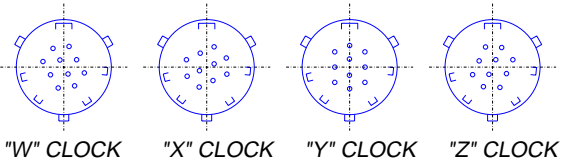
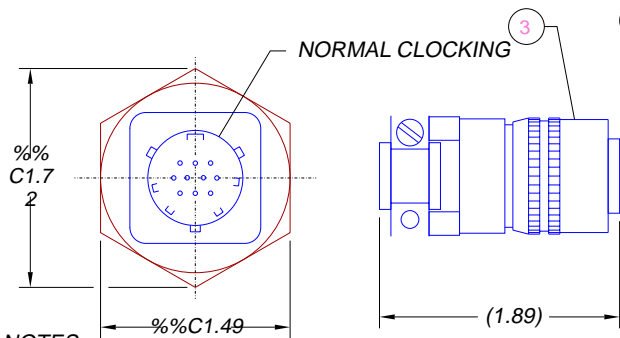


FACE VIEW OF (ITEM 1) PIN INSERTS



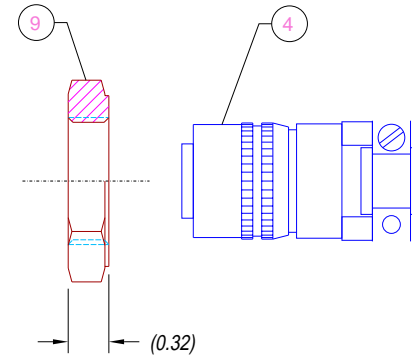
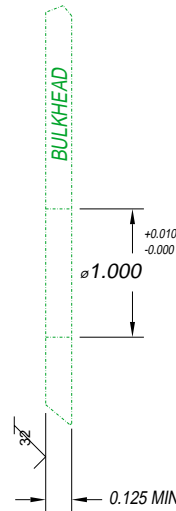
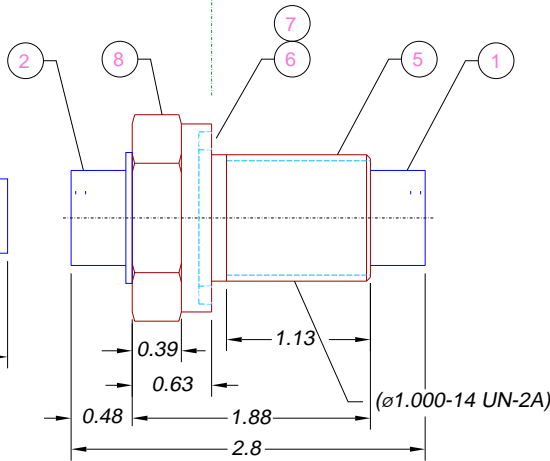
"W" CLOCK "X" CLOCK "Y" CLOCK "Z" CLOCK



NOTES:

1. HE LEAK TEST @1 ATM. 10^{-7} CC/S
2. HYPOT 630 VDC 500 MEGOHMS 0.01 SEC MINIMUM, PINS TO SOCKETS & THREADS W/MATING PLUGS.
3. ALTERNATE CLOCKING (W, X, Y OR Z) IS INDICATED BY APPENDING THE APPROPRIATE LETTER TO THE PART NUMBER AND TO THE PAVE ORDER CODE. THE SAME LETTER IS THEN ADDED TO ITEMS 1 THRU 4 (E.G., FOR AN X CLOCK 1656* USE "1656X" & ITEM 1 IS SC3112E12-10PX.).
4. ADDING "NP" TO PART NUMBER & ORDER CODE INDICATES THAT ITEMS 3 & 4 AREN'T TO BE INCLUDED.
5. ADDING "+PT" TO PART NUMBER & ORDER CODE INDICATES A 200PSI HELIUM TEST THREAD SIDE 10^{-10}-cc/s.
6. ALL TESTS DONE AT ROOM TEMPERATURE.
7. PERCENTAGE OF PARTS TESTED WILL BE 100% (MAY BE A LESSER PERCENTAGE FOR LARGE PRODUCTION QUANTITIES, UNLESS OTHERWISE NOTED OR REQUIRED).
8. TORQUE LABEL -PAVE (1656*) Dayton, OH USA TIGHTEN TO 27.12 Nm MAXIMUM

ATMOSPHERE VACUUM



9	1	0183	NUT VS15-SS
8	A/R	PAVE-Seal 150	EPOXY BLACK
7	A/R	SUPER O-LUBE	LUBRICANT O-RING SILICONE
6	1	-215 VITON	O-RING -215 VITON 75
5	1	0181	INSERT VS15L-SS
4	1	SC3126F12-10S	PLUG 10 #20 SOC
3	1	SC3126F12-10P	PLUG 10 #20 PIN
2	1	SC3112E12-10S	RCPT 10 #20 SOC
1	1	SC3112E12-10P	RCPT 10 #20 PIN
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

PAVE technology 2751 Thunderhawk Court
 Dayton, Ohio 45414-3445
 U.S.A.
 (937)890-1100
 fax (937)890-5165
 www.pavetechnologyco.com

DESCRIPTION
VS15L-E-150-10-20-3112SP

PART NUMBER
1656R

REVISION LEVEL
 -

PROJECTION