



# Leak Detecting Instruments

Leak D

PHOENIX

Helium Leak Detectors

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# General

## Applications for Leak Detecting Instruments

Test Instruments / Leak Detectors	PHOENIX Quadro	PHOENIX Quadro dry	PHOENIX Magno	PHOENIX Magno dry	PHOENIX Vario	PHOENIX Vario (öl-gedichtet)	PHOENIX L500i
<b>Applications</b>							
Semiconductor production	■	■	■	■	■		■
Vacuum coating	■	■	■	■		■	■
Research and development	■	■	■	■	■	■	■
Chemistry/pharmaceutical	■	■	■	■	■	■	■
Metallurgy/furnaces	■		■		■	■	■
Metallurgy/furnaces	■		■			■	■
Automotive industry	■		■			■	■
Laser engineering	■	■	■	■			■
Particle accelerators		■		■	■		■
Analytical engineering	■	■	■	■	■	■	■
Systems with cryopumps	■	■	■	■	■	■	■
Cooling and air conditioning		■		■	■		■
Electrical engineering	■	■	■	■	■	■	■
Mechanical engineering	■		■			■	■
Power plants	■		■			■	■
Systems engineering	■	■	■	■	■	■	■
UHV applications	■	■	■	■	■	■	■

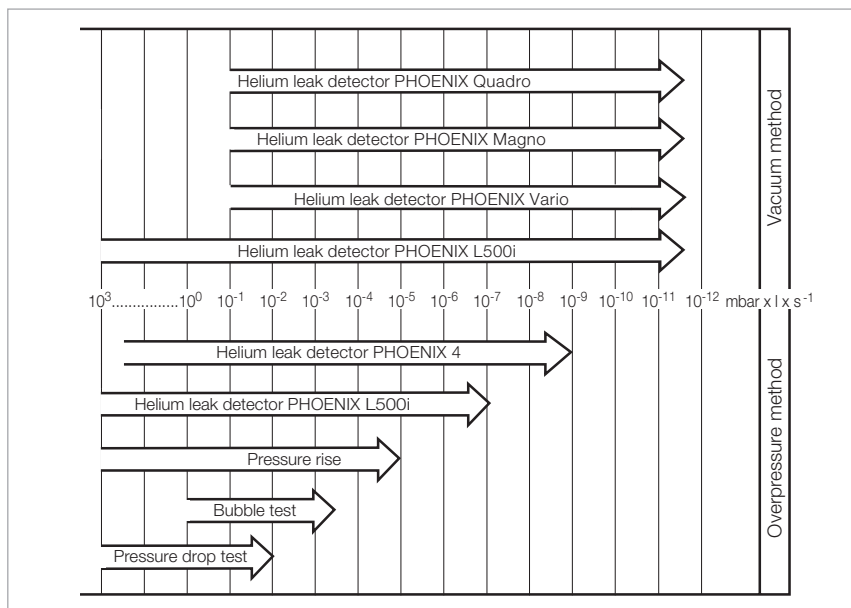
# Leak Detection – Leak Testing

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 mbar x l/s is used as the unit for leak rates.

A leak rate of 1 mbar x l/s 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.

$$q_L = \frac{V \times \Delta p}{\Delta t} \text{ (mbar x l/s)}$$

The wide range of leak rates from several 100 mbar x l/s to below  $10^{-11}$  mbar x l/s as they occur in practice necessitates the use of different leak



Overview of the leak rate detection ranges

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

	Pa x m <sup>3</sup> /s	atm x cm <sup>3</sup> /s <sup>*)</sup> mbar x l/s <sup>*)</sup>	atm x cm <sup>3</sup> /s <sup>*)</sup> cm <sup>3</sup> /s <sup>*)</sup>
Pa x m <sup>3</sup> /s	1	10	9.87
1 mbar x l/s (He)	0.1	1	0.99
1 atm x cm <sup>3</sup> /s <sup>*)</sup> = cm <sup>3</sup> (STP) /s	0.101	1.01	1
1 Torr x l/s <sup>*)</sup>	0.133	1.33	1.33
1 kg/h air	23.4	234	234
1 g/a C <sub>2</sub> H <sub>2</sub> F <sub>4</sub> (R 134a)	6.41 x 10 <sup>-7</sup>	7.58 x 10 <sup>-6</sup>	6.3 x 10 <sup>-6</sup>

## Leak Rate

	atm x cm <sup>3</sup> /s <sup>*)</sup> Torr x l/s <sup>*)</sup>	kg/h Air	g/a C <sub>2</sub> H <sub>2</sub> F <sub>4</sub> (R 134a)
Pa x m <sup>3</sup> /s	7.5	4.28 x 10 <sup>-2</sup>	2.28 x 10 <sup>6</sup>
1 mbar x l/s (He)	0.75	4.3 x 10 <sup>-3</sup>	2.28 x 10 <sup>5</sup>
1 atm x cm <sup>3</sup> /s <sup>*)</sup> = cm <sup>3</sup> (STP) /s	0.76	4.3 x 10 <sup>-3</sup>	2.3 x 10 <sup>5</sup>
1 Torr x l/s <sup>*)</sup>	1	5.7 x 10 <sup>-3</sup>	3.0 x 10 <sup>5</sup>
1 kg/h air	175	1	–
1 g/a C <sub>2</sub> H <sub>2</sub> F <sub>4</sub> (R 134a)	4.8 x 10 <sup>-6</sup>	–	1

<sup>\*)</sup> According to international system of units only Pa x m<sup>3</sup>/s 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

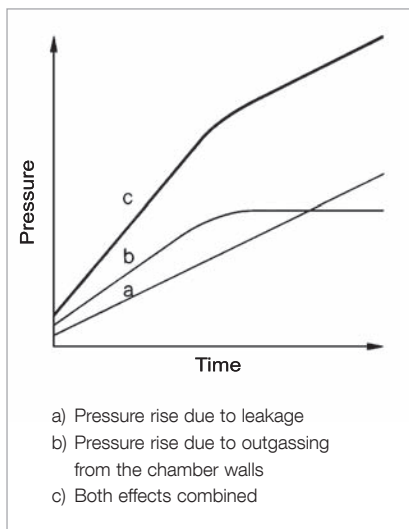
The equipment to be tested is pressurized with a search gas or a search gas mixture.

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.



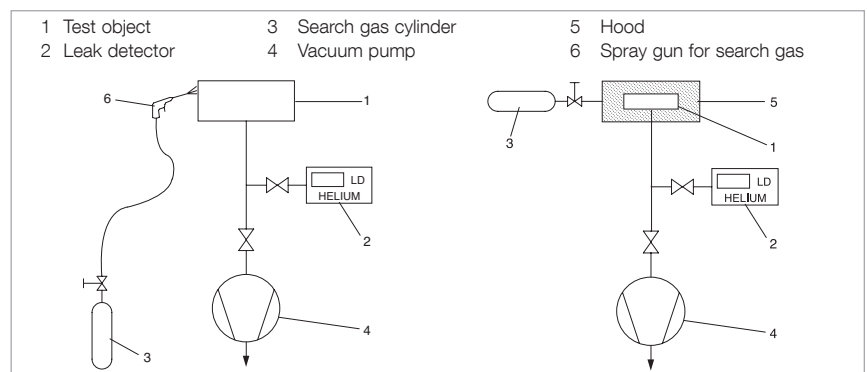
Pressure rise in a vacuum chamber after switching off the pump; double log. plot

## 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 before). Curve (c) shows the pressure rise as it occurs in practice, where out-gassing and leak rate add. The detectable leak rate depends on the volume of the test object, the obtained ultimate pressure and the out-gassing 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 – Evacuated test object (left) and Integral method – Evacuated test object (right)

## 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 chamber 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 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,  $\Delta p$  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

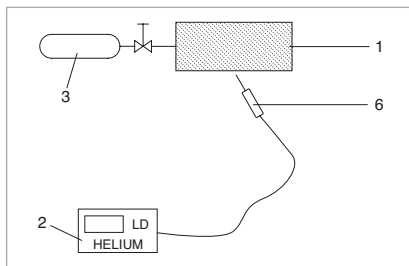
This method is used for testing hermetically sealed components such as transistors, IC-packages or dry reed relays. It is basically a variation of the vacuum hood test. Here the test objects are placed in a vessel which is pressurized with the search gas – preferably helium. At a fairly high search gas 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.

