



NOTES:

1. HE LEAK TEST @ 1 ATM. 1×10^{-7} CC/SEC OR LESS. A GREEN PAINT DOT ON THE ATMOSPHERE SIDE INDICATES THAT THE PART HAS PASSED THE TEST.
2. HYPOT 630 VDC 500 MEGOHMS MINIMUM 0.01 SECOND MINIMUM WIRE TO WIRE AND HOUSING.
3. ALL TESTS ARE PERFORMED AT ROOM TEMPERATURE.
4. ALL PARTS MUST PASS ALL TESTS.
5. 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
 REF-OPERATING TEMPERATURE RANGE -20°C TO 150°C .
6. DIMENSIONS ARE INCHES [millimeters].
7. 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. ALCOHOL OR FOMBLIN YVAC 3 MAY BE USED TO LUBRICATE O-RINGS FOR VACUUM HELIUM LEAK TESTING.
9. EACH THERMOCOUPLE WIRE PAIR WILL BE MARKED WITH A UNIQUE NUMBER (1-4), USING THE SAME NUMBER ON BOTH ENDS OF THE SAME WIRE.

9	1	1014	NUT VS18-SS
8	16	- SEE NOTE 10	BRADY WIRE MARKERS NUMBERED 1-4
7	1	-219 VITON	O-RING -219 VITON 75
6	4	W3RE 020 BARE	WIRE 24 THERMOCOUPLE TYPE D POSITIVE
5	4	W25RE 020 BARE	WIRE 24 THERMOCOUPLE TYPE D NEGATIVE
4	8	PIF-240-20	SLEEVING .035 ID FIBERGLASS .009
3	8	100713	WIRE 20 KAPTAN 19/#32
2	A/R	PAVE-Seal 200	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 ± 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

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DESCRIPTION
 VS18-SS-200-8/4P-K20/TCD-15-15FT

PART NUMBER
5650

MATERIAL NOTED

REVISION LEVEL -

PROJECTION