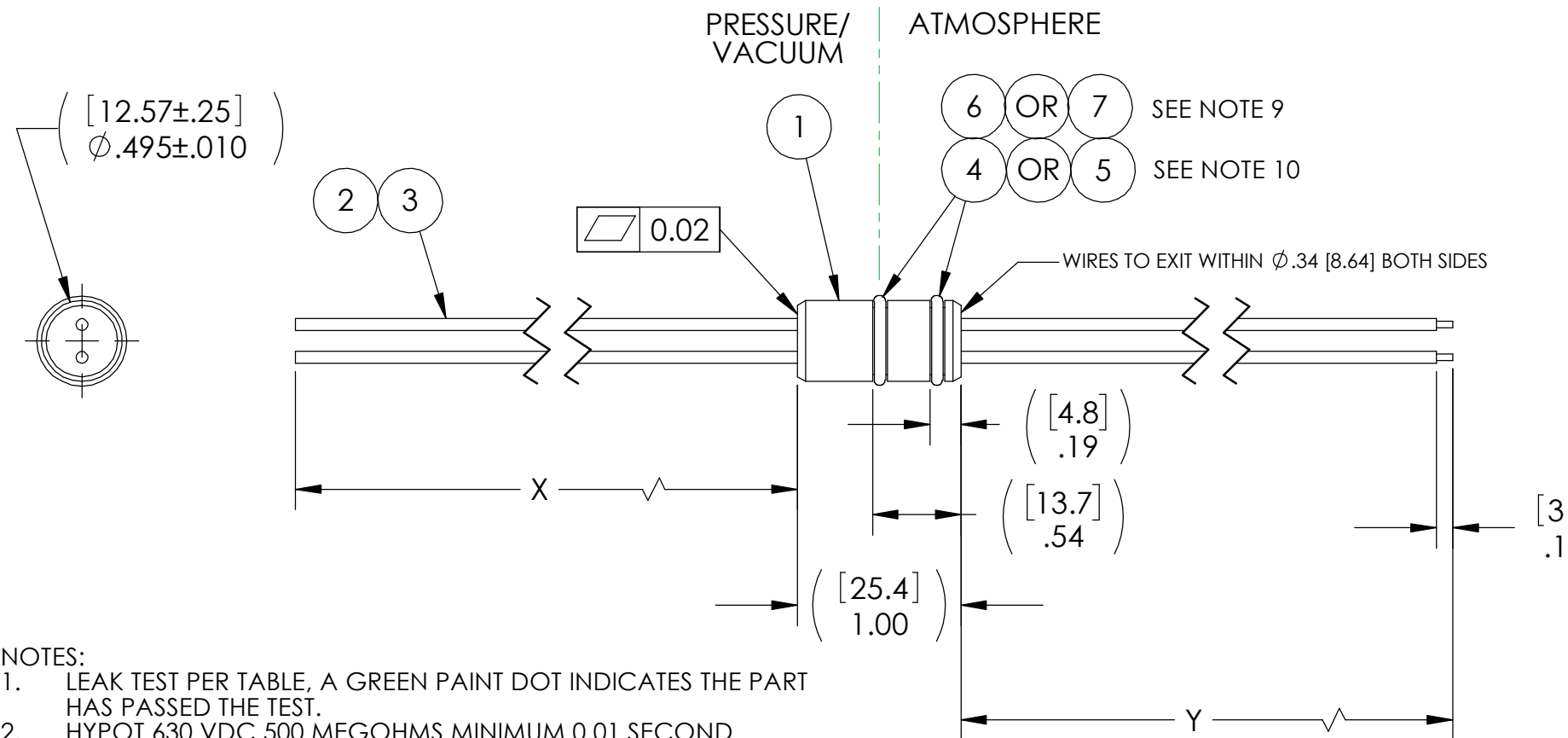


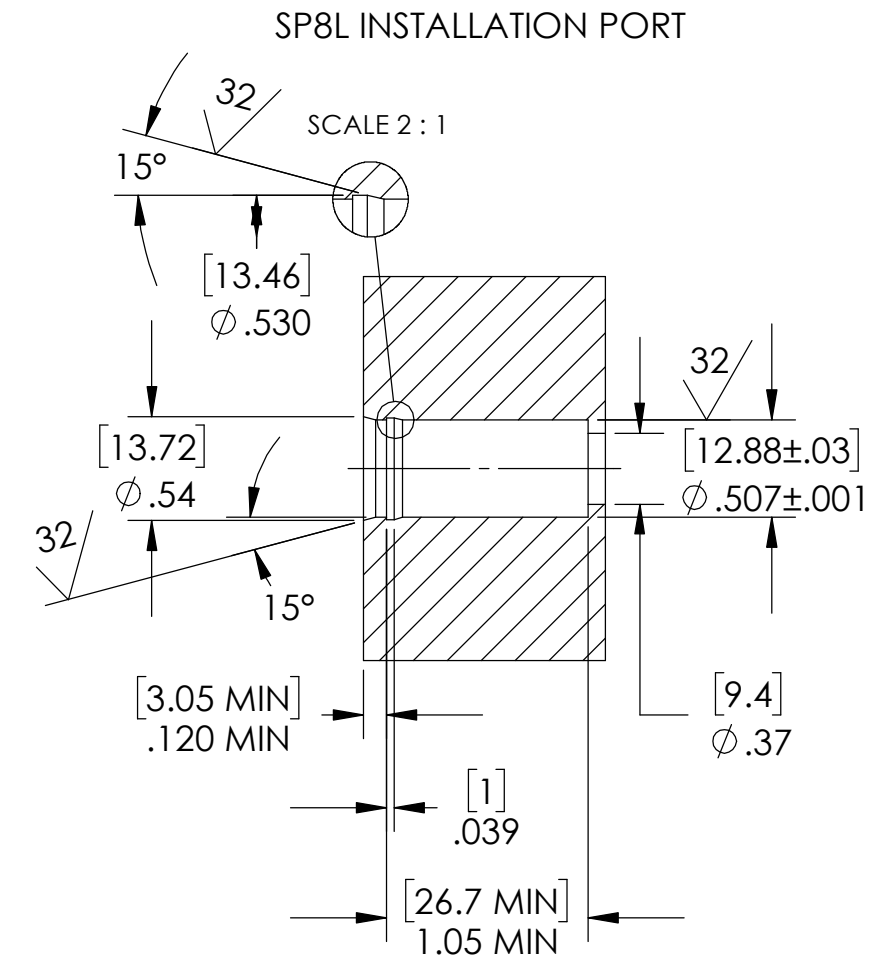
2390	11.5±.25 [292.1±6.35]	6±.25 [152.4±6.35]	SP8L-E-200UL94-2-TEE18-12-6	80 PSI, NO BUBBLES 1 MINUTE MINIMUM
2390-1	4±.25 [101.6±6.35]	10.0±.25 [254.0±6.35]	SP8L-E-200UL94-2-TEE18-4-10	80 PSI, NO BUBBLES 45 SECONDS MINIMUM
2390-2	19.7 MIN [500 MIN]	19.7 MIN [500 MIN]	SP8L-E-200UL94-2-TEE18-50-50cm	HE LEAK TEST @ 1 ATM. 1X10 ⁻⁸ CC/SEC OR LESS
2390-3	3.4±.25 [86.4±6.35]	6±.25 [152.4±6.35]	SP8L-E-200UL94-2-TEE18-3.4-6	80 PSI, NO BUBBLES 30 SECONDS MINIMUM
2390-4	19.7 MIN [500 MIN]	39.4 MIN [1000 MIN]	SP8L-E-200UL94-2-TEE18-50-100cm	HE LEAK TEST @ 1 ATM. 1X10 ⁻⁸ CC/SEC OR LESS
2390-5	11.5±.25 [292.1±6.35]	6±.25 [152.4±6.35]	SP8L-E-200UL94-2-TEE18-12-6	HE LEAK TEST @ 1100 PSI, 1X10 ⁻⁶ CC/SEC OR LESS
PAVE#	X	Y	PAVE DESCRIPTION	LEAK TEST



NOTES:

- LEAK TEST PER TABLE, A GREEN PAINT DOT INDICATES THE PART HAS PASSED THE TEST.
- HYPOT 630 VDC 500 MEGOHMS MINIMUM 0.01 SECOND MINIMUM WIRE TO WIRE.
- ALL TESTS ARE PERFORMED AT ROOM TEMPERATURE.
- ALL PARTS MUST PASS ALL TESTS.
- WIRES ARE NOT REQUIRED TO BEND SHARPLY AT EPOXY SEAL SURFACE.
- COSMETIC SURFACE VOIDS NOT ON O-RING SEALING SURFACES ARE ACCEPTABLE BASED ON THE SEAL'S DIAMETER:
 <= .5 [12.7] SEAL DIAMETER: ϕ .035 [.89] MAX ALLOWED VOID SIZE
