



- NOTES:
1. HE LEAK TEST @1 ATM.  $1 \times 10^{-6}$  CC/S OR LESS. LUBRICATE O-RING WITH ALCOHOL BEFORE INSTALLING INTO PORT.
  2. HYPOT 1000 VDC 500 MΩ 0.01 SEC MINIMUM, WIRE TO WIRE AND SHIELD.
  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. SOLDER ITEM 3 TO 6, ITEM 4 TO 7, AND ITEM 5 TO THE CENTER CONDUCTOR OF ITEM 8 WITHIN EPOXY.
  7. WIRE COLOR POSITIONS ARE APPROXIMATE AND VARIABLE.
  8. SOME PORTION OF SHIELDING MUST BE EMBEDDED IN THE EPOXY.
  9. DIMENSIONS ARE INCHES [millimeters].
  10. 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
  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.

9	2	-015 VITON	O-RING -015 VITON 75 BROWN ONLY
8	1	RG174U	CABLE COAX .110DIA PVC+PE
7	1	RB18 RED	WIRE 18 RUBBER ALPHA 1636 RED OR EQUAL
6	1	RB18 BLACK	WIRE 18 RUBBER ALPHA 1636 BLACK OR EQUAL
5	1	E26 WHITE	WIRE 26E MIL-W-16878/4 7/#34
4	1	E26 RED	WIRE 26E MIL-W-16878/4 7/#34
3	1	E26 BLACK	WIRE 26E MIL-W-16878/4 7/#34
2	A/R	PAVE-Seal 150	EPOXY BLACK
1	1	1374M	HOUSING SP11M-E
ITEM	QTY	PART#	DESCRIPTION

ALL DIMENSIONS AND TOLERANCES APPLY TO FINISHED PART IN INCHES  
 ALLOWABLE TOLERANCES UNLESS SPECIFIED OTHERWISE: NONE +/-0.5  
 .X DECIMAL +/- 0.1 .XX DECIMAL +/- 0.02 .XXX DECIMAL +/-0.005  
 ANGLES +/- 1 DEG SURFACE FINISH 128 microinch RMS

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DESCRIPTION **PAVE-Seal® Cable Harnesses**  
**SP11M-E-150-2/1-3-TEE18/RG174-TEE26-18-6**

PART NUMBER **2890**

REVISION LEVEL **C**

PROJECTION