

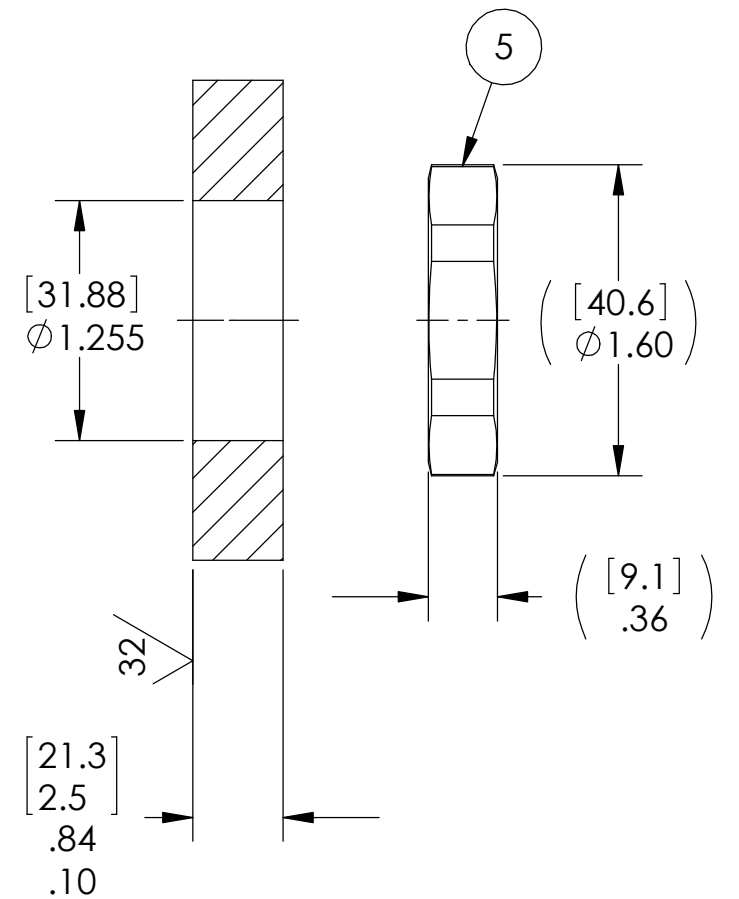
**NOTES:**

1. HE LEAK TEST @ 1 ATM. 1X10<sup>-8</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. ALCOHOL OR FOMBLIN YVAC 3 MAY BE USED TO LUBRICATE O-RINGS FOR VACUUM HELIUM LEAK TESTING.
4. ALL TESTS ARE PERFORMED AT ROOM TEMPERATURE.
5. ALL PARTS MUST PASS ALL TESTS.
6. WIRE POSITIONING IS APPROXIMATE & VARIABLE.
7. COSMETIC SURFACE VOIDS NOT ON O-RING SEALING SURFACES ARE ACCEPTABLE BASED ON THE SEAL'S DIAMETER:  
 <math>\leq .5 [12.7]</math> SEAL DIAMETER:  $\phi .035 [1.27]$  MAX ALLOWED VOID SIZE  
 $> .5 [12.7]$  SEAL DIAMETER:  $\phi .060 [1.52]$  MAX ALLOWED VOID SIZE
8. REF-OPERATING TEMPERATURE -20°C TO 125°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.

ITEM	QTY	PART NUMBER	DESCRIPTION
5	1	1014	NUT VS18-SS
4	1	-219 VITON	O-RING -219 VITON 75
3	16	TT24 SLE	CABLE T/C TYPE T#24 TEF SPECIAL LIMITS OF ERROR
2	A/R	PAVE-Seal 150	EPOXY BLACK
1	1	0660	HOUSING VS18-SS

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

**VS18 INSTALLATION PORT**



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DESCRIPTION  
 VS18-SS-150-16P-TT24SLE-144-144

PART NUMBER  
**5180**

MATERIAL NOTED

REVISION LEVEL -

PROJECTION