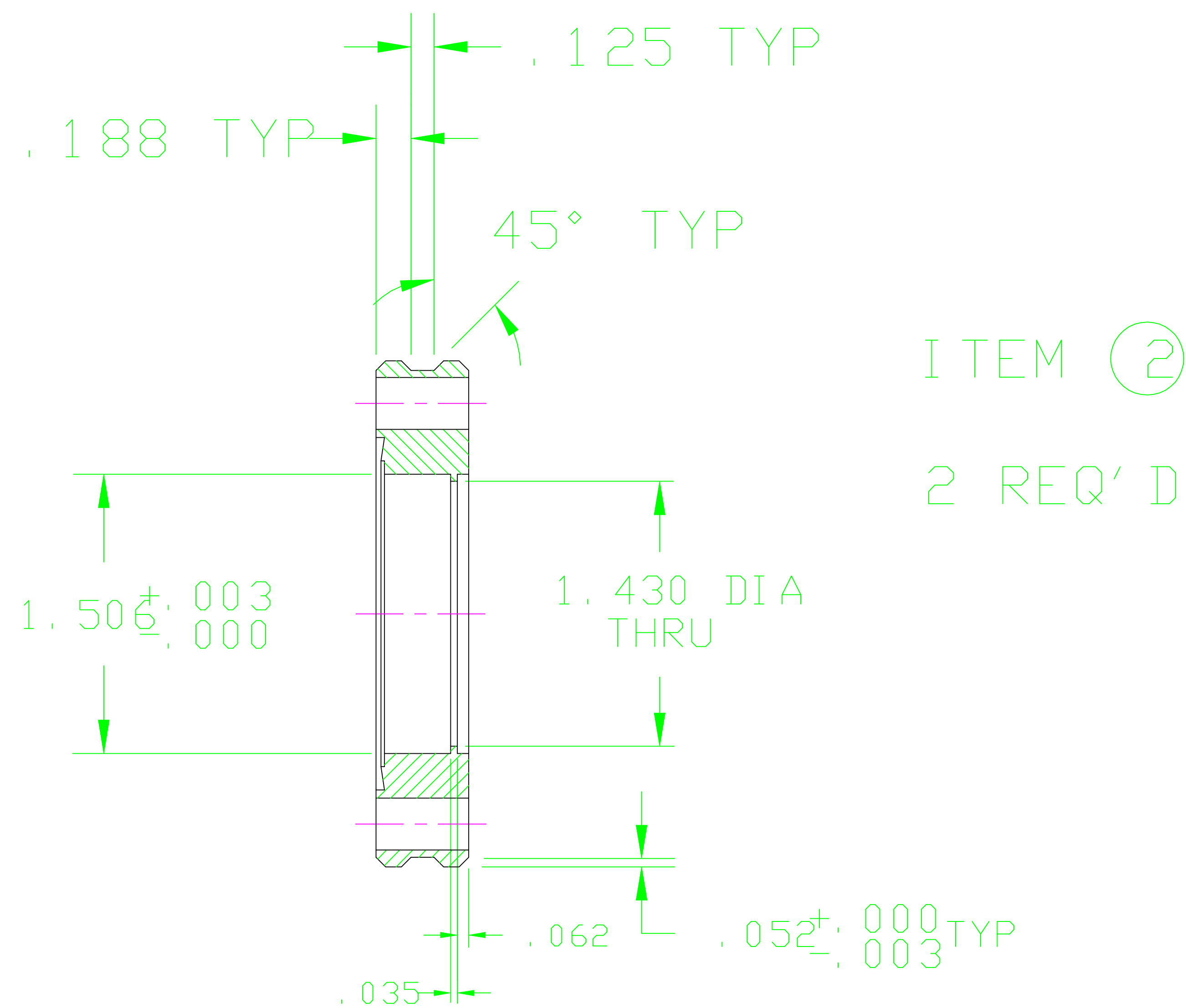


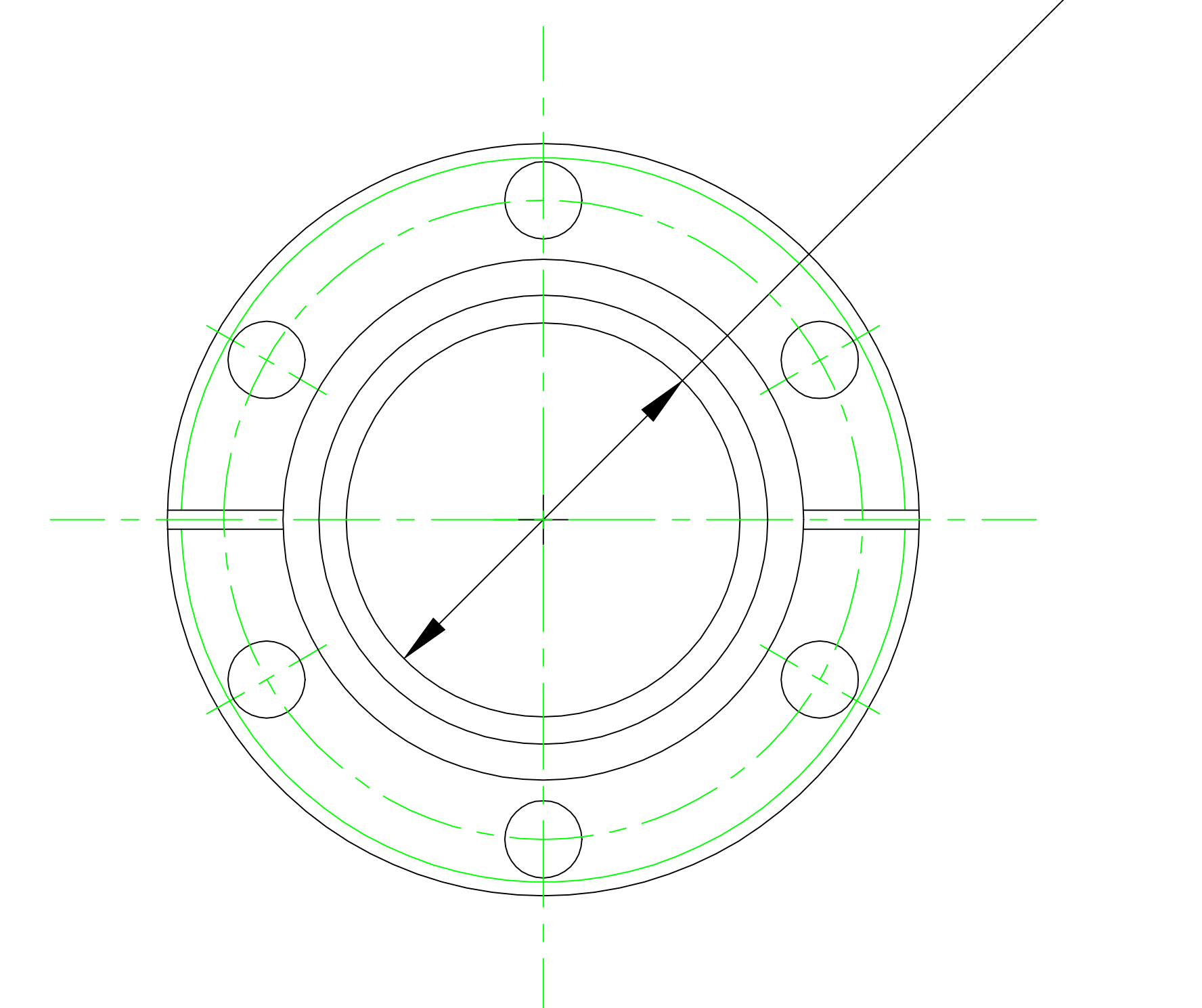
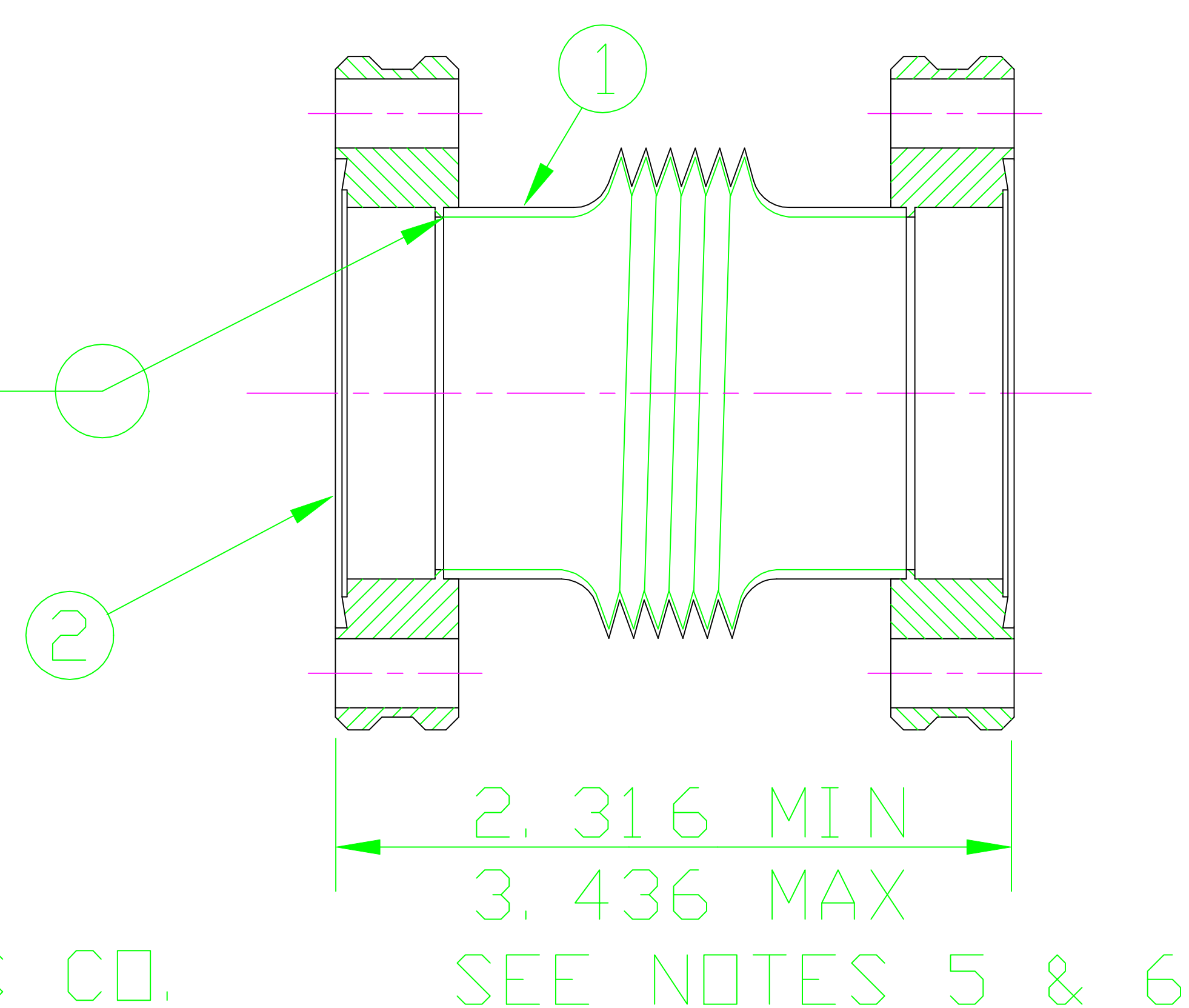
REV.	DATE	DESCRIPTION	BY	APP'D
1	10-88	ADDED CLEANING PROCEDURE TO NOTE 1	SPESE	
2	6-89	MODIFIED WELD PREP	WAALER	



