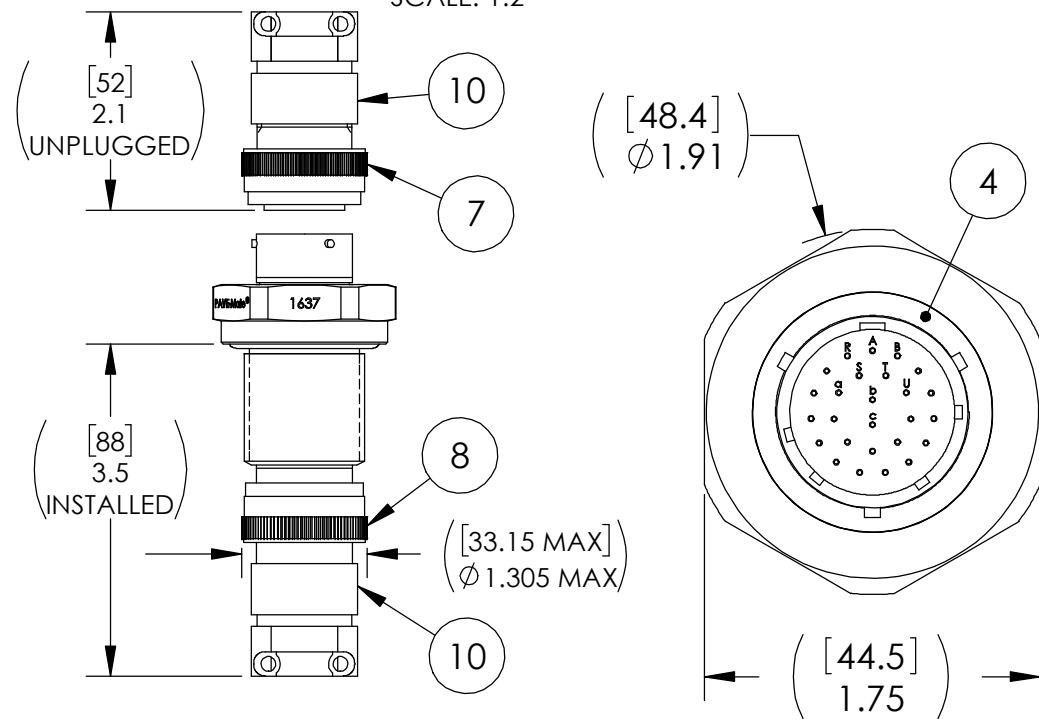


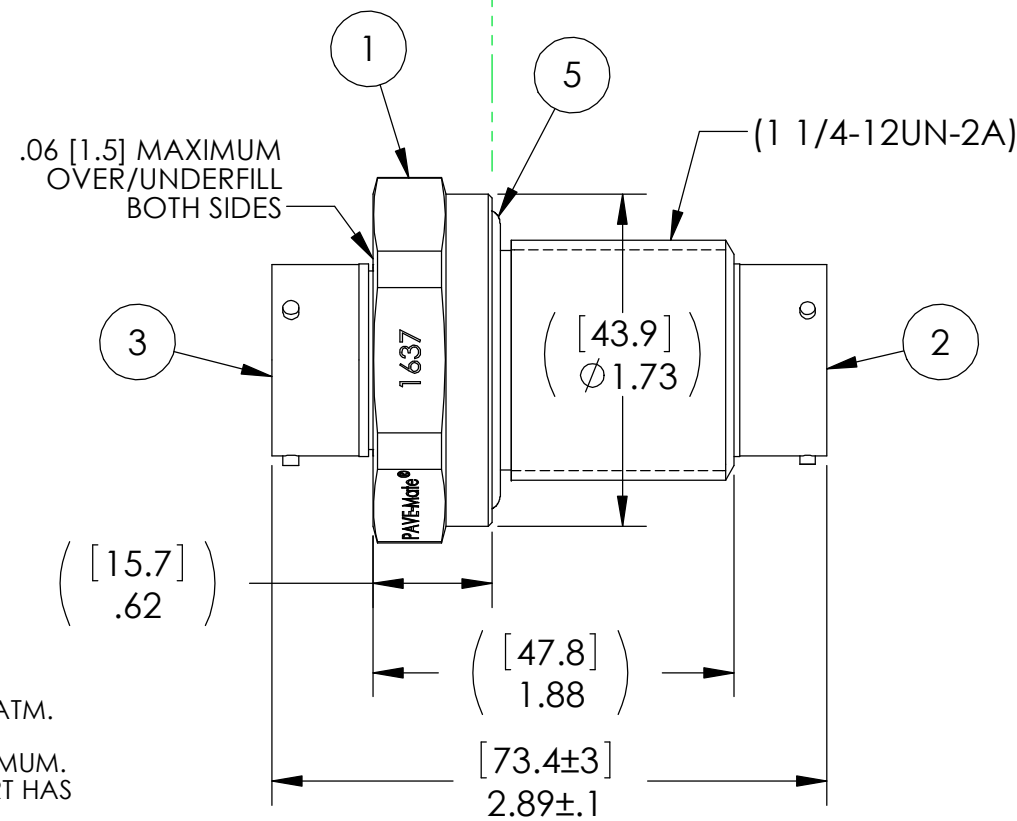
REF-ASSEMBLY W/PLUGS

SCALE: 1:2

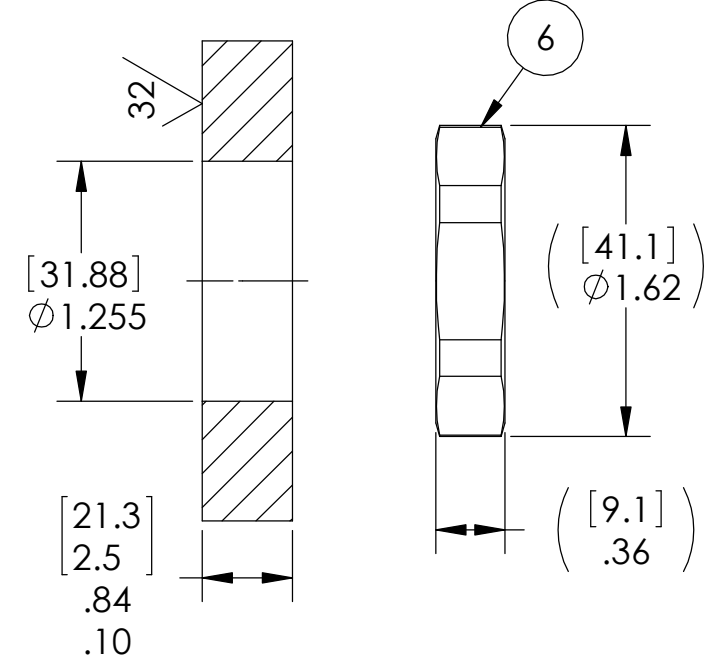


ATMOSPHERE
PRESSURE

VACUUM (SEE NOTE 1)
ATMOSPHERE (SEE NOTE 1)

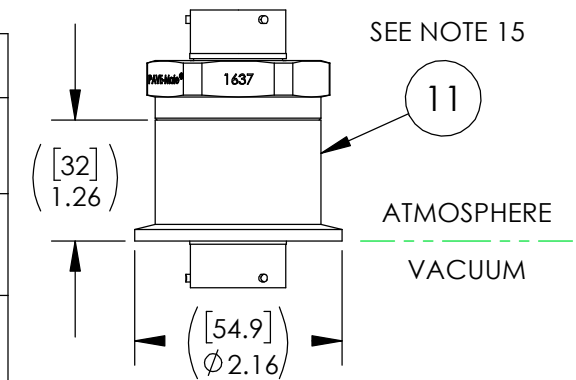


VS18 INSTALLATION PORT



1637-NW40

SCALE: 1:2



NOTES:

