



- NOTES:
1. HE LEAK TEST @ 2500 PSI. 1×10^{-5} CC/SEC OR LESS. ITEM 5 IS INSTALLED AND TORQUED TO 6 ft-lb (72 in-lb) PRIOR TO LEAK TESTING, A GREEN PAINT DOT ON THE ATMOSPHERE SIDE INDICATES THE PART HAS PASSED THE TEST.
 2. HYPOT 630 VDC 500 MEGOHMS MINIMUM 0.01 SECOND MINIMUM ROD TO HOUSING.
 3. ALCOHOL OR FOMBLIN YVAC 3 MAY BE USED TO LUBRICATE O-RINGS FOR PRESSURIZED HELIUM LEAK TESTING.
 4. ALL TESTS ARE PERFORMED AT ROOM TEMPERATURE.
 5. ALL PARTS MUST PASS ALL TESTS.
 6. COSMETIC SURFACE VOIDS NOT ON O-RING SEALING SURFACES ARE ACCEPTABLE BASED ON THE SEAL'S DIAMETER:
 $\leq .5$ [12.7] SEAL DIAMETER: $\phi .035$ [.89] MAX ALLOWED VOID SIZE
 $> .5$ [12.7] SEAL DIAMETER: $\phi .060$ [1.5] MAX ALLOWED VOID SIZE
 7. REF-OPERATING TEMPERATURE RANGE -20°C TO 125°C .
 8. DIMENSIONS ARE INCHES [millimeters].
 9. 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 |
|------|-----|-----------------|--|
| 6 | 1 | 1014 | NUT VS18-SS |
| 5 | 1 | 1/4-20X.5SSSHCS | SOCKET HEAD CAP SCREW SELF SEALING 1/4-20X.5" VITON O-RING |
| 4 | 1 | -219 VITON | O-RING -219 VITON 75 |
| 3 | 1 | 5346 | ROD .50" COPPER 5.31" |
| 2 | A/R | PAVE-Seal 150 | EPOXY BLACK |
| 1 | 1 | 0660 | HOUSING VS18-SS |

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DESCRIPTION
VS18-SS-150-1-.5CU-2.4-1

PART NUMBER
5314

MATERIAL NOTED

REVISION LEVEL -

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