

# **METHODS OF EXPERIMENTAL PHYSICS:**

**VOLUME 14**

**VACUUM PHYSICS AND TECHNOLOGY**

Volume 14

# Vacuum Physics and Technology

*Edited by*

**G. L. WEISSLER**

*Department of Physics  
University of Southern California  
University Park  
Los Angeles, California*

*and*

**R. W. CARLSON**

*Department of Physics  
University of Southern California  
University Park  
Los Angeles, California*

*Earth and Space Sciences Division  
Jet Propulsion Laboratory  
California Institute of Technology  
Pasadena, California*

1979



**ACADEMIC PRESS**

*A Subsidiary of Harcourt Brace Jovanovich, Publishers*

**New York      London      Toronto      Sydney      San Francisco**

**COPYRIGHT © 1979, BY ACADEMIC PRESS, INC.  
ALL RIGHTS RESERVED.**

**NO PART OF THIS PUBLICATION MAY BE REPRODUCED OR  
TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC  
OR MECHANICAL, INCLUDING PHOTOCOPY, RECORDING, OR ANY  
INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT  
PERMISSION IN WRITING FROM THE PUBLISHER.**

**ACADEMIC PRESS, INC.  
111 Fifth Avenue, New York, New York 10003**

*United Kingdom Edition published by*  
**ACADEMIC PRESS, INC. (LONDON) LTD.**  
24/28 Oval Road, London NW1 7DX

**Library of Congress Cataloging in Publication Data**  
Main entry under title:

Vacuum physics and technology.

(Methods of experimental physics; v. 14)

Includes bibliographical references.

1. Vacuum. 2. Vacuum technology. I. Weissler,  
G. L. II. Carlson, Robert Warner, Date

III. Series.

QC166.V34 533'.5 79-17200

ISBN 0-12-475914-9 (v. 14)

**PRINTED IN THE UNITED STATES OF AMERICA**

**79 80 81 82 9 8 7 6 5 4 3 2 1**

## CONTRIBUTORS

Numbers in parentheses indicate the pages on which the authors' contributions begin.

- V. O. ALTEMOSE, *Technical Staff Division, Corporate Research Laboratories, Corning Glass Works, Corning, New York 14830* (313)
- W. M. BRUBAKER, *1954 Highland Oaks Drive, Arcadia, California 91006* (81, 183, 216)
- R. W. CARLSON, *Department of Physics, University of Southern California, University Park, Los Angeles, California 90007, and Earth and Space Sciences Division, Jet Propulsion Laboratory, California Institute of Technology, Pasadena, California 91103* (6, 11)
- D. R. DENISON, *Perkin-Elmer, Ultek Division, P.O. Box 10920, Palo Alto, California 94303* (35)
- Z. C. DOBROWOLSKI, *Kinney Vacuum Company, 495 Turnpike Street, Canton, Massachusetts 02021* (111, 468)
- M. H. HABLANIAN, *Varian Vacuum Division, 121 Hartwell Avenue, Lexington, Massachusetts 02173* (101, 141, 180, 457, 465, 466, 472)
- DAVID J. HARRA, *Varian Associates, Vacuum Division, 611 Hansen Way, Palo Alto, California 94303* (193)
- LAWRENCE T. LAMONT, JR., *Varian Associates, Vacuum Research and Development, 611 Hansen Way, Palo Alto, California 94303* (231, 449, 477, 491, 505)
- DAVID LICHTMAN, *Department of Physics, University of Wisconsin, Milwaukee, Wisconsin 53201* (25, 345)
- N. MILLERON, *S\*E\*N VAC Services, Berkeley, California* (275, 425)
- G. OSTERSTROM, *Sargent-Welch Company, Vacuum Products Division, 7300 North Linder Avenue, Skokie, Illinois 60077* (247)

- Y. SHAPIRA\*, *Department of Physics, University of Wisconsin, Milwaukee, Wisconsin 53201* (345)
- M. T. THOMAS, *Battelle Pacific Northwest Laboratory, Battelle Memorial Institute, P.O. Box 999, Richland, Washington 99352* (521)
- G. L. WEISSLER, *Department of Physics, University of Southern California, University Park, Los Angeles, California 90007* (1)
- R. C. WOLGAST, *Department of Mechanical Engineering, Lawrence Berkeley Radiation Laboratory, 1 Cyclotron Road, Berkeley, California 94720* (275, 425)

\* Present address: School of Engineering, Tel Aviv University, Ramat Aviv, Tel Aviv, Israel 69978.

