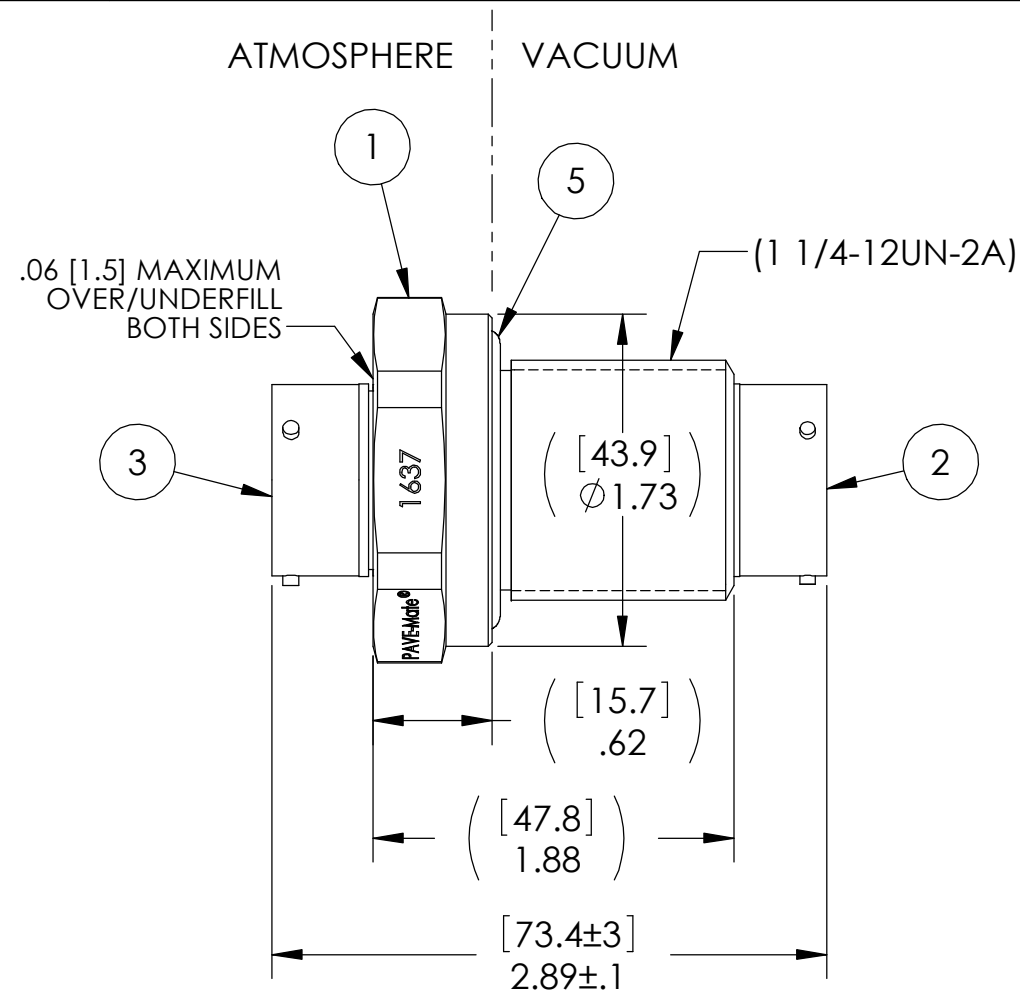
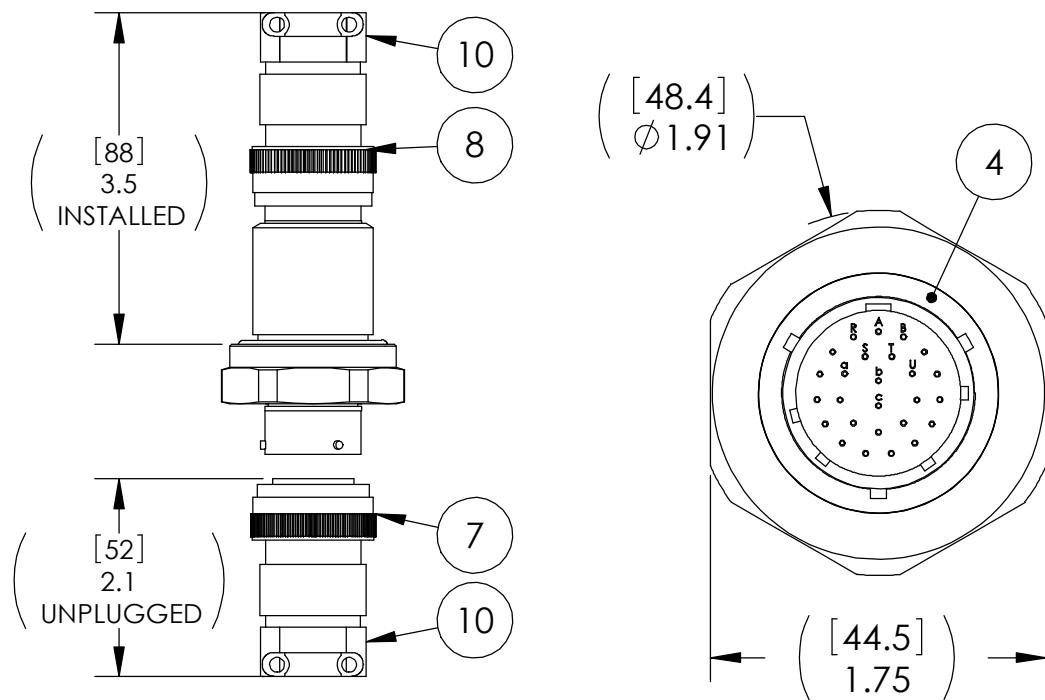