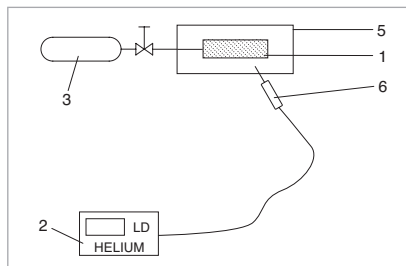
#### Key to the Figures

- |                 |                       |
|-----------------|-----------------------|
| 1 Test object   | 3 Search gas cylinder |
| 2 Leak detector | 4 Vacuum pump         |

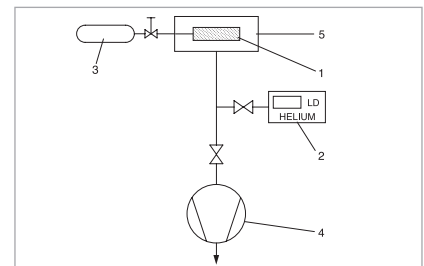


Local leak detection –  
Search gas overpressure in the test object

- |                 |
|-----------------|
| 5 Hood          |
| 6 Sniffer probe |



Integral method (search gas accumulation)  
Search gas overpressure in the test object



Integral method –  
Search gas overpressure in the test object

# 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 counterflow 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 multistage 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  
 $S_{\text{He}}$  = 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).

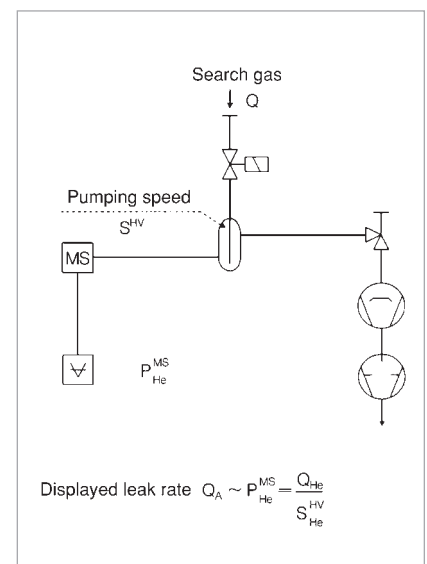
## Main Flow Method

This operating principle of helium leak detectors is based on the main flow method and was long time the classic method of leak detectors. 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 disadvantage of the main flow method is that the gas flow is being led through the mass spectrometer thus particles like dust and dirt penetrate into the measuring system and may disturb the helium measurements.



Main flow method

## Counterflow Method

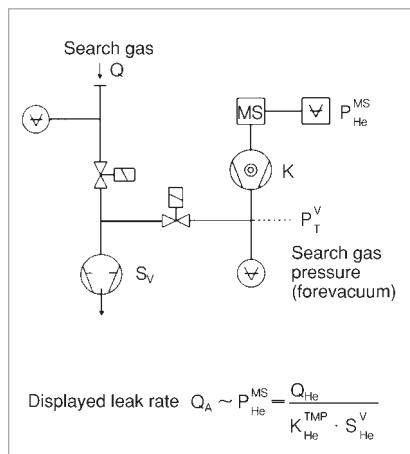
With this method the test object is not connected to the high vacuum. Instead it is connected to the forevacuum (between turbomolecular pump and backing pump), so that the entire gas flow (especially water vapor) does not contribute to the pressure increase in the mass spectrometer. Thus a cold trap 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.



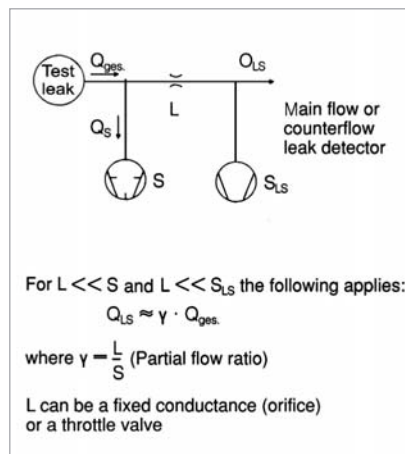
Counterflow method

## 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.



Partial flow method

## 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 x l/s as part of the standard range of products. All leak rates are traceable to the standards of the DAkkS 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 DAkkS Calibration Service. The calibration itself is performed by the DAkkS Calibration Service for Vacuum which is run by Leybold on behalf of the PTB.



# Products

## Fourth PHOENIX Generation

The new PHOENIX 4 family sets new standards in helium leak detection.

The product portfolio provides the perfect device for a variety of applications. The PHOENIX Quadro - as a universal, portable helium leak detector - is the all-rounder in its class. For applications with larger test volumes, which require faster pump down or

repeated measuring cycles from atmosphere to test pressure, the PHOENIX Magno provides just the right high pumping speed. Full flexibility is achieved with the PHOENIX Vario, which knows to convince with its unique compactness and free selection of the backing pump that is to be connected.

All versions are suited for the use in vacuum as well as sniffer operation. The PHOENIX Quadro and PHOENIX Magno are available with oil-sealed or dry-running backing pump as well as in a variety of different voltage versions.



# PHOENIX Quadro

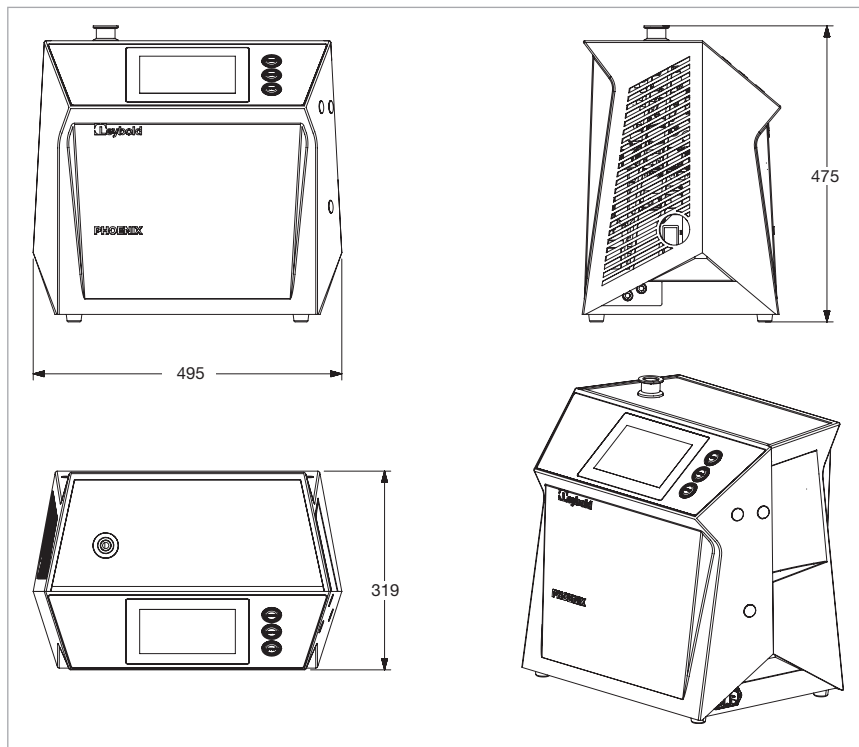


The PHOENIX Quadro is a portable helium leak detector, which can be used in many different applications. The accurate measuring system and the intuitive operation of the PHOENIX Quadro ensure simple and highly reliable leak detection. The PHOENIX Quadro dry has a dry-running backing pump and thus an oil-free pump system.

