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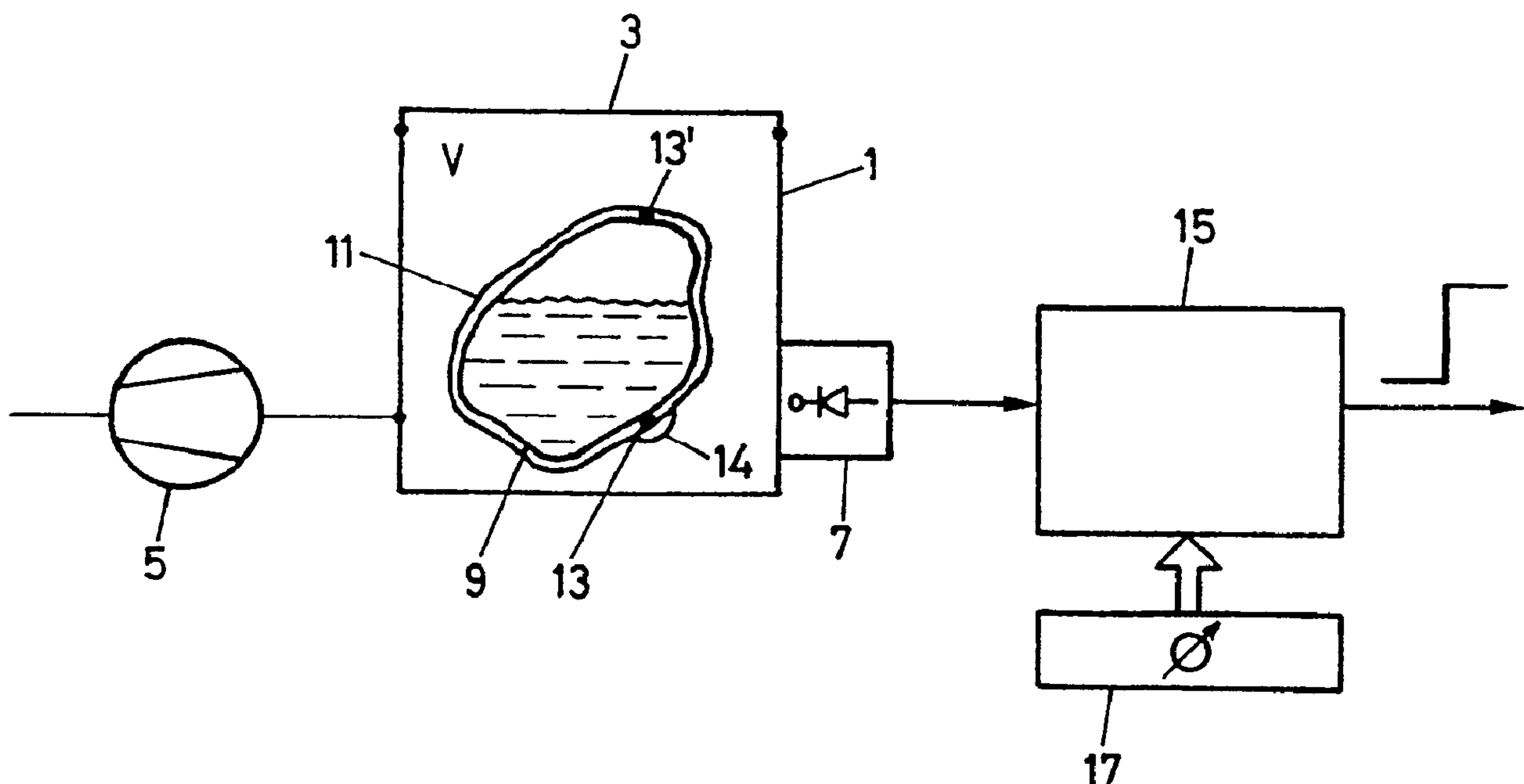
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(54) Title: METHOD AND APPARATUS FOR LEAK TESTING



(57) Abrégé/Abstract:

The invention relates to a technique for leak testing closed and filled containers, a method for producing closed and filled containers, and a leak testing apparatus. One aspect of the invention provides a method for leak testing at least one closed container, comprising applying a pressure difference across at least a part of the wall of the container, which part is to be leak tested, and monitoring the pressure on one side of the wall over a test time period as a leak indicative signal, and the method including: establishing a pressure reference signal; generating a dynamic signal range that represent an acceptable change across the part during the test period with respect to the pressure reference signal; monitoring whether a signal derived from the pressure monitored is, or is not, within the dynamic signal range; and enabling the signal derived from the pressure monitored to update the dynamic signal range, if the signal derived from the pressure monitored is within the dynamic signal range, thereby indicating the container to fulfill a predetermined condition of acceptable pressure change with respect to leakiness.



ABSTRACT

The invention relates to a technique for leak testing closed and filled containers, a method for producing closed and filled containers, and a leak testing apparatus. One aspect of the invention provides a method for leak testing at least one closed container, comprising applying a pressure difference across at least a part of the wall of the container, which part is to be leak tested, and monitoring the pressure on one side of the wall over a test time period as a leak indicative signal, and the method including: establishing a pressure reference signal; generating a dynamic signal range that represent an acceptable change across the part during the test period with respect to the pressure reference signal; monitoring whether a signal derived from the pressure monitored is, or is not, within the dynamic signal range; and enabling the signal derived from the pressure monitored to update the dynamic signal range, if the signal derived from the pressure monitored is within the dynamic signal range, thereby indicating the container to fulfill a predetermined condition of acceptable pressure change with respect to leakiness.

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METHOD AND APPARATUS FOR LEAK TESTING

(This is a divisional application of CA 2,291,181 filed March 10, 1998.)

Field of invention

The present invention is directed to a technique for leak testing closed and filled containers, a method for producing
5 closed and filled containers, and a leak testing apparatus.

Background

Leak testing techniques according to which closed containers are introduced in a test cavity which, after having sealingly been closed, is lowered in pressure by a suctioning pump are
10 known. If the container is not leaking, then once a predetermined pressure has been reached in the test cavity and thus in the surrounding of a container to be tested, this pressure will be kept substantially constant. If a leak is provided in an area of the container, wherein air is entrapped, a flow of air
15 out of the container will lead to a rise of the surrounding pressure. If a leak is present in the area of the container where filling good is entrapped, the question whether such leak will lead to a significant rise of the surrounding pressure is largely dependent on the kind of filling good as of its viscosity, whether solid particles are present in the filling good
20 and, obviously, on the largeness of the leak.

Different approaches have become known to accurately detect leaks at such product-filled containers, irrespective whether the leak is present in an air entrapping container area or in a
25 container area covered with filling good. One such approach which is the topic of the co-pending European patent application EP-A-0 791 814 and US Patent No. 5,907,093 proposes to provide an impedance measurement, specifically

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a resistance measurement, just adjacent to the outer wall of the container by means of an electrode arrangement: As soon as liquid emerges from a leak it will contact a respective pair of impedance measuring electrodes and lead to a significant change
5 of impedance measured between such electrodes.

Nevertheless, such an approach necessitates considerable additional expenditure with respect to provision of the impedance measuring arrangement in each test cavity, especially of a multi-cavity in-line inspection machine and does not enable de-
10 tection of very small leaks far below of one micron and largely independent from container shape and kind of filling good.

Object of the invention

It is a primary object of the present invention to provide a leakage test method and apparatus, which may be applied to a
15 very large scale of different containers and of different filling goods, provided at least one component thereof being liquid.

It is a further object of the present invention to provide such method and apparatus which are rather inexpensive with respect
20 to electronic and further equipment, and which thus allow for very economic testing.

It is still further an object of the present invention to provide such method and apparatus which have a short measuring cycle and nevertheless a very high measuring accuracy.

25 Summary of the invention

These objects are realised by the testing method for leak testing at least one closed container, comprising a method for leak

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testing at least one closed container, comprising applying a pressure difference across at least a part of the wall of the container, which part is to be leak tested, and monitoring the pressure on one side of the wall over a test time period as a
5 leak indicative signal, and the method including: establishing a pressure reference signal; generating a dynamic signal range that represent an acceptable change across the part during the test period with respect to the pressure reference signal; monitoring whether a signal derived from the pressure monitored
10 is, or is not, within the dynamic signal range; and enabling the signal derived from the pressure monitored to update the dynamic signal range, if the signal derived from the pressure monitored is within the dynamic signal range, thereby indicating the container to fulfill a predetermined condition
15 of acceptable pressure change with respect to leakiness.

The present invention departs from the recognition that if a container is leaking and liquid is drawn by the lower surrounding pressure to its outside this will - at a constant volume of
20 the surrounding - lead to evaporation of the liquid as soon as the surrounding pressure reaches its vapour pressure. This leads to a significant change in surrounding pressure compared with the surrounding pressure which would establish at the same measuring conditions but with an unleaking container.

