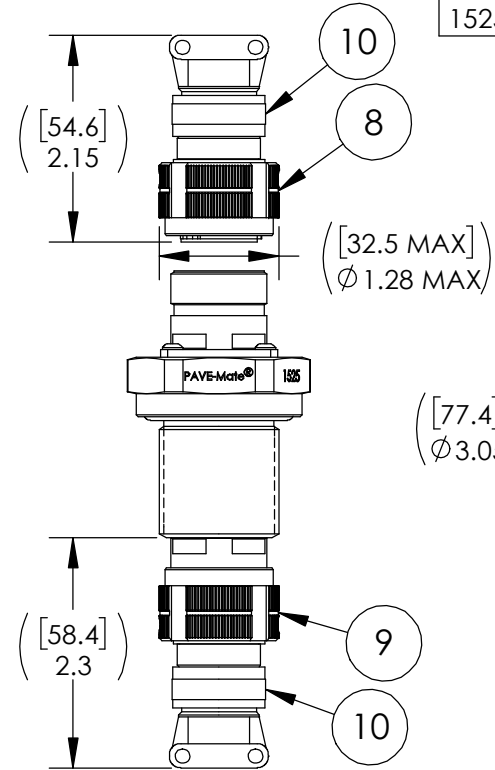
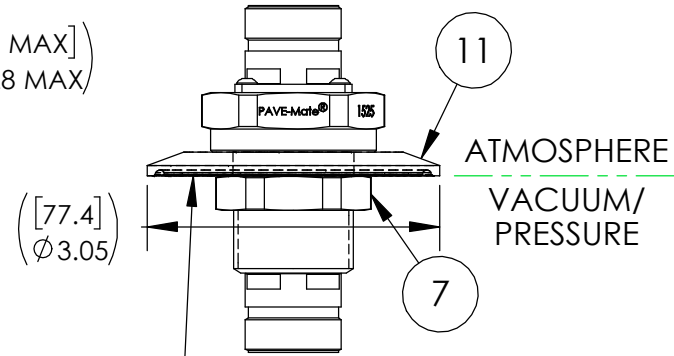