When it comes to applications that require oil-free pumping, the PHOENIX Quadro dry is therefore the ideal choice for reliable and efficient leak detection.

## Advantages to the User

- Detects even the smallest leak quickly and reliably
- Very fast operational readiness
- Extremely short response times
- Rapid decontamination time in case of helium contamination
- Very high detection sensitivity
- Convenient remote control via smartphone or tablet PC without software installation
- Variety of interfaces for optimal device communication
- Innovative color touch display
- Long life span of the components
- Oil-free pumping system with the PHOENIX Quadro dry
- Internal data memory as well as simple data output via USB



Dimensional drawing PHOENIX Quadro (Dimensions in mm)

## Technical Data

## PHOENIX 4

	Quadro	Quadro dry
Minimum detectable helium leak rate Vacuum mode mbar x l/s Sniffer mode mbar x l/s		$\leq 5 \times 10^{-12}$ $< 1 \times 10^{-9}$ <sup>1)</sup>
Minimum detectable hydrogen leak rate Vacuum mode mbar x l/s Sniffer mode mbar x l/s		$\leq 1 \times 10^{-8}$ $< 1 \times 10^{-7}$
Units of measurement (selectable) Pressure Leak rate Sniffer mode		mbar, Pa, atm, Torr mbar x l/s, Pa x m <sup>3</sup> /s, Torr x l/s, atm x cc/sec, sft <sup>3</sup> /yr ppm, g/a eq, oz/yr eq
Leak rate measurement range mbar x l/s		$1 \times 10^{-12}$ to $1 \times 10^{-1}$
Measurement ranges		12 decades
Max. inlet pressure mbar (Torr)		15 (11.25)
Pumping speed during the evacuation process 50 Hz m <sup>3</sup> /h (cfm) 60 Hz m <sup>3</sup> /h (cfm)	2.5 (1.5) 3.0 (1.8)	3.0 (1.8) 3.0 (1.8)
Pumping speed (helium) at the inlet GROSS mode l/s FINE mode l/s ULTRA modes l/s	0,4 1.2 > 3.1	0.04 1.2 > 3.1
Time constant of the leak rate signal (blanked off, 63% of final value) s		< 1
Run-up time (after starting) s		$\leq 110$
Mass spectrometer		180° magnetic sector field
Ion source		2 filaments; iridium/yttria-oxide
Detectable masses amu		2, 3 and 4
Inlet port DN		25 ISO-KF
Dimensions (W x H x D) mm		495 x 475 x 318
Weight kg (lbs)	41 (90.39)	35 (77.16)
Available languages		English, German, Chinese, Japanese (Katakana), Korean Russian, French, Italian, Spanish and Polish

## Ordering Information

## PHOENIX 4

	Quadro	Quadro dry
	Part No.	Part No.
PHOENIX Quadro EURO version 230 V, 50/60 Hz	<b>250000V02</b>	-
PHOENIX Quadro US version 115 V, 60 Hz	<b>251000V02</b>	-
PHOENIX Quadro Japan version 100 V, 60 Hz	<b>251100V02</b>	-
PHOENIX Quadro 100 - 240 V, 50/60 Hz	-	<b>250001V02</b>

<sup>1)</sup> Depending on the used sniffer line and site conditions. Leakage rate signal after zero:  $1 \cdot 10^{-8}$  mbar l/s when using the sniffer line SL 300 or SL 301

For further accessories see para. "Accessories for PHOENIX Quadro, PHOENIX Magno and PHOENIX Vario"

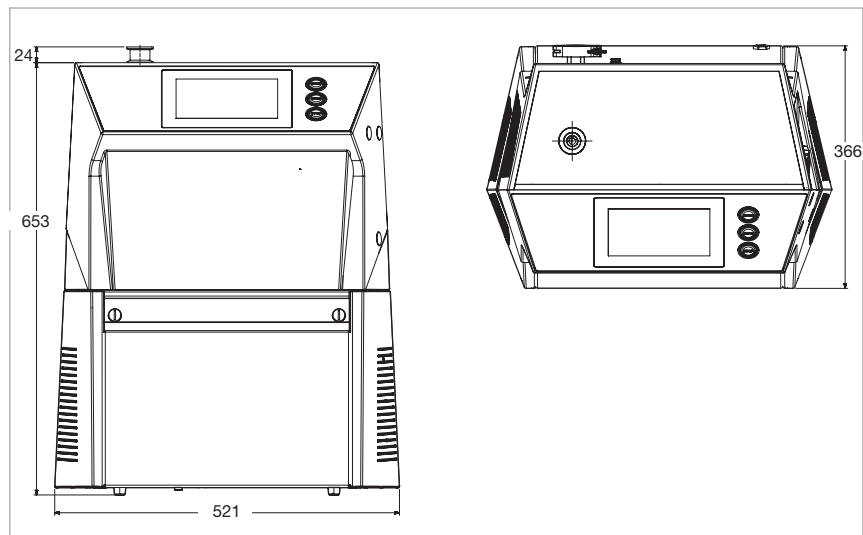
# PHOENIX Magno



The PHOENIX Magno is the high-performance leak detector in the PHOENIX 4 Series. With added fore vacuum suction capacity, the PHOENIX Magno ensures very rapid evacuation times and is therefore particularly suited for larger test volumes. It has the same, highly-precise measuring system as the PHOENIX Quadro. The oil-tightened version together with the integrated SOGEVAC SV16D provides highest suction capacity. The dry version has an integrated SCROLLVAC SC5D for applications that require an oil-free pump system.