25 Monitoring the pressure in a test cavity containing the container, once vapour pressure of the possibly leaking liquid is reached reveals as being a very accurate technique for leak testing. It has been noted that by such a technique leak detection of containers with a very large spectrum of filling products may accurately be performed and that leaks at present moment down to 0.02 μm are accurately detectable.
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Further, it has been noted that the volume of the test cavity is uncritical, so that by the inventive technique it becomes

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possible to simultaneously test batches of containers, thereby accurately detecting if one container of such a container batch is leaking.

As soon as the pressure surrounding a leaking container is lowered with respect to its interior pressure, some of the liquid is suctioned out of the container and as soon as the surrounding pressure reaches vapour pressure it starts to evaporate. As at a constant volume of the surrounding area of the container evaporation of the liquid leads to increase of pressure and the pump lowering the surrounding pressure must now remove vapour of the liquid too, significant measurements may be done especially after the surrounding pressure of the container becomes lower than the said vapour pressure. Nevertheless, it is preferred to provide pumping abilities which may evacuate the surrounding of the container to be tested to a significantly lower value than said vapour pressure, namely by at least two, preferably even by at least three decades.

As a leak-significant pressure change may be detected as soon as one of possibly several liquid components of the filling good starts to evaporate - in the case the content of the container contains more than one liquid component - it is recommended to select the vapour pressure of that component of the several liquid components which is the higher and to lower the pressure of the surrounding of the container at least to that vapour pressure value.

Although and as well known vapour pressure is a function of temperature and thus it might be advantageous in some cases e.g. to heat the surrounding of the container to a predetermined temperature so as to settle the relevant vapour pressure

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for a predetermined liquid, the inventive method and apparatus becomes significantly less complex if the test is performed at room temperature, and thus the vapour pressure to be at least reached is considered at room temperature, i.e. around 20°C.

5 Further, a very accurate leak detection becomes possible if the surrounding pressure of the container is measured at two subsequent points in time, whereby we understand under "point" that interval of time necessary for accurately measuring the prevailing pressure. Although it is absolutely possible to realise
10 leak detection by applying the pumping action of the evacuating pump to the surrounding of the container and then by measuring the resulting surrounding absolute pressure after a predetermined time span, the said measuring of the surrounding pressure at two specific points in time allows to use the first value
15 measured as a reference value and then to form the difference of the second value measured with respect to the reference value. There is thereby realised a pressure difference measurement instead of an absolute pressure measurement. More specifically, the first pressure signal which is measured at the first
20 point in time is stored as an electric signal, then, after having measured the second pressure value, a difference is formed between the first value (still stored) and the second value.

The PCT patent application No. WO94/05991 with its US counterpart No. US Pat. 5 239 859, assigned to the same applicant as
25 the present invention, describes a method and apparatus for very accurately offset-compensated pressure difference measurement. In a preferred mode of operating the method according to the present invention as well as of realising the inventive apparatus, that pressure difference measuring technique and apparatus
30 are used. Therefore, the WO94/05991 or the respective

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US Patent No. 5,239,859 are relevant to the present application, although, and as will be seen, most important features are specifically described in the present application.

- 5 Because it is largely uncritical how big the surrounding volume of a test cavity for the container is, with respect to the volume of the container to be tested, the inventive method and apparatus reveals to have a further significant advantage:

10 If the wall of the at least one container to be tested withstands the pressure difference between container internal pressure (normally ambient pressure) and lowered surrounding pressure, such a container may simply be introduced in the test cavity forming the surrounding, largely irrespective how big such container is with respect to the test cavity. Nevertheless,
15 less, a highly accurate indication of leakage will inventively be gained. Therefore, one and the same test cavity may be used for a large number of differently sized and different-volume containers. This results in a further advantage in that batches of more than one, even of a multitude of containers, may be introduced in one test cavity forming the surrounding and although
20 one single container occupying only a small percentage of the overall cavity volume, an accurate leak indication will be detected if even only one of the batch-containers is leaking into the surrounding atmosphere.

- 25 A further significant advantage of the present invention is the following:

Sometimes the filled containers are not completely filled, but there is some amount of air entrapped in the closed container. If a leak is present in that area of such a container, which is

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adjacent to entrapped air or gas, by lowering the surrounding pressure, such air will be suctioned through the leak out of the container. With the pressure of the entrapped air in the container becoming progressively lower, there will also start
5 vaporisation of the liquid component within the container and such vapour will also leave through the leak. Both, namely first the air leaving through the leak, then vapour leaving through the leak, will enlarge the surrounding pressure so that a leak in an entrapped air region of the container will lead to
10 a change in the surrounding pressure, i.e. to rising of said pressure, as if the leak was in the liquid content covered area of the container wall. Thus, by properly setting a threshold value for leak detection according to the smallest still tolerated pressure change in the surrounding, it becomes uncritical
15 whether such leak is present at an air-covered container area or at a content-covered container area.

If one and the same leak at an air-entrapped area of the container leads to a smaller pressure change in the surrounding, than the same leak would generate if situated at a liquid-
20 covered container area, it is such a pressure change which will govern setting of a threshold value to detect whether a container is leaky or not. If, inversely, one and the same leak in a liquid-covered area would result in a smaller pressure change in the surrounding than such leak in an air-contacted wall
25 area, then it is again that smaller pressure change which governs the threshold setting for detecting leaking/not leaking containers.

If a container under test is largely leaky, lowering of the surrounding pressure should be stopped as soon as such leaking
30 is detected so as to prevent the content of the container to

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spoil the interior of the test cavity or, generally spoken, the surrounding of the container and possibly even the pumping arrangement more than absolutely necessary. This is realised either by monitoring whether the pumping action results in a pre-
5 determined lowering of surrounding pressure or not or one may detect spreading of content of the container into its surrounding by means of an impedance, thereby preferably a DC resistance measurement in the surrounding of the container just adjacent to the wall of the container which is to be tested. This
10 is realised by providing an electrode arrangement in said adjacent surrounding and all around at least that part of the container to be tested. As soon as filling content of the container is suctioned to its outer wall, the electrode arrangement will be bridged by such content, leading abruptly to an
15 indicative impedance change which, after having been detected, is used to stop further pressure lowering at the surrounding of the container.

This latter technique of rapidly detecting large leaks is applied especially to containers where it is necessary to snugly
20 encapsulate them in the test cavity because their walls would not stand the pressure difference applied. In such a case the electrode arrangement for impedance measurement may be incorporated along the inner wall of the test cavity, which snugly fits with the at least one container. If such container is to
25 be tested and therefore the test cavity snugly fits its shape, nevertheless a continuous volume is maintained between the outer wall of the container and the wall of the test cavity for defining the surrounding of the container by providing a sustaining grid or mesh inlay or preferably by roughening the in-
30 terior wall of the test cavity so that a multitude of micro-

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embossments of the test cavity wall sustain the container wall and prevent it from further outward bowing due to the applied pressure difference. Thereby, the intercommunicating space between such embossments defines for the surrounding space of the
5 container.

Once the container in a test cavity, defining for its surrounding, has been detected as being leaky, it is probable that such test cavity will be contaminated by some of the container's content. Then, such cavity is cleaned after the leaky container
10 has been removed, be it by evacuation and/or flushing with a flushing gas, preferably nitrogen, be it by heating or by combining these techniques, e.g. by a heated flushing gas.

If the inventive method or apparatus is applied for in-line testing containers and thus two or more of the inventive methods and of the respective apparatus are operated in parallel
15 on a set of containers and one of such containers is detected to be leaky, then the respective test cavity defining for its surrounding is not anymore filled with a container at the next measuring cycle, but is kept empty, using that cycle during
20 which the other cavities are in testing condition for cleaning and reconditioning the probably contaminated cavity. Further, it is proposed in some cases to accelerate squeezing-out of liquid, if a leak is present, by mechanically biasing the wall of the container inwardly, thus rising its interior pressure
25 over atmospheric pressure.

To fulfil the object, the present invention proposes a leak testing apparatus for leak testing at least one closed and filled container, whereby the content of the container comprises at least one liquid component, which comprises: at least

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one sealingly closable test cavity; at least one evacuating pump operationally connected to the test cavity; at least one pressure sensor operationally connected to the test cavity; the evacuation pump being selected so as to enable pumping of the test cavity down to at least vapour pressure of the component approximately at room temperature and the pressure sensor being a vacuum pressure sensor; a timing unit enabling the evacuation pump to operate up to generating a pressure value in the test cavity as low as at least vapour pressure of the component and enabling evaluation of an output signal of the sensor as a leak indicative signal after the vapour pressure of the component is reached.

Certain other exemplary embodiments may provide a method for producing a closed and filled container comprising the steps of: filling a container with a material comprising at least one liquid component; sealingly closing the container; and leak testing the container by: applying a pressure difference across at least a part of the wall of the container which part is to be tested by evacuating the surrounding of the container by means of a pumping arrangement; and exploiting loading of the pumping arrangement by evaporation of liquid as an indicia for a leak in the container.

