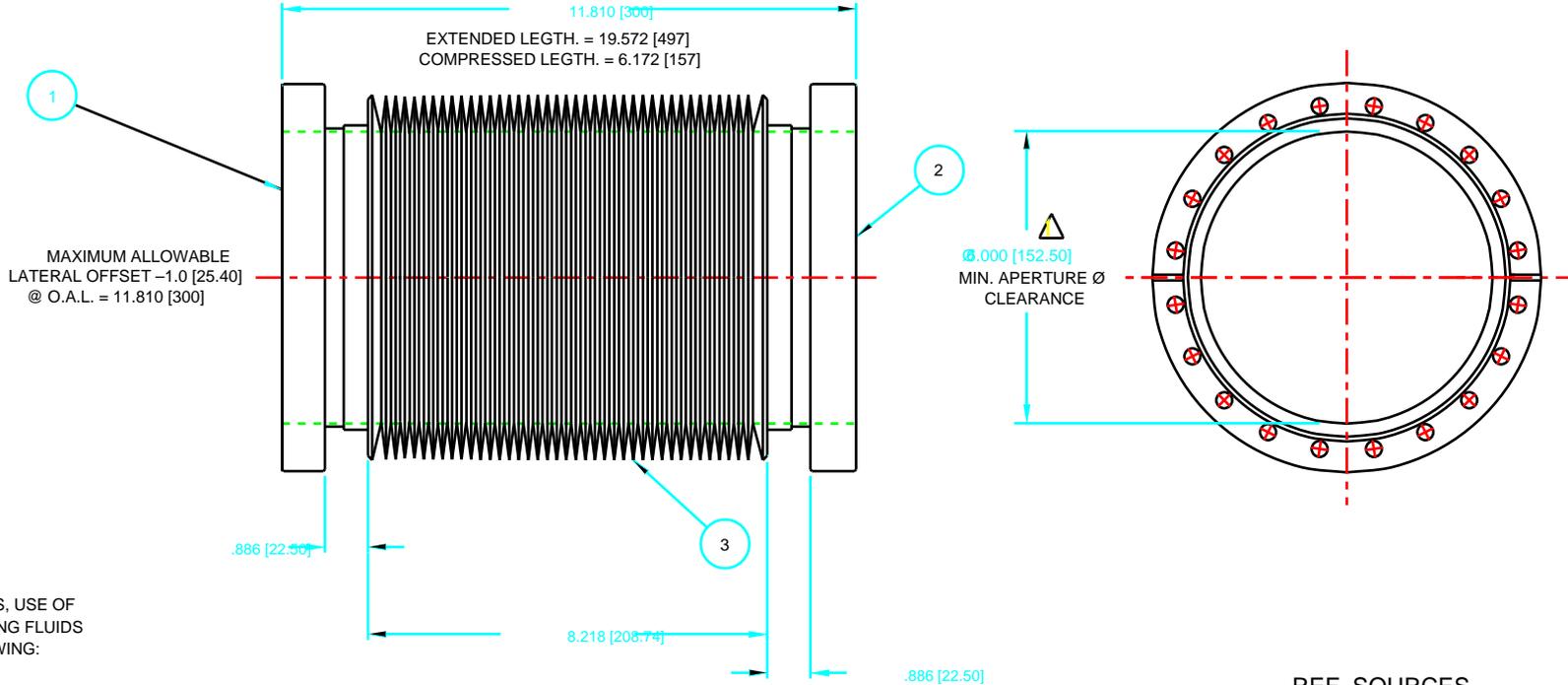


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NOTES:

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 10⁻¹⁰ 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



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
PARTS LIST				
UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES				
TOLERANCES				
DECIMALS	ANGLES	THIS DRAWING IS THE PROPERTY OF		
.X ± .03 [0.7620]	± .25 °	ARGONNE NATIONAL LABORATORY		
.XX ± .01 [0.25]		ADVANCED PHOTON SOURCE		
.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		
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ASST 046		SEE PARTS LIST		
DO NOT SCALE DRAWING		SCALE HALF SIZE SHEET 1st C V2-970000-01		

1	0.000 [152.40] WAS 0.000 [101.60]	M.J.M.		
SYW	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				

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