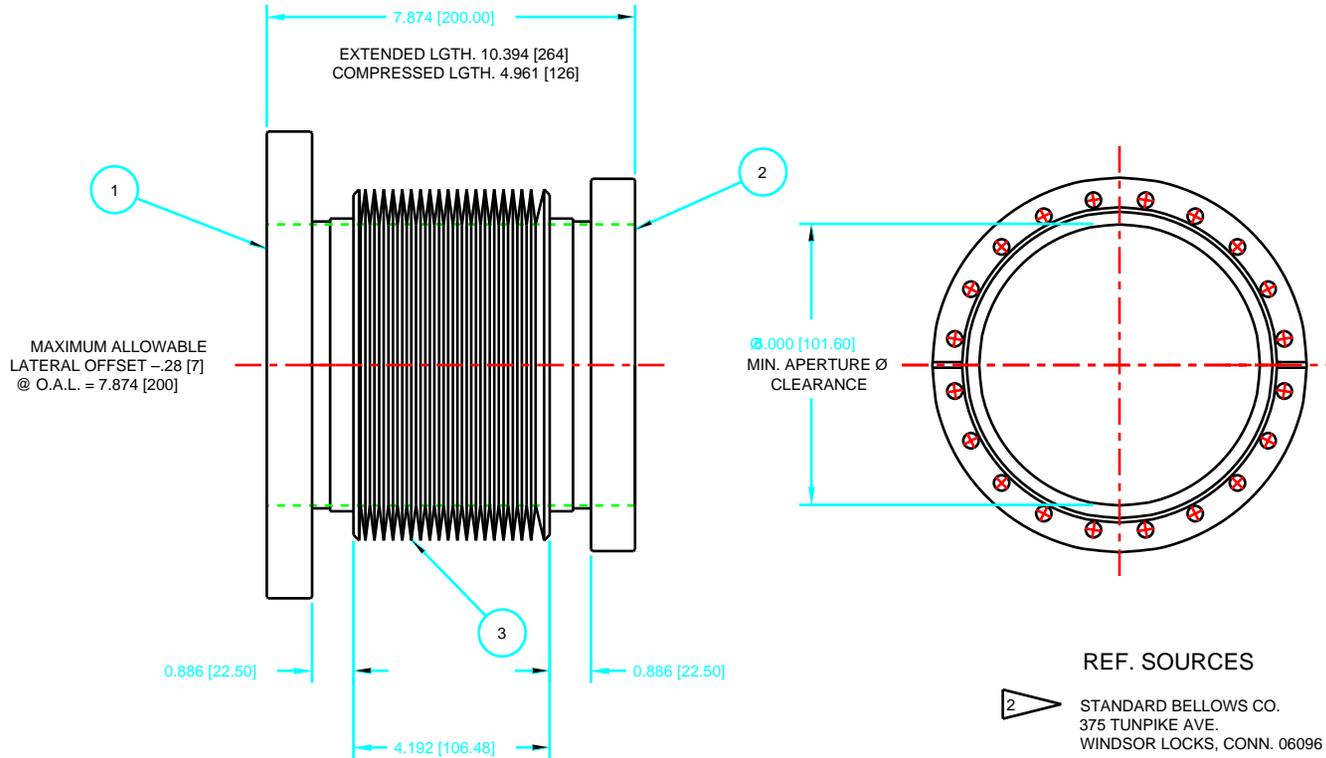


4

3

2

1



MAXIMUM ALLOWABLE
LATERAL OFFSET -.28 [7]
@ O.A.L. = 7.874 [200]

0.000 [101.60]
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



3		ST'D. BELLOWS CAT. #750 - 600 - 5 - EE	WITH EXTENDED ENDS	1
2	MDC'S CAT. #100031	8" CF. ROTATABLE FLANGE		1
1	MDC'C CAT. #110033	10" CF. NONROTATABLE FLANGE		1

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

UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES

DECIMALS ANGLES
X .03 (.7620) .25
XX .01 (0.25)
XXX .005 (0.127)

SURFACE ROUGHNESS 125 ✓

REMOVE ALL BURRS AND BREAK SHARP EDGES TO MAX. SURFACE FINISH TO BE IN ACCORDANCE WITH LATEST ASST 044

IDENTIFICATION & TOLERANCING IN ACCORDANCE WITH LATEST ASST 045

DO NOT SCALE DRAWING

THIS DRAWING IS THE PROPERTY OF
ARGONNE NATIONAL LABORATORY

A14770

DESIGNER: MUSCIA
CHECKED BY:
DESIGNER: MUSCIA
RESPONSIBLE ENGINEER

DATE: _____
DATE: _____
PROJECT MOR: _____
APPROVED/RELEASED: _____

TITLE: **ADVANCED PHOTON SOURCE**
V2-91 WELDED BELLOWS ASSY.
10" - 8" CF X 6" I.D. X 200mm

SCALE: 1:1
SHEET: 1 of 1

DRAWING NUMBER: **4105090702-910000-00**

SY#	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				

4

3

2

1