It must be pointed out that besides the leak testing of smaller containers, the present invention makes it possible to permanently monitor tightness of huge tank plants, as for gasoline, gases etc., e.g. on train or street transports, thereby generating an alarm signal as soon as a leak is detected.

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Short description of the figures

The present invention will now additionally be described with the help of figures showing specific and today preferred
5 examples of realising the present invention. Such figures show:

Fig. 1: qualitatively the dependency of vapour pressure from
temperature of a liquid;

10

Fig. 2: schematically an inventive test apparatus operating according to the inventive method;

15

Fig. 3: qualitatively the time course of the pressure of the surrounding of a container to be inventively tested.

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for explaining the inventive method and apparatus operation;

Fig. 4: in a functional block diagram a preferred form of realisation of an inventively operated inventive test apparatus;

Fig. 5: as a functional block diagram a preferred form of realisation of the evaluating electronic at an inventive apparatus performing the inventive method;

Fig. 6: schematically batch operation of an inventive apparatus;

Fig. 7: schematically a test cavity for testing flexible wall containers;

Fig. 8: in a perspective view one half of a test cavity for inventively testing three containers as a batch;

Fig. 9: schematically a double-wall tank directly used to perform the inventive method with an inventive apparatus so as to survey tank leakage;

Fig. 10: schematically a preferred sealing at a test cavity of the inventive apparatus;

Fig. 11a to 11c:

show the pressure courses on testing cycles, whereat the containers or medical application blisters are either largely or even very largely leaking (Fig. 11a), or have only a small leak (Fig. 11b), or are to be considered unleaky (Fig. 11c). The tests are performed with test cavities according to fig. 8 without

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impedance measurement and thus without electrodes 32, 34.

- Fig. 12 a signal flow/functional block diagram of the simplified preferred embodiment of an evaluation unit for operating the inventive method at an inventive apparatus;
- Fig. 13 in a pressure versus time diagram the statistical variation of pressure courses measured at unleaky containers or at test cavities void of any containers,
- Fig. 14 in a simplified functional block/signal flow diagram a part of the inventive apparatus operating according to preferred mode of the inventive method, thereby forming a dynamic reference value for leak testing by means of a subsequently updated averaging;
- Fig. 15 in a simplified signal versus time diagram qualitatively the preferred inventive method and accordingly operation of a preferred inventive apparatus, whereby dynamically updated reference values are formed for leak identification;
- Fig. 16 a simplified signal flow/functional block diagram showing a further preferred mode of operation of the inventive method and respectively of the inventive apparatus, wherein a dynamically updated average signal is formed as the basis for a reference value to be compared with a pressure difference signal evaluated during container testing;

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Fig. 17 in arbitrary unit over the time axis pressure measurements at subsequently operated test cavities of an inventive apparatus with multiple cavities to show dynamic update of an average signal, whereon reference values for comparison are based, leading to leakage identification;

Fig. 18 in a simplified schematic representation, a test cavity according to the present invention, which is pivoted during testing;

Fig. 19 the effect of pivoting the test cavity according to fig. 18 on the relative location of a leak with respect to filling product;

Fig. 20 in a simplified functional diagram provision of a calibration standard leak to calibrate the inventive apparatus as performing the inventive method.

In fig. 1 there is qualitatively shown the course of vapour pressure $p_v(T)$ in the pressure versus temperature diagram. At a predetermined temperature T_x a liquid starts to evaporate when the respective vapour pressure p_{vx} is reached. Above the vapour pressure course the material is liquid, below the material is gaseous.

According to fig. 2 an inventive apparatus comprises a test cavity 1 with a sealingly closable cover 3. A vacuum pump 5 connected to the test cavity 1 which may be a drag pump or a rotational piston valve pump or a diffusion pump or a turbo vacuum pump as a turbo molecular pump. This depends on the degree of vacuum which shall be established within cavity 1. Further, there is provided a vacuum pressure sensor 7 as e.g. a

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Pirani sensor, which measures the pressure prevailing in the test cavity 1. At least one closed container 9, which is filled at least to some extent with a filling product containing at least one liquid component is introduced through opened cover 3
5 into the test cavity 1 which is then sealingly closed. By starting operation of vacuum pump 5 the surrounding of container 9 and thus the intermediate volume V of test cavity and container 9 is lowered.

According to fig. 3 starting at ambient pressure p_0 the pressure in volume V is lowered at least down to the value p_v which
10 accords to the vapour pressure of the liquid component within the filling good of the container 9. It is advisable to select a vacuum pump 5 which enables to evacuate the test cavity 1 down to a pressure which is at least one, preferably two and
15 even more preferred three decades lower than the vapour pressure p_v of the liquid content of the filling product.

The test is preferably performed at room temperature, i.e. at a temperature T of about 20°C. If the liquid content is water then the vapour pressure p_v of water at room temperature is
20 about 20 mbar and it then is preferred to provide an evacuation pump 5 which is able to evacuate the test cavity to about 10^{-2} mbar.

If the container provided in the test cavity 1 having a relatively rigid wall 11 is not leaky, then qualitatively the pressure in volume V will follow the course (a) according to fig. 3
25 down to the more or less constant value of pressure, which may be reached by that type of vacuum pump installed. If, on the other hand, the container 9 is leaky as schematically shown in fig. 2 e.g. at location 13, then a small amount 14 of liquid

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component of the filling good will be drawn through the leak 13 out of the container 9 and as soon as the pressure prevailing in the volume V becomes p_v starts to evaporate into the volume V. As qualitatively shown in fig. 3 this leads to a pressure
5 versus time course according to (b), i.e. evaporation of the liquid leads to a pressure rise in volume V, counteracting the action of the vacuum pump 5. The vacuum pump 5 will have to remove additionally the vapour to finally achieve a vacuum level according to course (a). If the leak is situated at an area of
10 the container 9 where air is entrapped, as in fig. 2 at 13', then evacuation of volume V will first lead to suctioning air out of the container, again counteracting the operation of vacuum pump 5, then the liquid content within container 9 will start to evaporate within the container and vapour will be suc-
15 tioned out of leak 13'. This, too, will lead to a pressure rise in volume V, counteracting the pressure course which would be followed if just air had to be removed by vacuum pump 5.

By means of the vacuum sensor 7 the course of pressure in the volume V is monitored. Experiments have shown that largely in-
20 dependent of the amount of volume V in a test cavity a significant difference of pressure according to the courses (a) and (b) of fig. 3 is reached after a time span τ of a few seconds (one to three seconds) and at a leak smaller than 1 micron ($0,02 \mu\text{m}$), the pressure difference between a leaky and an un-
25 leaky container being of about one pressure decade. Measurements were performed with water as liquid content.

Although it is absolutely possible to measure the absolute pressure in volume V, e.g. after the time span τ to detect leakage of the container a pressure difference measurement is
30 preferred, as will first be explained with the help of fig. 4.

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Back to fig. 2 the pressure sensor 7 is operationally connected to an evaluating unit 15, whereat especially leak indicative threshold values are preset, as schematically shown by means of a presetting unit 17. The output of the evaluation unit 15 is a two-state signal indicating leaky or not leaky.

According to fig. 4 the output of the vacuum sensor 7 is input to a storage unit 19, controlled by a timing control signal s_1 , as schematically shown via switch S. According to fig. 3 this is performed at a first point in time t_1 . At a second point in time, according to fig. 3 t_2 , the output of the storage unit 19 and the output of the sensor 7 are connected to respective inputs of a difference forming unit 21, which generates an output signal which accords with the pressure difference Δp of fig. 3.

A further, most preferred realisation of the evaluation electronic is shown in fig. 5. The output signal of sensor 7 is input to a conversion unit 121, which comprises, as an input stage, an analogue to digital converter 121a, followed by a digital to analogue converter 121b. The output of the converter stage 121 is fed to a difference amplifier unit 123, which additionally receives directly the output signal from sensor 7. The output of the difference amplifier unit 123, according to the difference unit 21 of fig. 4, acts on a further amplifier unit 125, the output of which being superimposed at 128 to its input via storage unit 127. The input of the storage unit 127 is fed from the output of unit 125. A timer unit 129 time controls the arrangement. For storing a first pressure value from sensor 7, according to fig. 3 at time t_1 , the timer unit 129 enables a conversion cycle at unit 121, so that a reconverted analogue output signal e_1 appears at the output. Simultane-

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ously, the substantially same signal from sensor 7 is applied as signal e1 to the second input of unit 123. Thus, at the output of unit 125, a zero signal should appear. Nevertheless, in general a zero-offset signal will appear at the output of unit 5 125, which signal is stored in the storing unit 127, enabled by the timing unit 129. At time t_2 no conversion is triggered at the unit 121, so that there appears at the input of amplifier 123 directly from sensor 7 the pressure value prevailing at t_2 and, from stage 121, the stored pressure value which was pre- 10 vailing at t_1 . Further, the zero offset signal which was stored in unit 127 is superimposed as a offset-compensating signal so that the resulting signal at the output of amplifier unit 125 is zero-offset compensated.

