



NOTES:

- LEAK TEST: 300 PSI, NO N2 BUBBLES 1 MINUTE MINIMUM. A GREEN PAINT DOT INDICATES THE PART HAS PASSED THE TEST.
- HYPOT 630 VDC 500 MEGOHMS MINIMUM 0.01 SECOND MINIMUM WIRE TO WIRE AND HOUSING.
- CONTINUITY CHECK < 30 MILLIOHMS SOLDER CUP TO WIRE END.
- ALL TESTS ARE PERFORMED AT ROOM TEMPERATURE.
- ALL PARTS MUST PASS ALL TESTS.
- ITEMS 4 & 5 (RED & BLACK) AND ITEMS 6 & 7 (WHITE & YELLOW) ARE TWISTED INTO PAIRS, 1 TO 3 TWIST PER INCH.
- EACH TWISTED PAIR IS COVERED IN 2 LAYERS OF SHRINK TUBING, FIRST LAYER IS ITEM 8, SECOND LAYER IS ITEM 9.
- WIRES & TUBING ARE NOT REQUIRED TO BEND SHARPLY AT EPOXY SEAL SURFACE, TUBING MAY PULL OUT OF EPOXY.
- WHEN SOLDERING SOLDER CUPS, LIMIT DURATION & SOLDERING TEMPERATURE TO AVOID DAMAGING HERMETIC SEAL.
- COSMETIC SURFACE VOIDS NOT ON O-RING SEALING SURFACES ARE ACCEPTABLE BASED ON THE SEAL'S DIAMETER:  
 <= .5 [12.7] SEAL DIAMETER: ∅.035 [.89] MAX ALLOWED VOID SIZE  
 > .5 [12.7] SEAL DIAMETER: ∅.060 [1.5] MAX ALLOWED VOID SIZE
- REF-OPERATING/STORAGE TEMPERATURE RANGE 0°C TO 50°C.
- DIMENSIONS ARE INCHES [millimeters].
- 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.

11	A/R	SUPER O-LUBE	LUBRICANT O-RING SILICONE-BASED
10	1	M25988/1-013	O-RING -013 FLUOROSILICONE M25988/1
9	2	RNF150-1/4-0-SP	TUBING SHRINK 1/4" ID M23053/18 BLACK
8	2	M23053/11-106-C	TUBING SHRINK 14AWG FEP TEFLON CLEAR
7	1	E24 YLW	WIRE 24E MIL-W-22759/11 .010 19/#36
6	1	E24 WHT	WIRE 24E MIL-W-22759/11 .010 19/#36
5	1	E24 RED MIL	WIRE 24E MIL-W-22759/11 .010 19/#36
4	1	E24 BLK	WIRE 24E MIL-W-22759/11 .010 19/#36
3	A/R	PAVE-Seal 150	EPOXY BLACK
2	4	4674	SOLDER CUP 22-24AWG
1	1	5120	HOUSING SPF8.8-AL 6061-T6 ANODIZED
ITEM	QTY	PART NUMBER	DESCRIPTION

ALL DIMENSIONS AND TOLERANCES APPLY TO FINISHED PART IN INCHES.  
 ALLOWABLE TOLERANCES UNLESS SPECIFIED OTHERWISE: NONE ±.5  
 X.X DECIMAL ±.01 X.XX DECIMAL ±.02 X.XXX DECIMAL ±.005  
 ANGLES ±1 DEGREE SURFACE FINISH 128 microinch RMS

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

**PAVE technology co.**

DESCRIPTION  
 SPF8.8-AL-150-4-TE24-9.5-SC

PART NUMBER  
**5090**

MATERIAL NOTED

REVISION LEVEL  
 A

PROJECTION