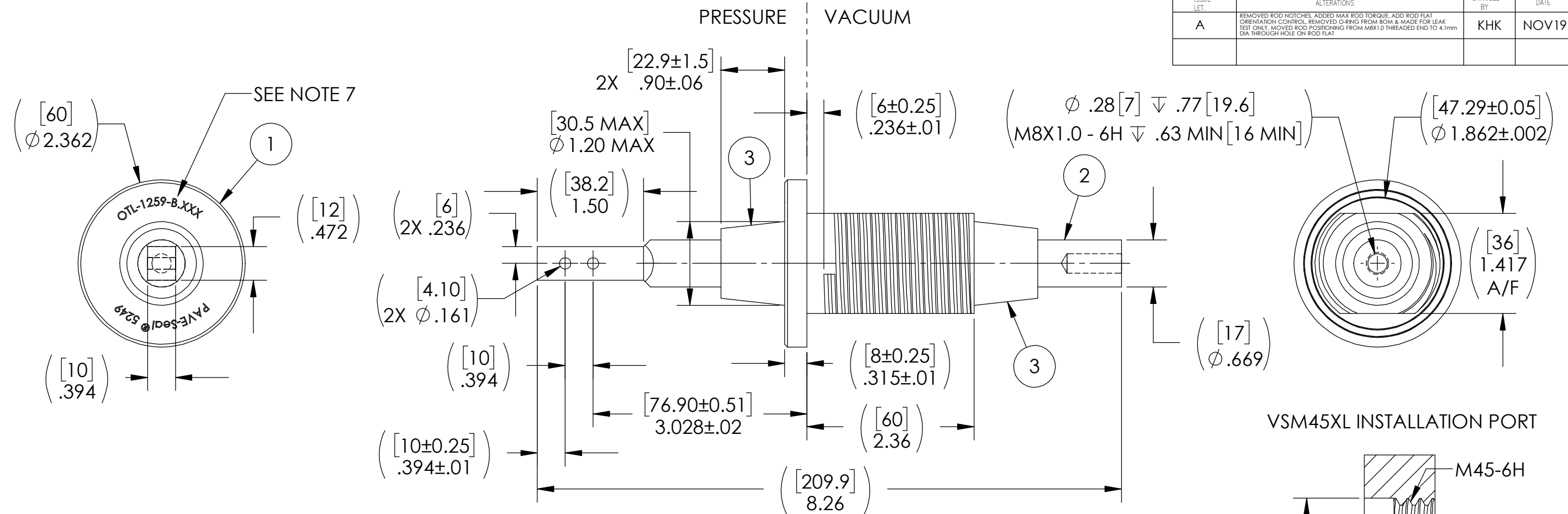
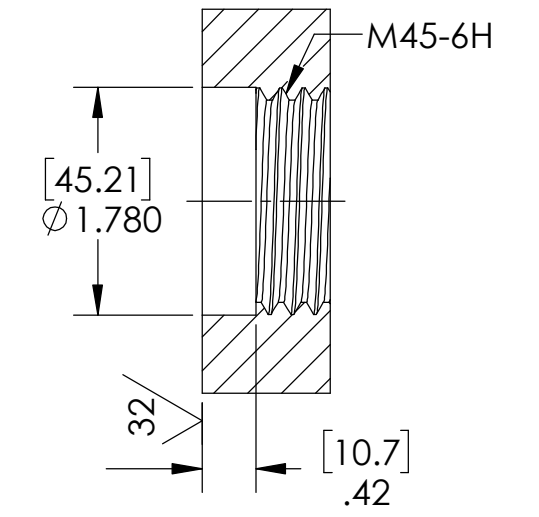


| ISSUE LET. | ALTERATIONS | CHANGED BY | DATE |
|------------|--|------------|-------|
| A | REMOVED ROD NOTCHES, ADDED MAX ROD TORQUE, ADD ROD FLAT ORIENTATION CONTROL, REMOVED O-RING FROM BOM & MADE FOR LEAK TEST ONLY, MOVED ROD POSITIONING FROM M8X1.0 THREADED END TO 4.1mm DIA THROUGH HOLE ON ROD FLAT | KHK | NOV19 |

