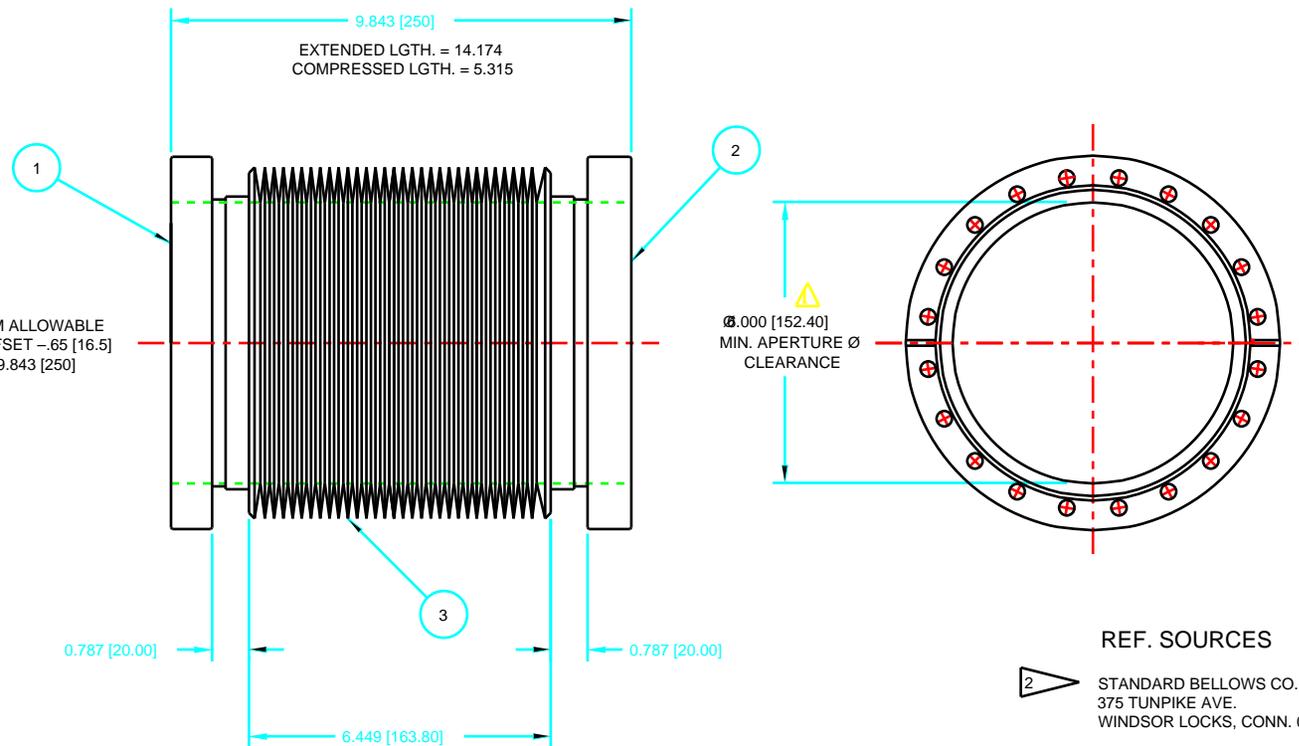


4

3

2

1



MAXIMUM ALLOWABLE
LATERAL OFFSET = .65 [16.5]
@ O.A.L. = 9.843 [250]

Ø.000 [152.40]
MIN. APERTURE Ø
CLEARANCE

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

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

REV	CHANGE DESCRIPTION	BY	CHKD	DATE
1	V2940000-01 WAS A14773			
	V2-940000-01 WAS			
	410509702-940000-00			
	(NEW LOG # & PART #)			
	Ø.000 [152.40] WAS Ø.000 [101.60]	M.J.M.		



ITEM	BYG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
3		ST'D. BELLOWS CAT. #750 - 600 - 8 - EE	WITH EXTENDED ENDS	1
2	MDC'S CAT. #1100031	8" CF. ROTATABLE FLANGE		1
1	MDC'C CAT. #1100031	8" CF. NONROTATABLE FLANGE		1

UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES		LOG NUMBER		THIS DRAWING IS THE PROPERTY OF	
TOLERANCES		V2940000-01		ARGONNE NATIONAL LABORATORY	
DECIMALS	ANGLES				
X .03 (.7620)	.25	DRAWN BY		DATE	
XX .01 (0.25)		MUSCIA		2/18/99	
XXX .005 (0.127)		CHECKED BY		DATE	
		D. SHU		7/6/99	
SURFACE ROUGHNESS 125 ✓		DESIGNER		DATE	
REMOVE ALL BURRS AND BREAK SHARP EDGES TO MAX		SHU/MUSCIA		2/18/99	
SURFACE FINISH TO BE IN ACCORDANCE WITH LATEST ASST 944		RESPONSIBLE ENGINEER		DATE	
IDENTIFICATION & VERIFICATION IN ACCORDANCE WITH LATEST ASST 944		D. SHU		7/6/99	
DO NOT SCALE DRAWING		MATERIAL		SCALE HALF	
		SEE PARTS LIST		SHEET 1 of 1	
				DRAWING NUMBER	
				V2-940000-01	

4

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2

1