1525 REF-ASSEMBLY  
SCALE: 1:2

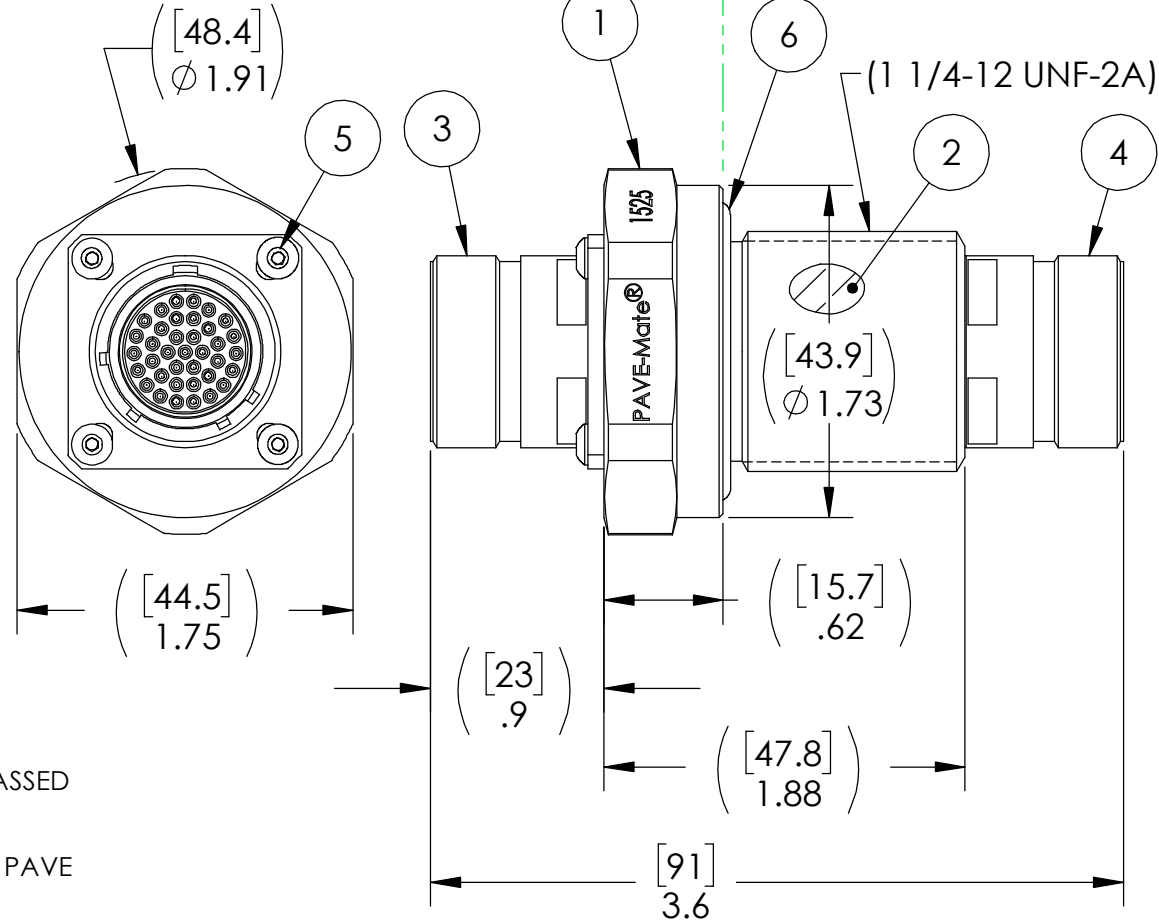


PAVE#	ITEM 6	ITEM 6 DESCRIPTION	TEMPERATURE
ALL VERSIONS EXCEPT 1525-1	-219 VITON LT	O-RING -219 VITON 75 LOW TEMP	-40 °C TO 125 °C
1525-1	-219 EPDM	O-RING -219 EPDM 70	-56 °C TO 121 °C

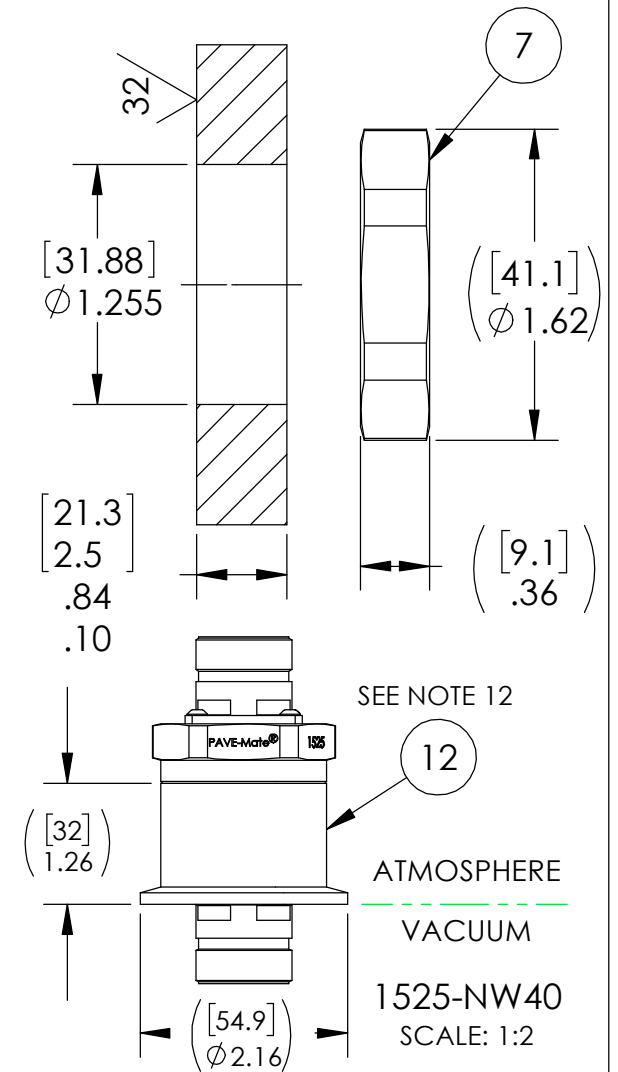
1525-TRI-C  
SCALE: 1:2



1525-TRI-C ONLY IS LEAK TESTED AND SHIPS MOUNTED TO A 2.5" TRI-CLAMP FLANGE AS SHOWN. MATING 2.5" TRI-CLAMP FLANGE AND ELASTOMER GASKET MUST HAVE A MINIMUM ID OF Ø 1.67" FOR JAM NUT CLEARANCE.