## Advantages to the User

- Very high suction capacity for rapid measuring cycles
- Detects even the smallest leaks quickly and reliably
- Very fast operational readiness
- Extremely short response times
- Rapid decontamination time in case of helium contamination
- Very high detection sensitivity
- Convenient remote control via smartphone or tablet PC without software installation
- Variety of interfaces for optimal device communication
- Innovative color touch display
- Long life span of the components
- Oil-free pumping system with the PHOENIX Magno dry
- Internal data memory as well as simple data output via USB



Dimensional drawing PHOENIX Magno (Dimensions in mm)

## Technical Data

## PHOENIX 4

		<b>Magno</b>	<b>Magno dry</b>
Minimum detectable helium leak rate			
Vacuum mode	mbar x l/s	$\leq 5 \times 10^{-12}$	
Sniffer mode	mbar x l/s	$< 1 \times 10^{-9}$ <sup>1)</sup>	
Minimum detectable hydrogen leak rate			
Vacuum mode	mbar x l/s	$\leq 1 \times 10^{-8}$	
Sniffer mode	mbar x l/s	$< 1 \times 10^{-7}$	
Units of measurement (selectable)		mbar, Pa, atm, Torr	
Pressure		mbar x l/s, Pa x m <sup>3</sup> /s, Torr x l/s, atm x cc/sec, sft <sup>3</sup> /yr	
Leak rate		ppm, g/a eq, oz/yr eq	
Sniffer mode			
Leak rate measurement range	mbar x l/s	$1 \times 10^{-12}$ to $1 \times 10^{-1}$	
Measurement ranges		12 decades	
Max. inlet pressure	mbar (Torr)	15 (3.75)	
Pumping speed during the evacuation process			
50 Hz	m <sup>3</sup> /h (cfm)	15 (8.83)	5 (2.94)
60 Hz	m <sup>3</sup> /h (cfm)	17 (10.01)	6 (3.53)
Pumping speed (helium) at the inlet			
GROSS mode	l/s	< 8	< 3,5
FINE mode	l/s	< 7	< 2
ULTRA modes	l/s	> 3,1	> 3,1
Time constant of the leak rate signal (blanked off, 63% of final value)	s	< 1	
Run-up time (after starting)	s	110	
Mass spectrometer		180° magnetic sector field	
Ion source		2 filaments; iridium/yttria-oxide	
Detectable masses	amu	2, 3 and 4	
Inlet port	DN	25 ISO-KF	
Dimensions (W x H x D)	mm	521 x 679 x 371	
Weight	kg (lbs)	67 (147.71)	57 (125.66)
Available languages		English, German, Chinese, Japanese (Katakana), Korean Russian, French, Italian, Spanish and Polish	

## Ordering Information

## PHOENIX 4

	<b>Magno</b>	<b>Magno dry</b>
	<b>Part No.</b>	<b>Part No.</b>
PHOENIX Magno EURO version 200 - 230 V, 50/60 Hz	<b>350000V02</b>	<b>350001V02</b>
PHOENIX Magno Japan / US version 100 - 115 V, 50/60 Hz	<b>352200V02</b>	<b>351101V02</b>

<sup>1)</sup> Depending on the used sniffer line and site conditions. Leakage rate signal after zero:  $1 \cdot 10^{-8}$  mbar l/s when using the sniffer line SL 300 or SL 301

For further accessories see para. "Accessories for PHOENIX Quadro, PHOENIX Magno and PHOENIX Vario"

# PHOENIX Vario

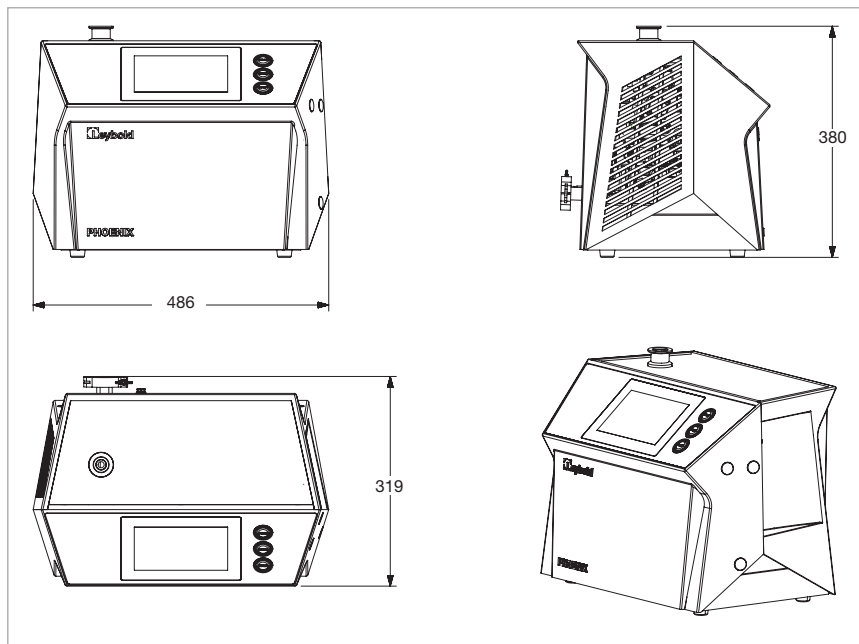


The PHOENIX Vario has no built-in backing pump, and therefore has the smallest installation space with maximum flexibility. The type and size of the backing pump can be chosen freely depending on applications and process requirements.

The PHOENIX Vario thus combines the excellent properties of the PHOENIX 4 series with the required pumping system. In that way both oil-sealed and dry backing pumps can be selected and the fore vacuum suction capacity can be adapted perfectly to the target application.

## Advantages to the User

- Application-optimized pumping speed
- Extremely small installation space
- Very light weight
- Highly reliable measuring system
- Simple, intuitive handling
- Very high detection sensitivity
- Convenient remote control via smartphone or tablet PC without software installation
- Variety of interfaces for optimal device communication
- Innovative color touch display
- Extremely short response times
- Internal data memory as well as simple data output via USB



Dimensional drawing PHOENIX Vario (Dimensions in mm)

## Technical Data

## PHOENIX Vario

Minimum detectable helium leak rate		
Vacuum mode	mbar x l/s	$\leq 5 \times 10^{-12}$
Sniffer mode	mbar x l/s	$< 1 \times 10^{-9}$ <sup>1)</sup>
Minimum detectable hydrogen leak rate		
Vacuum mode	mbar x l/s	$\leq 1 \times 10^{-8}$
Sniffer mode	mbar x l/s	$< 1 \times 10^{-7}$
Max. inlet pressure	mbar (Torr)	15 (11.25)
with partial flow pump set	mbar (Torr)	1000 (750)
Pumping speed (helium) at the inlet		
ULTRA mode	l/s	$> 3.1$
Time constant of the leak rate signal (blanked off, 63% of final value)	s	$< 1$
Units of measurement (selectable)		
Pressure		mbar, Pa, atm, Torr
Leak rate		mbar x l/s, Pa x m <sup>3</sup> /s, Torr x l/s, atm x cc/sec, sft <sup>3</sup> /yr
Sniffer mode		ppm, g/a eq, oz/yr eq
Leak rate measurement range	mbar x l/s	$1 \times 10^{-12}$ to $1 \times 10^{-1}$
Run-up time (after starting)	min	$\leq 2$
Mass spectrometer		180° magnetic sector field
Ion source		2 filaments; iridium/yttria-oxide
Detectable masses	amu	2, 3 and 4
Test port		1 x DN 25 ISO-KF
Dimensions (W x H x D)	mm	486 x 380 x 313
Weight	kg (lbs)	25 (55.12)
Available languages		English, German, Chinese, Japanese (Katakana), Korean Russian, French, Italian, Spanish and Polish

<sup>1)</sup> Depending on the used sniffer line and site conditions. Leakage rate signal after zero:  $1 \cdot 10^{-9}$  mbar l/s when using the sniffer line SL 300 or SL 301

For further accessories see para. "Accessories for PHOENIX Quadro, PHOENIX Magno and PHOENIX Vario"

## Ordering Information

## PHOENIX Vario

	Part No.
PHOENIX Vario	250002V02

### Recommended backing pumps for PHOENIX Vario

The PHOENIX Vario can be operated with any backing pump, allowing full flexibility for the fore vacuum suction capacity.

