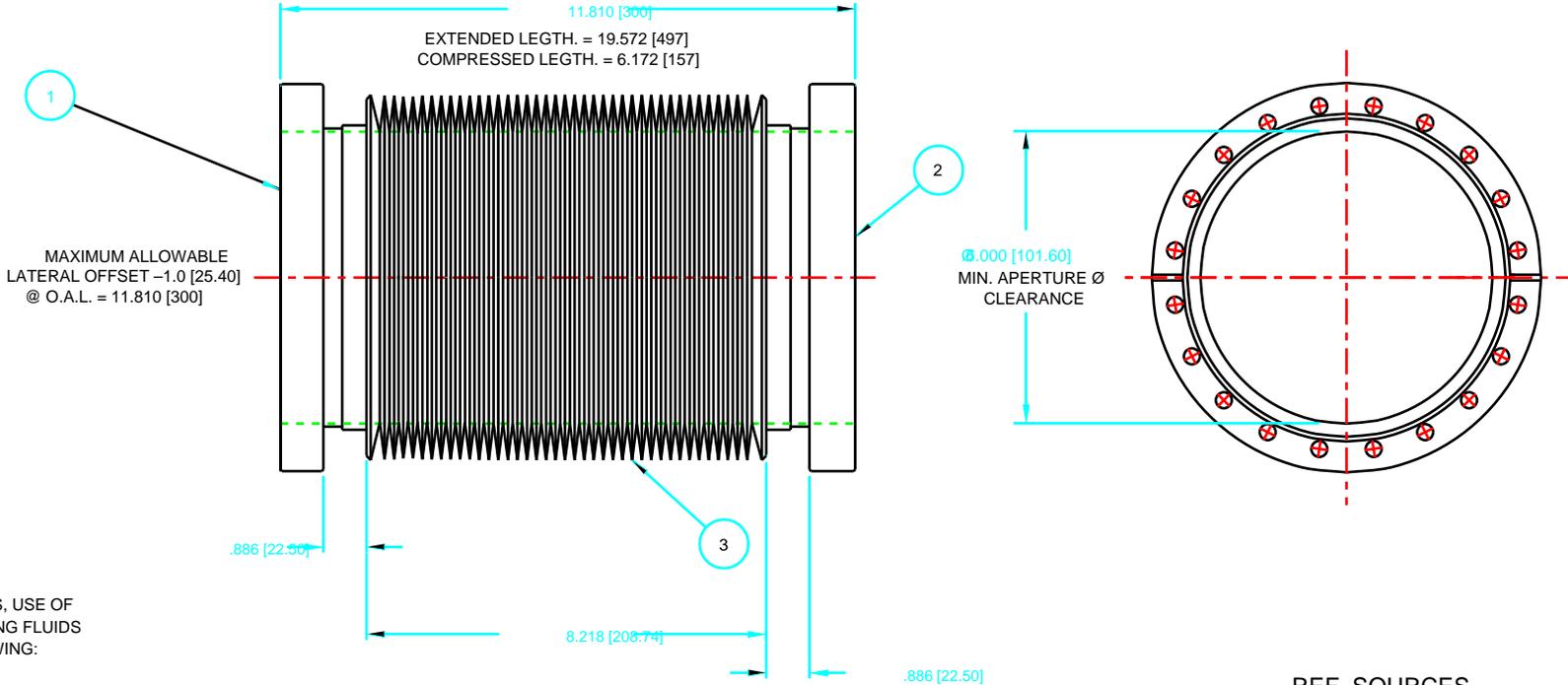


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NOTES:

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. #750 - 600 - 10 - EE	WITH EXTENDED ENDS	1
2	MDC'S CAT. #100031	8" CF. ROTATABLE FLANGE		1
1	MDC'C CAT. #110031	8" CF. NONROTATABLE FLANGE		1

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
<b>PARTS LIST</b>				
UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES				
TOLERANCES				
DECIMALS	ANGLES	THIS DRAWING IS THE PROPERTY OF		
.X .03 [.7620]	.25 °	<b>ARGONNE NATIONAL LABORATORY</b>		
.XX .01 [0.25]		<b>ADVANCED PHOTON SOURCE</b>		
.XXX .005 [0.127]		V2-97 WELDED BELLOWS ASSY. 8" - 8" CF. 6" I.D. X 300mm		
SURFACE ROUGHNESS 125 ✓		REMOVE ALL BUMPS AND BREAK SHARP EDGES .03 MAX.		
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ASST 046		MATERIAL SEE PARTS LIST		
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ASST 046		DO NOT SCALE DRAWING		
LOG NUMBER V2970000-00		SCALE HALF SIZE		
DRAWN BY MUSCIA		DATE 8/22/97		
CHECKED BY D. SHU		DATE 8/25/97		
DESIGNER SHU/MUSCIA		DATE 8/22/97		
RESPONSIBLE ENGINEER D. SHU		DATE 8/25/97		
CHIEF DESIGN ENGINEER D. SHU		DATE 8/25/97		
GP LEADER T.M. KUZAY		DATE 8/26/97		
PROJECT MGR.		APPROVED/RELEASED		
MATERIAL SEE PARTS LIST		SHEET 1st		
SCALE HALF SIZE		DRAWING NUMBER V2-970000-00		

SY#	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				

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