## **FOREWORD**

In this publication, "Methods of Experimental Physics," three volumes are not directed to specific fields of research: Classical Methods (Volume 1), Vacuum Physics and Technology (the present volume), and Quantum Electronics (the following Volume 15). Each of these has broad reference value, but the present volume is of importance to the widest range of research interests. Vacuums are required in nearly every physics laboratory and in many chemistry and engineering laboratories as well.

The general approach taken by the Editors should make this volume one of extreme value, and one that can be used in conjunction with almost every other volume of Methods.

To all involved with this presentation go our deepest thanks.

**L. MARTON  
C. MARTON**

## PREFACE

When we were asked by the Editor of "Methods of Experimental Physics," Dr. L. Marton, to compose one volume on the subject of vacuum physics and technology, we immediately thought of the influence on our own combined 60 years of experimental research of such path-breaking authors as John Strong in "Procedures of Experimental Physics" and Saul Dushman in "Scientific Foundations of Vacuum Technique."

Dushman mentions in his preface of 1949 that ". . . vacuum technique has emerged from the purely scientific environment of the research laboratory and has entered the engineering stage on a scale that could not have been conceived even as recently as two decades ago." Similarly, the decades since 1949 have seen an even more explosive expansion into industrial applications with an extremely strong market for a wide range of commercially produced vacuum equipment. This equipment, in its turn, has become available to the experimental physicist in his research. Unfortunately, the cost of some of these items in an era of both inflation and retrenchment in research funds forces many to either build vacuum devices themselves or at least select with great care from the many commercially available.

With this in mind, we contacted the contributors to this volume with the hope that their respective specialized knowledge would communicate to those less sophisticated in vacuum physics the basic scientific ideas and today's generally accepted methods of producing, maintaining, and measuring various degrees of vacua, as required for their specific efforts.

Obviously, the different contributors to this volume make impossible the uniformity of style and of viewpoint which single authors bring to their books. On the other hand, we hope that the diversity of outlook and of opinion of our authors will be fresh and stimulating to the reader and will provide him with a variety of useful opinions that can be applied to his unique experimental requirements. It is the intent of this volume to provide the individual experimentalist with, we hope, all the up-to-date information in this vast field, and we thank our authors for their efforts in presenting their particular views of and extensive experience in vacuum technology.

G. L. WEISSLER  
R. W. CARLSON

## **CONTENTS**

<b>CONTRIBUTORS</b>	.	.	.	.	.	.	.
<b>FOREWORD</b>	.	.	.	.	.	.	.
<b>PREFACE</b>	.	.	.	.	.	.	.
<b>1. Introduction</b>	.	.	.	.	.	.	.
<b>1.1. Survey</b>	.	.	.	.	.	.	1
by G. L. WEISSLER	.	.	.	.	.	.	.
<b>1.2. Basic Equations</b>	.	.	.	.	.	.	6
by R. W. CARLSON	.	.	.	.	.	.	.
<b>1.2.1. Introduction</b>	.	.	.	.	.	.	6
<b>1.2.2. Kinetic Properties of Ideal Gases</b>	.	.	.	.	.	.	6
<b>1.3. Molecular Transport</b>	.	.	.	.	.	.	11
by R. W. CARLSON	.	.	.	.	.	.	.
<b>1.3.1. Gaseous Flow</b>	.	.	.	.	.	.	11
<b>1.3.2. Conductance Calculations</b>	.	.	.	.	.	.	14
<b>1.4. Surface Physics</b>	.	.	.	.	.	.	25
by DAVID LICHTMAN	.	.	.	.	.	.	.
<b>1.4.1. Introduction</b>	.	.	.	.	.	.	25
<b>1.4.2. Adsorption</b>	.	.	.	.	.	.	25
<b>1.4.3. Desorption</b>	.	.	.	.	.	.	30
<b>1.4.4. Conclusion</b>	.	.	.	.	.	.	33