Fore vacuum pumps that are electrically controllable, can be operated directly via the PHOENIX Vario.

A prerequisite for this is a minimum final vacuum pressure of 2 mbar and a maximum current of 12 A.

Fore vacuum pumps that are not electrically controllable, require a separate power supply.

## Ordering Information

High Voltage  
230 V, 50 Hz

Low Voltage  
100 V, 50/60 Hz

	Part No.	Part No.
<b>Recommended backing pumps, electrically controlled</b>		
SCROLLVAC SC 5 D	133 000	133 100
SCROLLVAC SC 15 D	133 001	133 101
SCROLLVAC SC 30 D	133 002	133 102
TRIVAC D 4 B	112 45	140 081
TRIVAC D 8 B	112 55	140 082
TRIVAC D 16 B	112 65	-
TRIVAC D 25 B	112 75	-
SOGEVAC SV 16 D	960 186V	960 186V
SOGEVAC SV 28 BI	960 277	960 278
SOGEVAC SV 40 BI FC	960 364V	-
SCROLLVAC plus 7	-	141007V10
SCROLLVAC plus 10	141010V30	141010V10
SCROLLVAC plus 15	141015V30	141015V10
SCROLLVAC plus 18	141018V30	141018V10
<b>Recommended backing pumps, separate electrical supply</b>		
ECODRY 40 plus	161040V01	-
ECODRY 65 plus	161065V01	-

For further accessories see para. "Accessories for PHOENIX Quadro, PHOENIX Magno and PHOENIX Vario"





# Helium Leak Detector PHOENIX L500i



PHOENIX L500i

The PHOENIX L500i Helium leak detector opens up new dimensions of productivity and reliability for your applications. This is your solution, pioneered with an intelligent control. The smartest and unparalleled user experience in leak detection.

## Advantages to the User

- High reliable leak detection
- Fast and reproducible test results
- Improved system design for a high degree of productivity and uptime
- Approved for serial testing
- Rapid evacuation, low contamination degree
- Compact and mobile unit, ergonomic working position
- Simple and comfortable operation
- Sleep mode/wake-up function provides system ready at shift start
- All connections on the backside, easy access to all facilities
- 3 years warranty on the long-life cathodes in the ion sources

## Typical Applications

Quality control of components and subassemblies from industries like

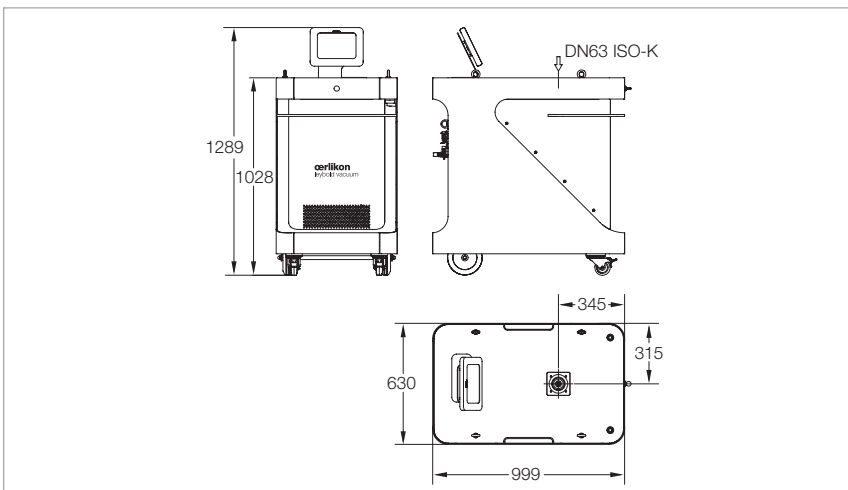
- Electrical engineering (feedthroughs, vacuum sensors, lamps, transformers)
- Automotive (fuel systems, gears)
- Refrigeration and air conditioning
- Packaging (medical, pharmaceutical and food products, barrels)
- Research (fusion facilities, space simulators, particle accelerators)

## Smart Monitoring and Control

- Wireless operation via WiFi
- Unique ergonomic tablet retainer (included within the standard delivery)
- Easy set-up and intuitive touch-screen operation
- Selectable operation mode for maximized flexibility
- Data logger and readout

## High Speed leak detection

- Response time < 1 s
- Helium pumping speed at the inlet up to 50 l/s
- Extremely short Helium recovery time
- Efficient standby mode and wake-up function saving time and energy
- Reliable and reproducible test results



Dimensional drawing for the PHOENIX L500i (Dimensions in mm)

## Technical Data

## PHOENIX L500i

Smallest detectable He leak rate (per AVS 2.1 and EN 1518)	mbar x l/s	< 5 x 10 <sup>-12</sup>
Max. permissible inlet pressure		
Qualitative measurement	mbar (Torr)	1000 (750)
Quantitative measurement	mbar (Torr)	100 (75)
Detectable masses	amu	2, 3 and 4
Run-up time (until ready of operation)	min	< 3
Inlet flange	DN	63 ISO-K
Max. He pumping speed at the inlet	l/s	50
Response time	s	< 1
Supply voltages 3 phases/N/PE, 50/60 Hz	V	200/208/380/400/460
Weight	kg (lbs)	385 (849)
Dimensions (L x W x H)	mm	999 x 630 x 1028
Available languages		English, German
Units of measurement (selectable)		
Pressure		mbar, Pa, atm, Torr
Leak rate		mbar x l/s, Pa x m <sup>3</sup> /s, Torr x l/s, atm x cc/sec, sft <sup>3</sup> /yr
Sniffer mode		ppm, g/a eq, oz/yr eq
Leak rate measurement range	mbar x l/s	5 x 10 <sup>-12</sup> to 1000
Pumping speed during the evacuation process		
50 Hz	m <sup>3</sup> /h (cfm)	65 (40.0)
60 Hz	m <sup>3</sup> /h (cfm)	78 (45.9)
Time constant of the leak rate signal (blanked off, 63% of final value)	s	< 0.2
Mass spectrometer		180° magnetic sector field
Ion source		2 filaments; iridium/yttria-oxide

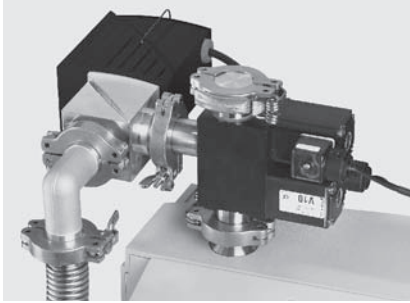
## Ordering Information

## PHOENIX L500i

	Part No.
Helium leak detector PHOENIX L500i DRY (with SCROLLVAC vacuum pump)	<b>503504V903</b>
Rotary vane vacuum pump filled with Mineral oil LVO 100	<b>503504V904</b>
PFPE oil LVO 400	<b>503504V905</b>
Calibrated leak	
TL 9	<b>144 08</b>
TL 8	<b>165 57</b>
TL 6	<b>155 66</b>
TL 4	<b>155 65</b>
TL 4-6	<b>155 80</b>
Reducer DN 63 ISO-K / DN 40 ISO-KF	<b>887 40</b>
Search gas spray gun for Helium (including 5 m long hose)	<b>165 55</b>

# Accessories

## Accessories for PHOENIX Quadro, PHOENIX Magno und PHOENIX Vario



Partial flow system without pump

### Partial Flow System

with following advantages:

- Faster response
- Start of measurement mode already at 1000 mbar inlet pressure.
- Faster venting of large test objects or leak detection of mass production.

