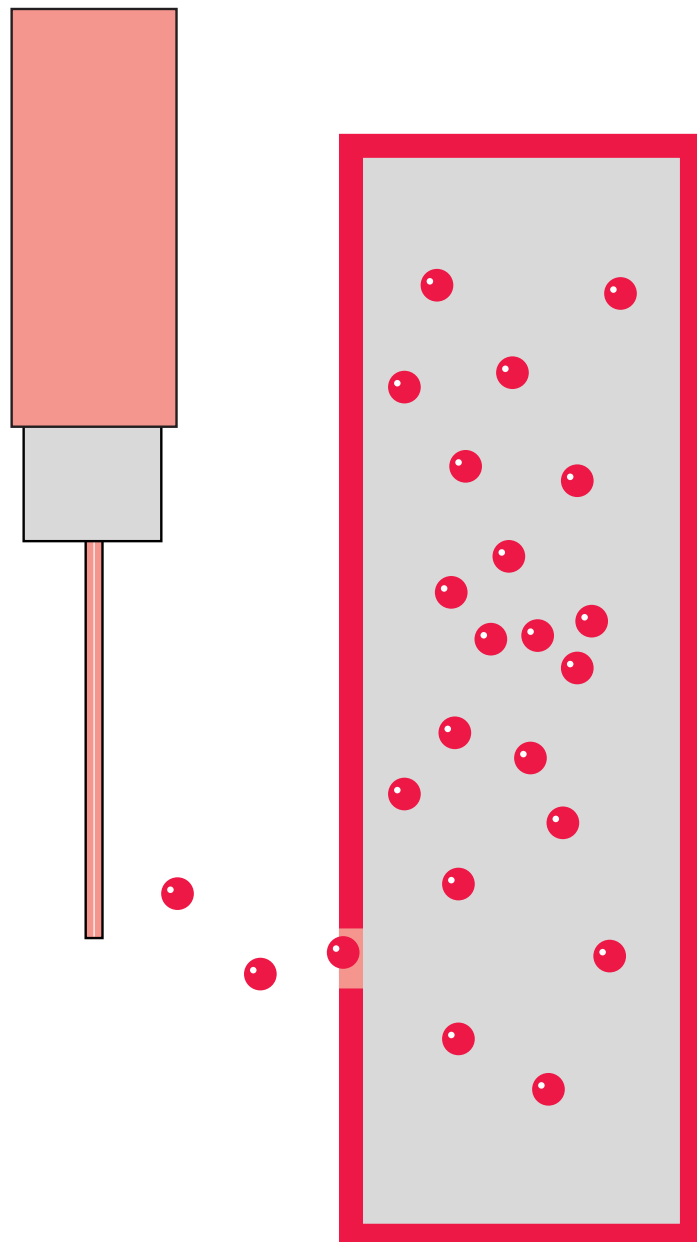


Leak Testing Instruments

Helium Leak Detectors



General

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Other Accessories

Connection Flanges	C17.21
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Applications and Accessories

Test Instruments / Leak Detectors		L 200 plus	L 200 dry	Modul L 200 plus, (oil-free)	Modul L 200 plus, (oil-sealed)
Applications					
Semiconductor production		◆	◆	◆	
Vacuum coating		◆			◆
Research and development		◆	◆	◆	
Chemistry/pharmaceutical		◆	◆	◆	◆
Metallurgy/furnaces		◆			◆
Lamps and tube manufacture		◆			◆
Automotive industry		◆			◆
Laser engineering		◆	◆		
Particle accelerators			◆	◆	
Analytical engineering		◆	◆	◆	◆
Systems with cryo pumps		◆	◆	◆	◆
Cooling and air conditioning		◆			◆
Electrical engineering		◆			◆
Mechanical engineering		◆			◆
Power plants		◆			◆
Systems engineering		◆			◆
UHV applications		◆	◆	◆	◆
Accessories					
	Page				
Calibrated leaks	C17.14	◆	◆	◆	◆
Screw-in calibrated leaks	C17.16	◆	◆	◆	◆
Transportation means	C17.18	◆	◆	◆	◆
Partial flow system	C17.18	◆	◆		
PC software LeakWare	C17.18	◆	◆	◆	◆
Helium sniffers	C17.20	◆	◆	◆	◆
Exhaust filter sets		standard	standard		
Interfaces		standard	standard	standard	standard
Gas ballast facilities		standard			
Trigger relay boards		standard	standard	standard	standard
Seal kits		◆	◆	◆	◆

Leak Detection — Leak Testing

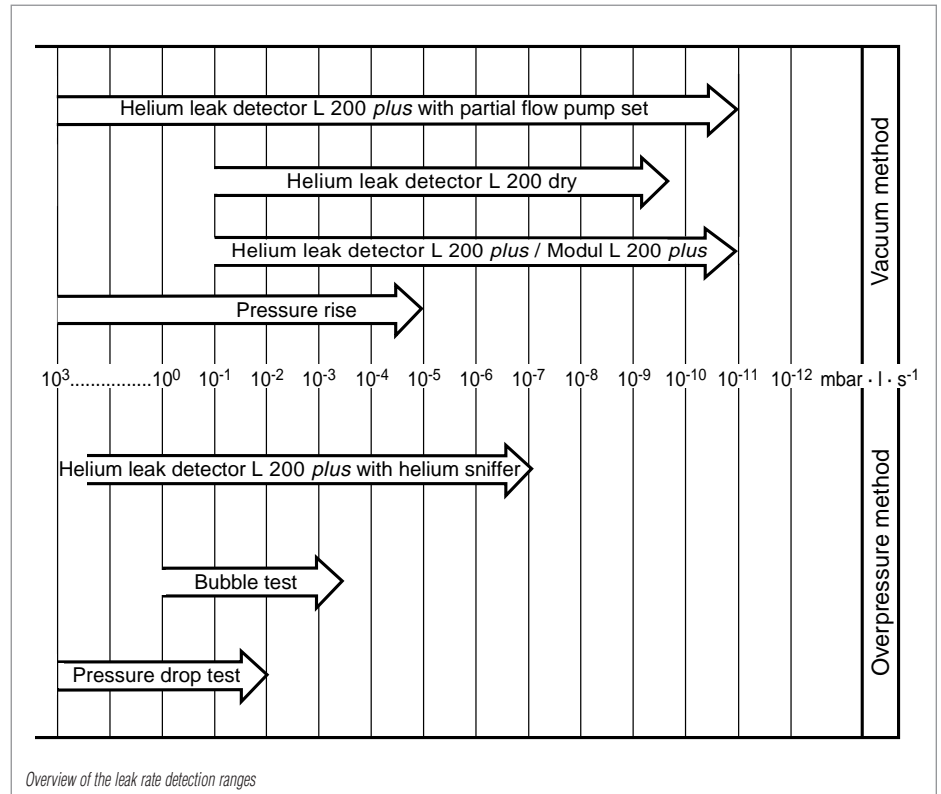
Whether a component or a system is leak-tight depends on the application it is to be used in and the leak rate that is acceptable. Absolutely leak-tight components and systems do not exist. A component is considered technically leak-tight if its leak rate remains below a value defined for this particular component. In order to provide a quantitative measure, the term “leak rate” with the symbol “ q_L ” was introduced. In vacuum technology $\text{mbar} \times \text{l} \times \text{s}^{-1}$ is used as the unit for leak rates.

A leak rate of $1 \text{ mbar} \times \text{l} \times \text{s}^{-1}$ exists in a closed vessel having a volume of 1 liter when the pressure increases by 1 mbar within one second, or in case of an overpressure it decreases by 1 mbar within one second.

$$q_L = \frac{V \times \Delta p}{\Delta t} \text{ (mbar} \times \text{l} \times \text{s}^{-1}\text{)}$$

The wide range of leak rates from several $100 \text{ mbar} \times \text{l} \times \text{s}^{-1}$ to below $10^{-11} \text{ mbar} \times \text{l} \times \text{s}^{-1}$ as they occur in practice necessitates the use of different leak detection principles and hence leak detectors (see figure).

Besides the determination of the total leak tightness, it is usually important to locate the leak, quickly and precisely, in order to seal it. Instruments for local leak detection are called leak detectors. The leak detectors presented in this product section can be used for the localization of leaks, and in addition some are suitable for determining the total leak rate of test objects.