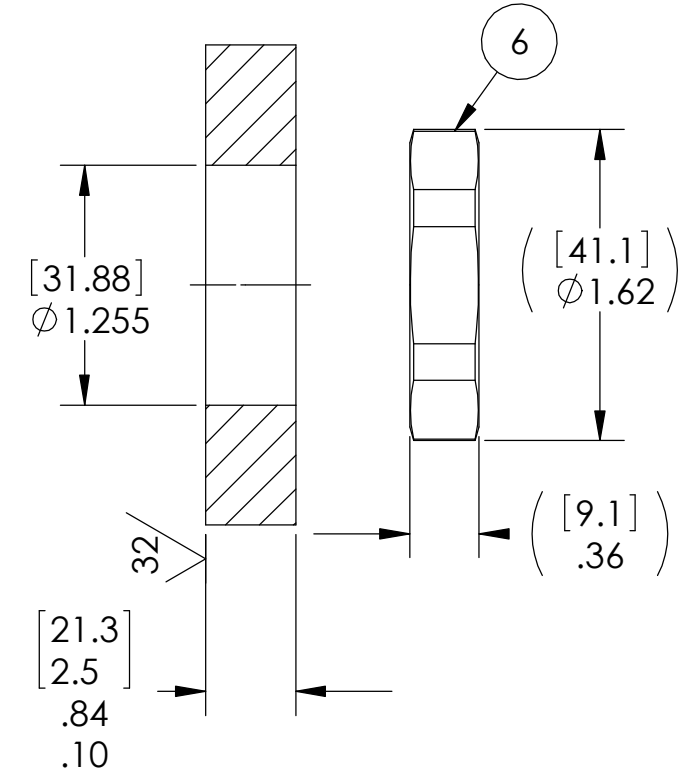


