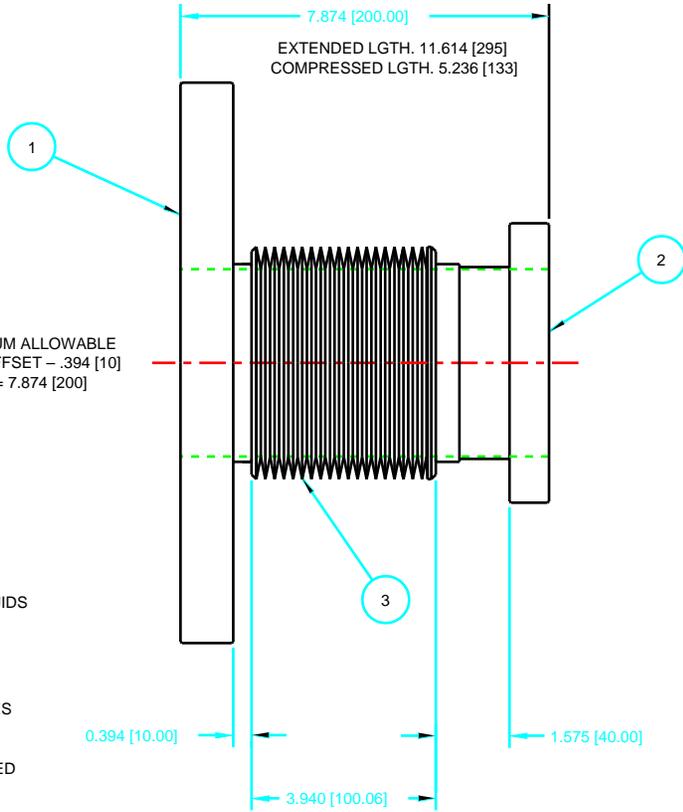


4

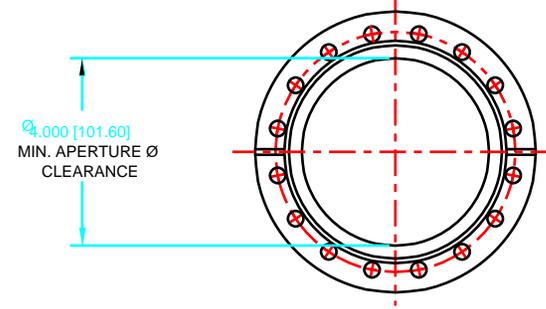
3

2

1



MAXIMUM ALLOWABLE
LATERAL OFFSET - .394 [10]
@ O.A.L. = 7.874 [200]



NOTES:

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

- KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
- DIMENSIONS IN [] ARE MILLIMETERS

REF. SOURCES

- 2 STANDARD BELLOWS CO.
375 TUNPIKE AVE.
WINDSOR LOCKS, CONN. 06096
- 2 MDC VACUUM PRODUCTS CORP.
23842 CABOT BLVD.
HAYWARD, CA. 94545-1651
- 1 NOR-CAL PRODUCTS, INC.
1967 S. OREGON ST.
P.O. BOX 518
YREKA, CA. 96097



3		ST'D. BELLOWS CAT. #497 - 400 - 6 - EE	WITH EXTENDED ENDS	1
2	MDC'S CAT. #100026	6" CF. ROTATABLE FLANGE		1
1	N.C. #1200-000N	12" CF. NONROTATABLE FLANGE 4" I.D.		1

ITEM	BYG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
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UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES

A09234

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DESIGNER: MUSCIA
CHECKED BY: []
DESIGNER: MUSCIA
RESPONSIBLE ENGINEER: D. SHU

DATE: 2/17/93
DATE: 2/22/93
DATE: 2/22/93

CHEF DESIGN ENGINEER: D. SHU
OP LEADER: T. M. KUZAY
PROJECT MGR: []
APPROVED/RELEASED: []

TITLE: **ADVANCED PHOTON SOURCE**
V2 - 85 WELDED BELLOWS ASSY.
12" - 6" CF. 4" I.D. X 200mm

MATERIAL: SEE PARTS LIST

SCALE: HALF
SHEET: 1 of 1

DRAWING NUMBER: 4105090702-850000-00

SYN	CHANGE DESCRIPTION	BY	CHKD	DATE
	REVISIONS			

4

3

2

1