Leak Rate	$\text{atm} \times \text{cm}^3 \times \text{s}^{-1} *$				$\text{kg} \times \text{h}^{-1}$ air	g/a $\text{C}_2\text{H}_2\text{F}_4$ (R 134a)
	$\text{Pa} \times \text{m}^3 \times \text{s}^{-1}$	$\text{mbar} \times \text{l} \times \text{s}^{-1}$	$\text{cm}^3 \times \text{s}^{-1} *$	$\text{torr} \times \text{l} \times \text{s}^{-1} *$		
$\text{Pa} \times \text{m}^3 \times \text{s}^{-1}$	1	10	9.87	7.5	4.28×10^{-2}	2.28×10^6
$1 \text{ mbar} \times \text{l} \times \text{s}^{-1}$ (He)	0.1	1	0.99	0.75	4.3×10^{-3}	2.28×10^5
$1 \text{ atm} \times \text{cm}^3 \times \text{s}^{-1} * = \text{cm}^3 \text{ (STP)} \times \text{s}^{-1}$	0.101	1.01	1	0.76	4.3×10^{-3}	2.3×10^5
$1 \text{ torr} \times \text{l} \times \text{s}^{-1}*$	0.133	1.33	1.33	1	5.7×10^{-3}	3.0×10^5
$1 \text{ kg} \times \text{h}^{-1}$ air	23.4	234	234	175	1	–
$1 \text{ g/a} \text{ C}_2\text{H}_2\text{F}_4$ (R 134a)	6.41×10^{-7}	7.58×10^{-6}	6.3×10^{-6}	4.8×10^{-6}	–	1

* According to international system of units only $\text{Pa} \times \text{m}^3 \times \text{s}^{-1}$ is permissible

Leak Detection Methods

There are two main groups of leak detection methods; for both there are special instruments available:

Vacuum Methods

The equipment to be tested is evacuated. The pressure ratio between inside and outside is 0:1.

Overpressure Methods

The equipment to be tested is pressurized with a search gas or a search gas mixture. The pressure ratio between inside and outside is over 1:1. Between the two methods there exist many variations depending on the particular application.

General Notes

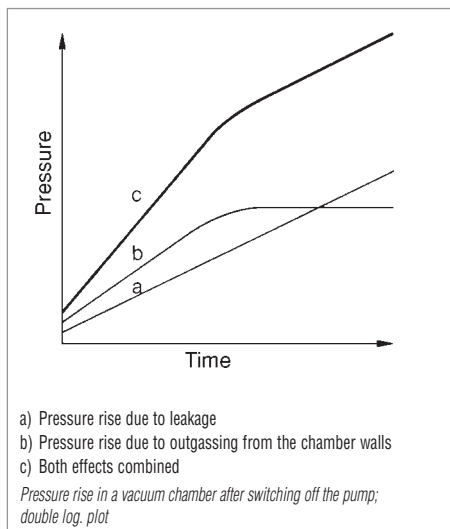
1. The lowest leak rates can only be measured by employing the vacuum method, whereby the following applies: The lower the leak rate, the higher the requirements are concerning cleanliness and ultimate vacuum.
2. If possible the test objects should be tested under the same conditions that will be used in their final application, i.e. parts for vacuum operation should be tested according to the vacuum method and parts for overpressure operation should be tested using the overpressure method.

Leak Testing Based on Vacuum Methods

(Vacuum inside the test object)

Pressure Rise Method

With this method it is only possible to determine the total leak rate. The test object is evacuated with a vacuum pump or a vacuum pump system. A valve is used to isolate the test object from the vacuum pump. The pressure will then rise as a function of time. Curve (a) shows the theoretical



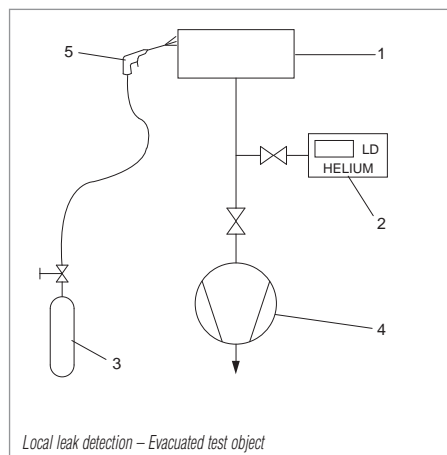
pressure rise if there is only a leak. Curve (b) shows the pressure rise due to outgassing from the surfaces of the test object. This pressure rise tends to tail off in the direction of a saturation level. If in such a case the time allowed for monitoring the pressure rise is too short, a leak will be indicated which in reality does not exist. If one waits long enough for the pressure to rise, i.e. after the bend of curve (b) the outgassing process can then be disregarded, so that the leak rate can be determined from the known volume of the test object and the measured pressure rise over a fixed rise time (see equation on page 4). Curve (c) shows the pressure rise as it occurs in practice, where outgassing and leak rate add. The detectable leak rate depends on the volume of the test object, the obtained ultimate pressure and the outgassing from the test object. In connection with very large test objects this method is time consuming if extremely low leak rates are to be determined in the fine and rough vacuum range.

Local Leak Detection

The test object is evacuated by a vacuum pump (auxiliary pump) until the pressure is low enough for the leak detector to operate. When using a helium leak detector, its own pump system will take care of further evacuation. Suspicious spots on the test object will then be sprayed with a fine jet of search gas. Search gas entering through leaks into the test object is pumped out by the vacuum pump and it is converted by the leak detector into an electrical signal which is then displayed. This permits rapid detection and determination of the size of even the smallest leaks.

Integral Method

Determination of the total leak rate of a test object. The testing arrangement is the same as for local leak detection, but in this case the test object is not sprayed with search gas on selected areas, but it is surrounded by a hood or a cham-



ber which is filled with the search gas. Thus the entire outer surface of the test object comes into contact with the search gas. If the search gas enters the test object, the total leak rate is indicated independently of the number of existing leaks. With helium leak detectors it is possible to determine the helium content of the air. This is utilized in the detection of gross leaks.

Leak Testing Based on Overpressure Methods

(Overpressure within the test object)

Pressure Drop Method

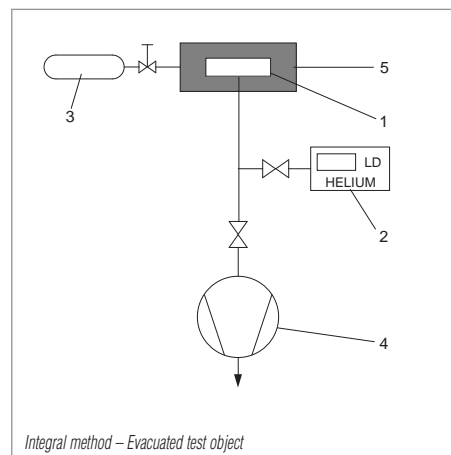
The test object is filled with a gas (for example air or nitrogen) until the testing pressure is reached. Precision vacuum gauges are used to detect a possible pressure drop during the testing period. This method is simple to implement, it is suitable for the determination of gross leaks and can be improved upon by using differential pressure gauges. By applying soap solutions or similar, leaks can be located.

Local Leak Detection with Leak Detectors – Sniffing

The test object is filled with the search gas or the search gas/air mixture to which the leak detector is sensitive. The leak detector is equipped with a sniffer probe, whereby there is a low pressure at the probe tip. If the sniffer tip passes suspicious points on the test object the search gas coming

Key to the Figures

- 1 Test object
- 2 Leak detector
- 3 Search gas cylinder
- 4 Vacuum pump
- 5 Hood
- 6 Spray gun for search gas
- 7 Sniffer probe



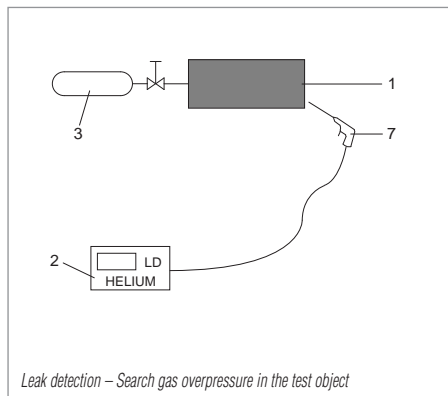
out of the leak is sucked in and transferred to the detection system of the leak detector. After conversion into electrical signals these are displayed optically and acoustically by the leak detector.

Integral Method – Hood Test

To determine the total leak rate of a test object subjected to a search gas overpressure, the test object is surrounded by a hood of a known volume. The search gas which escapes through the leaks collects in the hood.