 > .5 [12.7] SEAL DIAMETER: ϕ .060 [1.5] MAX ALLOWED VOID SIZE
 REF-PARTS ARE DEFLASHED ON PARTING LINE +0.005 [0.13] MAXIMUM.
- REF-OPERATING TEMPERATURE RANGE -40°C TO 150°C, FOR 2390-4 ONLY TEMPERATURE RANGE IS -59°C TO 120°C.
- USE ITEM 7 (FOMBLIN YVAC 3) FOR 2390-2, 2390-4 & 2390-5 ONLY, ALL OTHERS USE ITEM 6 (PARKER O-LUBE).
- FOR 2390-4 ONLY USE ITEM 5 (-012 BUTYL), ALL OTHERS USE ITEM 4 (-012 VITON LT).
- 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.
- DIMENSIONS ARE INCHES [millimeters].

7	A/R	FOMBLIN YVAC 3	LUBRICANT O-RING FOMBLIN GREASE
6	A/R	PARKER O-LUBE	LUBRICANT O-RING BARIUM-BASED
5	2	-012 BUTYL	O-RING -012 BUTYL B612-70
4	2	-012 VITON LT	O-RING -012 LOW-TEMP VITON 75
3	1	EE18 RED	WIRE 18EE MIL-W-16878/5 .015 19 STRAND
2	1	EE18 BLACK	WIRE 18EE MIL-W-16878/5 .015 19 STRAND
1	A/R	PAVE-Seal 200UL94	EPOXY BLACK
ITEM	QTY	PART NUMBER	DESCRIPTION



USE TRUARC N5000-50 RETAINING RING OR EQUAL
IF REMOVED FROM PORT, REPLACE O-RINGS

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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 Dayton, OH 45414-3445
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 tel (937) 890-1100
 fax (937) 8905165
 www.pavetechnologyco.com

DESCRIPTION
SEE TABLE

PART NUMBER
2390

MATERIAL NOTED

REVISION LEVEL
W

PROJECTION