



NOTES:

1. FOR 1791: HE LEAK TEST @1 ATM.  $10 \times 10^{-8}$  CC/S OR LESS.  
FOR 1791-1: 2 LEAK TESTS @ 750 PSI N<sub>2</sub>, NO BUBBLES 1 MINUTE MINIMUM FROM BOTH DIRECTIONS.  
A GREEN PAINT DOT INDICATES PART HAS PASSED THE TEST.
2. HYPOT 630 VDC 500 MΩ 0.01 SEC MINIMUM, WIRE TO WIRE & HOUSING.
3. ALL TESTS ARE PERFORMED AT ROOM TEMPERATURE.
4. ALL PARTS MUST PASS ALL TESTS.
5. WIRE COLOR POSITIONS MAY VARY.
6. WIRES ARE NOT REQUIRED TO BEND SHARPLY AT EPOXY SEAL SURFACE.
7. VOIDS LARGER THAN  $\phi 0.035$  [0.89] ARE NOT ACCEPTABLE.
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 LUBE O-RINGS FOR VACUUM HELIUM LEAK TESTING.

10	1	1014	NUT VS18-SS
9	1	-219 NITRILE LT	O-RING -219 NITRILE N0304-75
8	7	EE20 MIL YELLOW	WIRE 20EE MIL-W-16878/5 7/#28
7	6	EE20 MIL WHITE	WIRE 20EE MIL-W-16878/5 7/#28
6	6	EE20 MIL RED	WIRE 20EE MIL-W-16878/5 7/#28
5	6	EE20 MIL ORG	WIRE 20EE MIL-W-16878/5 7/#28
4	6	EE20 MIL GRAY	WIRE 20EE MIL-W-16878/5 7/#28
3	6	EE20 MIL BLUE	WIRE 20EE MIL-W-16878/5 7/#28
2	A/R	PAVE-Seal 150	EPOXY BLACK
1	1	0660	HOUSING VS18-SS
ITEM	QTY	PART#	DESCRIPTION

PAVE will meet the assembly and test specifications of the customer as documented on this assembly drawing. Any changes must be approved by PAVE.

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**PAVE technology co.**

DESCRIPTION PAVE-Seal Cable Harnesses  
**VS18-SS-150-37-TEE20-48-48**

PART NUMBER **1791**

REVISION LEVEL **E**

PROJECTION

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