After a fixed accumulation period a sniffer probe is used to measure the concentration of the search gas which has collected in the hood. Before this the leak detector should be calibrated by a reference measurement using a known search gas concentration.

The leak rate can then be determined by the equation for q_L where V is the volume of the hood, Δp is the partial pressure difference of the search gas (concentration change) and t is the accumulation period.



Uncertainties in the determination of the volume, leaks in the hood and a wrong accumulation period make precise leak rate measurements based on this method very questionable.

Integral Method – Vacuum Hood Test

This test is a variation of the hood test described above, which has considerable advantages. A vacuum chamber which is evacuated by an auxiliary pump and which is connected to a leak detector is used as the hood. The search gas escaping through the leaks is converted by the detection system of the leak detector into electrical signals which are immediately displayed. After calibration of the leak detector with a calibrated leak it is possible to quantitatively determine the total leak rate.

This method permits the detection of very small leaks and is especially suited for automatic industrial leak detection.

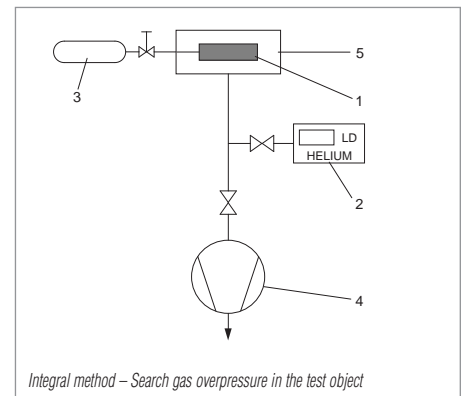
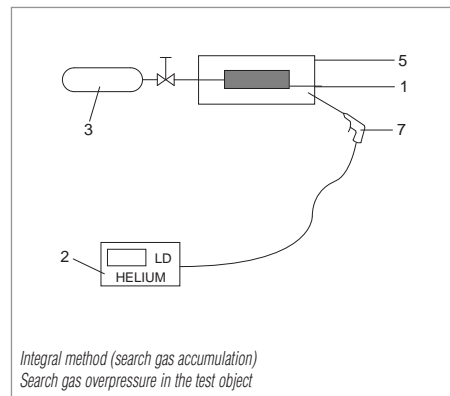
Integral Method – Bombing-Test

This method is used for testing hermetically sealed components such as transistors, IC-packages or

dry reed relays. It is basically a variation of the vacuum hood test. Here the test objects are placed in a vessel which is pressurized with the search gas - preferably helium. At a fairly high search gas pressure and after a period of up to several hours it is tried to enrich the search gas inside leaky test objects. This is the actual so called “bombing” process.

After this, the test objects are transferred to a vacuum chamber and their total leak rate is determined in the same way as in the vacuum hood test. During evacuation of the vacuum chamber down to the required testing pressure, those test objects which have a gross leak already lost their accumulated search gas. These parts are not detected as leaking during the actual leak test. Therefore the test with the vacuum chamber is often preceded by a “bubble test”.

This method permits the detection of the lowest leak rates and is used mainly in automatic industrial leak testing especially when it is not possible to fill the parts with gas in any other way.



Operating Principles of the Helium Leak Detectors

Operating Principle

A helium leak detector permits the localization of leaks and the quantitative determination of the leak rate, i.e. the gas flow through the leak. Such a leak detector is therefore a helium flow meter.

In practice the leak detector performs this task by firstly evacuating the part which is to be tested, so that gas from the outside may enter through an existing leak due to the pressure difference present. If only helium is brought in front of the leak (for example by using a spray gun) this helium flows through the leak and is pumped out by the leak detector. The helium partial pressure present in the leak detector is measured by a sector mass spectrometer and is displayed as a leak rate. This is usually given in terms of volume flow of the helium (pV-flow).

Important Specifications

The two most important features of a leak detector are its measurement range (detection limits) and its response time.

The measurement range is limited by the lowest and the highest detectable leak rate. The lowest detectable leak rate is defined by the sum of drift and noise in the most sensitive measurement range. Usually the sum of noise amplitude and zero drift per minute is made to be equivalent to the lowest detectable leak rate. With leak detectors the amount of drift is so low, that the noise amplitude alone determines the detection limit.

The highest detectable leak rate depends strongly on the method employed. Especially the counter-flow method and partial flow operation (see description below) permit the measurement of very high leak rates even with a sensitive helium

leak detector. In addition the multi-stage switchable high impedance input amplifiers of the leak detectors also permit the measurement of high leak rates.

In practical applications, especially in the localization of leaks the response time is of great significance. This is the time it takes from spraying the test object with helium until a measured value is displayed by the leak detector. The response time of the electronic signal conditioning circuitry is an important factor in the overall response time. In the case of leak detectors the response time of the electronic circuitry is well below 1 s.

The volume flow rate for helium at the point of the test object is of decisive significance to leak detection on components which are pumped down solely by the leak detector. This volume flow rate provided by the leak detector takes care

of the helium entering through a leak and it ensures quick detection by the leak detector. On the other hand the volume of the test object delays the arrival of the helium signal. The response time can be calculated on the basis of the following simple equation:

$$\text{Response time for helium } t_A = 3 \frac{V}{S_{\text{He}}} \quad (\text{for 95\% of the final value})$$

with V = Volume of the test object
 S_{He} = Volume flow rate for helium at the point of the test object (or at the inlet of the leak detector, if it alone pumps down the test object).

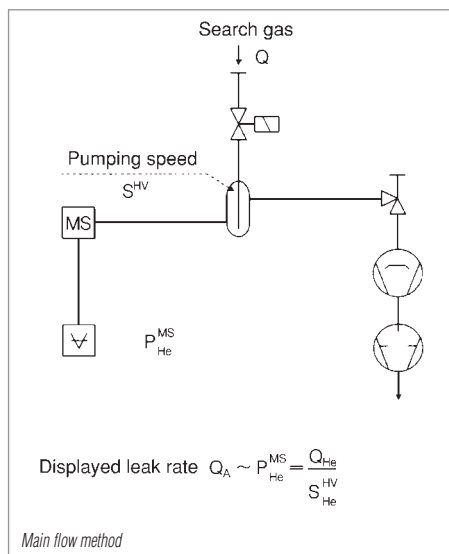
Main Flow Method

The classic operating principle of helium leak detectors is based on the main flow method. Here the entire helium flow passes through the high vacuum system of the leak detector, where the mass spectrometer measures the partial pressure of the helium. In this, the use of a liquid nitrogen cold trap is essential to remove water vapor or other condensable gases in the vacuum system which impair the operation. Moreover, the use of a cold trap permits the low operating pressures for the mass spectrometer to be reached (below 10^{-4} mbar) despite the directly connected (and possibly contaminated) test object.

The advantages of the main flow method are:

- Highest sensitivity, i.e. low detection limit
- Short response time due to a high volume flow rate at the inlet.

The main flow method is thus especially suitable for stationary leak detection on components. Leak detection on systems having their own pump sets and at higher pressures requires the use of an external throttling valve, i.e. a partial flow with subsequently reduced sensitivity is utilized.



Counterflow Method

With this method the test object is not connected to the high vacuum. Instead it is connected to the forevacuum (between turbomolecular pump and backing pump), so that the entire gas flow (especially water vapor) does not contribute to the pressure increase in the mass spectrometer. Thus a cold trap is no longer required!

The helium which now enters the forevacuum can still be detected, as it is able to flow against the pumping direction of the turbomolecular pump into the mass spectrometer. This is due to the high particle velocity of the helium. The sensitivity of this counterflow arrangement is equal to that of the main flow principle, provided the right combination of volume flow rate of the backing pump and helium compression of the turbomolecular pump is used.

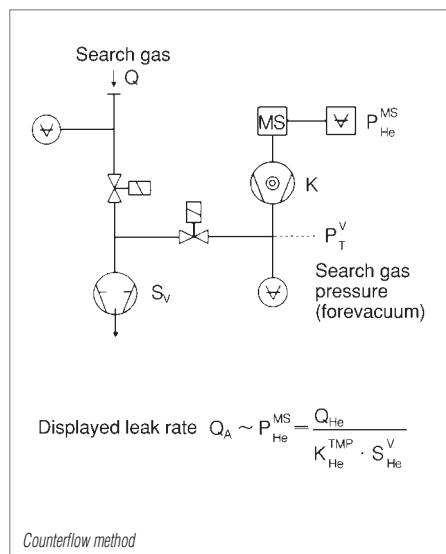
The advantages of the counterflow method are:

- No liquid nitrogen is required
- High permissible inlet pressures (i.e. pressure within the test object)

This makes the counterflow method especially suitable for mobile leak detection on systems. For leak detection on larger components where a short response time is essential (i.e. high volume flow rate) an additional turbomolecular pump stage is required at the inlet of the leak detector.