This allows a very accurate measurement of pressure difference 15 Δp according to fig. 3.

If the container under test has a large leak, then, and according to fig. 3 course (c) the pressure prevailing in the volume V of the test cavity 1 will have just from the beginning of operating the vacuum pump 5 a different course. This may easily 20 be detected, e.g. by comparing at a previous point in time t_0 the output signal of sensor 7 with a predetermined threshold value (not shown), and if such threshold value is not reached by the actual pressure, the effect of the vacuum pump 5 on test cavity 1 is disabled. This to avoid that, with a larger leak, a 25 huge amount of content of the container is suctioned into the test cavity and contaminates that cavity.

As was mentioned, the proposed method accurately functions largely independently from the volume V between test cavity 1 and the at least one container to be tested. This allows, ac-

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according to fig. 6, to simultaneously test batches 9' of containers 9, thereby maintaining accuracy of detecting whether one or more than one of the containers 9 leak. Further, the fact that detection accuracy is not critical with respect to difference volume V leads to the possibility of providing one test cavity 1 for a multitude of differently shaped and different-volume containers 9 to be tested therein.

If the wall of a container to be tested may not mechanically withstand the pressure loading of approx. 1 bar, then, and as schematically shown in fig. 7, a test cavity 1' with cover 3' is provided which snugly fits with the shape of the container 9. Thereby, protrusions 20, as schematically shown in fig. 7, prevent that by effect of the evacuation the walls of the container are firmly suctioned on to the inner wall of the test cavity and thus make sure that there remains a volume V between container and test cavity wall for being evacuated according to the invention. Such protrusions 20 may be realised by a mesh or grid inlay or, and preferably, by mechanically roughening the inner wall of the cavity, so that micro-embossments sustain the wall of the container, thereby leaving a continuous interspace as volume V.

As shown in dashed line in fig. 7 it might further be advantageous, e.g. when closing the cover 3 or 3' of the cavity, to mechanically bias a part of the container's wall inwardly, thereby increasing the inner pressure of the container 9 and additionally pressing liquid component of the filling product out of a leak if such a leak is existent.

According to fig. 9 the method and apparatus according to the present invention may be used to monitor huge tanks with re-

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spect to leakage. In fig. 9 there is shown a tank with double-wall, namely with an inner wall 23 and an outer wall 25. Testing tightness of both these walls is performed by using the intermediate volume of the two walls, as volume V according to
5 fig. 2. Such a technique may be applied e.g. for tanks on road or rail vehicles or for huge stationary tank plants, e.g. for gasoline.

In fig. 8 there is shown one half 1a of a test cavity 1 for applying the inventive method in an inventive apparatus on three
10 containers at 29 as on small plastic containers for medical appliance. The containers may have flexible walls as the test cavity 1 snugly fits their shape. There is further shown another technique to rapidly detect whether one of the containers has a large leak. There are provided impedance measurement
15 electrodes 32 and 34 integrated in the wall of the cavity 1 and mutually electrically isolated. They are connected to an impedance or, preferably, resistance measuring unit 35. If by applying a vacuum to the test cavity, preferably with a roughened interior wall, liquid filling content is suctioned to the outside of the container wall, this is quickly detected by an
20 abrupt change of impedance measured between the electrodes 32 and 34. The output of the impedance measuring unit 35 disables (not shown) further evacuation of the test cavity 1.

Once a test cavity has been spoiled by outpouring filling good
25 of a leaking container it is cleaned, either by cleaning evacuation and/or pouring with a gas, preferably with nitrogen, and/or by heating. In fig. 8 there is shown a feeding line for a flushing or cleaning gas, controllably fed from a gas tank 37 to a contaminated test cavity 1, which gas preferably is nitrogen.
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Two cavity halves, 1a according to fig. 8 are sealingly put one upon the other to complete a test cavity 1 according to fig. 2.

If in-line testing of containers shall be performed, for which the present invention is especially suited due to its short measuring cycle, more than one, namely a set of several test cavities is provided, e.g. on a carousel, which are automatically loaded with containers to be tested (not shown) from a conveyor and which perform simultaneously the described testing technique. If one of the containers tested in such cavity is detected to be leaky, then the respective cavity is not reloaded with a further container afterwards, but this cavity is maintained empty during the measuring cycle on a next set of containers. Meanwhile, the cavity kept unloaded is cleaned, as was described, either by evacuation and/or gas flushing and/or heating.

Obviously, there must be realised a good vacuum-tight sealing between a cover 3 or 3' of the test cavity and the main body of the test cavity 1 or between the two halves 1a of test cavity according to fig. 8. This is realised preferably by providing at least a pair of parallel seals 28 as of concentric O seals and by separately pumping an intermediate space 29 between such seals, as shown in fig. 10. If the container to be tested contains a filling product with more than one specific liquid component, the vapour pressure of that component is selected for leak detection which has the highest vapour pressure, i.e. which component starts to evaporate at relatively highest pressure. Thereby, viscosity has to be considered too, i.e. a component is to be selected for defining the vapour pressure, which component is liquid enough to penetrate smallest leaks. By evacuating the test cavity down to a pressure which is sig-

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nificantly lower than the vapour pressure of any liquid component it becomes uncritical which vapour pressure valve is to be considered.

Pressure versus time courses as measured according to the inventive method and with an inventive apparatus, both in preferred mode, are showing pressure course for containers with large leaks (fig. 11a), small leaks (fig. 11b) and for unleaky containers (fig. 11c).

These figures shall be discussed in connection with fig. 12, which shows a preferred monitoring and control unit according to units 15, 17 of fig. 2.

According to fig. 11a the timing unit 201 of fig. 12 initiates at time t_{10} evacuation of a test cavity 103 by means of the pumping arrangement 105. This is shown in fig. 12 by the evacuation start signal $EVST/t_{10}$.

After a fixed predetermined amount of time ΔT of e.g. 0.75 sec. the output signal of the pressure sensor within test cavity 103 (not shown in fig. 12), A_s , becomes compared with a first reference signal preset at a presetting source 107, RFVGL. To this target, comparator unit 109 is enabled by timer unit 201 at $t_{10} + \Delta T$.

If after time span ΔT the actual monitored pressure according to electric signal A_s of fig. 12 has not reached the value of RFVGL according to course I of fig. 11a, this means that a very large leak VGL is present. This is detected at comparator 109 generating the output signal A_{109} . If according to the characteristics shown in the block 109 of fig. 12 the output signal of this comparator unit 109 enabled at $t_{11} = t_{10} + \Delta T$ is e.g.

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still at a high level indicating presence of a VGL, this is output at the VGL output. If the pressure prevailing in the surrounding of the container 103 under test, i.e. in the test cavity, has reached and crossed reference level RFVGL according to course II of fig. 11a, the VGL output signal is not generated.

As will be explained later, occurrence of the VGL signal preferably stops the evacuation cycle because contamination of the vacuum pump 105 may have occurred or might occur due to the very large leak of the container under test.

As shown by the course II of fig. 11a as VGL does not occur evacuation continues up to a further moment of time t_{13} . At the time t_{13} the timer unit 201 disables pumping arrangement 105 and disconnects as by a valve 106 the pumping arrangement from chamber 103. Further, timer unit 201 enables comparator unit 111, to which a further reference value RFGL is led, generated by a reference signal source 113. If at t_{13} the pressure prevailing in the surrounding of the test cavity has not reached RFGL then comparator unit 111 generates an output signal GL indicating that the container under test has a large leak. Here again, and as will be further explained later on, some reactions are taken with respect to further operation of the testing system.

If either the signals VGL or GL are initiated by the respective comparators 109, 111, the timer unit 201 is principally reset because the testing has been completed and the quality of the instantaneously tested container established has been identified. This is schematically shown in fig. 12 by the signal RS_{201} . If not reset, shortly after t_{13} the value $A_s(t_{13})$ of the

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pressure prevailing in the surrounding of the container is stored in a holding or storing unit 117. The output of the holding or storing unit 117 is led to one input of a difference forming unit 119, whereas the second input of this unit 119 is
5 connected to the output A_s of the pressure sensor monitoring the pressure in the surrounding of the container under test. After a presettable test cycle time T_r starting at t_{13} , as schematically shown by unit 121 of fig. 12, the pressure difference DP at the output of unit 119 is evaluated, as represented in
10 fig. 12 by switching unit 123. This pressure difference DP is fed to a further comparator unit 125 enabled at the lapse of testing time T_r . By means of a further reference value source 127 the reference value DPREF is fed to the comparator unit 125. As will be explained later, the value of DPREF may con-
15 trollably be varied in time and/or a reference value ϕ_r to which DPREF is referred to may also controllably be varied in time.

