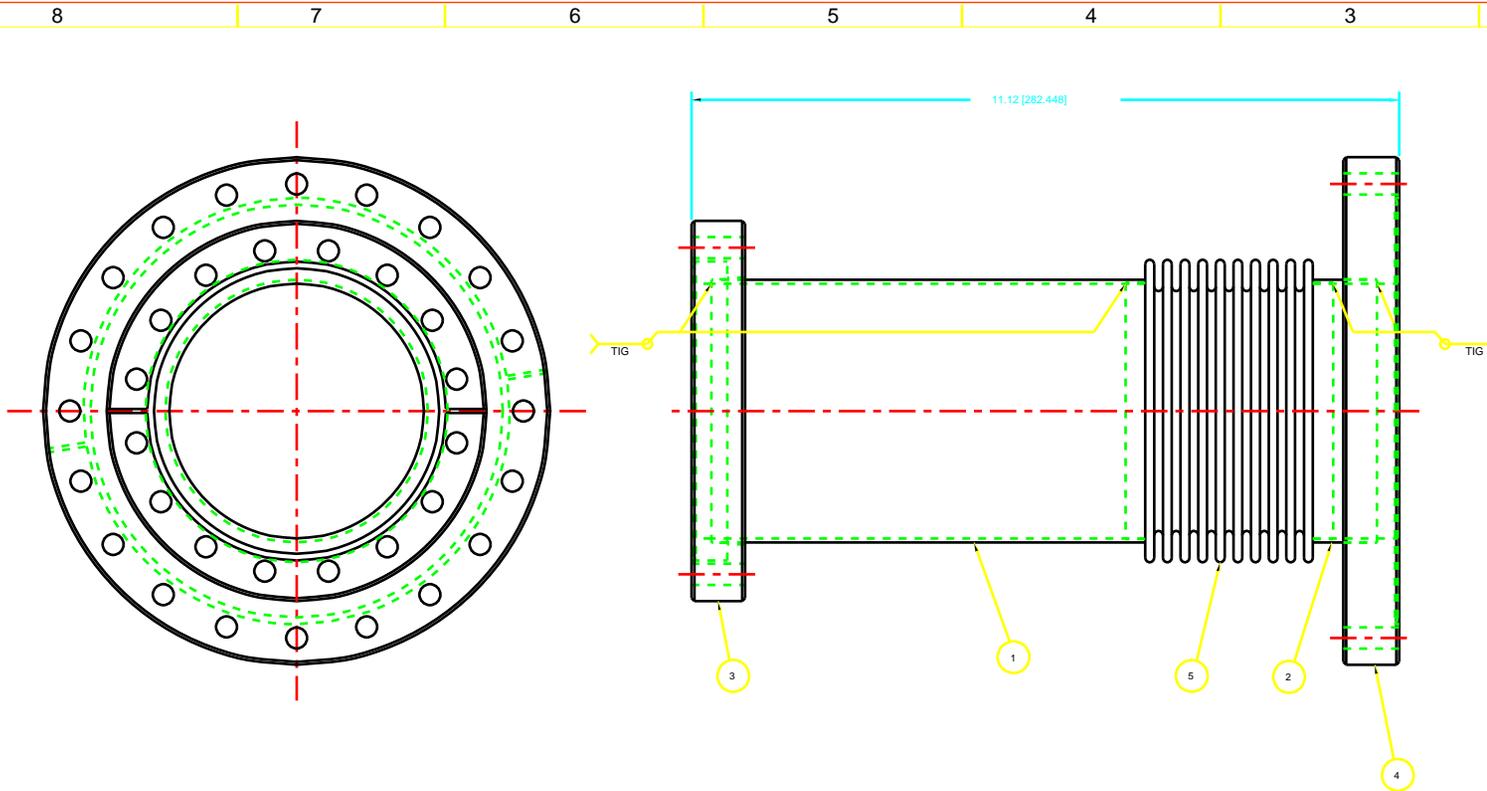


(∅) PLOT SCALE: 1=1 DWG. SCALE: 1



- NOTES:
- THIS IS A UHV ASSEMBLY. KEEP THE UHV PARTS CLEAN DURING ASSEMBLY AND WRAP UP FOR PACKING WITH ALUMINUM FOIL.
  - DEVICE 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 ASM-110TCL  
VARIAN NCR 925 OR 936  
VEECO MS-9, MS-90 OR MS-18  
DuPONT CEC 24-120B  
CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TESTING.  
FINAL TEST WILL CONSIST OF SURROUNDING THE CHAMBER (BAGGING) WITH HELIUM. THE CHAMBER WILL BE REJECTED IF A 2% DEFLECTION IN THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.
  - WELDS SHALL BE GAS TUNGSTEN ARC (GTAW) OR TUNGSTEN INERT GAS (TIG) ON VACUUM SIDE OF JOINTS.
  - ALL DIMENSIONS IN [ ] ARE MILLIMETERS AND ARE FOR REFERENCE ONLY.
  - TOLERANCE SPECIFICATIONS TO CONFORM TO TOLERANCE BLOCK.

SOURCE

1 FLEXONICS, INC.  
300 EAST DEVON AVENUE  
BARLETT, IL. 60103  
(708) 837-1811

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
5		FORMED BELLOW WITH EXTENDED ENDS 9 and HALF CONVOLUTIONS	FLEXONICS #J348	1
4	P4105091407-330002-00	8" QNOM. MODIFIED NON-ROTATABLE FLANGE		1
3	P4105091407-330001-00	6" QNOM. MODIFIED ROTATABLE FLANGE		1
2	P4105091407-330004-00	SHORT BELLOW TUBE	SST 304	1
1	P4105091407-330003-00	LONG BELLOW TUBE	SST 304	1

UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES TOLERANCES:		LOG NUMBER		THIS DRAWING IS THE PROPERTY OF	
DECIMALS	ANGULAR	A18058	ARGONNE NATIONAL LABORATORY		
X - .010 (.254)	- .05	DRAWN BY	DATE	CHIEF DESIGN ENGINEER	DATE
XX - .002 (.051)	- .01	P. ENGELBRECHT	3/94	D. SHU	6/8/94
XXX - .001 (.025)	- .005	DESIGNED BY	OF WORK		
		J. CHANG	6/8/94	T. M. KUZAY	6/8/94
		DESIGNER	PROJECT LEAD		
		R. KRAKORA	3/94		
		RESPONSIBLE ENGINEER	APPROVED/RELEASED		
		J. CHANG	6/8/94		
		MATERIAL	SEE NOTES		
			SCALE	SIZE	DRAWING NUMBER
			1:1	D	P4105091407-330000-00
			SHEET	1 of 1	

BY	CHANGE DESCRIPTION	BY	CHKD	DATE

DO NOT SCALE DRAWING

ADVANCED PHOTON SOURCE

B7 BM BEAM MIS-STEERING  
SAFETY MONITOR  
BELLOW WELDMENT