



(SOME ITEMS REMOVED IN THIS VIEW FOR CLARITY)

NOTES:

1. HE LEAK TEST @ 1 ATM. 1X10⁻⁷ CC/SEC OR LESS. 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 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:
 <= .5 [12.7] SEAL DIAMETER: ϕ .035 [.89] MAX ALLOWED VOID SIZE
 > .5 [12.7] SEAL DIAMETER: ϕ .060 [1.5] MAX ALLOWED VOID SIZE
8. REF-SEAL OPERATING TEMPERATURE RANGE -20 °C TO 125 °C, ITEM 7 RATED 105 °C MAXIMUM, ITEM 8 RATED 50 °C MAXIMUM.
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.

8	6	5169-0	SEE NOTE 8	BANANA PLUG, 15A, 22-18 AWG CRIMP/SOLDER, BLACK PVC
7	6	190670055	SEE NOTE 8	TERMINAL RING 6 AWG TPC CRIMP NYLON INSULATED M8 [5/16] STUD
6	1	1014		NUT VS18-SS
5	1	-219 VITON		O-RING -219 VITON 75
4	3	E20 GREEN		WIRE 20E MIL-W-16878/4 .010 7/#28
3	3	EE6 UL1330 BLK		WIRE 6EE UL1330 FEP TEFLON .030 133/#27
2	A/R	PAVE-Seal 150		EPOXY BLACK
1	1	0660		HOUSING VS18-SS
ITEM	QTY	PART NUMBER		DESCRIPTION

ALL DIMENSIONS AND TOLERANCES APPLY TO FINISHED PART IN INCHES.
 ALLOWABLE TOLERANCES UNLESS SPECIFIED OTHERWISE: NONE \pm 0.5
 X.X DECIMAL \pm 0.1 X.XX DECIMAL \pm 0.02 X.XXX DECIMAL \pm 0.005
 ANGLES \pm 1 DEGREE SURFACE FINISH 128 microinch RMS

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DESCRIPTION
 VS18-SS-150-3/3-TEE6/TE20-108T-36T

PART NUMBER
5518

MATERIAL NOTED

REVISION LEVEL
 A

PROJECTION