If DP at time $t_{13} + T_r$ is larger than the reference value DPREF, then a signal FL is generated at unit 125, indicating presence
20 of a fine leak FL in the container under test. This according to the situation as shown in fig. 11b. If DP does not reach DPREF, then the container is considered unleaky as none of the signals VGL, GL and FL have been generated. This according to fig. 11c.

25 If the VGL signal is generated according to fig. 12, the evacuation pump 105 is immediately disconnected from any testing chamber 103 it is connected to, be it a single chamber or be it in an in-line processing where one pump 105 is parallel connected to a multitude of testing chambers 103, from all such
30 chambers. This because at a very large leak the vacuum pump 105

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could have been contaminated by leaking content of the container. It thereby is absolutely possible to provide for such a case a redundant pumping arrangement which may be connected to the one or the more than one testing chambers to continue testing, whereas the possibly contaminated first pumping arrangement is reconditioned.

In a multiple chamber in-line testing system, as e.g. in a carousel testing plant with a multitude of testing chambers, occurrence of the signal GL indicating a large leak and possibly also the occurrence of the signal FL indicating for a fine leak leads preferably to disabling or "bypassing" that chamber with the leaky container from further being supplied with containers to be tested, whereas the other chambers are still operating and performing tests on newly supplied containers. This bypass of a testing chamber, whereat a container has been identified as heavily or even slightly leaking, is performed so as not to influence further testing results at that chamber which wouldn't thus be representative anymore due to content of the leaky container having possibly contaminated that chamber.

This bypassed chamber is reconditioned during further testing cycles at the other chambers.

Reconditioning may be done by heating that chamber, flushing it by a liquid and/or a gas, especially by a heater gas. Whether or not that chamber has been properly reconditioned is checked by having it tested as if it was filled with a container to be tested. Thereby, the condition of proper reconditioning is indicated if DP according to fig. 12 at that empty chamber does e.g. not reach DPREF or an appropriately set "Empty Chamber DP-REF"-value (ECDP-REF).

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Such ECDP-REV may be provided by measuring DP_e at the clean, empty test chambers and by storing these measuring values DP_e as respective reference values for testing the chambers on proper reconditioning.

- 5 When looking to the fig. 11a to 11b, it may be recognised that setting the reference value RFGL and especially setting of the reference pressure difference value DPREF may be very critical and may largely influence accuracy of the system. Thereby, influences as surrounding temperature, moisture of ambient air,
10 slight contamination of pump etc., may influence the prevailing pressure course and lead to false results if these critical reference levels and especially DPREF are set for utmost accuracy.

In fig. 13 there is quantitatively shown the pressure course
15 according to the courses of fig. 11a to 11c, but measured at test cavities void of containers. At t_1 , there occur statistically distributed slightly different pressure values. Thus, before beginning testing of containers at a multiple test cavity plant, the unfilled, tightly closed test cavities are tested
20 according to fig. 13 to establish an average $(RFGL)_m$. The value of RFGL as used at the comparator 111 of fig. 12 or as used according to the figures 11a to 11c is found in that an offset value $\Delta RFGL$ is added to $(RFGL)_m$. It must be pointed out that ambient parameters as temperature, humidity of ambient air etc.
25 may be considered constant during the calibrating cycle performed at the empty and conditioned test cavities and leading to the measuring results according to fig. 13. Nevertheless, during ongoing time as during on-line testing, these disturbing parameters may slowly change and may vary $(RFGL)_m$.

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Every time during multiple or in-line testing, be it subsequently with a single test cavity or consecutively with a multitude or at least more than one test cavity, at the respective time t_{13} , up to which the respective container has been identified as not heavily leaky, the actual output signal of the pressure sensor is entered into an averaging unit 113, wherein the last m values of actual pressure of not heavily leaky containers are averaged. The output average result signal accords with $(RFGL)_m$ of fig. 13, but varies in time, e.g. due to varying ambient parameters. To the output average result $\overline{A5}$ and according to fig. 13 the offset $\Delta RFGL$ is added, the result of that addition is a dynamically varying reference value $RFGL$, which is applied to comparator unit 111 of fig. 12. This dynamically varying reference value $RFGL$ is shown in fig. 15, starting from an initial setting, as e.g. found as was explained with the help measurements at empty test cavities 103.

As may clearly be seen now from fig. 15, the average pressure value $\overline{A5}(t_{13})$ is now the basis for also referring $DPREF$ to. Therefore, and as shown in fig. 12, the difference pressure reference value $DPREF$ is not referred to an absolute static value as ϕ_R , but is referred to $\overline{A5}$.

An even further improvement of accuracy is reached as will now be described, which may be realised separately or additionally to realising a dynamic $RFGL$ and based thereon a dynamic upper limit of $DPREF$. Thereby and according to fig. 16 at the end of the time span T_T the actual pressure difference DP is led to an averaging unit 135 whenever the output signal FL indicates that the container under test is unleaky. The output signal of unit 135 which accords to an average pressure difference signal $\overline{DP}$

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averaged over the last m test cycles, is offset by an amount ΔDP , the result thereof being used as $DPREF$ signal applied at unit 127 of fig. 12.

Looking back on fig. 15, whereat, as discussed before, a constant $DPREF$ signal was applied the technique of averaging DP results, as schematically shown with a course $(DPREF)_t$, in a dynamically varying check value $DPREF$, varying according to variations of disturbing parameters, influencing such pressure difference.

- 10 It is clear that provision of a dynamically varying $(DPREF)_t$ signal according to that representation in fig. 15 could be realised without providing a dynamically varying base value $\overline{A5}$, in referring $(DPREF)_t$ to a stable, constant value ϕ_R , as shown in fig. 12 in dashed representation instead of referring to a
15 dynamically varying $\overline{A5}$ value.

It is evident that preferably the evaluations of the output signal A_s of the one or more than one test cavities is performed digitally, i.e. after analogue to digital conversion of the output signal of the respective sensor or sensors.

- 20 In fig. 17 there is shown over the time axis and in arbitrary units the actual pressure difference values DP measured successively at a multitude of test cavities of an in-line testing plant. According to fig. 16 the calculated average pressure difference $\overline{DP}$ is shown and the offset ΔDP finally leading to
25 $(DPREF)_t$ according to fig. 15 or 16. As may clearly be seen, the average $\overline{DP}$ and thus $(DPREF)_t$ vary in time and along successive testing, whereby pressure difference values as at A, which are higher than the instantaneously prevailing $(DPREF)_t$,

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are disregarded with respect to influencing the averaged $\overline{DP}$, as such measurements are due to leaky containers according to fig. 11b.

Further, whenever the test of a container within a specific
5 test cavity results in a leak-indication for a predetermined number of subsequent tests, as e.g. three times subsequently, such test cavity is also bypassed for further testing and is considered as contaminated or as leaky itself, thus being re-conditioned. Such a test cavity is likely to have been contami-
10 nated during succeeding testings at leaky containers or is likely not to be tight, which will be recognised during reconditioning and testing on proper reconditioning too, as was described above.

Further, and as was already mentioned, for some containers to
15 be tested and especially for some filling products it is advisable to heat the test cavities to a predetermined temperature which is preferably controlled at each test cavity, e.g. by a negative feedback temperature control. Thereby, the temperature-dependent evaporation pressure of the filling product is
20 set within a predetermined pressure range. Such heating is thereby preferably accomplished in a pre-heating cycle before the actual testing cycle according the figures 11a to 11c is performed.

As was mentioned above, a leak in a container will be identi-
25 fied irrespective of the fact whether such leak is in an area of container's wall exposed to entrapped air within the container or to the filling product. Nevertheless, for some filling goods as e.g. with particulate content in liquid, there might occur differences with respect to time a respective pres-

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sure difference develops in the surrounding of the container under test.

Therefore, and as schematically shown in fig. 18, it may be advisable in some cases to provide the one or the several test cavities 103 for the container to be tested 9 to be movable. This is e.g. accomplished by mounting the test cavities 103 pivotable with respect to a pivot axis A and driven via a rotational axis 140. Thereby, leads to and from the pressure sensor within such test cavity, to and from a heating arrangement at such a test cavity etc. may be led through the driving axis 140. The cavity 1, 103 is preferably not rotated, but is rotatably oscillated as shown by $\pm\phi$ in fig. 18. By this technique, and as schematically shown in fig. 19, a leak L is moved into air and into liquid contact, so that testing will consider vaporising of liquid content whenever it occurs, be it in the position according to fig. 19a or in the position according to fig. 19b.

Proper functioning of the testing apparatus and calibration of the evaluation unit, be it a one-chamber tester or a at multiple-chamber testing plant as for in-line testing, is further preferably accomplished with the help of a standard leakage arrangement which is preferably mounted on the test plant, so that recalibration and/or overall testing of the plant may be accomplished whenever desired. The arrangement of such a standard or calibration leak arrangement is shown in fig. 20.

