

Manufacturing:

Custom-built Vacuum Components & Assemblies
Ceramic-to-metal & Glass-to-metal Joints

Plot No 17, Road A, Phase I,
GIDC Kathwada, Ahmedabad 382430

Gujarat, India

Services:

Testing : Vacuum, Helium Leak
Labour Works : Vacuum Brazing, Vacuum Heat Treatment
Calibration : Vacuum Gauges, Helium Standard Leaks
Training : Vacuum Testing, Helium Leak Testing

Phone : +91 79 22901482
Fax : +91 79 22901483
Email : pvt@plasmavac.com
Website : www.plasmavac.com

TEST REPORT - HELIUM LEAK TESTING

Report No :	PVT/TD/TR 040	Report Date :	November 1, 2012
Client :	TOYO ENGINEERING INDIA LTD	Testing Equipment :	HLD ASM 310 ADIXEN
Manufacturer :	Engineers Combine, Ahmedabad	Calibrated Leak :	PES/SLV/01, SLV/01/001
Item :	Valves	Code / Standard :	ASME Sec V, Art 10
P O Reference :	PRC/6277Y/P/MISC-083	Qualification :	He Leak Rate <math>10^{-6}</math> mbar l/s

Leak Detector Instrument Calibration			
1	Standard Leak Value 2.6×10^{-6} mbar l/s	Observed Leak Value $- 2.6 \times 10^{-6}$ mbar l/s	Instrument Sensitivity better than 10^{-9} mbar l/s
System Calibration / Probe Calibration			
2	Standard Leak Value 3.0×10^{-6} mbar l/s	Observed Leak Value $- 2.0 \times 10^{-6}$ mbar l/s	Correction Factor - 1.5
3	Evacuation		Pressurisation
	Hood ✓	Spray	Bombing
3	Pressure		Bombing Pressure
	0.001 mbar		Hood Vacuum
Test Particulars		Valve Reference	Leak Rate (mbar l/s)
4	The valve was pressurised to 10 bar with Helium.		1.5", 1500 #, GTV, Body Heat 4233A, Bonnet Heat 4292A, Sr No 121
	A sniffer probe was connected to And taken around the valve for measuring leak rate at body, Bonnet joint and Gland		1.5", 1500 #, GTV, Body Heat 4233A, Bonnet Heat 4292A, Sr No 122
			1.5", 1500 #, GTV, Body Heat 4233A, Bonnet Heat 4292A, Sr No 123
			0.75", 1500 #, GBV, Body Heat 4771A, Bonnet Heat 4794, Sr No 124
			0.75", 1500 #, GTV, Body Heat 4771A, Bonnet Heat 4794, Sr No 125

Final Remarks: **The Helium leak rate observed was within acceptable limit in all the valves**



Testing Agency



Manufacturer

✓
B. S. Shrivastava

Inspection Authority

Client