

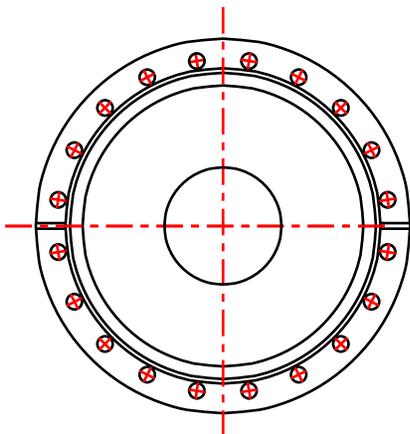
4

3

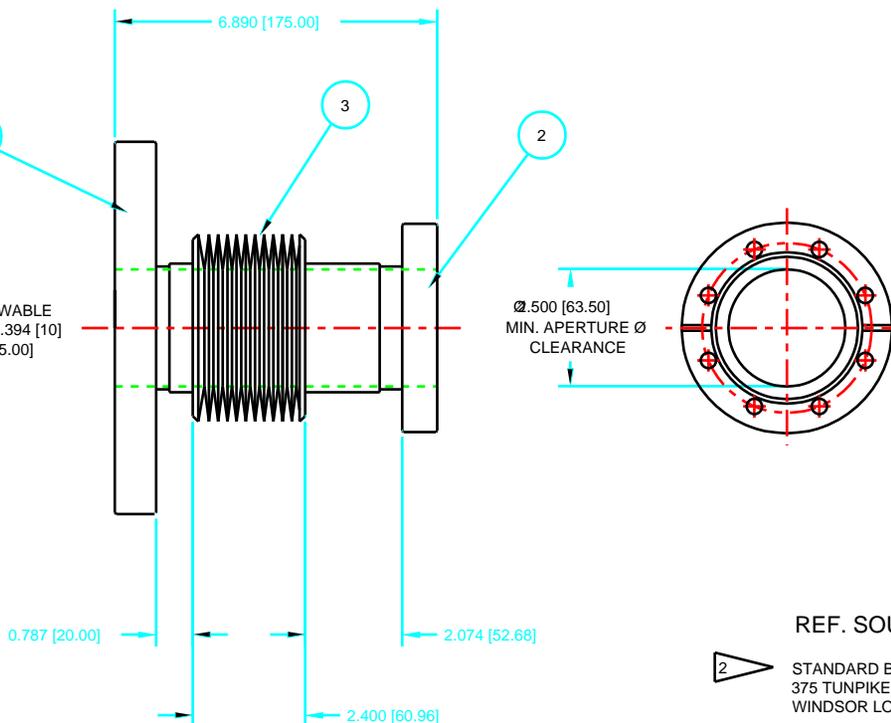
2

1

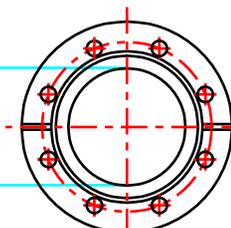
EXTENDED LGTH. = 8.33 [281.6]
COMPRESSED LGTH. = 5.45 [138.4]



MAXIMUM ALLOWABLE
LATERAL OFFSET -0.394 [10]
@ O.A.L. = 6.890 [175.00]



Ø.500 [63.50]
MIN. APERTURE Ø
CLEARANCE



NOTES:

1. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
A) CIMCOOL 5 STAR 49
B) TRIM SOL

2. ALL WELDS JOINING BELLOWS AND FLANGES ARE TO BE INTERNAL

3. BELLOWS ASSEMBLY SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2 X 10⁻¹⁰ STANDARD CC/SEC PER LEAK METER DIVISION, SUCH AS

- ALCATEL SAM-110TCL
- Du PONT CEC 24-120B
- VARIAN MS-9, MS-90 OR MS-18

CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TESTING.

FINAL TEST WILL CONSIST OF SURROUNDING THE ASSEMBLY (BAGGING) WITH HELIUM. THE ASSEMBLY WILL BE REJECTED IF A 2% DEFLECTION ON THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.

4. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.

5. DIMENSIONS IN [] ARE MILLIMETERS

REF. SOURCES

2 STANDARD BELLOWS CO.
375 TUNPIKE AVE.
WINDSOR LOCKS, CONN. 06096

1 MDC VACUUM PRODUCTS CORP.
23842 CABOT BLVD.
HAYWARD, CA. 94545-1651



3		ST'D. BELLOWS CAT. #350 - 250 - 6 - EE	WITH EXTENDED ENDS	1
2	MDC'S CAT. #100021	4.5" CF. ROTATABLE FLANGE		1
1	MDC'C CAT. #110030	8" CF. NONROTATABLE FLANGE		1

ITEM	DRG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				

UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES

LOG NUMBER: A1962200

ARGONNE NATIONAL LABORATORY

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DESIGNED BY D. SHU	DATE 8/4/94	CHECKED BY D. SHU	DATE 8/4/94	TITLE ADVANCED PHOTON SOURCE
DESIGNER D. SHU/FUHRMANN		OP LEADER T.M. KUZAY	DATE 8/4/96	V2-72 WELDED BELLOWS ASSY
RESPONSIBLE ENGINEER D. SHU	DATE 8/4/94	APPROVED/RELEASED		8" - 4.5" CF. 2.5" I.D. X 175mm

MATERIAL: SEE PARTS LIST

SCALE: HALF SHEET 1 of 1

SHEET: 1 of 1

DRAWING NUMBER: 4105090702-720000-00

SYN	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				

4

3

2

1