According to fig. 20 there is provided in the line from a test cavity, as 103 according to fig. 12, to the vacuum pump 105 a needle valve 142, which is adjustable but which preferably is preset not variable by the user of the plant on a predetermined

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leakage value. Via the needle valve 142, the line to the vacuum pump 105 is connected to a liquid reservoir 144, which preferably is filled with distilled water. Via a pressurising line and valve 146 the reservoir 144 may be adjustably pressurised. The
5 needle valve is set to such a value that no distilled water of reservoir 144 will penetrate into the connection line of chamber 103 to vacuum pump 105, but only vapour. Nevertheless, by adjusting pressurisation of the water within reservoir 144 via line and valve 146 a leak of different and varying extent may
10 be simulated without liquid penetrating and spoiling chamber and/or connection line and/or vacuum pump. For a plant with a multitude of testing cavities such a calibration arrangement with needle valve 142 may centrally be provided and connected in parallel to all chambers 103, as in such a plant preferably
15 there is provided one central pumping arrangement 105 acting in parallel on all the chambers or cavities provided. Alternatively such a calibration arrangement may be provided separately for each of the chambers 103 provided.

It has been recognised that by applying the described technique
20 of leak testing by lowering the surrounding pressure of a container under test below vapour pressure of a liquid component of its content, it is mostly not necessary to additionally provide resistance measurements, as was explained with the help of fig. 8, so that, at the respective test chambers, the electrode
25 arrangements and measurement units may be omitted, which significantly reduces costs for the overall plant and its complexity. The invention is especially suited for testing vials or blisters, especially for medical appliances, in-line with their production by checking every singly vial or blister. If and as
30 schematically shown in fig. 6 a multitude of containers 9 are

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mechanically linked together to form a set of such of containers, clearly such a set is considered as one container with respect to leak testing.

With the inventive method and apparatus as for blisters the entire testing cycle, i.e. from t_{10} to the end of T_r according to the figures 11 is performed in less than 2 sec. This leads at an in-line plant with a multitude of test cavities, e.g. with 24, e.g. arranged on a carousel, to a very high throughput.

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The embodiments of the invention in which an exclusive property or privilege is claimed are defined as follows:

1. A method for producing a closed and filled container
5 comprising the steps of:

filling a container with a material comprising at least one liquid component;

sealingly closing said container; and

leak testing said container by:

- 10 applying a pressure difference across at least a part of the wall of the container which part is to be tested by evacuating the surrounding of said container by means of a pumping arrangement; and

- 15 exploiting loading of said pumping arrangement by evaporation of liquid as an indicia for a leak in said container.

2. The method of claim 1, wherein said evacuating lowers the pressure in said surrounding toward a pressure valve
20 which is lower than a vapour pressure of the at least one liquid component by a factor of at least two decades (10^{-2}).

3. The method of claim 2, wherein said container is filled with more than one liquid component, and said vapour
25 pressure is the higher vapour pressure of the vapour pressures of said at least two components.

4. The method of claim 1, wherein said testing is performed at room temperature.

30

5. The method of claim 1, wherein said exploiting is performed after the surrounding has been evacuated to a

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pressure value at least according to vapour pressure of said at least one liquid component.

6. The method of claim 1, wherein the exploiting includes
5 monitoring the pressure in the surrounding at first and second points in time and utilizing a difference in the results of the monitoring as said indicia for a leak in said container.

10 7. The method of claim 6, wherein said monitoring the pressure at said first point in time results in a first pressure measuring signal which is stored at least up to said second point in time.

15 8. The method of claim 6, including the step of providing a pressure measuring sensor in said surrounding and operationally connecting said sensor to both inputs of a difference forming unit at said first point in time, generating a zero offset signal dependent from the output
20 signal of said difference forming unit, storing said zero offset signal and compensating zero-offset when utilizing said difference in the results of said monitoring as said indicia for a leak in said container.

25 9. The method of claim 6, including the step of providing a pressure measuring sensor in said surrounding and comparing the output signal of said sensor with one or more than one predetermined signal values.

30 10. The method of claim 6, including storing a first measuring signal which results from said monitoring the pressure at said first point in time by means of an analog-

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to-digital converter, which is enabled for conversion at said first point in time.

11. The method of claim 10, including reconverting the
5 digital output signal of said analog-to-digital converter into an analog signal.

12. The method of claim 1, including simultaneously leak
testing a batch of filled and closed containers as one
10 container.

13. The method of claim 1, further comprising performing an
impedance measurement at or at least adjacent to said part
of said wall in said surrounding wherein said impedance
15 measurement is a resistance measurement with DC and enabling
or disabling further lowering of said pressure in said
surrounding by the result of said impedance measurement.

14. The method of claim 1, including providing a test
20 cavity with a test chamber snugly fitting the outer shape of
said container, thereby maintaining at least at said part a
residual volume to be lowered in pressure and between said
part and the wall of said test cavity.

25 15. The method of claim 1, further comprising providing a
test cavity for said container, said test cavity defining a
test chamber significantly larger than the volume of said
container.

30 16. The method of claim 1, including providing a test
cavity for said container and cleaning at least said test
cavity after a container therein has been detected as

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leaking.

17. The method of claim 1, including in-line testing a series of said containers in a set of test cavities and
5 further comprising disabling testing in a test cavity for at least one testing cycle if the container previously tested therein has turned out to be leaky.

18. The method of claim 1, further comprising the step of
10 increasing internal pressure of said container by mechanically biasing at least a part of its wall inwardly.

19. The method of claim 1, wherein said liquid component is water, and including evacuating said surrounding to less
15 than 20 mbar.

20. The method according to claim 1, wherein said pressure in said surrounding is lowered towards a pressure value which is lower than said vapour pressure by a factor of at
20 least three decades (10^{-3}).

21. A method for producing a closed and filled container comprising the steps of:

filling a container with a material comprising at least
25 one liquid component;

sealingly closing said container; and

leak testing said container by:

applying a pressure difference across at least a part of the wall of the container which part is to be
30 tested by evacuating the surrounding of said container at least along said part of said wall by means of a

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pumping arrangement at least down to vapour pressure of said liquid component;

5 sensing the pressure in said surrounding and
evaluating said pressure as sensed after having reached
said vapour pressure as an indicia for a leak in said
container.

22. The method of claim 21, wherein said evacuating lowers
said pressure in said surrounding towards a pressure value
10 which is lower than said vapour pressure by a factor of at
least two decades (10^{-2}).

23. The method of claim 21, wherein said container is
filled with more than one liquid component and said vapour
15 pressure is the higher vapour pressure of the vapour
pressures of said at least two components.

24. The method of claim 21, wherein said testing is
performed at room temperature.

20

25. The method of claim 21, wherein said evaluating
comprises monitoring said pressure in said surrounding at a
first and at a second point in time and utilizing a
difference in the results of said monitoring at said first
25 and second points in time as an indicia for a leak in said
container.

26. A method for testing a closed and filled container,
filled with a material comprising at least one liquid
30 component and comprising the steps of:

applying a pressure difference across at least a part
of the wall of said container, which part is to be tested by

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evacuating the surrounding of said container at least along said part by means of a pumping arrangement at least down to vapour pressure of said liquid component; and

sensing the pressure in said surrounding and evaluating
5 said pressure as sensed after having reached said vapour pressure as an indicia for a leak in said container.

27. The method of claim 26, wherein said evacuating lowers said pressure in said surrounding towards a pressure value
10 which is lower than said vapour pressure by a factor of at least two decades (10^{-2}).

28. The method of claim 26, wherein said container is filled with more than one liquid component and said vapour
15 pressure is the higher vapour pressure of the vapour pressures of said at least two components.

29. The method of claim 26, wherein said testing is performed at room temperature.

20

30. The method of claim 26, wherein said exploiting comprises monitoring said pressure in said surrounding at a first and at a second point in time and utilizing a difference in the results of said monitoring at said first
25 and second point in time as an indicia for a leak in said container.

31. A leak testing apparatus for leak testing at least one closed and filled container, whereby the content of said
30 container comprises at least one liquid component and comprising:

at least one sealingly closable test cavity;

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at least one evacuating pump operationally connected to said test cavity;

at least one pressure sensor operationally connected to said test cavity;

5 said evacuation pump being selected so as to enable pumping of said test cavity down to at least vapour pressure of said component approximately at room temperature and said pressure sensor being a vacuum pressure sensor;

10 a timing unit enabling said evacuation pump to operate up to generating a pressure value in said test cavity as low as at least vapour pressure of said component and enabling evaluation of an output signal of said sensor as a leak indicative signal after said vapour pressure of said component is reached.

15

32. The apparatus of claim 31, wherein said evacuation pump is at least one of a drag vacuum pump, a piston valve vacuum pump, a diffusion pump, a turbo vacuum pump.

20 33. The apparatus of claim 31, wherein said sensor comprises a Pirani sensor.

