



RECOMMENDED RETAINING RING
SMALLEY WHM-62 OR EQUAL

NOTES:

- LEAK TEST: 10,000 PSI, NO N2 BUBBLES 1 MINUTE MINIMUM. A GREEN PAINT DOT ON THE PRESSURE SIDE INDICATES THE PART HAS PASSED THE TEST.
- ALL TESTS ARE PERFORMED AT ROOM TEMPERATURE.
- ALL PARTS MUST PASS ALL TESTS.
- COSMETIC SURFACE VOIDS NOT ON O-RING SEALING SURFACES ARE ACCEPTABLE BASED ON THE SEAL'S DIAMETER:
 $\leq .5$ [12.7] SEAL DIAMETER: $\phi .035$ [.89] MAX ALLOWED VOID SIZE
 $> .5$ [12.7] SEAL DIAMETER: $\phi .060$ [1.5] MAX ALLOWED VOID SIZE
- REF-OPERATING TEMPERATURE RANGE -20 °C TO 150 °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.

ITEM	QTY	PART NUMBER	DESCRIPTION
4	2	B-U M8791-1-013	BACK UP RING -013 SINGLE TURN
3	A/R	PARKER O-LUBE	LUBRICANT O-RING BARIUM-BASED
2	3	-013 VITON	O-RING -013 VITON 75
1	A/R	PAVE-Seal 200	EPOXY BLACK

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DESCRIPTION
SP9/128-E-200-DUMMY PLUG

PART NUMBER
5480

MATERIAL NOTED

REVISION LEVEL -

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