



NOTES:

1. **2519 ONLY:** HE LEAK TEST @ 1 ATM. 1X10<sup>-7</sup> CC/SEC OR LESS. **2519 QUALIFICATION ONLY:** LEAK TEST @ 1450 PSI (100 BAR), NO N2 BUBBLES 45 SECONDS MINIMUM. **2519-1 ONLY:** LEAK TEST @ 2000 PSI, NO N2 BUBBLES 5 MINUTES MINIMUM. A GREEN PAINT DOT ON THE ATMOSPHERE SIDE INDICATES THE PART HAS PASSED THE SPECIFIED LEAK TEST.
2. HYPOT 1000 VDC 100 MEGOHMS MINIMUM 0.01 SECOND MINIMUM WIRE TO WIRE.
3. ALL TESTS ARE PERFORMED AT ROOM TEMPERATURE.
4. ALL PARTS MUST PASS ALL TESTS.
5. WIRES ARE NOT REQUIRED TO BEND SHARPLY AT EPOXY SEAL SURFACE.
6. 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
7. WIRE POSITIONING IS APPROXIMATE & VARIABLE.
8. DIMENSIONS ARE INCHES [millimeters].
9. DIMENSION IS OVER-ALL-LENGTH EXCLUDING OVERFILL ON PRESSURE SIDE OF HOUSING.
10. REF-PARTS ARE DEFLASHED ON PARTING LINE +0.005 [0.13] MAXIMUM.
11. 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.
12. REF-OPERATING TEMPERATURE RANGE -56 °C TO 125 °C.

10	A/R	PAVE-Seal 200	EPOXY BLACK
9	1	TFEMF22 WHT/RED	WIRE 22TFEMF M22759/7-22-92 19#34 .022
8	1	TFEMF22 WHT/YEL	WIRE 22TFEMF M22759/7-22-94 19#34 .022
7	1	TFEMF22 WHT/GRN	WIRE 22TFEMF M22759/7-22-95 19#34 .022
6	1	TFEMF22 RED	WIRE 22TFEMF M22759/7-22-2 19#34 .022
5	1	TFEMF22 WHITE	WIRE 22TFEMF M22759/7-22-9 19#34 .022
4	1	TFEMF22 WHT/ORG	WIRE 22TFEMF M22759/7-22-93 19#34 .022
3	A/R	SUPER O-LUBE	LUBRICANT O-RING SILICONE-BASED
2	2	-012 EP	O-RING -012 ETHYLENE PROPYLENE NAS1611-012 OR EQUAL
1	1	1226M	HOUSING SP8M-E
<b>ITEM</b>	<b>QTY</b>	<b>PART NUMBER</b>	<b>DESCRIPTION</b>

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DESCRIPTION  
 SP8M-E-200-6-TE22-50mm-350mm

PART NUMBER  
**2519**

MATERIAL NOTED

REVISION LEVEL  
 D

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