34. The apparatus of claim 31, further comprising a storage unit operationally connected to the output of said sensor
25 and a difference forming unit, one input thereof being operationally connected to the output of said storage unit, the second input thereof being operationally connectable to the output of said sensor, a timing unit operationally connecting the output of said sensor at a first point in
30 time to the input of said storage unit and operationally connecting at a second point in time the output of said sensor to said other input of said difference forming unit.

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35. A method for leak testing at least one closed container, comprising applying a pressure difference across at least a part of the wall of the container, which part is to be leak tested, and monitoring the pressure on one side of said wall over a test time period as a leak indicative signal, and said method including:

- establishing a pressure reference signal;
- generating a dynamic signal range that represent an acceptable change across said part during said test period with respect to the pressure reference signal;
- monitoring whether a signal derived from said pressure monitored is, or is not, within said dynamic signal range; and
- enabling said signal derived from said pressure monitored to update said dynamic signal range, if said signal derived from said pressure monitored is within said dynamic signal range, thereby indicating the container to fulfill a predetermined condition of acceptable pressure change with respect to leakiness.

36. A method for producing at least one closed, and unleaky container comprising leak testing said container by applying a pressure difference across at least a part of the wall of said container, between the inside of said container and the surrounding of said container, which part is to be leak tested, monitoring the pressure on one side of said part of said wall over a test time period as a leak indicative signal, and wherein said method includes:

- establishing at least one pressure reference signal,
- generating a dynamic signal range that represents an acceptable pressure change across said part during said test

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period with respect to said at least one pressure reference signal,

monitoring whether a first signal derived from the pressure monitored is, or is not, within said dynamic signal
5 range,

enabling a second signal derived from said pressure monitored to update said dynamic signal range if said first signal derived from said pressure monitored is within said dynamic signal range, thereby indicating the container to
10 fulfill a predetermined condition of acceptable pressure change with respect to unleakiness.

37. The method of claim 36, including forming a difference signal of said first signal and said at least one pressure
15 reference signal and updating said dynamic signal range by said difference signal by averaging an actual difference signal with previously formed difference signals formed at containers fulfilling said predetermined condition.

20 38. The method of claim 37, including forming said dynamic signal range by a result signal of adding said averaged difference signal to a constant signal value.

39. The method of claim 36 or 37, further comprising
25 establishing said at least one pressure reference signal as a dynamic pressure reference signal.

40. The method of claim 39, including establishing said dynamic pressure reference signal by averaging said first
30 signal derived from said pressure actually monitored if the actual container under test is considered as fulfilling said condition with first signals previously monitored at

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containers fulfilling said condition.

41. The method of claim 36, wherein said leak testing is performed at a respective container filled with a content comprising at least one liquid component and wherein said pressure difference is directed towards said surrounding, comprising lowering pressure in said surrounding at least to a value according to vapour pressure of at least one of said liquid components.

10

42. The method of claim 41, wherein more than one liquid component is present within said container and said pressure in said surrounding is lowered to at least said vapour pressure, being the higher vapour pressure of the vapour pressures of said more than one liquid components.

15

43. The method of claim 41, wherein said leak testing is performed at room temperature.

44. The method of claim 41, wherein said pressure is monitored after reaching said vapour pressure.

20

45. The method of claim 36, wherein said pressure monitored is sampled at a first point in time for establishing said pressure reference signal, and said pressure monitored being sampled at a second subsequent point in time, said first signal being derived from said pressure monitored at said second subsequent point in time.

25

46. The method of claim 45, wherein said second signal is formed as a difference signal from said first signal and

30

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said reference signal.

47. The method of claim 46, wherein said pressure sampled at a first point in time is stored at least up to said
5 second point in time as an electrical signal.

48. The method of claim 45, further comprising providing a pressure measuring sensor in the surrounding of said container and operationally connecting said sensor to both
10 inputs of a difference forming unit at said first point in time, thereby generating a zero offset signal dependent from the output signal of said difference forming unit, storing said zero offset signal and compensating zero offset when
15 evaluating said pressure monitored at said second subsequent point in time.

49. The method of claim 45, further comprising storing said pressure monitored at said first point in time by means of an analogue to digital converter enabled for conversion at
20 said first point in time.

50. The method of claim 36, comprising simultaneously testing a batch of said containers as one container.

25 51. The method of claim 36, further comprising performing an impedance measurement at or at least adjacent to said part of said wall in said surrounding, particularly a resistance measurement with DC and enabling or disabling further increase of said pressure difference by the result
30 of said impedance measurement.

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52. The method of claim 36 or 37, further comprising providing a test cavity with a test chamber snugly fitting the outer shape of said container, thereby maintaining a residual volume at least adjacent said part for applying
5 said pressure difference.

53. The method of claim 36, further comprising providing a test cavity for said at least one container, said test cavity defining a test chamber significantly larger than the
10 volume of said at least one container.

54. The method of claim 36, further comprising providing a test cavity for said at least one container and cleaning said test cavity after a container therein has been detected
15 as leaking, said cleaning being performed by at least one of evacuating said cavity, flushing said cavity with a gas, and heating said cavity.

55. The method of claim 36, further comprising inline
20 testing a series of said containers in a set of test cavities and disabling testing in a test cavity of said set for at least one subsequent testing cycle if the container tested therein has turned out to be leaky.

25 56. The method of claim 36, further comprising increasing internal pressure of said at least one container by mechanically biasing at least a part of its wall inwardly when applying said pressure difference.

30 57. The method of claim 36, wherein the content of said container comprises water, and wherein said applying a pressure difference includes evacuating said surrounding to

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less than 20 mbar pressure.

58. The method of claim 36, further comprising:

initiating lowering pressure of said surrounding to
5 establish said pressure difference with a predetermined
suctioning power,

identifying for a large leak if said pressure monitored
does not reach a value according to said pressure reference
signal in a predetermined time, and

10 disabling further lowering of said pressure, if a large
leak is identified, otherwise continuing for testing on a
smaller leak.

59. The method of claim 58, said disabling comprising
15 disconnecting a pumping arrangement from the surrounding of
said at least one container.

60. The method of claim 59, further comprising the step of
switching from one pumping arrangement for said lowering the
20 pressure of said surrounding of said at least one container
to another pumping arrangement for subsequent testing, once
a large leak has been identified.

61. The method of claim 59, further comprising disabling a
25 test cavity for said testing for at least one subsequent
testing cycle, once testing with said test cavity has led to
identifying a large leak.

62. The method of claim 61, further comprising
30 reconditioning said test cavity during said at least one
subsequent testing cycle.

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63. The method of claim 62, further comprising performing said reconditioning by at least one of heating said test cavity, gas purging and liquid purging said test cavity.

5 64. The method of claim 63, further comprising checking whether said test cavity is properly reconditioned by performing said leak testing at said test cavity emptied from any container to be tested.

10 65. The method of claim 36, further comprising establishing said pressure reference signal from a pressure monitored at a test cavity void of any container.

15 66. The method of claim 36, further comprising providing at least one test cavity and calibrating said pressure monitored by performing said leak testing at said test cavity void of any container and connected to a reference leak arrangement.

20 67. The method of claim 66, further comprising providing said reference leak arrangement by a needle valve connected to a reservoir containing a liquid being controllably pressurized.

25 68. The method of claim 67, said reservoir containing distilled water.

30 69. The method of claim 68, comprising controlling said reference leak arrangement to prevent liquid from leaking therefrom and to enable vapour of said liquid to transit therefrom.

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70. The method of claim 36, wherein said surrounding is in a test cavity and further performing said leak testing in said test cavity on differently sized containers.

5 71. The method of claim 36, further comprising heating the surrounding of said at least one container to a predetermined temperature during testing.

72. The method of claim 36, further comprising performing a
10 testing operation for identifying larger leaks of said at least one container previously to performing said leak testing.

73. The method of claim 36, wherein said container is
15 selected from the group consisting of blisters, vials, mechanical application containers, and foodstuff containers, beverage containers and tanks.

74. A method for manufacturing closed, unleaky containers
20 comprising: manufacturing closed containers; subjecting at least one of said containers to test conditions and thereby monitoring a signal, which is dependent on leak condition of said container; generating at least one signal derived from said signal monitored; comparing said signal
25 derived with a dynamic threshold value for identifying leak condition of said container; enabling a further signal derived from said signal monitored to be averaged with similar further signals of other containers previously tested as unleaky, if said leak condition identifying of
30 said container now under test reveals an unleaky container; deriving said threshold

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value from the result of said averaging; identifying said one container as unleaky in dependency of a result of said comparing.

5 75. The method of claim 74, further comprising sampling at a point in time said signal monitored to generate a measuring signal and selecting said further signal derived to be said measuring signal.

10 76. The method of claim 75, further selecting said measuring signal to be said signal derived.

77. The method of claim 76, including generating said measuring signals as electrical signals and storing said one
15 measuring signal at least up to said further point in time.

