



welding seam and welding geometrie  
at the choice of manufacturer  
Vacuum welding circulating

Integral leak rate  $< 1 \times 10^{-10}$  mbar l/s  
Outgassing rate  $< 5 \times 10^{-12}$  mbar l/s cm<sup>2</sup>

pay attention to F-TG-QUA-de-Schweisstechnik-V007

UHV-suitable cleaning, an example can be found in the guideline  
F-TG-V6.1e and F-TG-V-6.3e

Details, also to the alternative materials can be found in  
F-DS-HEB-en-VC\_0092\_Detailed\_Specification\_Bellow-V004

<b>Welding classification</b> DIN EN ISO 5817	Quality level
Vacuum weldings	-B-

Edges ISO 13715  $\begin{matrix} +0.3 \\ -0.1 \end{matrix}$   $\begin{matrix} -0.3 \\ -0.1 \end{matrix}$   $\sqrt{Rz25}$

Bakeout temperature: max. 300°C  
Operating temperature: 20°C  
Installation position: horizontal  
Axial movement per convolution +/- 3.1mm  
Inside Diameter: 144.1mm  
Outside Diameter: 189.9mm  
Vacuum: inside

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<b>GSi</b> Helmholtzzentrum für Schwerionenforschung GmbH Planckstrasse 1, 64291 Darmstadt		Surfaces DIN EN ISO 1302:2002	-----Approved-----	
		Dimensions without tolerance indication DIN ISO 2768-1-M DIN ISO 2768-2-K:1991 DIN EN ISO 13920-BF	Weight 4 kg	Scale 1:1
Drawn 12.08.2025 EHEGER	Name ZURKAN	Description Bellow-Unit bakeable		Size A2
Checked 12.08.2025 ZURKAN	Approved 22.09.2025 TEBERL	Drawing No. VC-1452725-A-V01	Rev. -	Sheet 1 of 1
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