Partial Flow Method

In order to expand the measurement range in the direction of higher leak rates and for operation at higher inlet pressures, helium leak detectors incorporate a partial flow or a gross leak system. This consists basically of a throttle and a rotary vane pump. At pressures above the normal inlet pressure (main flow: above 10^{-2} mbar, counterflow: above 10^{-1} mbar) or in the case of high helium leak rates, the inlet valve is closed and the main flow is allowed to enter the partial flow pump, whereas only a small part enters the leak



detector via the partial flow throttle. Thus the total pressure and the helium pressure are dropped to values suitable for operation of the leak detector.

To obtain correct leak rate readings in the partial flow mode, the partial flow ratio, i.e. the ratio between the actually measured gas flow and the total gas flow must be known and stable.

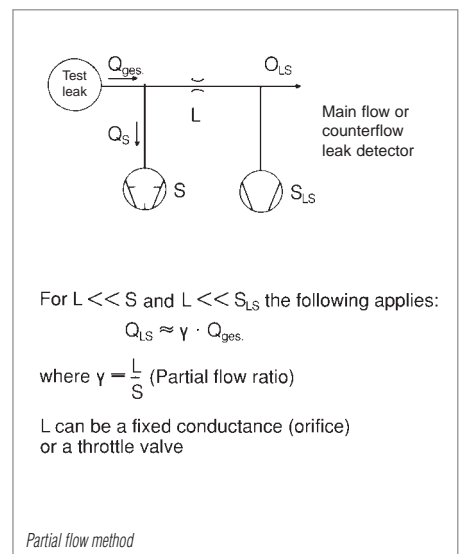
In all leak detectors this is achieved by a partial flow throttle made of ruby with a precisely machined hole. This ensures that the quantitatively determined leak rates are always correct without calibration, even for gross leaks.

Calibration of Helium Leak Detectors with Calibrated Leaks

In the process of leak detection one expects that a test object which does not have a leak produces a zero reading on the leak detector. In this any malfunctions are excluded. Thus calibrated leaks, i.e. artificial leaks which produce a known helium leak rate are essential for reliable results.

To obtain a quantitatively correct leak rate reading the sensitivity of the leak detector must also be adjusted. This requires the use of a calibrated leak.

LEYBOLD offers calibrated helium leaks of various designs covering the range between 10^{-9} to 10^{-4} mbar \times l \times s $^{-1}$ as part of the standard range of products. All leak rates are traceable to the standards of the German Calibration Service controlled by the PTB (Federal Institution of Physics and Technology). If requested each helium calibrated leak can be supplied with a calibration certificate issued by the German Calibration Service. The calibration itself is performed by the German Calibration Service for Vacuum which is run by LEYBOLD on behalf of the PTB.



For $L \ll S$ and $L \ll S_{LS}$ the following applies:

$$Q_{LS} \approx \gamma \cdot Q_{ges}$$

where $\gamma = \frac{L}{S}$ (Partial flow ratio)

L can be a fixed conductance (orifice) or a throttle valve

Helium Leak Detector L 200 plus



The L 200 plus is a portable multi-purpose helium leak detector and equally well suited to both service and series production testing.

Its rugged design and its ease of use make the L 200 plus to the best selling leak detector in the world.

Advantages to the User

- ◆ Quick start-up
- ◆ Extremely fast response time
- ◆ Oil-free gas admission system
- ◆ One of the smallest helium leak detectors in the world
- ◆ High sensitivity
- ◆ Ergonomically designed
- ◆ Hand unit can be operated with one hand equally well by right and left-handers
- ◆ Fast leak rate readout also at low leak rates

Typical Applications

Leak tests in connection with

- ◆ Quality assurance
- ◆ Automotive industry
- ◆ Analytical instruments
- ◆ Systems manufacture
- ◆ Power station engineering
- ◆ Research and development
- ◆ Semiconductor industry
- ◆ High vacuum and ultra-high vacuum engineering
- ◆ Ideal tool for industrial series production testing – in the cooling and air conditioning industries, for example

In connection with the sniffer lines which are available as accessories the L 200 plus may also be used as a sniffer leak detector.

In connection with a partial flow pump set the L 200 may also be used for the detection of leaks on large vessels.

Technical Data		L 200 plus
Smallest detectable helium leak rate (Vacuum mode)	mbar x l x s ⁻¹	< 10 x 10 ⁻¹²
Smallest detectable helium leak rate (Sniffer mode)	mbar x l x s ⁻¹	< 1 x 10 ⁻⁷
Max. detectable helium leak rate (Vacuum mode)	mbar x l x s ⁻¹	1 x 10 ⁻¹
Max. inlet pressure	mbar (Torr)	3 (2.25)
with partial flow pump set	mbar (Torr)	1000 (760)
Pumping speed during the evacuation process		
50 Hz	m ³ x h ⁻¹ (cfm)	2.5 (1.5)
60 Hz	m ³ x h ⁻¹ (cfm)	3.0 (1.8)
Pumping speed for helium at the inlet	l/s	1
Time constant of the leak signal (blanked off, 63 % of final value)	s	< 1
Leak rate measurement range	mbar x l x s ⁻¹	1 x 10 ⁻¹² to 1 x 10 ⁻¹
Units of measurement (selectable)		mbar x l x s ⁻¹ , atm x cc x sec ⁻¹ , Pa x m ³ x s ⁻¹ , ppm, Torr x l x s ⁻¹ , g/a, oz/y
Time until ready for operation	min	< 3
Mass spectrometer		180° magnetic sector field
Ion source		2 yttrium/iridium long-life cathodes
Detectable masses	amu	2, 3 and 4
Test port	DN	1 x 25 KF
Length of the cable on the hand unit	m	4
Dimensions (W x H x D)	mm	490 x 430 x 250
Weight	kg (lbs)	35.5 (78.4)

Ordering Information	L 200 plus
L 200 plus	
230 V / 50/60 Hz, mbar readout, with TL 7	Part No. 140 00 L
230 V / 50/60 Hz, mbar readout, without TL 7	Part No. 140 01 L
PC software LeakWare	Part No. 140 90
Seal kit	Part No. 200 99 150
Calibrated leak TL 7 for fitting into the L 200	Part No. 140 23
For further accessories see Section "Accessories for L 200 plus, L 200 dry and Modul L 200 plus"	

Portable and Dry Helium Leak Detector L 200 dry



The L 200 dry is a compact portable helium leak detector capable of meeting the highest cleanliness requirements.

Based on the well-proven technology of the L 200, but equipped with an oil-free pump system, the L 200 dry meets the highest requirements concerning cleanliness while at the same time being small in size.

Advantages to the User

- ◆ Oil-free “dry” pump system
- ◆ Small footprint
- ◆ Quick start-up
- ◆ Extremely fast response

Typical Applications

Leak tests with stringent requirements concerning cleanliness, for example

- ◆ Semiconductor industry
 - after repairs or maintenance work
- ◆ Semiconductor industry
 - Production of semiconductor components
- ◆ Pharmaceutical/medicine
- ◆ Laser

Technical Data		L 200 dry
Smallest detectable helium leak rate (Vacuum mode)	mbar x l x s ⁻¹	< 3 x 10 ⁻¹⁰
Smallest detectable helium leak rate (Sniffer mode)	mbar x l x s ⁻¹	< 1 x 10 ⁻⁷
Max. detectable helium leak rate (Vacuum mode)	mbar x l x s ⁻¹	1 x 10 ⁻¹
Max. permissible inlet pressure	mbar (Torr)	3.5 (2.63)
Pumping speed during the evacuation process		
50 Hz	m ³ x h ⁻¹ (cfm)	1.6 (0.94)
60 Hz	m ³ x h ⁻¹ (cfm)	1.9 (1.12)
Pumping speed for helium at the inlet	l/s	0.6
Time constant of the leak signal (blanked off, 63 % of final value)	s	< 1
Leak rate measurement range	mbar x l x s ⁻¹	1 x 10 ⁻¹¹ to 1 x 10 ⁻¹
Units of measurement (selectable)		mbar x l x s ⁻¹ , atm x cc x sec ⁻¹ , Pa x m ³ x s ⁻¹ , ppm Torr x l x s ⁻¹ , g/a, oz/ly
Time until ready for operation	min	< 3
Mass spectrometer		180° magnetic sector field
Ion source		2 yttrium/iridium long-life cathodes
Detectable masses	amu	2, 3 and 4
Test port	DN	1 x 25 KF
Length of the cable on the hand unit	m	4
Dimensions (W x H x D)	mm	490 x 430 x 250
Weight	kg (lbs)	33 (72.8)
Ordering Information		L 200 dry
L 200 dry 230 V / 50/60 Hz, mbar readout, with TL 7		Part No. 140 15 L
PC software LeakWare		Part No. 140 90
Seal kit		Part No. 200 99 150
For further accessories see Section “Accessories for L 200 plus, L 200 dry and Modul L 200 plus”		

Mobile and Flexible Helium Leak Detector Modul L 200 *plus*



Modul L 200 plus

The Modul L 200 *plus* combines the excellent characteristics of the L 200 *plus* with those of the pump system which has been added to the basic leak detector module.