ITEM ②
2 REQ'D

1.430 DIA CLEAR BORE
(LESS WELD THICKNESS)

2 PLCS
SEE NOTES
2, 3, AND 4



NOTES

- PURCHASE FROM STANDARD WELDED BELLOWS CO.
375 TURNPIKE AVE. WINDSOR LOCKS, CONN. 06096.
THEIR PART #: 189-139-2-EE (G DIMENSION .60)
SPEC FABRICATION TO SLAC VACUUM SPEC
OR CLEAN BY DEGREASING IN TCA VAPOR THEN
FIRING TO 625°C FOR > 8 HOURS IN A
VACUUM OVEN FOLLOWED BY A 24-HOUR COOL
- WELDS MUST BE GOOD FOR ULTRA-HIGH VACUUM
- ASSEMBLY MUST BE KEPT CLEAN
- WORKING RANGE SHOULD BE KEPT TO 2.441 MIN/3.311 MAX
GIVING A WORKING STROKE OF .870
- WHEN USED WITH GUIDE FRAME (C-2709-6, -16, & -24)
DIMENSIONS ARE 2.750 MIN/3.500 MAX (.750 STROKE)
- ALL MACHINING TO BE DONE WITH SULFUR-FREE
CUTTING OIL

3	MADE FROM MDC F275000R	MODIFIED AS SHOWN	1
2	MADE FROM MDC F275000	MODIFIED AS SHOWN	1
1		BELLOWS - SEE NOTE 1	1
ITEM	PART NO.	DESCRIPTION	QTY.
DRAWN BY	NUCLEAR PHYSICS LABORATORY		CESIATOR BELLOWS ASSEMBLY
SPESE	UNIVERSITY OF ILLINOIS AT URBANA-CHAMPAIGN		
CHECKED BY	UNLESS OTHERWISE SPECIFIED		PART NO.
	DIMENSIONS IN INCHES 2 PLACE DEC. ± .01		SCALE
	BREAK SHARP CORNERS 3 PLACES DEC. ± .003		1=1
	FRACTIONAL ± 1/32"		ANGULAR ± 0° 30'
APPROVED BY	CHASSIS NO. OR MATERIAL LISTED	DATE	FILE
		7-10-88	12
			DWG. NO.
			C-2709-7A