

B.3.2 Pressure Testing Method (Inside-out)

In this technique, the part is pressurized with helium or a mixture of helium and air, and tested by one of the following methods.

B.3.2.1 Measuring Leaks

To determine the total quantity of leakage (but not the number or location of leaks), the part is pressurized with helium (or a mixture of helium and air or nitrogen). This can be done by bombing or backfilling small hermetically sealed parts. Larger parts can be actively pressurized using a hose or tubing to deliver the helium. The part is placed in a volume that is then evacuated by the leak detector. All the helium escaping from the part is captured and quantified (Figure B-5).

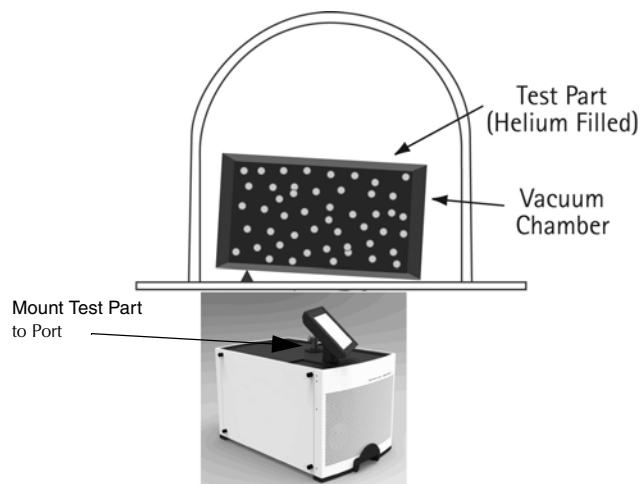


Figure B-5 Measuring Leaks: Inside Out

B.3.2.2 Locating Leaks

To pinpoint the location of the leak(s) (but not measure the total leakage), the likely potential leak sites of the part are scanned using a **Sniffer Probe** connected to the inlet of the leak detector (Figure B-6).

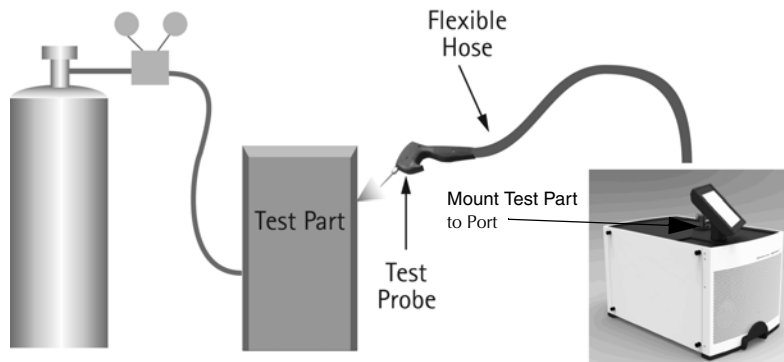


Figure B-6 Locating Leaks: Inside Out