Equipment:

Valve block (with inlet valve, venting valve, bypass or purging valve) plus right-angle bellows valve DN 25 ISO-KF made of stainless steel, solenoid drives, suited for remote control by the PHOENIX.

The partial flow systems are available without pumps.



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.

### PHOENIX Transport Case

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

### PHOENIX Wi-Fi Antenna

The PHOENIX Quadro series can be controlled conveniently via any mobile terminal such as tablet PC or smartphones, without the installation of a software or app. In order to be able to use the Wi-Fi function, a PHOENIX Wi-Fi antenna is available.



Interface module

### PHOENIX interface modules for the use of other interfaces.

The modules can be mounted directly on the device or be placed in a control cabinet or similar by the customer via a cable connection.

The appropriate cables are available in various lengths.

The PHOENIX IO interface features the following:

- PLC IN
- PLC OUT
- ANALOG OUT
- RS232

The PHOENIX bus interface is available for:

- Profibus
- ProfiNet
- DeviceNet
- Ethernet I/P

### PHOENIX Vario connector

A matching connector for the electrical connection between the leak detector and fore vacuum pump is available in order to control the vacuum pump directly via the PHOENIX Vario.

## Ordering Information

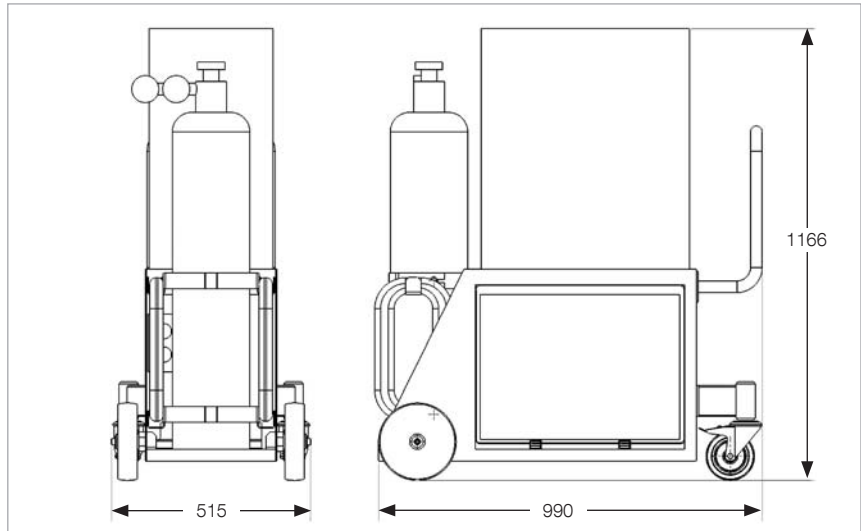
## Accessories

	Part No.
Transport Case PHOENIX Quadro	252004V02
Transport Case PHOENIX Magno	352004V02
Transport Case PHOENIX Vario	252024V02
Partial flow system <sup>1)</sup> 115 - 230 V / 50/60 Hz, without pump	140 20
AF 16-25 exhaust filter, for partial flow system	189 11
Search gas spray gun	165 55
PHOENIX WLAN Antenna (different versions)	upon request
PHOENIX IO Interface	252211V02
PHOENIX Bus Interface Profibus	252212V02
PHOENIX Bus Interface ProfiNet	252213V02
PHOENIX Bus Interface DeviceNet	252214V02
PHOENIX Bus Interface EtherNet/IP	252215V02
PHOENIX Vario connector plug	252300V02
Cable for PHOENIX Interfaces - 2 m	252290V02
Cable for PHOENIX Interfaces - 5 m	252291V02
Cable for PHOENIX Interfaces - 10 m	252292V02

<sup>1)</sup> 5 centering rings, 5 clamping rings and 1 vacuum hose 1 m with DN 25 ISO-KF are included

# CART for PHOENIX Quadro and PHOENIX Vario

The CART for the PHOENIX 4 allows maximum mobility of the leak detector with all required accessories. The high-quality construction thus provides work surfaces for test leaks, as well as the flexible mounting possibility of helium bottles of various sizes. Furthermore, external fore vacuum pumps can also be mounted via a flexible rail construction in the lower level. Due to the innovative design, the helium supply is located on the side facing away from the inlet of the leak detector. Large stable rollers ensure easy transportation and mobility of the leak detector structure.



Dimensional drawing (Dimensions in mm)

## Technical Data

## CART

Dimensions (L x W x H)	mm	515 x 990 x 1166
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## Ordering Information

## Cart

	Part No.
CART PHOENIX 4 for PHOENIX Quadro and PHOENIX Vario	252005V02

# CART for PHOENIX Magno

For details please contact Leybold

## Ordering Information

## Cart

	Part No.
CART LC PHOENIX Magno	252008V02



# RC 310 C / RC 310 WL

## Remote Control Units for Leak Detectors



Wired remote control unit RC 310 C



Wireless remote control unit RC 310 WL

The RC 310 remote control unit with their industrial design RC 310 WL (wireless) and RC 310 C (cable) and integrated data memory offer utmost flexibility during the leak detection process.

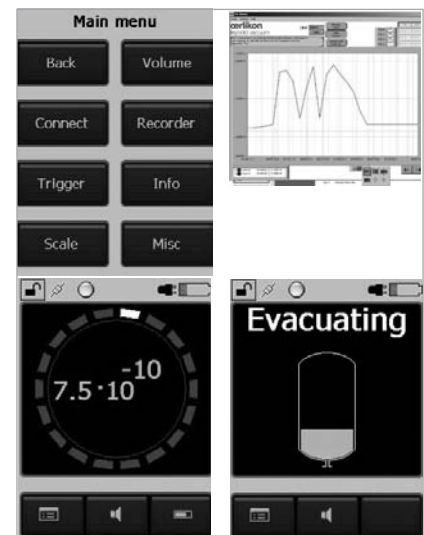
The RC 310 WL permits wireless remote monitoring up to a distance of 100 m. The RC 310 units support the current leak detectors of the PHOENIX 4 series as well as the L300i, UL 200 and L 200 models.

### Advantages to the User

- Easy operation via Touch Screen Panel 3.5"
- Wireless transmission up to 100 m, wired transmission up to 34 m
- Data transfer to Windows is possible
- Data backup on internal 32 MB data logger or USB stick is possible
- Possible operating with or without cable
- Adjustable alarm trigger
- Magnetic holder on the rear of the instrument
- Rugged industrial design with an IP 42 rating
- Scroll function for measured data (optional)
- USB connection for data transfer and software updates
- Adjustable loudspeaker and headphone output
- Search function (paging) via audible signal
- Peak hold (maximum value indication)
- For simultaneous detection of up to 10 leak detectors

### Typical Applications

- Mobile use with a portable leak detector due to wireless link
- Leak detection for analytics
  - Medicine technology
  - Solar systems
  - Research and development
  - Vacuum equipment
  - Accessories for the automotive industry
  - IT branch
  - Process industry



