

# *Contents*

<b>1 Major Sectors of Vacuum Technique</b>	<b>1</b>
History	2
<b>2 Materials of Construction</b>	<b>4</b>
Metals	6
Elastomers	10
<b>3 Behavior of Gases at Low Pressures</b>	<b>13</b>
Pressure	13
Mean Free Path	14
Flow of Gases at Low Pressure	17
Molecular Conductance of Circular Aperture	20
Adsorption and Condensation	22
Chemisorption	24
Viscosity	25
Gas Reflection from Container Wall	25
<b>4 Methods of Obtaining Vacuum</b>	<b>26</b>
Positive Displacement Oil-sealed Mechanical Pumps	27
Handling of Condensable Vapors	30
Roots Blowers	33
Molecular Pumps	37
Diffusion Pumps	39
Oil Sorption Pumping	63
Cryogenic Pumping	65
<b>5 Gauges</b>	<b>80</b>
Mechanical Gauges	80
Manometers	81
McLeod Gauge	81
Measurement of Condensable Vapors	82
Thermocouple Gauges	83
Pirani Gauge	85
Hot-Wire Ion Gauges	86
Bayard-Alpert Gauge	87

vi **Contents**

Ultrahigh Vacuum Ion-Gauge Design	88
Improved Bayard-Alpert Gauge	89
Pumping Speed of Bayard-Alpert Gauges	89
Other Ultrahigh Vacuum Gauges	90
Russian Ionization Gauges	91
Conventional Ion Gauges for Low Pressures	91
Ion-Gauge Sensitivity	91
Sorption Effects in Hot-Wire Ionization Gauges	92
Ion Gauge for Use in a Magnetic Field	92
Tetrode Ionization Manometer	93
Fast Ionization Gauge Circuits	93
Ion Gauge for Higher Pressures	93
Barkhausen Oscillations in Ionization Gauges	94
Nude vs. Tubulated Gauges	94
Cold Cathode Gauges	96
Redhead Ultrahigh Vacuum Gauge	97
“Alphatron” Ionization Gauge	97
Radioactive Altimeter	99
Radioactive Ionization Gauge for Wind Tunnels	100
Pulse Type Ionization Gauges	100
Photomultiplier Ion Gauge	101
The Tensimeter	102
Pressure Measurement by Molecular Beam Attenuation	103
Ultraviolet Vacuum Gauge	103
Hot Cathode Magnetron Gauge	103
Viscosity Manometers	104
Knudsen Gauge	105
Piezoelectric Oscillator Manometer	105
Throughput Measurement	108
Field Emission	108
Partial Pressure Analysis	110
<b>6 Leak Detection</b>	<b>131</b>
Introduction	131
Commercial Mass-Spectrometer Leak Detectors	132
Thermal Conductivity Leak Detector	134
High-Sensitivity Leak Detector	135
Radioactive Leak Detection	135
Palladium-Barrier Leak Detector	136
Lens Mass-Spectrometer Leak Detector	137
“Vac-Ion” Pump Leak Detector	138
Thoriated Tungsten Filaments for Leak Detection	138
Halogen Leak Detector	138

<b>7</b>	<b>Valves</b>	<b>140</b>
	Introduction	140
	Angle Valves	140
	Slide Valves	141
	Globe Valves	142
	Ball Valves	142
	Block Valves	144
	Quarter-Swing Valve	144
	Ultrahigh Vacuum Valves	145
<b>8</b>	<b>Seals</b>	<b>149</b>
	Demountable Seals with Metallic Gaskets	150
	Shaft Seals	152
	Glass-to-Metal Seals	154
	Sight-glasses	156
	Ceramic-to-Metal Seals	157
<b>9</b>	<b>Vessel Design</b>	<b>159</b>
	ASME Code	159
	Thickness of Shell Using UG-28	161
	Design of Stiffener Rings	164
	Head Design (Torispherical)	167
	Reinforcement of Openings	168
	Ferrous Pipe and Tubing	173
	Nonferrous Pipe and Tubing	177
	Joints	177
<b>10</b>	<b>Baffles and Traps</b>	<b>178</b>
	Water-Cooled Baffles	178
	Chevron Baffles	179
	Liquid-Nitrogen Baffles	179
	Thermoelectric Baffles	181
	Molecular Sieve Baffles	181
	Ion Baffle	183
	Baffle Geometry	186
<b>11</b>	<b>Pumping System Design</b>	<b>191</b>
	Evacuation of a Chamber by Mechanical Pumps	191
	Outgassing Loads	193
	Pumpdown Calculation—Below $10^{-4}$ Torr	194
	Use of Experimental Outgassing Data	197
	Pressure vs. Time Relationship	199
	Pressure Profile in an Ultrahigh Vacuum Tube	200
	Half-Life Concept	201

viii **Contents**

Other Characteristic System Constants	201
Piping Impedance	202
Chamber Performance	203
Vacuum System—3000 ft <sup>3</sup> Facility	207
Design Calculations vs. Performance	211
Bakeout	214
Double-Pumped Systems	215
Evaporation Design	217
Conductance of Complex Geometries	222
<b>12 Furnaces</b>	<b>224</b>
Vacuum Furnaces	224
Arc Furnaces	224
Skull Furnace	231
Induction Furnace	233
Electron-Beam Melting	245
Industrial Electron-Beam Furnaces	255
Resistance-Heated Furnaces	265
<b>13 Coating</b>	<b>274</b>
Sources	274
Sputtering	279
Bell Jar Evaporator	282
Industrial Batch Coater	283
Cleaning the Substrate	285
Batch Coaters—Refrigerated Traps	287
Ultrahigh Vacuum	289
Semicontinuous Coaters	290
Applications for Vacuum Coatings	293
Thick Film Aluminum Coating	293
Cadmium Coating	294
Lens Coating	294
Electronic Applications	294
Resistors	295
Ferromagnetic Thin Films	295
Superconducting Films	296
Photoconductors	296
Luminescent Films	296
Capacitors	297
Microcircuit Fabrication	299
<b>14 Drying and Impregnation</b>	<b>300</b>
Electrical Insulating Oils	300
Dielectric Cable Drying	303
Impregnation of Capacitors	303

Drying of Synthetic Materials	304
Compressor Dehydration	306
<b>15 Freeze Drying</b>	<b>307</b>
Freezing Temperature	308
Evaporative Freezing	308
Equipment Design Considerations	308
Heat Transfer	309
Microwave Heating	310
Vapor Removal	310
Condenser Temperature	312
Drying Rate	312
Operating Experience	312
Large Commercial Installation	314
Freeze-Drying Pilot Plant—Radiant Heated	315
Production Freeze-Drying Plant—Radiant Heated	316
Continuous Freeze-Drying	318
<b>16 Distillation</b>	<b>319</b>
<b>17 Cryogenic Insulation</b>	<b>322</b>
Thermal Conductivity vs. Pressure	322
Flat-Panel Vacuum Insulation	324
<b>18 Space Environment Simulation</b>	<b>325</b>
Thermal Sink	327
Vibration	328
Gas Loads	329
Testing of Ion and Plasma Engines	332
Cryogenic Pumping for Space Simulation	332
Small General-Purpose Chambers	334
Large Vacuum Environmental Test Chambers	335
<b>References</b>	<b>340</b>
<b>Index</b>	<b>353</b>