**2. Measurement of Total Pressure in Vacuum Systems  
by D. R. DENISON**

<b>2.1. Introduction . . . . .</b>	<b>35</b>
<b>2.1.1. General Remarks . . . . .</b>	<b>35</b>
<b>2.1.2. Units . . . . .</b>	<b>35</b>
<b>2.1.3. Pressure Ranges and Corresponding         Measurement Techniques . . . . .</b>	<b>37</b>
<b>2.2. Manometers . . . . .</b>	<b>38</b>
<b>2.2.1. Ideal Gas Laws . . . . .</b>	<b>38</b>
<b>2.2.2. Liquid Manometers . . . . .</b>	<b>40</b>
<b>2.2.3. Mechanical Manometers . . . . .</b>	<b>47</b>
<b>2.3. Thermal Conductivity Gauges . . . . .</b>	<b>51</b>
<b>2.3.1. Theory and Principles . . . . .</b>	<b>51</b>
<b>2.3.2. Pirani Gauge . . . . .</b>	<b>54</b>
<b>2.3.3. Thermistor Gauge . . . . .</b>	<b>56</b>
<b>2.3.4. Thermocouple Gauge . . . . .</b>	<b>58</b>
<b>2.3.5. Sensitivities of Thermal Conductivities for         Various Gases . . . . .</b>	<b>59</b>
<b>2.4. Ionization Gauges . . . . .</b>	<b>60</b>
<b>2.4.1. Theory and Principles . . . . .</b>	<b>60</b>
<b>2.4.2. Conventional Triode Hot Filament Gauges . . . . .</b>	<b>62</b>
<b>2.4.3. Cold Cathode Discharge Gauge . . . . .</b>	<b>64</b>
<b>2.4.4. Bayard-Alpert Ionization Gauge . . . . .</b>	<b>67</b>
<b>2.4.5. Special Gauges for Ultravacuum and Extreme         High Vacuum . . . . .</b>	<b>70</b>
<b>2.4.6. Sensitivities of Ionization Gauges for         Different Gases . . . . .</b>	<b>73</b>
<b>2.5. Placement and Calibration of Gauges . . . . .</b>	<b>75</b>
<b>2.5.1. Problems Associated with Gauge Placement . . . . .</b>	<b>75</b>
<b>2.5.2. Gauge Calibration . . . . .</b>	<b>77</b>

**3. Partial Pressure Measurement****by W. M. BRUBAKER**

<b>3.1. Mass Spectrometer . . . . .</b>	<b>81</b>
3.1.1. Introduction to Partial Pressure Measurement . . . . .	81
3.1.2. Requirements of Mass Spectrometers for Use as Partial Pressure Analyzers . . . . .	82
3.1.3. Types of Mass Spectrometers Used as Partial Pressure Analyzers . . . . .	85
3.1.4. Discussion of Mass Spectrometer Types . . . . .	86
3.1.5. Mass Spectra of the Atmosphere in Vacuum Systems . . . . .	98
3.1.6. Practical Aspects . . . . .	100

**4. Production of High Vacua**

<b>4.1. Overview and Formulation of General Requirements . . . . .</b>	<b>101</b>
<b>by M. H. HABLANIAN</b>	
4.1.1. Gas Transport: Throughput. . . . .	101
4.1.2. Pumping Speed in Liters per Second . . . . .	102
4.1.3. Pump-Down Time . . . . .	104
4.1.4. Ultimate Pressure . . . . .	107
4.1.5. Fore-Vacuum and High Vacuum Pumping . . . . .	108
<b>4.2. Fore-Vacuum Pumps . . . . .</b>	<b>111</b>
<b>by Z. C. DOBROWOLSKI</b>	
4.2.1. Overview. . . . .	111
4.2.2. Rotary Oil Sealed Pumps. . . . .	114
4.2.3. Lobe Pumps . . . . .	128
4.2.4. Liquid Piston Pumps. . . . .	133
4.2.5. Ejectors . . . . .	136
4.2.6. Sorption Pumps . . . . .	138
<b>4.3. Diffusion Pumps . . . . .</b>	<b>141</b>
<b>by M. H. HABLANIAN</b>	
4.3.1. Basic Pumping Mechanism . . . . .	141
4.3.2. Pumping Speed . . . . .	145
4.3.3. Throughput . . . . .	151

