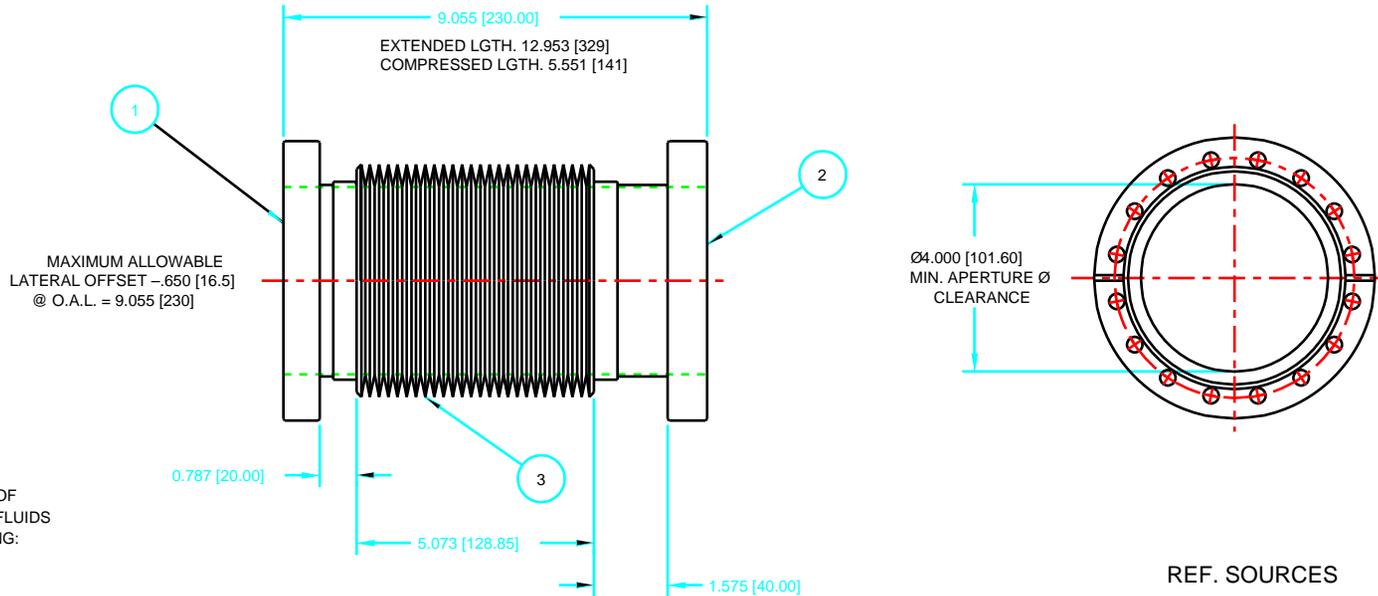


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NOTES:

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<sup>-10</sup> 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	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				

UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES

TOLERANCES

DECIMALS	ANGLES
F ± .03 (.7620)	± 25'
M ± .01 (0.25)	
XX ± .005 (0.127)	

SURFACE ROUGHNESS 125 ✓

REMOVE ALL BURRS AND BREAK SHARP EDGES TO RAZ

SURFACE FINISH TO BE IN ACCORDANCE WITH LATEST ASST 944

IDENTIFICATION & TOLERANCE TO BE IN ACCORDANCE WITH LATEST ASST 944

DO NOT SCALE DRAWING

THIS DRAWING IS THE PROPERTY OF  
**ARGONNE NATIONAL LABORATORY**

**A09235**

DRAWN 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 - 86 WELDED BELLOWS ASSY. 6" - 6" CF. 4" I.D. X 230mm
DESIGNER MUSCIA		APPROVED/RELEASED		
RESPONSIBLE ENGINEER D. SHU	DATE 2/22/93			

MATERIAL	SCALE HALF	SIZE C	DRAWING NUMBER
SEE PARTS LIST	SHEET 1 of 1		4105090702-860000-00

SYN	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				

4

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2

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