.035 [.89] ARE ACCEPTABLE ON ALL OTHER SURFACES.
6. ENVIRONMENTAL SPECIFICATIONS (REFERENCE)
  - OPERATING TEMPERATURE -40°C TO 170°C.
  - STORAGE TEMPERATURE -40°C TO 170°C.
7. REF-PARTS ARE DEFLASHED ON PARTING LINE +0.005 [.13] MAXIMUM.
8. IT IS ACCEPTABLE FOR RETAINED ENDS (SLUGS) TO BE LOST DURING HANDLING.
9. DIMENSIONS ARE INCHES [millimeters].
10. 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/BLUE	WIRE 18EE MIL-W-16878/5 .015 19/#30
7	1	EE18 WHT	WIRE 18EE MIL-W-16878/5 .015 19/#30
6	1	1381-1098	RING -012 TEFLON BACKUP SINGLE TURN SCARF CUT
5	A/R	PARKER O-LUBE	LUBRICANT O-RING BARIUM BASED
4	2	-012 VITON GF	O-RING -012 VITON 75 -8782
3	1	RW200E-1/4-0-SP	TUBING VITON HEAT SHRINK 1/4" BLACK
2	1	M27500-18LE2S09	CABLE 2/C EE#18AWG TEFLON WHITE 1000V 19 STRAND
1	A/R	PAVE-Seal 200UL94	EPOXY BLACK

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

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DESCRIPTION  
SP8C-E-200UL94-2-TE18-2-21

PART NUMBER  
**3635**

MATERIAL NOTED

REVISION LEVEL  
H

PROJECTION