Different color displays on the remote control unit



## Technical Data

## RC 310

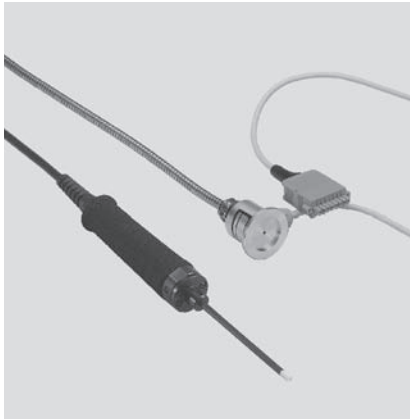
Display		TFT graphic touch panel 1/4 VGA / 3.5"; 240 x 320 px
Memory capacity		
Internal memory capacity	MB	64
of this available for recording data	MB	32
or memory stick		
Battery operating time (RC 310 WL only), (depending on charging condition)	hours	> 8
Wireless transmission range RC 310 WL	m	up to 100
HF output power (4 mW)	dBm	+6
Wireless transmission frequency RC 310 WL	GHz	2.4
Audio alarm at 1 m distance, max.	dB(A)	70
Headphone jack stereo 3.5 mm	Ohm	> 2 x 32
Permissible ambient temperature	°C	+5 to +40
Battery charger		
Mains voltages	V	100 -240 (+/- 10%)
Frequencies	Hz	50/60
Connectable leak detectors		PHOENIX 4 series, L300i series, UL 200 series, L 200 series
Detection of leak detectors		up to 10
Available languages		English, German
Further languages		Chinese, Japanese (Katakana), Russian, French, Italian, Spanish and Polish
Protection class	IP	42
Charger protection class	IP	56
RC 310 WL radio permits		CE, FCC, IC, TELEC, MIC, MII
Dimensions (L x W x H)	mm	210 x 90 x 45
Weight		
RC 310 C, approx.	kg (lbs)	0.4 (0.88)
RC 310 WL, approx.	kg (lbs)	0.5 (1.1)

## Ordering Information

## RC 310

	Part No.
Remote control	
RC 310 C, wired with 4 m long connection cable	<b>252 013 V01</b>
RC 310 WL, wireless with battery charger (for integrated rechargeable battery) and wireless transmitter with connection cable (additional 4 m long connection cable)	<b>252 014 V01</b>
Accessories	
Wireless transmitter with connection cable (for operation of a further PHOENIX Quadro)	<b>252 015 V01</b>
Extension cable, 10 m (three extensions max. are possible)	<b>140 22</b>

# Helium Sample Probes (Sniffers)



Helium sniffer line SL 300



Helium sniffer QUICK-TEST QT 100 with sniffer

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



Helium sniffer line SL 301 in transport case

## Advantages to the User

### Helium Sniffer Line SL 300 and SL 301

- Sniffer line connects directly at the test connection
- **SL 300**  
Comfortable helium sniffer with red and green status LED and ZERO push-button
- **SL 301**  
Robust and easy helium sniffer in practical transport case
- Easy filter removable
- Very fast response
- Extremely low detection limit  
 $< 1 \times 10^{-7}$  mbar x l/s
- Rigid sniffer tip 120 mm
- Very rugged industrial design

### Helium Sniffers QUICK-TEST QT 100

- Sniffer leak detection for greater distances between test object and leak detector
- Diaphragm pump for sucking the search gas
- Smallest detectable leak rate  
 $1 \times 10^{-6}$  mbar x l/s
- 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 300 / SL 301****QT 100**

Smallest detectable leak rate	mbar x l/s	< 10 <sup>-7</sup>	10 <sup>-6</sup>
Inlet pressure	mbar	< 0.13	-
Supply voltage		-	100-230 V, 50/60 Hz
Signal response time for			
SL 301 at a length of			
4 m	s	< 1	-
10 m	s	< 4	-
SL 300 at a length of			
5 m	s	< 1	1
10 m	s	< 5	-
20 m	s	-	< 6
50 m	s	-	20
Connection flange	DN	25 ISO-KF	25 ISO-KF
Weight	kg (lbs)	0.6 (1.3)	3.5 (7.7)

**Ordering Information****SL 300 / SL 301**

	Part No.
Helium sniffer line with rigid sniffer tip 120 mm SL 300 red/green LED ZERO button 4 m long, straight handle	<b>252 003</b>
SL 301 4 m long, straight handle 10 m long, straight handle	<b>252 025 V01</b> <b>252 026 V01</b>
Spare Parts for SL 301 Filter insert, 2 pieces Stainless steel tube with capillary tube	<b>ESLMSA-92097</b> <b>E-LST-30</b>

**Bestelldaten****QT 100**

	Part No.
Helium sniffer QUICK-TEST QT 100	<b>155 94</b>
Sniffer line for the QT 100 5 m 20 m 50 m	<b>140 08</b> <b>140 09</b> <b>121 83</b>

# Calibrated Leaks for Vacuum and Sniffer Applications



Test leaks

## 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/s for TL 4 and  $10^{-6}$  mbar x l/s 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/s, 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 4

Calibrated helium leak (capillary leak) with reservoir which may be refilled and with a leak rate in the range of  $10^{-4}$  mbar x l/s. Special calibrated leak for use in a vacuum.

### TL 7 (For installation within the PHOENIX 4)

Helium calibrated leak (capillary leak) with helium reservoir and electromagnetically operated valve. Leak rate range  $10^{-7}$  mbar x l/s. The electromagnetically operated valve provided permits the opening and closing of the calibrated leak to be controlled by the leak detector's software.

### TL 7

Calibrated helium leak (capillary leak) with helium reservoir, manual valve and He gas.

### TL 8 and TL 9

Helium calibrated leak calibrated for a leak rate in the range of  $10^{-8}$  mbar x l/s (helium leak rate) for TL 8 and  $10^{-9}$  mbar x l/s 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 4 are not suited for use in a vacuum.

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.

## Advantages to the User

- Inspection certificate (included) in accordance with DIN EN 10204-3.1
- Highly accurate
- Very low temperature dependence
- Determination of the nominal leak rate by comparison with a calibrated leak having a PTB <sup>1)</sup> certificate
- DAKKS <sup>2)</sup> 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.

<sup>1)</sup> Federal Institution of Physics and Technology

<sup>2)</sup> Deutsche Akkreditierungsstelle GmbH (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/s.

### Set of Calibrated Leaks for Power Plants

These three calibrated leaks of 1000, 100 and 10 mbar x l/s 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/s	Vacuum and sniffer	DN 16 ISO-KF
TL 6, without helium gas reservoir	$10^{-6}$ mbar x l/s	Vacuum and sniffer	DN 16 ISO-KF
TL 4-6, with helium gas reservoir	$10^{-4}$ to $10^{-6}$ mbar x l/s	Vacuum and sniffer	DN 16 ISO-KF
TL 4, with helium gas reservoir	$10^{-4}$ mbar x l/s	Vacuum	Discharging opening
TL 7, with helium gas reservoir	$10^{-7}$ mbar x l/s	Vacuum (for installation within the PHOENIX)	Nozzle
TL 7, with manual valve and helium gas reservoir	$10^{-7}$ mbar x l/s	Vacuum	DN 10 ISO-KF
TL 8, with helium gas reservoir	$10^{-8}$ mbar x l/s	Vacuum	DN 10 ISO-KF
TL 9, with helium gas reservoir	$10^{-9}$ mbar x l/s	Vacuum	DN 10 ISO-KF
S-TL 4, with helium gas reservoir	$10^{-4}$ mbar x l/s	Sniffer	Nozzle
S-TL 5, with helium gas reservoir	$10^{-5}$ mbar x l/s	Sniffer	Nozzle
S-TL 6, with helium gas reservoir	$10^{-6}$ mbar x l/s	Sniffer	Nozzle