This results in two basic groups:

- ◆ Dry, mobile leak detectors with selectable pumping speed
- ◆ Oil-sealed, mobile leak detectors offering a high pumping speed at an optimum price-to-performance ratio.

Modul L 200 *plus* with Oil-Sealed Backing Pump

This combination represents a powerful leak detector, the pumping speed of which is adapted to the particular application in each case.

Advantages to the User

- ◆ Cost-effective leak detector
- ◆ Pumping speed optimized for the particular application
- ◆ Fast response
- ◆ Quick recovery
- ◆ High sensitivity
- ◆ Fast leak rate readout also at low leak rates

Typical Applications

All applications involving short cycles and/or larger volumes and which require a mobile system, like for example:

- ◆ Automotive industry
- ◆ Cooling and air conditioning
- ◆ Manufacturers of furnaces/machines/systems
- ◆ Packaging

The Modul L 200 *plus* represents the basic unit of an entire family of leak detectors. It is based on the L 200 *plus*, is not equipped with an integrated backing pump and may be easily adapted by adding an external backing pump to suit a wide range of applications.

Modul L 200 *plus* with Dry-Compressing Scroll Pump

This combination represents a dry high-performance leak detector.

Advantages to the User

- ◆ Very high pumping speed which is also acceptable for testing semiconductor production chambers without having to use their own pump systems
- ◆ Fast response
- ◆ Quick recovery (after helium contamination)
- ◆ Absolutely dry
- ◆ High sensitivity

Typical Applications

All applications which demand a clean process, like for example:

- ◆ Semiconductor industry (chip manufacturers)
- ◆ Semiconductor industry (tool manufacturers and subcontractors)
- ◆ High purity gas industry
- ◆ Research and development
- ◆ UHV applications

Technical Data		Modul L 200 <i>plus</i>	
		with Rotary Vane Vacuum Pump	with Scroll Pump
Smallest detectable helium leak rate (Vacuum mode)	mbar x l x s ⁻¹	< 10 x 10 ⁻¹²	
Smallest detectable helium leak rate (Sniffer mode)	mbar x l x s ⁻¹	< 1 x 10 ⁻⁷	
Max. detectable helium leak rate (Vacuum mode)	mbar x l x s ⁻¹	10 ⁻¹	
Max. permissible inlet pressure	mbar (Torr)	3 (2.25)	
Pumping speed during the evacuation process Scroll pump / TRIVAC D 25 B pump	m ³ x h ⁻¹ (cfm)	25 (14.7)	25 (14.7)
Pumping speed for helium at the inlet flange	l/s	8	8
Time constant of the leak signal (blanked off, 63 % of final value)	s	< 1	
Leak rate measurement range	mbar x l x s ⁻¹	1 x 10 ⁻¹² to 1 x 10 ⁻¹	
Units of measurement (selectable)		mbar x l x s ⁻¹ , atm x cc x sec ⁻¹ , Pa x m ³ x s ⁻¹ , ppm, Torr x l x s ⁻¹ , g/a, oz/y	
Time until ready for operation	min	< 3	
Mass spectrometer		180° magnetic sector field	
Ion source		2 yttrium/iridium long-life cathodes	
Detectable masses	amu	2, 3 and 4	
Test port	DN	1 x 25 KF	
Length of the cable on the hand unit	m	4	
Dimensions (W x H x D)	mm	490 x 430 x 250	
Weight (without pump)	kg (lbs)	30.5 (67)	

The following Part Nos. contain only the individual components needed for assembly by the customer. For building a portable system we recommend our factory tested and pre-assembled systems (see next page "Mobile Leak Detection Systems fitted to the CART 200").

Ordering Information	Modul L 200 <i>plus</i>
Modul L 200 <i>plus</i> without pump ¹⁾ Euro, 230 V / 50/60 Hz	Part No. 140 34 L
PC software LeakWare	Part No. 140 90
Seal kit	Part No. 200 99 150
Pumps TRIVAC D 25 B; 230 V, 50/60 Hz Scroll, 230 V / 50/60 Hz	Part No. 113 35 Part No. 200 000 214
CART 200	Part No. 140 93
For further accessories see Section "Accessories for L 200 <i>plus</i> , L 200 dry and Modul L 200 <i>plus</i> "	

¹⁾ But without integrated backing pump

Please order cart separately

Mobile Leak Detection Systems fitted to the CART 200



CART 200 with Modul L 200 plus and TRIVAC D 25 B

These mobile systems are accommodated on the CART 200. Placed on these carts are the leak detectors L 200 *plus*, L 200 dry or Modul L 200 *plus*.

Additional backing pumps (depending on the version required) are accommodated on the bottom level of the carts.

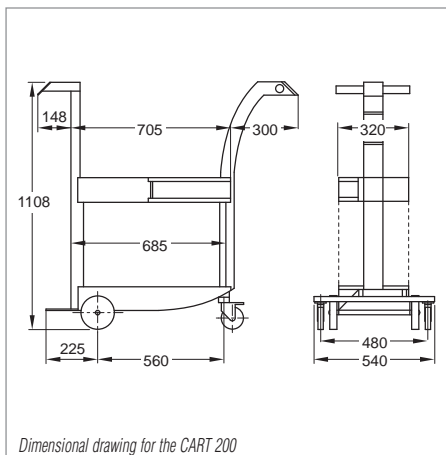
CART 200

The CART 200 is a special transport cart made of painted steel with an integrated holder for gas cylinders and space for small parts and documents. The leak detector and the pump are accommodated on two levels.

The pre-assembled and tested system according to the Part Nos. on the next page include all required connecting components between leak detector and backing pump. Then only the upper section of the system will be packaged separately. The helium cylinder is not part of the delivery.

Advantages to the User

- ◆ Complete, fully operational leak detection system
- ◆ Simple to operate
- ◆ Choice of either oil-sealed or dry compressing backing pump
- ◆ In the case of these systems, the transport cart CART 200 is included



Dimensional drawing for the CART 200

Technical Data		CART L 200 <i>plus</i>	CART L 200 dry	CART Modul L 200 <i>plus</i>
Smallest detectable leak rate for air (Vacuum mode)	mbar x l x s ⁻¹	< 10 x 10 ⁻¹²	< 3 x 10 ⁻¹⁰	< 10 x 10 ⁻¹²
Smallest detectable leak rate for helium (Sniffer mode)	mbar x l x s ⁻¹	< 1 x 10 ⁻⁷		
Max. detectable leak rate for helium (Vacuum mode)	mbar x l x s ⁻¹	10 ⁻¹		
Max. inlet pressure	mbar (Torr)	1000 (752)	3.5 (2.63)	3 (2.25)
Pumping speed during the evacuation process with				
Scroll	m ³ x h ⁻¹	25		
TRIVAC D 25 B, Euro	m ³ x h ⁻¹	25		
Max. pumping speed for helium at the inlet flange	l/s	8		
Time constant of the leak signal (blanked off, 63 % of final value)	s	< 1		
Leak rate measurement range	mbar x l x s ⁻¹	1 x 10 ⁻¹² to 1 x 10 ⁻¹	1 x 10 ⁻¹¹ to 1 x 10 ⁻¹	1 x 10 ⁻¹² to 1 x 10 ⁻¹
Units of measurement (selectable)		mbar x l x s ⁻¹ , atm x cc x sec ⁻¹ , Pa x m ³ x s ⁻¹ , ppm, Torr x l x s ⁻¹ , g/a, oz/y		
Time until ready for operation	min	< 3		
Mass spectrometer		180° magnetic sector field		
Ion source		2 yttrium/iridium long-life cathodes		
Detectable masses	amu	2, 3 and 4		
Test port	DN	1 x 25 KF		
Cable length for the hand unit	m	4		
Dimensions (W x H x D)	mm	540 x 1350 x 1150		
Weight	kg (lbs)	119 (263)	128 (283)	115 / 125 (254 / 276)
Ordering Information		CART L 200 <i>plus</i>	CART L 200 dry	CART Modul L 200 <i>plus</i>
CART L 200 <i>plus</i> with partial flow pump set TRIVAC D 25 B		Part No. 140 85 L	-	-
CART L 200 dry with partial flow pump set Scroll pump		-	Part No. 140 75 L	-
CART Modul 200 <i>plus</i> ¹⁾ with Scroll pump		-	-	upon request
TRIVAC D 25 B		-	-	upon request

¹⁾ Without integrated backing pump

Calibrated Leaks for Vacuum and Sniffer Applications



Calibrated leaks are required for the alignment of mass spectrometers, for the calibration of leak rates and for determining the response time of vacuum systems.