4.3.4. Tolerable Forepressure. . . . .	154
4.3.5. Ultimate Pressure : . . . . .	158
4.3.6. Backstreaming . . . . .	166
4.3.7. Other Performance Aspects. . . . .	173
4.4. Other High Vacuum Pumps . . . . .	180
by M. H. HABLANIAN	
4.4.1. Molecular Pumps . . . . .	180
4.4.2. Oil Ejectors. . . . .	180
4.4.3. Mercury Diffusion Pumps . . . . .	181
4.4.4. Sorption Pumps (High Vacuum). . . . .	181
<b>5. Production of Ultrahigh Vacuum</b>	
5.1. Fundamental Concepts in the Production of Ultrahigh Vacuum . . . . .	183
by W. M. BRUBAKER	
5.1.1. Projected Performance of an Ideal Vacuum System . . . . .	183
5.1.2. Performance of a Real Vacuum System . . . . .	184
5.1.3. Discussion of Gross Differences between Performances of Ideal and Real Vacuum Systems . . . . .	184
5.1.4. Practical Considerations . . . . .	184
5.2. Getter Pumping . . . . .	193
by DAVID J. HARRA	
5.2.1. Introduction . . . . .	193
5.2.2. Principle of Operation . . . . .	193
5.2.3. Titanium Film-Pumping Speed Parameters . . . . .	195
5.2.4. Methods for Estimating Pumping Speed . . . . .	198
5.2.5. Titanium Sublimators: Desirable Characteristics and Types of Construction . . . . .	202
5.2.6. Substrate Design Considerations . . . . .	208
5.2.7. Achieving Efficient Operation. . . . .	212

5.3. Ion Pumps . . . . .	216
by W. M. BRUBAKER	
5.3.1. Introduction . . . . .	216
5.3.2. The First Commercial Ion Pump . . . . .	218
5.3.3. The Penning Discharge-Type Pump . . . . .	218
5.3.4. Orbitron Ion Pump . . . . .	225
5.3.5. Practical Aspects of Ion Pumps . . . . .	227
5.4. Cryogenic Pumping . . . . .	231
by LAWRENCE T. LAMONT, JR.	
5.4.1. General Considerations . . . . .	231
5.4.2. Cryopumps . . . . .	233
5.4.3. Cryosorption Pumps . . . . .	237
5.4.4. Some Special Considerations for Cryogenic Pumps . . . . .	244
5.4.5. Safety Considerations . . . . .	245
5.5. Turbomolecular Vacuum Pumps . . . . .	247
by G. OSTERSTROM	
5.5.1. Introduction . . . . .	247
5.5.2. History . . . . .	247
5.5.3. Distinguishing Features . . . . .	247
5.5.4. Application Area . . . . .	247
5.5.5. Theory of the Turbomolecular Vacuum Pump .	249
5.5.6. Residual Gas Composition . . . . .	257
5.5.7. A Comparison with Diffusion Pumps . . . . .	258
5.5.8. Pumping Hydrogen . . . . .	259
5.5.9. Choice Between "Horizontal" and "Vertical" Types . . . . .	260
5.5.10. Bearings . . . . .	263
5.5.11. Drives . . . . .	265
5.5.12. Fast Opening Inlet Valves and Implosions .	267
5.5.13. Vibration and Noise Reduction . . . . .	267
5.5.14. Starting and Stopping Turbopumps . . . . .	269
5.5.15. Protecting against Turbopump Stoppage .	271
5.5.16. "Baking" Turbomolecular Pumps . . . . .	272

