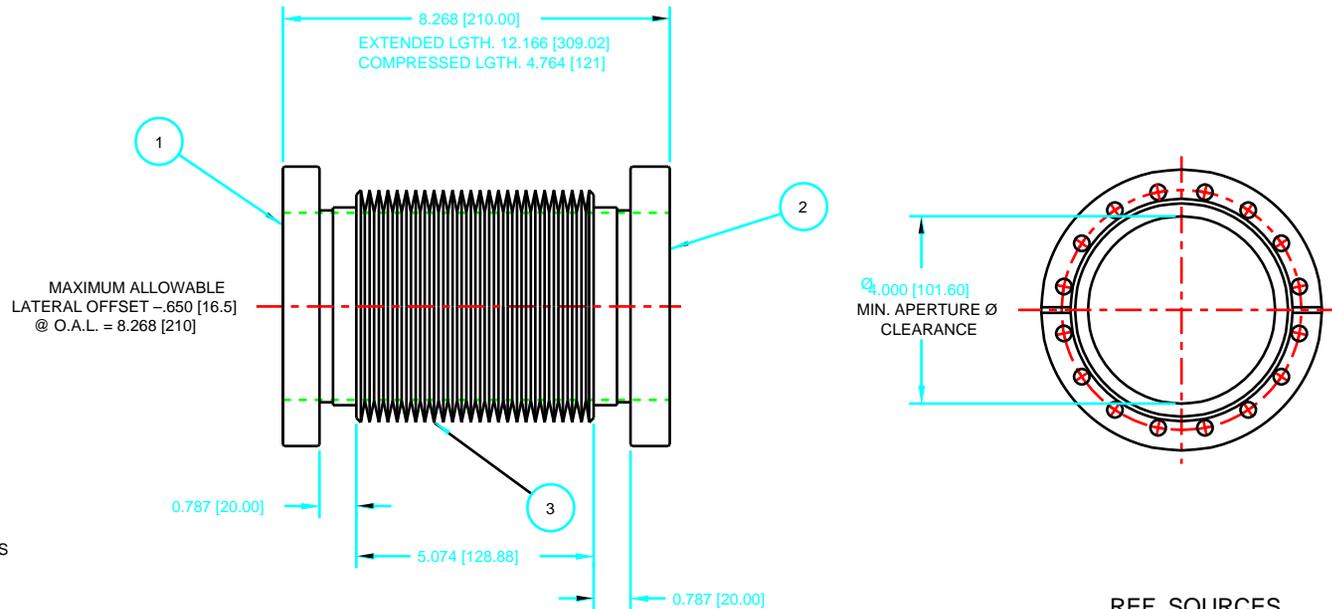


4

3

2

1



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 TRESTING.

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. #497 - 400 - 7 - EE	WITH EXTENDED ENDS	1
2	MDC'S CAT. #100026	6" CF. ROTATABLE FLANGE		1
1	MDC' C CAT. #110026	6" CF. NONROTATABLE FLANGE		1

ITEM	BYG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
------	-----------------	-----------------------------	-----------------	-----

UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES

LOG NUMBER: A09231

THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY

DESIGNED BY MUSCIA	DATE 2/17/93	CHIEF DESIGN ENGINEER D. SHU	DATE 2/22/93	TITLE ADVANCED PHOTON SOURCE
CHECKED BY		OP LEADER T. M. KUZAY	DATE 2/22/93	V2 - 82 WELDED BELLOWS ASSY.
DESIGNER MUSCIA		PROJECT MGR		6" - 6" CF. 4" I.D. X 210mm
RESPONSIBLE ENGINEER D. SHU	DATE 2/22/93	APPROVED/RELEASED		

MATERIAL: SEE PARTS LIST

SCALE: HALF SHEET 1 of 1

SIZE: C

DRAWING NUMBER: 4105090702-820000-00

SYN	CHANGE DESCRIPTION	BY	CHKD	DATE
	REVISIONS			

4

3

2

1