### Ordering Information

### Calibrated Leak

	Part No.
TL 4, without helium gas reservoir <sup>1)</sup>	<b>155 65</b>
TL 6, without helium gas reservoir <sup>1)</sup>	<b>155 66</b>
TL 4-6, with helium gas reservoir <sup>1)</sup>	<b>155 80</b>
TL 7, with helium gas reservoir <sup>1)</sup> for installation within the PHOENIX L300i filling pressure 2,9 bar	<b>140 23 V01</b>
TL 7, with manual valve and helium gas reservoir <sup>1)</sup>	<b>142 10</b>
TL 8, with helium gas reservoir <sup>1)</sup>	<b>165 57</b>
TL 9, with helium gas reservoir <sup>1)</sup>	<b>144 08</b>
S-TL 4, with helium gas reservoir <sup>1)</sup>	<b>122 37</b>
S-TL 5, with helium gas reservoir <sup>1)</sup>	<b>122 38</b>
S-TL 6, with helium gas reservoir <sup>1)</sup>	<b>122 39</b>
Set of calibrated leaks for power plants 1000, 100, 10 mbar x l/s	<b>115 16</b>
Rubber bladder with hose clamp	<b>890 11</b>
Helium can; 1 l, 12 bar (for TL 4-6)	<b>252 001</b>
DAkKS calibration for TL 7/8/9	<b>154 15</b>
Factory calibration for He test leaks	<b>154 16</b>

<sup>1)</sup> 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 offering a complete 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 pin type casing



Calibrated leak with cylindrical casing

## 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

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

### Advantages to the User

- Various types adapted to different customer requirements
- Simple to operate
- Easy to install

## 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.

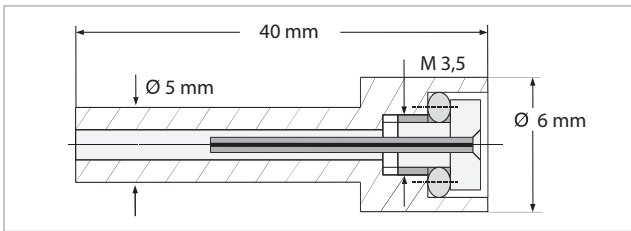
The connection on the side of the customer's system is provided via a VCO fitting for a diameter of 10 mm.

- 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

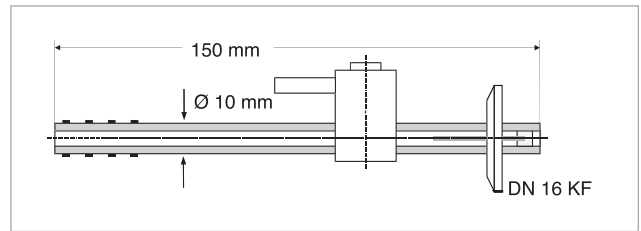
## Customer-specific test leaks

The specified test leaks are customer-specific, which is why the specification of the leakage rate, the test pressure and the type of gas is necessary.

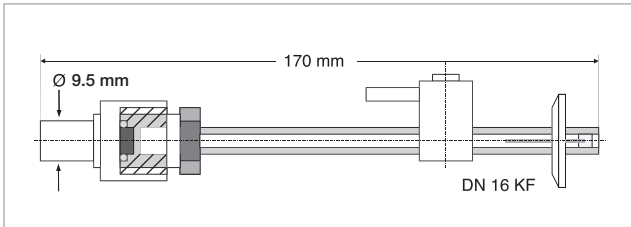
The specification is carried out via the test leakage form on the Leybold website → [www.leyboldproducts.com/test-leak-form](http://www.leyboldproducts.com/test-leak-form)



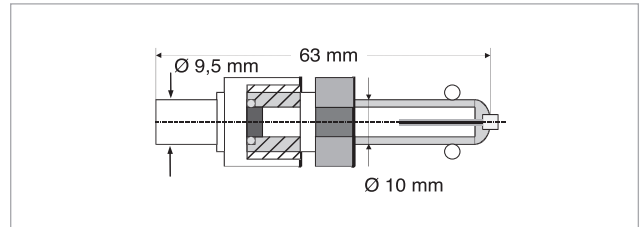
Calibrated leak with screw-in sleeve



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

## Ordering Information <sup>1)</sup>

## Calibrated Leak

	Part No.
Calibrated leak	
with screw-in sleeve	143 00
with pin type casing and VCO fitting	143 04
with pin type casing and hose nozzle	143 08
with cylindrical casing and VCO fitting	143 12

<sup>1)</sup> When ordering please always specify the test leak via the testleak-form and indicate the generated code. Please request form if required.

# Miscellaneous

## Connection Flanges

### Leak Detectors

### Helium Sniffers

### Calibrated Leaks

PHOENIX Quadro	– DN 25 ISO-KF	SL 300	– DN 25 ISO-KF	TL 4	– DN 16 ISO-KF
PHOENIX Magno	– DN 25 ISO-KF	QT	– DN 25 ISO-KF	TL 6	– DN 16 ISO-KF
PHOENIX Vario	– DN 25 ISO-KF	ST 100	– DN 25 ISO-KF	TL 4-6	– DN 16 ISO-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 Stainless steel/FPM

#### Clamping Rings Aluminum

	Part No.	Part No.	Part No.
DN 25 ISO-KF / 16 ISO-KF	<b>183 86 (Aluminum) or 885 04 (Stainless steel)</b>	<b>DN 25 ISO-KF, 883 47 DN 16 ISO-KF, 883 46</b>	<b>DN 20 / 25 ISO-KF 183 42 DN 10 / 16 ISO-KF, 183 41</b>
DN 40 ISO-KF / 25 ISO-KF	<b>183 87 (Aluminum) or 885 05 (Stainless steel)</b>	<b>DN 40 ISO-KF, 883 48 DN 25 ISO-KF, 883 47</b>	<b>DN 32 / 40 ISO-KF, 183 43 DN 20 / 25 ISO-KF, 183 42</b>
DN 40 ISO-KF / 16 ISO-KF	<b>183 89 (Aluminum) or 885 07 (Stainless steel)</b>	<b>DN 40 ISO-KF, 883 48 DN 16 ISO-KF, 883 46</b>	<b>DN 32 / 40 ISO-KF, 183 43 DN 10 / 16 ISO-KF, 183 41</b>
DN 63 ISO-K / 40 ISO-KF	<b>269 40 (Aluminum) or 887 40 (Stainless steel)</b>	<b>DN 63 ISO-K, 887 03 DN 40 ISO-KF, 883 48</b>	<b>DN 63 / 250 ISO-K, <sup>1)</sup> DN 32 / 40 ISO-KF, 183 43</b>

<sup>1)</sup> See clamps for ISO-K flanges in the Product Part "Flanges and Fittings"

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

### Nominal Width

### Length

### Ordering Information

		Part No.
DN 16 ISO-KF	1.0 m	<b>868 01</b>
DN 16 ISO-KF	0.5 m	<b>867 91</b>
DN 25 ISO-KF	1.0 m	<b>868 03</b>
DN 25 ISO-KF	0.5 m	<b>867 93</b>
DN 40 ISO-KF	1.0 m	<b>868 05</b>
DN 40 ISO-KF	0.5 m	<b>867 95</b>

Further connecting components, like quick clamping rings and other components are described in Product Part "Flanges and Fittings"





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