**6. Metal Vacuum Systems and Components**  
by N. MILLERON and R. C. WOLGAST

<b>6.1. A Diffusion Pumped Vacuum System and Its Schematic Representation . . . . .</b>	<b>277</b>
<b>6.2. Vacuum Flanges . . . . .</b>	<b>279</b>
6.2.1. Characteristics of the Ideal Flanged Joint . . . . .	280
6.2.2. Elastomer Gasketed Flanges . . . . .	280
6.2.3. All-Metal Flanges . . . . .	287
<b>6.3. Vacuum, Water, and Gas Connectors: Function and Choices . . . . .</b>	<b>294</b>
6.3.1. Types of Available Connectors . . . . .	295
6.3.2. Indium Wire Seals, Metal-Glass, Metal-Metal . . . . .	296
<b>6.4. Vacuum Valves . . . . .</b>	<b>296</b>
6.4.1. Selecting a Value for Routine Service . . . . .	297
6.4.2. Leak Valves . . . . .	297
6.4.3. Bakeable Valves . . . . .	298
<b>6.5. Traps, Baffles, and Valves in Combination . . . . .</b>	<b>299</b>
6.5.1. Liquid Nitrogen Traps . . . . .	300
<b>6.6. Flexible Connectors . . . . .</b>	<b>300</b>
<b>6.7. Mechanical Motion Feedthroughs . . . . .</b>	<b>302</b>
6.7.1. Rotary Motion Feedthroughs . . . . .	302
6.7.2. Linear Motion Feedthroughs . . . . .	304
<b>6.8. Electrical Feedthroughs . . . . .</b>	<b>306</b>
6.8.1. High Current, Low Voltage, Water Cooled Feedthrough . . . . .	309
6.8.2. High Voltage, Electrically Leak Proof . . . . .	309
6.8.3. Sputter-proof Feedthrough . . . . .	310

6.9. Viewports . . . . .	311
<b>7. Glass Vacuum Systems</b>	
by V. O. ALTEMOSE	
7.1. Use of Glass as the Vacuum Envelope . . . . .	313
7.1.1. Advantages of Glass . . . . .	313
7.1.2. Disadvantage of Glass . . . . .	313
7.2. Systems and Components . . . . .	314
7.2.1. Fabrication of Glass Systems . . . . .	314
7.2.2. Typical Glass Systems and Components . . . . .	317
7.3. Outgassing of Glass . . . . .	322
7.3.1. General . . . . .	322
7.3.2. Thermal Outgassing . . . . .	322
7.3.3. Outgassing by Electron Bombardment . . . . .	327
7.3.4. Outgassing by Ultraviolet Radiation . . . . .	329
7.3.5. Outgassing by Nuclear Radiation . . . . .	333
7.4. Gas Permeation in Glass . . . . .	337
7.4.1. Vacuum Limitations Due to Gas Diffusion . . . . .	337
7.4.2. Helium Permeation . . . . .	338
7.4.3. Permeation of Other Gases . . . . .	340
<b>8. Properties of Materials Used in Vacuum Technology</b>	
by Y. SHAPIRA and D. LICHTMAN	
8.1. Introduction . . . . .	345
8.1.1. Preface . . . . .	345
8.1.2. General Considerations in Material Selection . . . . .	346
8.2. Metals and Metal Alloys . . . . .	354
8.2.1. Steels, Stainless and Others . . . . .	354
8.2.2. Common Metals . . . . .	357
8.2.3. Refractory Metals and Alloys . . . . .	367

