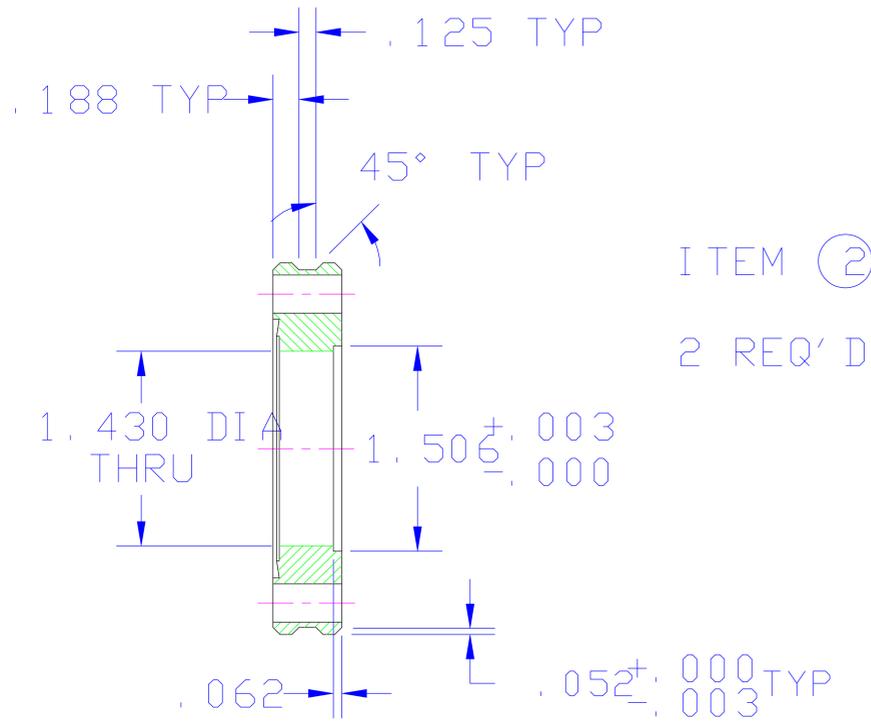
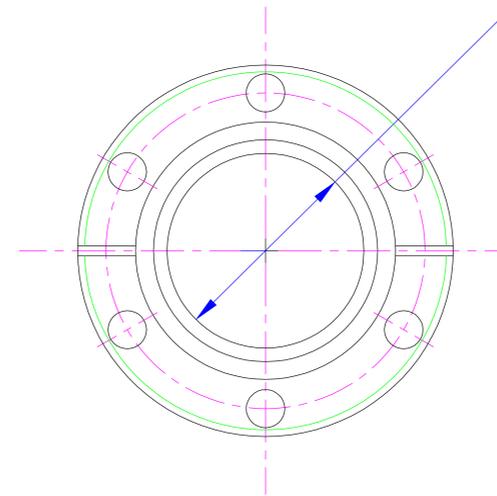
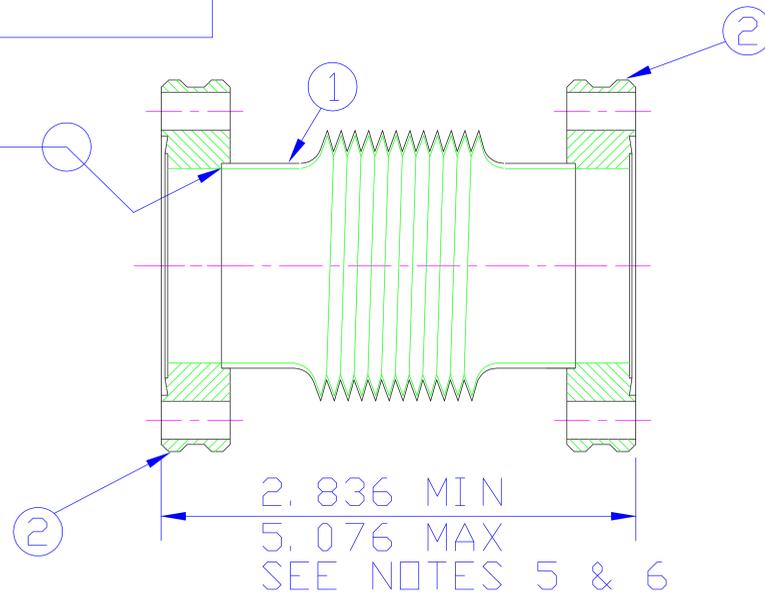


REV.	DATE	DESCRIPTION	BY	APP'D
1	10-88	ADDED CLEANING PROCEDURE TO NOTE 1	URI BE	
2	3-91	ADDED NOTE 8	URI BE	



1.430 DIA THRU CLEAR HOLE  
(LESS WELD THICKNESS)

2 PLCS  
SEE NOTES  
2, 3, AND 4



NOTES

1. PURCHASE FROM STANDARD WELDED BELLOWS CO.  
375 TURNPIKE AVE. WINDSOR LOCKS, CONN. 06096.  
THEIR PART #: 189-139-4-EE (G DIMENSION .60)  
SPEC FABRICATION TO SLAC VACUUM SPEC  
OR CLEAN BY DEGREASING IN TSA VAPOR THEN  
FIRING TO 625°C FOR ≥ 8 HOURS IN A VACUUM  
OVEN FOLLOWED BY A 24-HOUR COOL.
2. HOLES AND LEAK CHECK GROOVES MUST BE ALIGNED
3. WELDS MUST BE GOOD FOR ULTRA-HIGH VACUUM
4. ASSEMBLY MUST BE KEPT CLEAN
5. WORKING RANGE SHOULD BE KEPT TO 3.086 MIN/4.826MAX  
GIVING A WORKING STROKE OF 1.740
6. WHEN USED WITH BELLOWS STALK GUIDE FRAME  
(2709-66, -68 & -6) DIMENSIONS ARE 3.125 MIN/4.750 MAX  
(1.625 STROKE)
7. ALL MACHINING TO BE DONE WITH SULFUR-FREE  
CUTTING OIL.
8. DRAWING FOR PART AS BUILT FOR ORIGINAL GUN  
USE C-2709-69A FOR NEW CONSTRUCTION.

SLAC : SA795-649-20 MODIFIED

2	MADE FROM MDC F275000	MODIFIED AS SHOWN	2
1		BELLOWS - SEE NOTE 1	1
ITEM	PART NO.	DESCRIPTION	QTY.
DRAWN BY	NUCLEAR PHYSICS LABORATORY		STALK BELLOWS
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		NO. REQ'D.
	FRACTIONAL ± 1/32" ANGULAR ± 0° 30'		DATE
APPROVED BY	CHASSIS NO. OR MATERIAL LISTED		DWG. NO.
			7-10-88
			C-2709-69