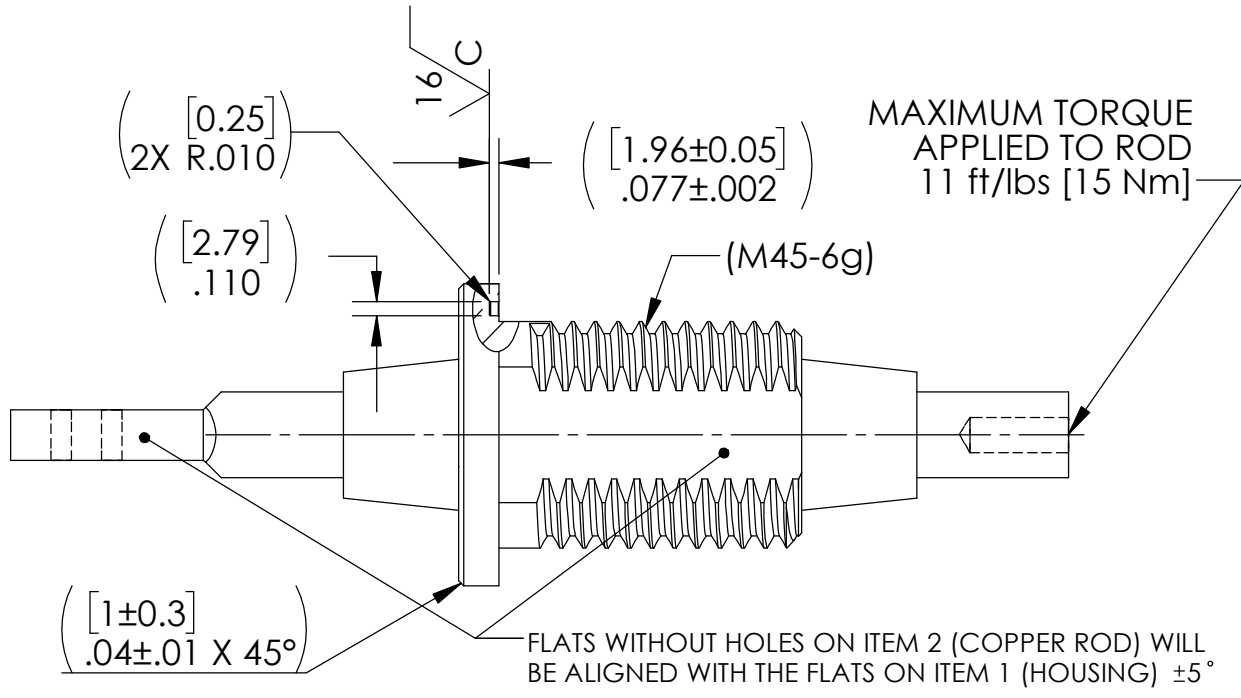


VSM45XL INSTALLATION PORT



NOTES:

- a.) LEAK TEST: 290 PSI, NO N2 BUBBLES 5 MINUTES MINIMUM.
b.) HE LEAK TEST @ 1 ATM. 1X10⁻⁶ CC/SEC OR LESS. A GREEN PAINT DOT ON THE PRESSURE SIDE OF THE HOUSING INDICATES THE PART HAS PASSED BOTH LEAK TESTS. LEAK TESTS ARE PERFORMED USING A 2-134 SIZE O-RING.
- HYPOT 2000 VAC, 0.5 mA MAXIMUM LEAKAGE ROD TO HOUSING, 1 SECOND MINIMUM.
- ALCOHOL OR FOMBLIN YVAC 3 MAY BE USED TO LUBRICATE O-RINGS FOR VACUUM HELIUM LEAK TESTING.
- ALL TESTS ARE PERFORMED AT ROOM TEMPERATURE.
- ALL PARTS MUST PASS ALL TESTS.
- MATERIAL CERTIFICATIONS IN COMPLIANCE WITH EN 10204-3.1 ARE REQUIRED FOR ITEMS 1 AND 2.
- ITEM 1 (HOUSING) SHALL BE LASER ENGRAVED, CHARACTER SIZE APPROXIMATELY .118 [3], WITH THE PAVE IDENTIFIER, OFTTECH DRAWING NUMBER AND SERIAL NUMBER STARTING WITH 001 (e.g. OTL-1259-B.001).
- 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
- REF-OPERATING TEMPERATURE RANGE -20°C TO 125°C.
- DIMENSIONS ARE INCHES [millimeters].
- 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.



PAVE will meet the assembly and test specifications of OFTTECH #OTL-1259-B as documented on this assembly drawing. Any changes must be approved by PAVE.

PAVE technology co.
 2751 Thunderhawk Court
 Dayton, OH 45414-3445
 U.S.A.
 tel (937) 890-1100
 fax (937) 8905165
 www.pavetechnologyco.com

DESCRIPTION PAVE-Seal® Cable Harnesses
 VSM45XL-SS-150-1-.67CU-3.5-2

MATERIAL NOTED

| | | | | | |
|-------------|------|----------------|-----------|------------|---------|
| DR. BY | KHK | APPROVED BY | | DRAWN FROM | OFTTEUK |
| CH'D BY | | DATE | 11 NOV 19 | SCALE | 2:3 |
| PART NUMBER | 5249 | REVISION LEVEL | 1 | PROJECTION | ⊙ □ |
| | | | 2 | | |

| ITEM | QTY | PART NUMBER | DESCRIPTION |
|------|-----|-----------------|------------------------------------|
| 3 | A/R | PAVE-Seal 150 | EPOXY BLACK |
| 2 | 1 | 5283 SEE NOTE 6 | ROD 17mm COPPER HIGH CURRENT |
| 1 | 1 | 5284 SEE NOTE 6 | HOUSING VSM45XL-SS (316L <0.2% Co) |

FINISH 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