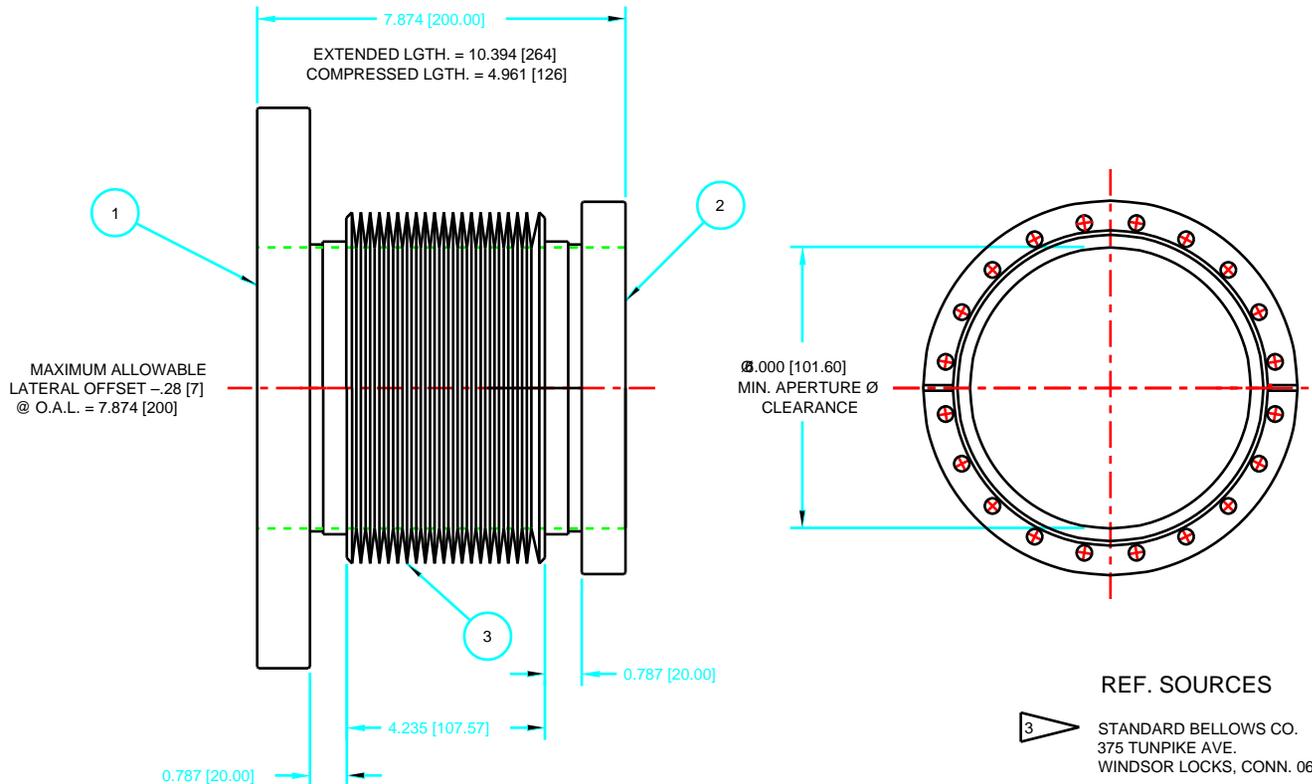


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NOTES:

- 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  $2 \times 10^{-10}$  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

- 3 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.  
YREKA, CA. 96097



3	ST'D. BELLOWS CAT. #750 - 600 - 5 - EE	WITH EXTENDED ENDS	1
2	MDC'S CAT. #100031	8" CF. ROTATABLE FLANGE	1
1	N.C. #1200-00N	12" CF. NONROTATABLE FLANGE	1

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

UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES

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**A14771**

DESIGNER: MUSCIA  
CHECKED BY: [ ]  
RESPONSIBLE ENGINEER: [ ]

DATE: 2/18/93  
DATE: [ ]  
DATE: [ ]

CHEF DESIGN ENGINEER: [ ]  
OP LEADER: [ ]  
PROJECT MGR: [ ]  
APPROVED/RELEASED: [ ]

TITLE: ADVANCED PHOTON SOURCE  
V2-92 WELDED BELLOWS ASSY.  
12"-8" CF. 6" I.D. X 200mm

MATERIAL: SEE PARTS LIST

SCALE: HALF  
SHEET: 1 of 1

DRAWING NUMBER: 4105090702-920000-00

SY#	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				

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