Calibrated Leaks for Vacuum Applications

TL 4 and TL 6

Calibrated leaks without gas reservoir (capillary type of leak) for sensitivity and signal response time determinations during vacuum leak detection and for determination of sniffer sensitivity for overpressure leak detection. Nominal leak rate ranges 10^{-4} mbar x l x s⁻¹ for TL 4 and 10^{-6} mbar x l x s⁻¹ for TL 6. Suitable for helium. A purging valve with hose nozzle permits a rapid exchange of the gas in the dead volume.

TL 4-6

Helium calibrated leak (capillary leak) for gross leaks, adjustable in the range between 10^{-4} to 10^{-6} mbar x l x s⁻¹, with exchangeable helium reservoir, pressure gauge and two manually operated valves. For calibration of leak rate readings and the alignment of helium mass spectrometers in the vacuum pressure range and for determining the sensitivity of sniffers in the overpressure range.

TL 5

Calibrated helium leak (capillary leak) with reservoir which may be refilled and with a leak rate in

the range of 10^{-5} mbar x l x s⁻¹. Special calibrated leak for use in a vacuum.

TL 7

Helium calibrated leak (capillary leak) with helium reservoir and electromagnetically operated valve, for installation in the ULTRATEST L 200. Leak rate range 10^{-7} mbar x l x s⁻¹. The electromagnetically operated valve provided permits the opening and closing of the calibrated leak to be controlled by the leak detector's software.

TL 8 and TL 9

Helium calibrated leak calibrated for a leak rate in the range of 10^{-8} mbar x l x s⁻¹ (helium leak rate) for TL 8 and 10^{-9} mbar x l x s⁻¹ for TL 9, with gas reservoir and diaphragm shutoff valve. For alignment of a helium mass spectrometer, for calibration of the leak rate display of helium leak detectors and for response time measurements in connection with larger volumes.

Note

All calibrated leaks with the exception of the TL 5 are not suited for use in a vacuum.

Advantages to the User

- ◆ Factory certificate (included) in accordance with DIN 55 350-18-4.2.2
- ◆ Highly accurate
- ◆ Very low temperature dependence
- ◆ Determination of the nominal leak rate by comparison with a calibrated leak having a PTB ¹⁾ certificate
- ◆ DKD ²⁾ certificate (optional) traceable to PTB
- ◆ Custom models for special applications

The nominal leak rate applies only if the calibrated leak has been connected to a vacuum system at a pressure of less than 1 mbar.

¹⁾ Federal Institution of Physics and Technology

²⁾ German Calibration Service

Calibrated Leaks for Sniffer Applications

These calibrated leaks have been set to a fixed value within the typical leak rate range (see Ordering Information).

The exchangeable calibration gas reservoir is monitored through the built-in manometer.

Helium calibrated leaks

S-TL 4 to S-TL 6 with leak rates from 10^{-4} to 10^{-6} mbar x l x s⁻¹.

Set of Calibrated Leaks for Power Plants

These three calibrated leaks of 1000, 100 and 10 mbar x l x s⁻¹ allow leak tests under partial flow conditions under the ambient conditions of power plants.

Technical Data	Leak Rate Range	Leak Detection Method	Connection Flange
TL 4, without helium gas reservoir	10^{-4} mbar x l x s ⁻¹	Vacuum and sniffer	DN 16 KF
TL 6, without helium gas reservoir	10^{-6} mbar x l x s ⁻¹	Vacuum and sniffer	DN 16 KF
TL 4-6, with helium gas reservoir	10^{-4} to 10^{-6} mbar x l x s ⁻¹	Vacuum and sniffer	DN 16 KF
TL 5, mit He-Gasvorrat	10^{-5} mbar x l x s ⁻¹	Vacuum	Discharging opening
TL 7, with helium gas reservoir	10^{-7} mbar x l x s ⁻¹	Vacuum (for installation in the L 200 <i>plus</i>)	DN 10 KF
TL 8, with helium gas reservoir	10^{-8} mbar x l x s ⁻¹	Vacuum	DN 10 KF
TL 9, with helium gas reservoir	10^{-9} mbar x l x s ⁻¹	Vacuum	DN 10 KF
S-TL 4, with helium gas reservoir	10^{-4} mbar x l x s ⁻¹	Sniffer	Nozzle
S-TL 5, with helium gas reservoir	10^{-5} mbar x l x s ⁻¹	Sniffer	Nozzle
S-TL 6, with helium gas reservoir	10^{-6} mbar x l x s ⁻¹	Sniffer	Nozzle

Ordering Information	Calibrated Leak
TL 4, without helium gas reservoir *)	Part No. 155 65
TL 6, without helium gas reservoir *)	Part No. 155 66
TL 4-6, with helium gas reservoir *)	Part No. 155 80
TL 5, mit He-Gasvorrat *)	Part No. 122 67
TL 7, with helium gas reservoir, for installation within the L 200 *)	Part No. 140 23
TL 8, with helium gas reservoir *)	Part No. 165 57
TL 9, with helium gas reservoir *)	Part No. 144 08
S-TL 4, with helium gas reservoir *)	Part No. 122 37
S-TL 5, with helium gas reservoir *)	Part No. 122 38
S-TL 6, with helium gas reservoir *)	Part No. 122 39
Set of calibrated leaks for power plants 1000, 100, 10 mbar x l x s ⁻¹	Part No. 115 16
Rubber bladder	Part No. 200 20 218
Hose clamp	Part No. 200 20 217
Helium can; 1 l, 12 bar (for TL 4-6)	Part No. 252 001
DKD calibration for TL 7/8	Part No. 154 15

*) with factory certificate

Screw-in Calibrated Leaks

The manufacturers of helium leak testing systems are in need of calibrated leaks of various sizes with individually adjusted leak rates for the purpose of setting up and calibrating their systems.

Depending on the type of application these calibrated leaks are either installed in the test sample as a master leak or used as a continually available facility in the test chamber itself.

LEYBOLD is now offering a new family of calibrated leaks which are capable of meeting the requirements concerning type and required leak rate.



Calibrated leak with screw-in sleeve

Calibrated Leak with Screw-in Sleeve

Is used as a so-called master leak to check the entire helium leak testing system.

Generally two leaktight test samples are equipped with these calibrated leaks. These will ensure proper separation between "passed and rejected" parts.

They are fitted to the customer's test samples either by a welded joint or the screw-in sleeve is glued in place.

Typical Applications

- ◆ As a master calibrated leak built-in directly into the test sample
- ◆ Directly installed to the test chamber
- ◆ Use as a calibrated leak for sniffer applications

Advantages to the User

- ◆ Various types adapted to different customer requirements
- ◆ Simple to operate
- ◆ Easy to install
- ◆ Ideal installation dimensions
- ◆ As a rule, all calibrated leaks are supplied with a certificate (factory certificate) indicating the leak rate which has been set up



Calibrated leak with pin type casing

Calibrated Leak with Pin Type Casing

Serves as a calibrated leak for the entire helium leak testing system without being influenced by the presence of a test sample.

Here a dummy is placed in the test chamber. The connection to the test chamber is directly by a DN 10 KF fitting. The test gas connection is either by a VCO fitting or a hose nozzle for flexible connections.