VS18 INSTALLATION PORT



NOTES:

- A GREEN PAINT DOT ON THE ATMOSPHERE SIDE INDICATES THE PART HAS PASSED THE HELIUM LEAK TEST:  
a.) FOR ALL VERSIONS: HE LEAK TEST @ 1 ATM. 1X10<sup>-7</sup> CC/SEC OR LESS.  
b.) FOR A LOWER LEAK RATE OF 1X10<sup>-9</sup> CC/SEC OR LESS, ADD "LL" TO THE PAVE PART NUMBER. (E.G. 1525LL, 1525-ELL, ETC.)  
c.) FOR 1525-TRI-C ONLY: ADDITIONAL LEAK TEST 80 PSI, NO BUBBLES 30 SECONDS MINIMUM USING A BUNA GASKET (NOT SUPPLIED). AN ADDITIONAL GREEN PAINT DOT INDICATES THE PART HAS PASSED THIS TEST.
- HYPOT 1000 VDC 500 MEGOHMS MINIMUM 0.01 SECOND MINIMUM PIN TO PIN AND HOUSING WITH MATING CONNECTORS.
- CONTINUITY TEST <1.0 OHM PIN TO SOCKET WITH MATING CONNECTORS.
- ALCOHOL OR FOMBLIN YVAC 3 MAY BE USED TO LUBRICATE O-RINGS FOR VACUUM HELIUM LEAK TESTING.
- ALL TESTS ARE PERFORMED AT ROOM TEMPERATURE.
- ALL PARTS MUST PASS ALL TESTS.
- ALTERNATE CLOCKING IS INDICATED BY ADDING AN "A", "B", "C", "D", OR "E" TO THE END OF THE PAVE PART NUMBER AND DESCRIPTION. THIS ALSO CHANGES THE "N" AT THE END OF THE PART# OF ITEMS 3, 4, 8, & 9 TO THE SAME CLOCKING LETTER.
- ITEMS 8, 9, & 10 ARE INCLUDED UNLESS "NP" IS ADDED TO THE PAVE PART NUMBER AND DESCRIPTION (NO PLUGS).
- REF-OPERATING TEMPERATURE RANGE SEE TABLE.
- 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.
- 1525-NW40 ONLY SHIPS INSTALLED AND LEAK TESTED, PER NOTE 1, IN ITEM 17 (NW40 ADAPTER) AND DOES NOT INCLUDE ITEM 7 (JAM NUT). THE MATING NW40 CONNECTION MUST HAVE A MINIMUM ID OF Ø 1.30 [33] FOR PLUG CLEARANCE.

12	1	5134 <sup>*1525-NW40 ONLY</sup>	HOUSING NW40-SS VS18 ADAPTER
11	1	5453 <sup>*1525-TRI-C ONLY</sup>	FLANGE TRI-CLAMP 2.5" (3.05" OD) 316SS VS18 ADAPTER
10	2	M85049-38-15N <sup>*SEE NOTE 8</sup>	STRAIN RELIEF 38999 SHELL 15 NICKEL PLATED ALUMINUM
9	1	26FD35PN <sup>*SEE NOTES 7 &amp; 8</sup>	PLUG 37#22 PIN NICKEL PLATED ALUMINUM SHELL GOLD PLATED COPPER ALLOY CRIMP CONTACTS
8	1	26FD35SN <sup>*SEE NOTES 7 &amp; 8</sup>	PLUG 37#22 SOCKET NICKEL PLATED ALUMINUM SHELL GOLD PLATED COPPER ALLOY CRIMP CONTACTS
7	1	1014 <sup>*SEE NOTE 12</sup>	NUT VS18-SS
6	1	SEE TABLE	SEE TABLE
5	4	1608-25	SCREW 4-40 X .25 BH SOC SS
4	1	20FD35SN <sup>*SEE NOTE 7</sup>	RCPT 37#22 SOCKET NICKEL PLATED ALUMINUM SHELL GOLD PLATED COPPER ALLOY CONTACTS
3	1	20FD35PN <sup>*SEE NOTE 7</sup>	RCPT 37#22 PIN NICKEL PLATED ALUMINUM SHELL GOLD PLATED COPPER ALLOY CONTACTS
2	A/R	PAVE-Seal 150	EPOXY BLACK
1	1	3389	HOUSING VS18-SS
ITEM	QTY	PART NUMBER	DESCRIPTION

**PAVE technology co.**  
2751 Thunderhawk Court  
Dayton, OH 45414-3445  
U.S.A.  
tel (937) 890-1100  
fax (937) 8905165  
www.pavetechnologyco.com

DESCRIPTION  
VS18-SS-150-37-22-99920PS

PART NUMBER  
**1525**

MATERIAL  
NOTED

REVISION LEVEL  
Q

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