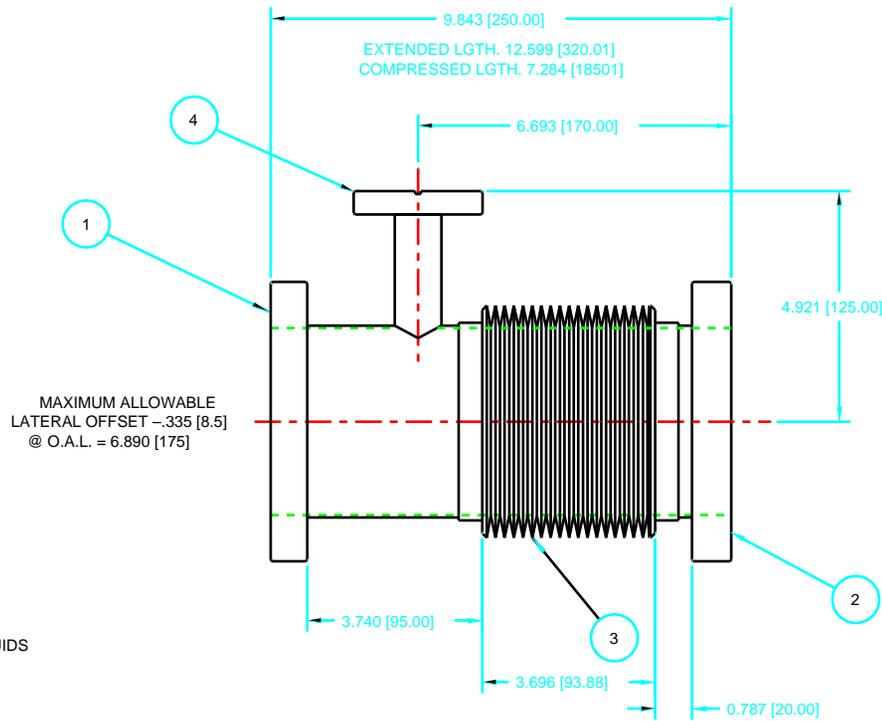


4

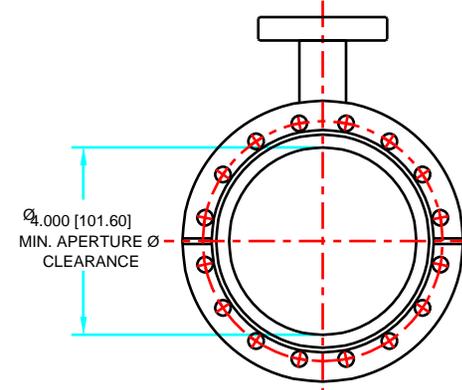
3

2

1



MAXIMUM ALLOWABLE
LATERAL OFFSET -.335 [8.5]
@ O.A.L. = 6.890 [175]



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 2×10^{-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

4	MDC'C CAT. #110012	2 3/4" CF. NONROTATABLE FLANGE	1
3		ST'D. BELLOWS CAT. #497 - 400 - 5 - 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
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UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES

LOG NUMBER: A14777

ARGONNE NATIONAL LABORATORY

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DATE: 11/16/83

DESIGNER: MUSCIA

CHECKED BY: []

SCALE: HALF

SHEET: 1 of 1

DRAWING NUMBER: 4105090702-890000-00

SYN	CHANGE DESCRIPTION	BY	CHKD	DATE
	REVISIONS			

4

3

2

1