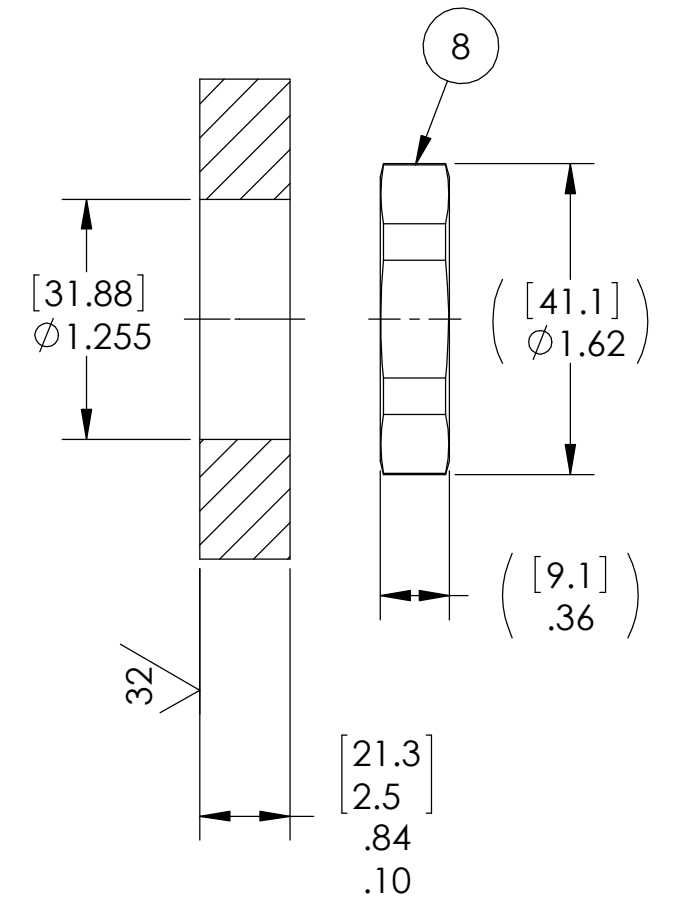


VS18 INSTALLATION PORT



NOTES:

1. FOR 1791: HE LEAK TEST @ 1 ATM.  $1 \times 10^{-7}$  CC/SEC OR LESS. FOR 1791-1: 2 LEAK TESTS @ 750 PSI, NO N<sub>2</sub> BUBBLES 1 MINUTE MINIMUM FROM BOTH DIRECTIONS. A GREEN PAINT DOT INDICATES THE PART HAS PASSED THE LEAK TEST(S).
2. HYPOT 630 VDC 500 MEGOHMS MINIMUM 0.01 SECOND MINIMUM WIRE TO WIRE AND HOUSING.
3. ALL TESTS ARE PERFORMED AT ROOM TEMPERATURE.
4. ALL PARTS MUST PASS ALL TESTS.
5. WIRE POSITIONING IS APPROXIMATE & COLOR POSITIONS ARE VARIABLE.
6. WIRES ARE NOT REQUIRED TO BEND SHARPLY AT EPOXY SEAL SURFACE.
7. 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
8. DIMENSIONS ARE INCHES [millimeters].
9. REF-OPERATING TEMPERATURE RANGE -50°C TO 105°C.
10. 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.
11. ALCOHOL OR FOMBLIN YVAC 3 MAY BE USED TO LUBRICATE O-RINGS FOR VACUUM HELIUM LEAK TESTING.

ITEM	QTY	PART NUMBER	DESCRIPTION
8	1	1014	NUT VS18-SS
7	1	-219 NITRILE LT	O-RING -219 NITRILE N0304-75
6	10	EE20 MIL YELLOW	WIRE 20EE MIL-W-16878/5 7/#28
5	7	EE20 MIL WHITE	WIRE 20EE MIL-W-16878/5 7/#28
4	10	EE20 MIL BROWN	WIRE 20EE MIL-W-16878/5 7/#28
3	10	EE20 MIL BLACK	WIRE 20EE MIL-W-16878/5 7/#28
2	1	PAVE-Seal 150	EPOXY BLACK
1	1	0660	HOUSING VS18-SS

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DESCRIPTION  
 VS18-SS-150-37-TEE20-48-48

PART NUMBER  
**1791**

MATERIAL NOTED

REVISION LEVEL  
 G

PROJECTION

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