Connections on the side of the customer's system are

- 16 KF running to the vacuum chamber
- Hose nozzle, 10 mm in diameter or VCO fitting, 10 mm in diameter



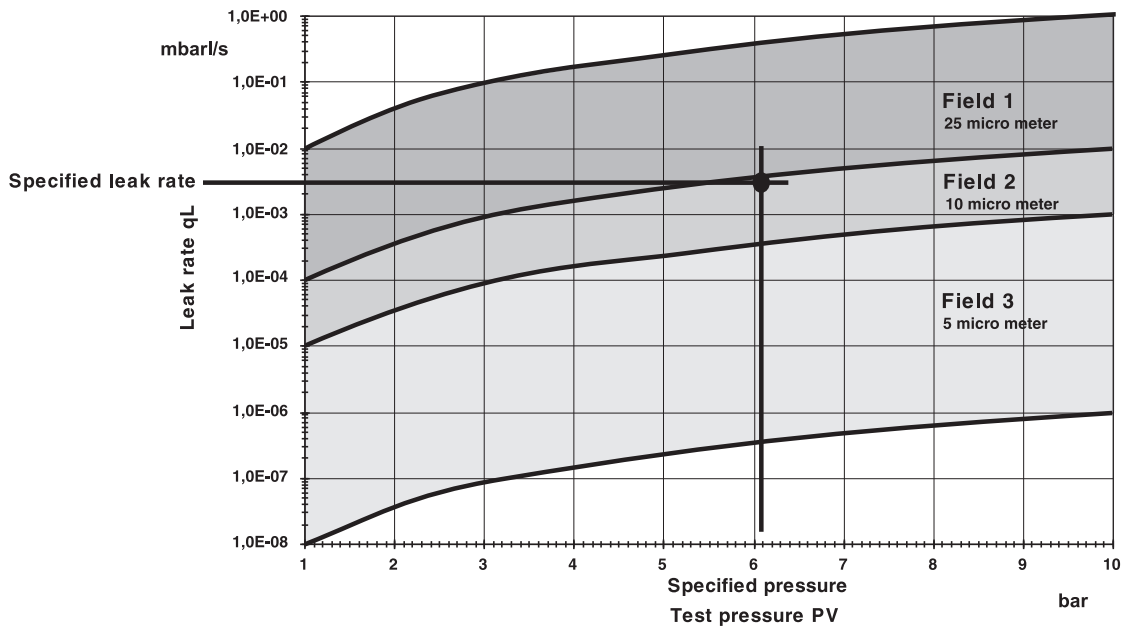
Calibrated leak with cylindrical casing

Calibrated Leak with Cylindrical Casing

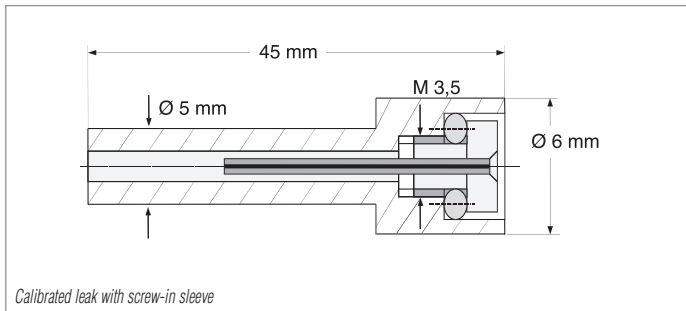
Is used to check the sensitivity of a sniffing facility.

Before and after the actual test, the operator checks the sensitivity of his test facility within the scope of a plausibility check.

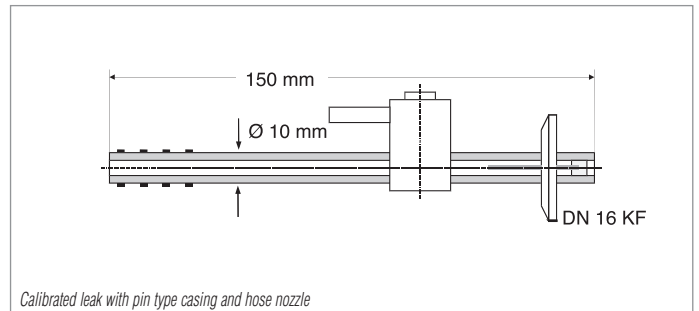
The connection on the side of the customer's system is provided via a VCO fitting for a diameter of 10 mm.



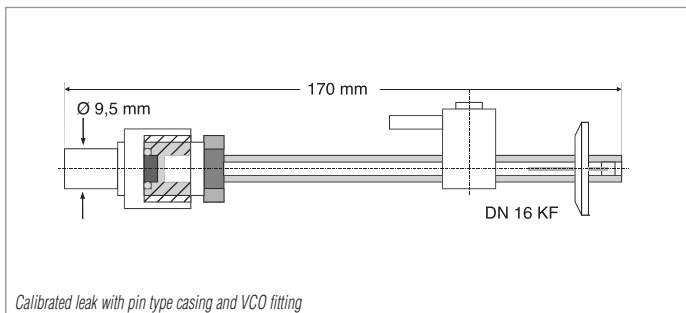
Leak rate as a function of applied test pressure vs. 0 bar



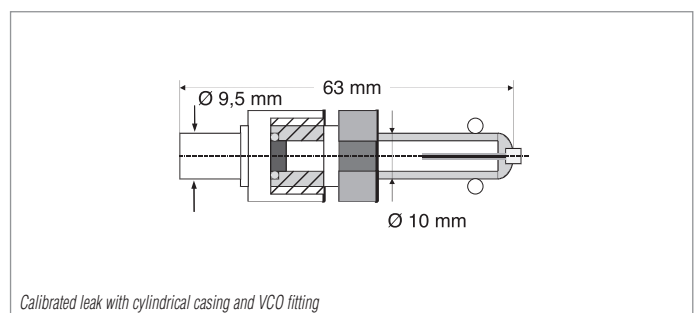
Calibrated leak with screw-in sleeve



Calibrated leak with pin type casing and hose nozzle



Calibrated leak with pin type casing and VCO fitting



Calibrated leak with cylindrical casing and VCO fitting

Technical Data

Leak rate	mbar x l x s-1	Casing only	Calibrated Leak		
			Field 1 1 - 10 ⁻⁴	Field 2 10 ⁻² - 10 ⁻⁵	Field 3 10 ⁻³ - 10 ⁻⁸

Ordering Information *)

Calibrated leak		Calibrated Leak		
		Part No. 143 00	Part No. 143 01	Part No. 143 02
with screw-in sleeve	-	Part No. 143 04	Part No. 143 05	Part No. 143 06
with pin type casing and VCO fitting	Part No. 143 03	Part No. 143 08	Part No. 143 09	Part No. 143 10
with pin type casing and hose nozzle	Part No. 143 07	Part No. 143 12	Part No. 143 13	Part No. 143 14
with cylindrical casing and VCO fitting	Part No. 143 11			

*) When ordering please always state leak rate, test pressure and helium concentration

Accessories for the L 200 *plus*, L 200 dry and Modul L 200 *plus*



CART 200 (standard steel, painted)

CART 200

For the L 200 *plus*, L 200 dry and Modul L 200 *plus*; including shelf and holder for gas cylinders; made of painted sheet steel.

The CART's are prepared for accommodating the Scroll and the TRIVAC D 25 B pumps.



Transport case

Transport Case

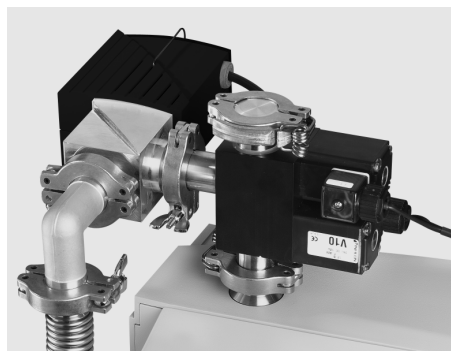
For impact protected transportation of the L 200 *plus*; complete with strong carrying handles and plastic castors. Separate case for accessories.



Search gas spray gun

Search Gas Spray Gun

The search gas spray gun with PVC hose (5 m long) is used for well aimed spraying of search gas at places where a leak is suspected.



Partial flow system without pump

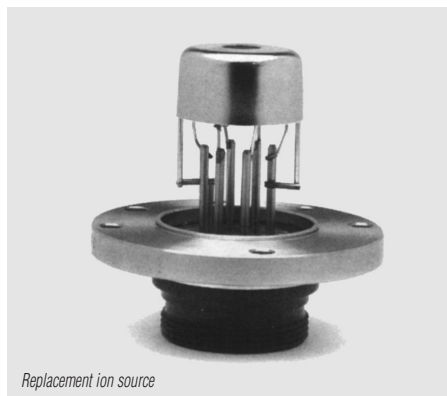
Partial Flow System L 200 *plus* and L 200 dry

For evacuation of test objects up to 100 l. Gross leak detection up to $10 \text{ mbar} \times \text{l} \times \text{s}^{-1}$. Maximum test pressure: 1000 mbar.

