



**NOTES:**

1. 3416 & 3416-2: LEAK TEST: 80 PSI, NO BUBBLES, MINIMUM TEST TIME PER TABLE.  
3416-1 ONLY: HE LEAK TEST @ 1 ATM. 1X10<sup>-6</sup> CC/SEC OR LESS. A GREEN APINT DOT ON THE ATMOSPHERE SIDE INDICATES THAT THE PART HAS PASSED THE SPECIFIED LEAK TEST.
2. 3416 & 3416-2: HYPOT 630 VDC 500 MEGOHMS MINIMUM 0.01 SECOND MINIMUM WIRE TO WIRE AND HOUSING.  
3416-1 ONLY: HYPOT 500 VDC 5000 MEGOHMS MINIMUM 1 SECOND MINIMUM WIRE TO WIRE AND HOUSING.
3. 3416-1 ONLY: CONTINUITY CHECK < .5Ω WIRE END TO WIRE END.
4. ALL TESTS ARE PERFORMED AT ROOM TEMPERATURE.
5. ALL PARTS MUST PASS ALL TESTS.
6. WIRE POSITIONING IS APPROXIMATE & COLOR POSITIONS VARY.
7. 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
8. REF-OPERATING TEMPERATURE RANGE -20°C TO 150°C.
9. DIMENSIONS ARE INCHES [millimeters].
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.
12. 3416-1 ONLY: HOUSINGS WILL HAVE A UNIQUE ID NUMBER MARKED ON A HEX FLAT MMDDYY-XX.
13. 3416-1 ONLY: A CMTR FOR SS MATERIAL AND A C OF C FOR THE O-RING TO BE SHIPPED WITH PART.
14. 3416-2 ONLY: EACH WIRE WILL BE MARKED WITH A UNIQUE NUMBER (1-24), USING THE SAME NUMBER ON BOTH ENDS OF THE SAME WIRE.

PAVE#	X	TEST TIME
3416	72 [1829]	6 MINUTES
3416-1	72 [1829]	N/A
3416-2	18 [457]	1.5 MINUTES

ITEM	QTY	PART NUMBER	DESCRIPTION
9	48	-	SEE NOTE 14 BRADY WIRE MARKERS NUMBERED 1-24
8	1	1014	NUT VS18-SS
7	1	-219 VITON	O-RING -219 VITON 75
6	6	EE20 MIL YELLOW	WIRE 20EE MIL-W-16878/5 7/#28
5	6	EE20 MIL BLUE	WIRE 20EE MIL-W-16878/5 7/#28
4	6	EE20 MIL WHITE	WIRE 20EE MIL-W-16878/5 7/#28
3	6	EE20 MIL BLK	WIRE 20EE MIL-W-16878/5 7/#28
2	A/R	PAVE-Seal 200	EPOXY BLACK
1	1	0660	HOUSING VS18-SS

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DESCRIPTION  
VS18-SS-200-24-TEE20-X-X

PART NUMBER  
**3416**

MATERIAL NOTED  
REVISION LEVEL F  
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