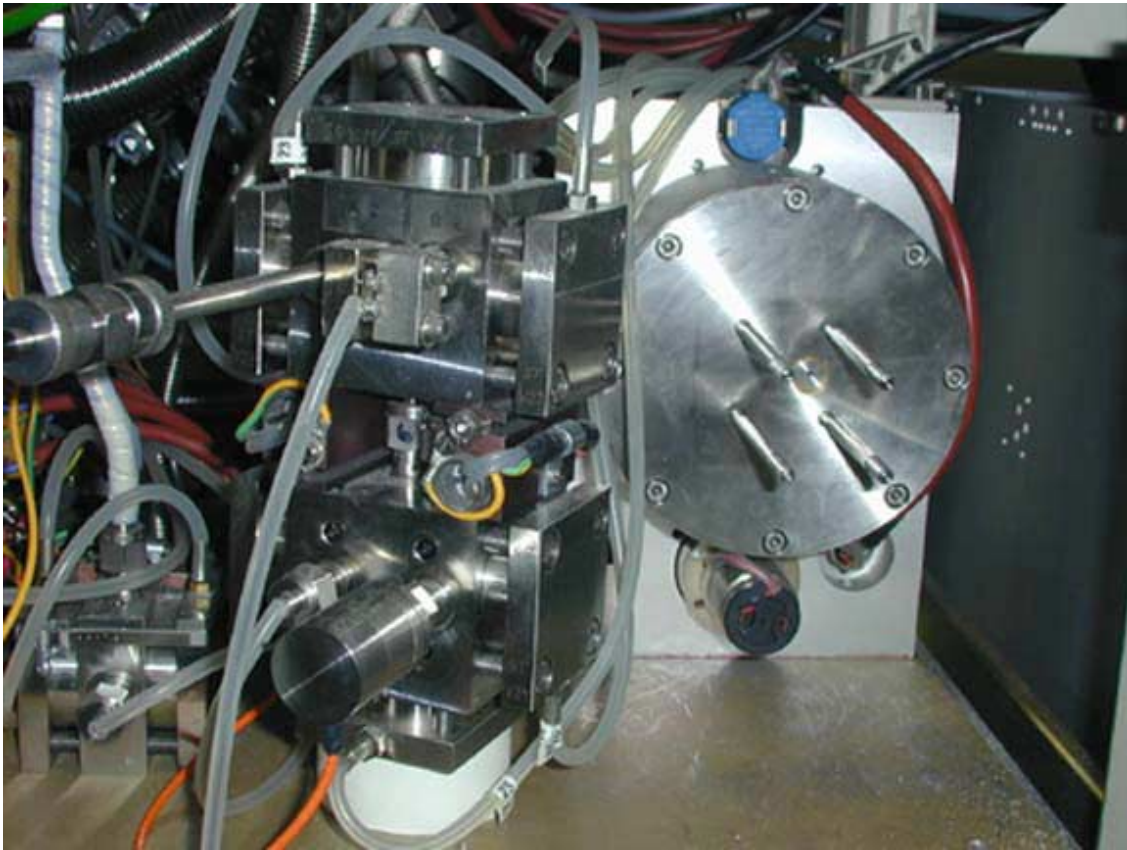


To Replace the Bellows unit in the Variable Volume Assembly

The bellows shaft must be disengaged from the drive gears. Follow the procedure for cleaning and greasing of the drive to step 4, and remove the shaft screw/pin.

Once the bellows shaft pin/screw has been removed, remove the valve body from the front of the volume assembly. See photo.

To remove the valve body, loosen and remove the four stud bolt nuts, then gently pull the valve body off of the stud bolts and support it to the side.



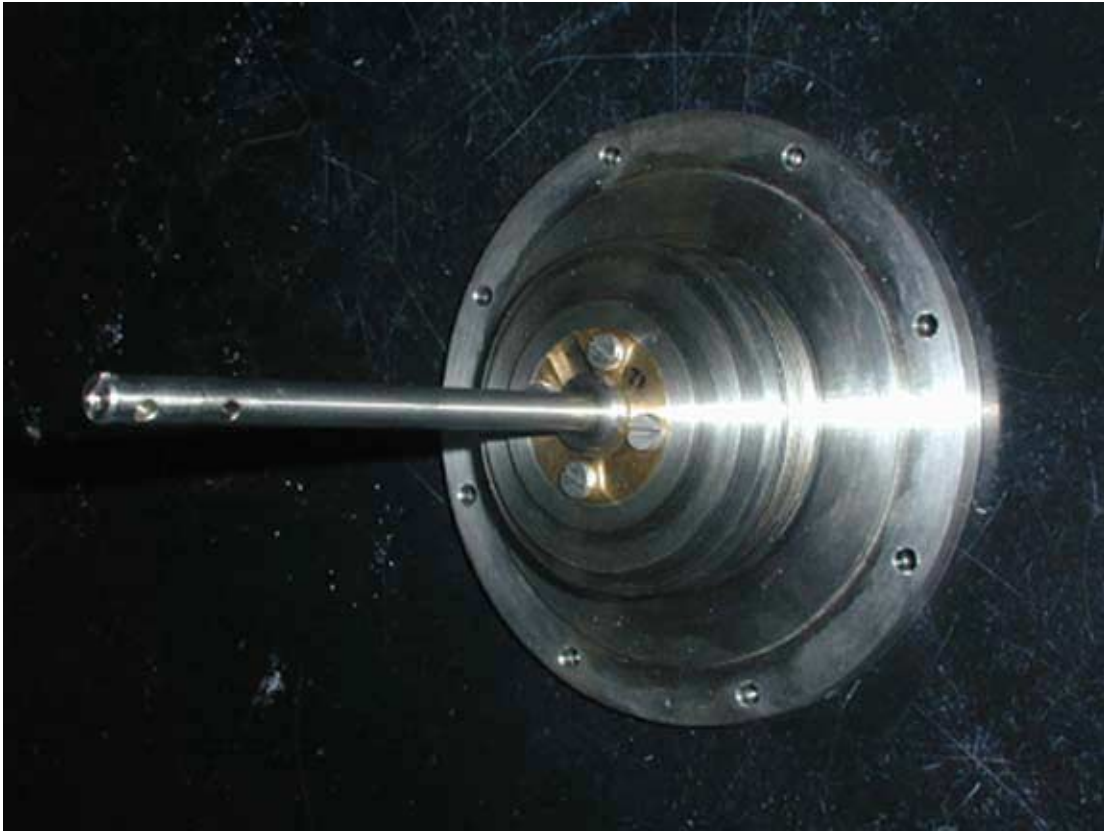
***Please note the small gold gasket in the recessed port in this picture. A new gasket will be required during reassembly. ***

Now loosen and remove the eight bellows allen bolts.

Gently, using the stud bolts, pull the bellows out of the assembly. You may need to also gently push on the bellows shaft from the other side at the same time. This can happen if there is a bur on the shaft at the pin/screw hole.

Once the bellows is removed, you will need to move the stud bolts from the old bellows to the new bellows.

The bellows shaft from the old bellows must be moved to the new bellows. This is done by removing the four bolts in the brass retainer. Shaft and retain then pull out.



Reassemble with the new bellows by following the procedures in reverse.

*** Remember to install the new gold gasket in the bellows face plate port.

Once the volume reassembly is complete, pump down and perform a leak test of the volume and all connections.

*****Last and important step, perform the Bellows Calibration, both parts, so that Isodat will learn the bellows end points.