8.2.4. Precious Metals . . . . .	373
8.2.5. Soft Metals . . . . .	375
8.2.6. Alloys . . . . .	377
8.2.7. Special Elements (Hg, C). . . . .	382
8.3. Glasses . . . . .	384
8.3.1. Mechanical Properties . . . . .	386
8.3.2. Viscosity . . . . .	387
8.3.3. Coefficient of Thermal Expansion . . . . .	388
8.3.4. Thermal Shock Resistance. . . . .	389
8.3.5. Thermal Conductivity . . . . .	390
8.3.6. Electrical Resistivity . . . . .	390
8.3.7. Dielectric Constant and Dielectric Loss Factor. . . . .	391
8.3.8. Electrical Breakdown Strength. . . . .	392
8.3.9. Permeability to Gases. . . . .	394
8.3.10. Optical Properties . . . . .	394
8.3.11. Chemical Resistance of Glass . . . . .	396
8.3.12. Degassing Glass . . . . .	396
8.4. Ceramics . . . . .	396
8.4.1. Silicate Ceramics . . . . .	398
8.4.2. Pure Oxide Ceramics . . . . .	401
8.4.3. Machinable Ceramics (Macor, Lavas, BN) . . . . .	404
8.5. Elastomers and Plastomers . . . . .	406
8.5.1. Natural and Synthetic Rubbers . . . . .	408
8.5.2. Plastomers . . . . .	411
8.6. Sealants, Waxes, Greases, and Oils . . . . .	414
8.6.1. Sealants and Lubricants . . . . .	414
8.6.2. Pump and Manometer Fluids . . . . .	417
8.7. Gases—Preparation, Properties, and Uses . . . . .	418
8.7.1. Inert Gases . . . . .	419
8.7.2. Reactive Gases . . . . .	420

## CONTENTS

xiii

8.8. Conclusion . . . . .	423
9. Guidelines for the Fabrication of Vacuum Systems and Components by N. MILLERON and R. C. WOLGAST	
9.1. Soft Soldering . . . . .	426
9.2. Hard Soldering . . . . .	426
9.3. Welding . . . . .	427
9.3.1. Welding Design Details . . . . .	427
9.3.2. Cut-Weld Joints . . . . .	434
9.3.3. Bonded Aluminum to Stainless Steel Joints . . . . .	437
9.3.4. Electron Beam Welding . . . . .	437
9.4. Bakeable and Coolable Vacuum Joints . . . . .	439
9.5. Cleaning Techniques . . . . .	441
9.5.1. Stainless Steel and Mild Steel Acid Pickle . . . . .	443
9.5.2. Mechanical Methods . . . . .	443
9.5.3. Electropolishing . . . . .	443
9.5.4. Chemical Polish for Stainless Steel, Kovar, Invar, and Nickel and Cobalt Alloys . . . . .	444
9.5.5. Nonferrous Metals . . . . .	445
9.5.6. Solvent Cleaning . . . . .	445
9.5.7. Sequence of Fabrication and Cleaning Steps . . . . .	446
9.5.8. Effect of Air Exposure . . . . .	446
9.5.9. Cleanup Methods <i>in Situ</i> . . . . .	447
10. Protective Devices for Vacuum Systems by LAWRENCE T. LAMONT, JR.	
10.1. Safety Considerations and Protective Devices . . . . .	449
10.1.1. Mechanical Hazards . . . . .	450
10.1.2. Explosion and Implosion Hazards . . . . .	450

10.1.3. Magnet Hazards . . . . .	451
10.1.4. Electrical Hazards . . . . .	451
10.1.5. Thermal Hazards to Personnel . . . . .	453
10.1.6. Radio Frequency and Microwave Radiation Hazards . . . . .	454
10.1.7. X Rays . . . . .	455
10.2. Interlocks and System Protective Devices . . . . .	455
<b>11. Design of High Vacuum Systems</b> by M. H. HABLANIAN	
11.1. General Considerations . . . . .	457
11.1.1. Surface-to-Volume Ratio . . . . .	457
11.1.2. Pump Choice . . . . .	458
11.1.3. Evacuation of Process Pumping . . . . .	459
11.2. Metal Systems . . . . .	460
11.2.1. Pumping System Design. . . . .	460
<b>12. Operating and Maintaining High Vacuum Systems</b>	
12.1. General Considerations . . . . .	465
by M. H. HABLANIAN	
12.2. High Vacuum Valve Control. . . . .	466
by M. H. HABLANIAN	
12.2.1. When to Open High Vacuum Valve . . . . .	466
12.3. Mechanical Pumps . . . . .	468
by Z. C. DOBROWOLSKI	
12.4. Diffusion Pump Maintenance . . . . .	472
by M. H. HABLANIAN	
12.4.1. Power Variations . . . . .	473
12.4.2. Safety, Hazards, and Protection . . . . .	474
12.4.3. Dos and Do nots Regarding Diffusion Pumps .	474