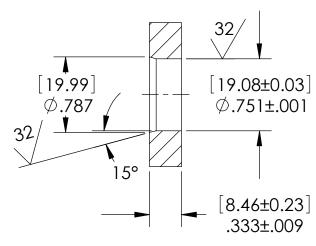


SPF12 INSTALLATION PORT



RECOMMENDED RETAINING RING TRUARC #5100-75 OR EQUAL

NOTES:

- HE LEAK TEST @ 1 ATM. 1X10^-7 CC/SEC OR LESS. A GREEN PAINT DOT ON THE ATMOSPHERE SIDE INDICATES THE PART HAS PASSED THE TEST.
- HYPOT 2500 VDC, 10uA MAX LEAKAGE, 1 SECOND MINIMUM ROD TO ROD, THEN BOTH RODS TO TEST PORT.
- 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:
 <= .5 [12.7] SEAL DIAMETER: \$\Omega\$.035 [.89] MAX ALLOWED VOID SIZE
 > .5 [12.7] SEAL DIAMETER: \$\Omega\$.060 [1.5] MAX ALLOWED VOID SIZE
 REF-OPERATING TEMPERATURE RANGE -20 °C TO 125 °C.
- DIMENSIONS ARE INCHES [millimeters].
- DIMENSION IS OVER-ALL-LENGTH EXCLUDING OVERFILL ON ATMOSPHERE SIDE OF HOUSING.
- REF-PARTS ARE DEFLASHED ON PARTING LINE +0.005 [0.13] MAXIMUM.
- 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. ALCOHOL NEEDS TO BE USED TO LUBRICATE O-RINGS FOR VACUUM HELIUM LEAK TESTING AND PORT INSTALLATION.

ITEM	QTY	PART NUMBER	DESCRIPTION	5/20	REVISION LEVEL _	PROJECTION O
1	1	0130	HOUSING SPF12-E	PART NUMBER	ART NUMBER MATERIAL NOTED	
2	A/R	PAVE-Seal 150	EPOXY BLACK	SPF12-E-150-2032SS65		
3	2	5733	ROD .032 \$\$	O	W.C.	fax (937) 8905165 www.pavetechnologyco.com
4	1	-016 VITON	O-RING -016 VITON 75	PAVE techno	10011 (0).	Dayton, OH 45414-3445 U.S.A. tel (937) 890-1100
				6 0		2751 Thunderhawk Court

ALL DIMENSIONS AND TOLERANCES APPLY TO FINISHED PART IN INCHES. ALLOWABILE 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