- FOR 1637, 1637-1, 1637-2, 1637-R, 1637EMI & 1637-NW40 ONLY: HE LEAK TEST @ 1 ATM. 1X10⁻⁶ CC/SEC OR LESS.
FOR 1637-4 ONLY: LEAK TEST 1100 PSI HEX SIDE, NO N₂ BUBBLES 30 SECONDS MINIMUM. EXCEPT FOR 1637, A GREEN PAINT DOT ON THE HOUSING HEX INDICATES THE PART HAS PASSED THE SPECIFIED LEAK TEST.
- HYPOT 1000 VDC 500 MEGOHMS MINIMUM 0.01 SECOND MINIMUM PIN TO PIN AND HOUSING WITH MATING CONNECTORS.
- ALCOHOL OR FOMBLIN YVAC 3 MAY BE USED TO LUBRICATE O-RINGS FOR VACUUM HELIUM LEAK TESTING.
- CONTINUITY TEST: <1 OHM PIN TO SOCKET WITH MATING CONNECTORS.
- ALL TESTS ARE PERFORMED AT ROOM TEMPERATURE, ALL PARTS MUST PASS ALL TESTS.
- ITEM 9 IS LISTED AND INCLUDED WITH 1637-2, BUT NOT SHOWN.
- 1637: DOES NOT INCLUDE ITEMS 7, 8, 9, OR 10 (NO PLUGS).
1637-1: INCLUDES ITEMS 7, 8, & 10 FOR MATING PLUGS W/STRAIGHT STRAIN RELIEFS.
1637-2: INCLUDES ITEMS 7, 8, & 9 FOR MATING PLUGS W/90° STRAIN RELIEFS.
1637-4: INCLUDES ITEMS 7, 8, & 10 FOR MATING PLUGS W/STRAIGHT STRAIN RELIEFS.
1637-R: INCLUDES ITEMS 7, 8, & 10 FOR MATING PLUGS W/STRAIGHT STRAIN RELIEFS.
1637-NW40: INCLUDES ITEMS 7, 8, & 10 FOR MATING PLUGS W/STRAIGHT STRAIN RELIEFS.
1637EMI: INCLUDES ITEMS 7, 8, & 10 FOR MATING PLUGS W/STRAIGHT STRAIN RELIEFS.
- 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.
- 1637-R ONLY: ITEM 2 IS ON ATMOSPHERE SIDE & ITEMS 3 ON VACUUM SIDE (REVERSE PINS AND SOCKETS).
- COSMETIC SURFACE VOIDS NOT ON O-RING SEALING SURFACES ARE ACCEPTABLE BASED ON THE SEAL'S DIAMETER:
<= .5 [12.7] SEAL DIAMETER: Ø .035 [.89] MAX ALLOWED VOID SIZE
> .5 [12.7] SEAL DIAMETER: Ø .060 [1.5] MAX ALLOWED VOID SIZE
- REF-OPERATING TEMPERATURE RANGE -20°C TO 125°C.
- 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.
- 1637EMI ONLY: HAS AN ELECTRICAL CONNECTION BETWEEN THE RECEPTACLE SHELLS (ITEMS 2 & 3).
- 1637-NW40 ONLY: SHIPS INSTALLED AND LEAK TESTED, PER NOTE 1, IN ITEM 11 (NW40 ADAPTER) AND DOES NOT INCLUDE ITEM 6 (JAM NUT). THE MATING NW40 CONNECTION MUST HAVE A MINIMUM ID OF Ø 1.32 [33.5] FOR PLUG CLEARANCE.

11	1, SEE NOTE 15	5134	HOUSING NW40-SS VS18 ADAPTER
10	2, SEE NOTE 8	M85049/52-1-16N	STRAIN RELIEF CLAMP SHELL SIZE 16, STRAIGHT, NON SELF-LOCKING, NICKEL PLATED ALUMINUM
9	2, SEE NOTES 7 & 8	M85049/51-1-16N	STRAIN RELIEF CLAMP SHELL SIZE 16, RIGHT ANGLE 90 DEGREES, NON SELF-LOCKING, NICKEL PLATED ALUMINUM
8	1, SEE NOTE 8	AE776L16-26P513	PLUG 26#20 GOLD PLATED COPPER ALLOY CRIMP PINS, EPOXY INSERT, NICKEL PLATED ALUMINUM SHELL
7	1, 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
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-150-26-20-3112PS

PART NUMBER *SEE NOTES 1, 7, 8, 9, 14, & 15
1637*

MATERIAL NOTED

REVISION LEVEL Y

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