SCALE: 1:2



VS18 INSTALLATION PORT



NOTES:

1. HE LEAK TEST @ 1 ATM. 1X10⁻⁷ CC/SEC OR LESS. EXCEPT FOR 1637, A GREEN PAINT DOT ON THE ATMOSPHERE SIDE INDICATES THE PART HAS PASSED THE TEST.
2. HYPOT 1000 VDC 500 MEGOHMS MINIMUM 0.01 SECOND MINIMUM WIRE TO WIRE AND HOUSING WITH MATING CONNECTORS.
3. ALCOHOL OR FOMBLIN YVAC 3 MAY BE USED TO LUBRICATE O-RINGS FOR VACUUM HELIUM LEAK TESTING.
4. CONTINUITY TEST: <1 OHM PIN TO SOCKET WITH MATING CONNECTORS.
5. ALL TESTS ARE PERFORMED AT ROOM TEMPERATURE.
6. ALL PARTS MUST PASS ALL TESTS.
7. ITEMS 9 IS LISTED, BUT NOT SHOWN.
8. 1637: DOES NOT INCLUDE ITEMS 7, 8, 9, & 10 (NO PLUGS)
1637-1: INCLUDES ITEMS 7, 8, & 10 FOR MATING PLUGS.
1637-2: INCLUDES ITEMS 7, 8, & 9 FOR MATING PLUGS.
1637-R: INCLUDES ITEMS 7, 8, & 10 FOR MATING PLUGS.
1637EMI: INCLUDES ITEMS 7, 8, & 10 FOR MATING PLUGS.
9. ONLY PART# 1637: THESE PARTS ARE CLEANED IN A DEGREASER SOLVENT VAPOR THEN PACKAGED IN A LAMINAR FLOW HOOD PROVIDING AN ISO CLASS 5 (CLASS 100) ENVIRONMENT WITHIN THE WORK AREA.
10. THERMAL CYCLE 105°C TO -40°C 3 CYCLES 2HR. HOLD.
11. 1637-R: ITEM 2 IS ON ATMOSPHERE SIDE & ITEMS 3 ON VACUUM SIDE (REVERSE PINS AND SOCKETS).
12. COSMETIC SURFACE VOIDS NOT ON O-RING SEALING SURFACES ARE ACCEPTABLE BASED ON THE SEAL'S DIAMETER:
<= .5 [12.7] SEAL DIAMETER: ϕ .035 [.89] MAX ALLOWED VOID SIZE
> .5 [12.7] SEAL DIAMETER: ϕ .060 [1.5] MAX ALLOWED VOID SIZE
13. REF-OPERATING TEMPERATURE RANGE -20°C TO 125°C.
14. DIMENSIONS ARE INCHES [millimeters].
15. 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.
16. 1637EMI: HAS AN ELECTRICAL CONNECTION BETWEEN THE RECEPTACLE SHELLS (ITEMS 2 & 3).

ITEM	QTY	PART NUMBER	DESCRIPTION
10	SEE NOTE 8	M85049/52-1-16N	STRAIN RELIEF CLAMP SHELL SIZE 16, STRAIGHT, NON SELF-LOCKING, NICKEL PLATED ALUMINUM
9	SEE NOTE 7 & 8	M85049/51-1-16N	STRAIN RELIEF CLAMP SHELL SIZE 16, RIGHT ANGLE 90 DEGREES, NON SELF-LOCKING, NICKEL PLATED ALUMINUM
8	SEE NOTE 8	AE776L16-26P513	PLUG 26#20 GOLD PLATED COPPER ALLOY CRIMP PINS, EPOXY INSERT, NICKEL PLATED ALUMINUM SHELL
7	SEE NOTE 8	MS3476L16-26S	PLUG 26#20 GOLD PLATED COPPER ALLOY CRIMP SOCKETS, RIGID DIELECTRIC INSERT, SILICONE GROMMET, NICKEL PLATED ALUMINUM SHELL
6	1	1014	NUT VS18-SS
5	1	-219 VITON	O-RING -219 VITON 75
4	A/R	PAVE-Seal 150	EPOXY BLACK
3	1	SC3112E16-26P	RCPT 26#20 GOLD PLATED COPPER ALLOY PINS, NEOPRENE INSERT, NICKEL PLATED ALUMINUM SHELL
2	1	AE771L16-26S460	RCPT 26#20 GOLD PLATED COPPER ALLOY SOCKETS, EPOXY INSERT, NICKEL PLATED ALUMINUM SHELL
1	1	3207	HOUSING VS18-SS

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DESCRIPTION
VS18-SS-150-26-20-3112PS

PART NUMBER
1637

MATERIAL NOTED

REVISION LEVEL X

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