Equipment:

Valve block (with inlet valve, venting valve, bypass or purging valve) plus right-angle bellows valve DN 25 KF made of stainless steel, solenoid drives, suited for remote control by the L 200 *plus*, mains power 230 V / 50/60 Hz.

The partial flow systems are available without pumps or in mobile systems with oil-sealed TRIVAC D 25 B rotary vane pumps or dry scroll pumps.



Replacement ion source

Replacement Ion Source

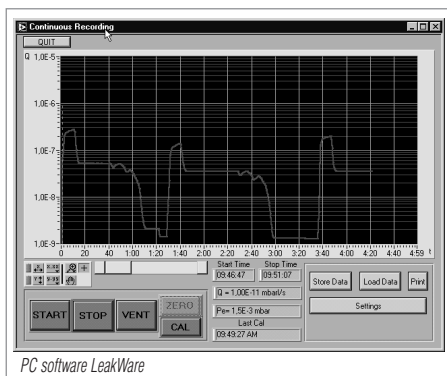
Complete replacement component, including two built-in yttrium coated iridium cathodes



Extension line

8 m Extension Line

The use of extension lines permits operation of the L 200 *plus* up to 30 m away from the test objects. A maximum of three extension lines (of 8 m each) may be connected in series.



PC software LeakWare

PC software LeakWare

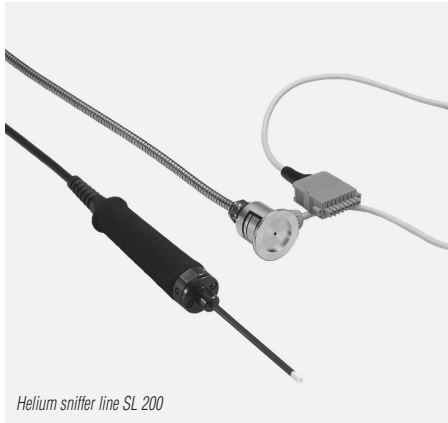
The Windows PC software is used for data acquisition, documentation of the measurements and to control the operation of the leak detector.

Hardware > 486 DX and 8 MB Ram
Software Windows 95, 98, NT, 2000.

Technical Data		Accessories
Transport case	kg (lbs)	16.5 (36.4)
Transport cart CART 200	kg (lbs)	39 (86.1)
Partial flow system		
for L 200; 230 V / 50/60 Hz, without pump	kg (lbs)	5.3 (11.7)
for L 200 dry; 230 V / 50/60 Hz, without pump	kg (lbs)	5.8 (12.8)
Ordering Information		Accessories
Transport case		Part No. 140 96
Transport cart CART 200		Part No. 140 93
Partial flow system *)		
for L 200; 230 V / 50/60 Hz, without pump		Part No. 140 20
for L 200 dry; 230 V / 50/60 Hz, without pump		Part No. 140 29
Pumps		
TRIVAC D 25 B, 230 V / 50/60 Hz		Part No. 113 35
Scroll, 230 V / 50/60 Hz		Part No. 200 000 214
AF 16-25 exhaust filter, for partial flow system		Part No. 189 11
Replacement ion source		Part No. 165 04
PC software LeakWare		Part No. 140 90
8 m long extension line		Part No. 140 22
Search gas spray gun		Part No. 165 55

*) 5 centering rings, 5 clamping rings and 1 vacuum hose 1 m with DN 25 KF are included

Helium Sample Probes (Sniffers)



Helium sniffers in connection with the leak detectors are used for leak testing test samples in which a helium overpressure is present. Besides accurate pinpointing of leaks it is also possible to determine the leak rate of the escaping helium.

Advantages to the User

Helium Sniffer Line SL 200 for L 200 plus

- ◆ Sniffer line connects directly at the test connection
- ◆ Very fast response
- ◆ Extremely low detection limit $< 1 \times 10^{-7}$ mbar x l x s⁻¹
- ◆ Rigid sniffer tips 120 mm (included)
- ◆ Very rugged industrial design

Helium Sniffers QUICK-TEST QT 100 for L 200 plus

- ◆ Sniffer leak detection for greater distances between test object and leak detector
- ◆ Diaphragm pump for sucking the search gas
- ◆ Smallest detectable leak rate 1×10^{-6} mbar x l x s⁻¹
- ◆ Short response and decay times
- ◆ High sniffer velocity
- ◆ Switching power supply, can be run off mains voltages from 100 to 230 V AC

Typical Applications

- ◆ Storage and transportation vessels for gases and liquids
- ◆ Gas supply systems
- ◆ Gas compressors
- ◆ Components for the cooling and air conditioning industries
- ◆ Heat pumps and components for thermal energy recovery units
- ◆ Chemical production plants
- ◆ Supply and phone lines laid in the ground
- ◆ Power station condensers and turbines
- ◆ Window and door seals of car bodies, refrigerators and alike
- ◆ Revision checks on leak testing systems
- ◆ Measurement of helium concentrations ranging from ppm to %
- ◆ All hollow objects exposed to overpressures

Technical Data		SL 200	QT 100
Smallest detectable leak rate	mbar x l x s ⁻¹	$< 10^{-7}$	10^{-6}
Supply voltage		–	100-230 V, 50/60 Hz
Signal response time, approx.			
at a length of			
5 m	s	< 1	1
20 m	s	–	< 6
50 m	s	–	20
Connection flange	DN	25 KF	25 KF
Weight	kg (lbs)	0.6 (1.3)	3.5 (7.7)
Ordering Information		SL 200	QT 100
Helium sniffer line SL 200 4 m long, straight handle with red/green LED for go/no-go indication, rigid and flexible sniffer tip 120 mm		Part No. 140 05	–
Helium sniffer QUICK-TEST QT 100		–	Part No. 155 94
Sniffer line for the QT 100			
5 m		–	Part No. 140 08
20 m		–	Part No. 140 09
50 m		–	Part No. 121 83

Connection Flanges

Leak Detectors		Helium Sniffers		Calibrated Leaks	
L 200 <i>plus</i>	- DN 25 KF	SL 200	- DN 25 KF	TL 4	- DN 16 KF
L 200 <i>dry</i>	- DN 25 KF	QT	- DN 25 KF	TL 6	- DN 16 KF
Modul L 200 <i>plus</i>	- DN 25 KF	ST 100	- DN 25 KF	TL 4-6	- DN 16 KF

If components of the same nominal width are connected, only one centering ring and one clamping ring will be required.

Connection Components

When wanting to connect accessories (helium sniffer and calibrated leaks) to a leak detector, the following reducers and components may be necessary:

Reduction	Reducers	Centering Rings		Clamping Rings	
		Stainless steel/FPM		Aluminium	
DN 25 / 16 KF	Part No. 183 86, aluminium or Part No. 885 04, stainless steel	DN 25 KF, DN 16 KF,	Part No. 883 47 Part No. 883 46	DN 20 / 25 KF, DN 10 / 16 KF,	Part No. 183 42 Part No. 183 41
DN 40 / 25 KF	Part No. 183 87, aluminium or Part No. 885 05, stainless steel	DN 25 KF, DN 40 KF,	Part No. 883 47 Part No. 883 48	DN 20 / 25 KF, DN 32 / 40 KF,	Part No. 183 42 Part No. 183 43
DN 40 / 16 KF	Part No. 183 89, aluminium or Part No. 885 07, stainless steel	DN 16 KF, DN 40 KF,	Part No. 883 46 Part No. 883 48	DN 10 / 16 KF, DN 32 / 40 KF,	Part No. 183 41 Part No. 183 43

The following metal hoses are recommended to connect the leak detectors to systems:

Nominal Width	Length	Ordering Information
DN 16 KF	1.0 m	Part No. 868 01
DN 16 KF	0.5 m	Part No. 867 91
DN 25 KF	1.0 m	Part No. 868 03
DN 25 KF	0.5 m	Part No. 867 93
DN 40 KF	1.0 m	Part No. 868 01
DN 40 KF	0.5 m	Part No. 867 95

Further connecting components, like quick clamping rings and other components are described in Product Section C13 "Vacuum Fittings and Feedthroughs"

