



**NOTES:**

1. HE LEAK TEST @ 1 ATM. 1X10<sup>-7</sup> CC/SEC OR LESS. A GREEN PAINT DOT INDICATES THE PART HAS PASSED THE TEST.
2. HYPOT 630 VDC 500 MEGOHMS MINIMUM 0.01 SECOND MINIMUM WIRE TO WIRE AND HOUSING.
3. MINIMUM OF 78 GOOD WIRES (ITEM 3).
4. ALCOHOL OR FOMBLIN YVAC 3 MAY BE USED TO LUBRICATE O-RINGS FOR VACUUM HELIUM LEAK TESTING.
5. ALL TESTS ARE PERFORMED AT ROOM TEMPERATURE.
6. ALL PARTS MUST PASS ALL TESTS.
7. WIRE POSITIONING IS APPROXIMATE & VARIABLE.
8. MARK EACH WIRE ON BOTH ENDS WITH A UNIQUE LETTER OR LETTER COMBINATION (A-Z, AA-ZZ, AAA-ZZZ).
9. COSMETIC SURFACE VOIDS SMALLER THAN  $\phi 0.035$  [0.89] ARE ACCEPTABLE.
10. REF-OPERATING TEMPERATURE -40°C TO 105°C.
11. DIMENSIONS ARE INCHES [millimeters].
12. 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.

ITEM	QTY	PART NUMBER	DESCRIPTION
8	1	1014	NUT VS18-SS
7	A/R	FIT-221L 3/32 MK	TUBING SHRINK 3/32" LSZH POLYOLEFIN BLACK WITH WHITE PRINT MARKED A THRU Z
6	1	-219 NITRILE LT	O-RING -219 NITRILE N0304-75
5	1	HTN1.00 BLACK	SLEEVING 1" BRAIDED EXPANDABLE ECTFE (HALAR) BLACK
4	1	PTN1.00 BLACK	SLEEVING 1" BRAIDED EXPANDABLE PET BLACK
3	81*	E22 WHT *SEE NOTE 3	WIRE 22E MIL-W-16878/4 .010 7/#30
2	A/R	PAVE-Seal 150	EPOXY BLACK
1	1	0660	HOUSING VS18-SS

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DESCRIPTION  
 VS18-SS-150-78-TE22-4-3m

PART NUMBER  
**4671**

MATERIAL NOTED

REVISION LEVEL  
 A

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