78. The method of claim 75, further comprising storing said measuring signal by means of an analogue to digital converter enabled for conversion at said point in time.

20

79. The method of claim 77, including reconvertng the digital output signal of said analogue to digital converter into an analogue signal.

25 80. The method of claim 74, further generating a result signal of said comparing, further comparing said result signal of said comparing with a further dynamic threshold value for identifying a further leak condition of said container, enabling a still further signal derived from said
30 result signal to be averaged with still further signals of other containers previously tested, if identifying said further leak condition of said container now under test

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reveals an unleaky container, and deriving said further threshold value from the result of said further averaging.

81. The method of claim 74, further comprising
5 simultaneously testing a batch of said containers as one container.

82. The method of claim 74, wherein said test conditions
comprise pressurizing said container with respect to its
10 surrounding and performing an impedance measurement at or
at least adjacent an outside surface of said container,
particularly a resistance measurement with DC, and enabling
or disabling further pressurizing of said container by the
result of said impedance measurement.

15

83. The method of claim 74, said subjecting comprising
providing a test cavity with a test chamber snugly fitting
the outer shape of said container, thereby maintaining a
residual volume between said container and said test cavity.

20

84. The method of claim 74, wherein said subjecting
comprises providing a test cavity for said container, said
test cavity defining for a test chamber significantly larger
than the volume of said container.

25

85. The method of claim 74, wherein said subjecting
comprises providing a test cavity for said container and
cleaning at least said test cavity after a container therein
has been detected as leaky, said cleaning being performed by
30 at least one of evacuating said cavity, flushing said cavity
with a gas, and heating.

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86. The method of claim 74, further comprising inline testing a series of said containers in a set of test locations and disabling testing in a testing location for at least one testing cycle, if the container previously tested
5 therein has turned out to be leaky.

87. The method of claim 74, said subjecting comprising varying internal pressure of said one container.

10 88. The method of claim 87, wherein said varying comprises increasing said internal pressure.

89. The method of claim 88, wherein said increasing is performed by mechanical biasing at least a part of the wall
15 of said container inwardly.

90. The method of claim 74, said subjecting comprising initiating pressure loading the wall of said container, identifying for a large leak, if said signal derived does
20 not reach said threshold value in a predetermined time, disabling further loading of said container wall, monitoring a change of said signal monitored during a further predetermined time and identifying a small leak or no leak dependent on the extent of said change.

25

91. The method of claim 74, said subjecting further comprising pressure loading said container and disabling said loading, if said signal derived does not reach said threshold value at a predetermined time.

30

92. The method of claim 74, wherein said subjecting further comprises subjecting said container to test conditions

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within a test cavity and disabling said subjecting for at least one further testing cycle, if a leaky container is detected in said test cavity.

5 93. The method of claim 92, further comprising reconditioning said test cavity during said at least one testing cycle.

94. The method of claim 92, further comprising performing
10 said reconditioning by at least one of heating, gas purging and liquid purging.

95. The method of claim 93, further comprising checking whether said test cavity is properly reconditioned by
15 applying at least a part of said test conditions to said test cavity emptied from a container to be tested.

96. The method of claim 74, wherein said subjecting comprises subjecting said container to test conditions
20 within a test cavity and further comprising subjecting said container to test conditions previously to applying test conditions within said test cavity for identifying a larger leak of said container previously to subjecting said container to test conditions within said test cavity.

25

97. The method of claim 74, further comprising providing a set of testing locations, said threshold value being a common threshold value for identifying leak condition of containers in said testing locations.

30

98. The method of claim 74, wherein said container is selected from the group consisting of blisters, vials,

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mechanical application containers, foodstuff containers, beverage containers and tanks.

99. The method of claim 74, wherein said method is for
5 permanently testing tanks for leakage.

100. A leak testing apparatus for leak testing at least one closed container comprising at least one testing station generating an output signal at an output, which is dependent
10 on leak condition of a container introduced therein, said output of said testing station being operationally connected to an input of an evaluation unit, said evaluation unit comprising at least one comparator unit, one comparator unit input thereof being operationally connected to said input, a
15 second input of said comparator unit being operationally connected to a controllable dynamic threshold value unit, an averaging unit controllably operationally connected to said input of said evaluation unit, said evaluation unit generating a leak-identifying signal, said leak-identifying
20 signal controlling said operational connection between said input of said evaluation unit and said averaging unit, the output of said averaging unit controlling said controllable threshold value unit.

25 101. The apparatus of claim 100, wherein said testing station comprises a pressurizing member operationally connected with a container to be tested within said testing station.

30 102. The apparatus of claim 100, further comprising a storage unit operationally connected to said input of said evaluation unit and a difference-forming unit, one

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difference-forming unit input thereof being operationally connected to the output of said storage unit, the second input thereof being operationally connected to said input of said evaluation unit, a timing unit operationally connecting
5 the input of said evaluation unit at a first point in time to the input of said storage unit, and operationally connecting at the second point in time the output of said storage unit to said one input of said difference-forming unit and the input of said evaluation unit to said other
10 input of said difference-forming unit.

103. The apparatus of claim 102, wherein said storage unit comprises an analogue to digital converter, said timing unit being operationally connected to the conversion control
15 input of said analogue to digital converter.

104. The apparatus of claim 103, further comprising a digital to analogue converter operationally connected to the output of said analogue to digital converter, the output of
20 said digital to analogue converter being operationally connected to said difference-forming unit.

105. The apparatus of claim 102, further comprising a further storage unit operationally connected to the output
25 of said difference-forming unit and being enabled at said second point in time, the output of said further storage unit being operationally connected to the output of said difference-forming unit.

30 106. The apparatus of claim 100, wherein said testing unit comprises a test cavity with a shape snugly fitting said at least one container and comprises sustaining means at its

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inner wall to maintain a free space between the wall of said container and the wall of said test cavity, once the volume therebetween is lowered.

5 107. The apparatus of claim 106, further comprising at least one pair of impedance measuring electrodes within said cavity connected to an impedance measuring unit, the output thereof switchingly enabling and disabling said testing unit.

10

108. The apparatus of claim 100, wherein said testing unit comprises a test cavity large enough to receive a multi-container batch of said containers.

15 109. The apparatus of claim 100, wherein said testing unit comprises a test cavity which is significantly larger than said container and thus is apt to flexibly receive differently shaped and different-volume containers.

20 110. The apparatus of claim 100, wherein said testing unit comprises a test cavity, which comprises a removable cover and at least a pair of seals around the opening opened by said cover, the space between said two seals being pumped.

25 111. The apparatus of claim 100 for inline testing a multitude of containers, further comprising a set of test cavities to which a respective number of containers is fed for testing and further comprising control means to prevent a test cavity being filled with at least one container to be
30 tested, once the container previously tested therein has been detected as leaky.

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112. The device of claim 100, wherein said testing unit comprises at least one test cavity and further comprises at least one cleaning gas line abutting into said cavity and being connected to a cleaning gas or liquid tank.

5

113. The apparatus of claim 100, comprising a multitude of testing units arranged on a carousel for conducting inline leak testing of multiple containers.

10 114. A method for manufacturing unleaky containers comprising: manufacturing containers; subjecting at least one of said containers to test conditions and thereby monitoring a signal which is dependent on leak condition of said container; generating at least one signal derived from
15 said signal monitored; further monitoring whether said signal derived from said signal monitored is, or is not, within a dynamic signal range; identifying said one container as unleaky in dependency of a result of said further monitoring; and enabling a further signal derived
20 from said signal monitored to update said dynamic range if said result of said identifying reveals that said container is unleaky.

115. The method of claim 114, including forming a difference
25 signal of said signal monitored and at least one reference signal and updating a further dynamic range by said difference signal, said dynamic range being dependent from said further dynamic range.

30 116. The method of claim 115, including forming said dynamic range by a result signal of adding said further dynamic

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range to a constant signal value.

117. The method of claim 115, further comprising
establishing said at least one reference signal as a dynamic
5 reference signal.

118. The method of claim 117, including establishing said
dynamic reference signal by averaging a signal dependent on
said signal monitored if the actual container under test is
10 identified as unleaky with such signals dependent on
containers previously identified as unleaky.

119. The method of claim 115, wherein a signal dependent on
said signal monitored is sampled at a first point in time
15 for establishing said reference signal and said signal
dependent is sampled at a second subsequent point in time,
said signal derived being derived from said signal dependent
sampled at said second subsequent point in time.

20 120. The method of claim 119, wherein said signal derived
from said signal dependent is derived from a difference
signal from said signal dependent and said reference signal.

121. The method of claim 119, wherein said signal dependent
25 sampled at said first point in time is stored at least up to
said second point in time as an electrical signal.

122. The method of claim 121, wherein said signal dependent
sampled at said first point in time is stored by means of an
30 analog to digital converter enabled for conversion at said
first point in time.

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123. The method of claim 114, including simultaneously identifying a batch of containers as said container.

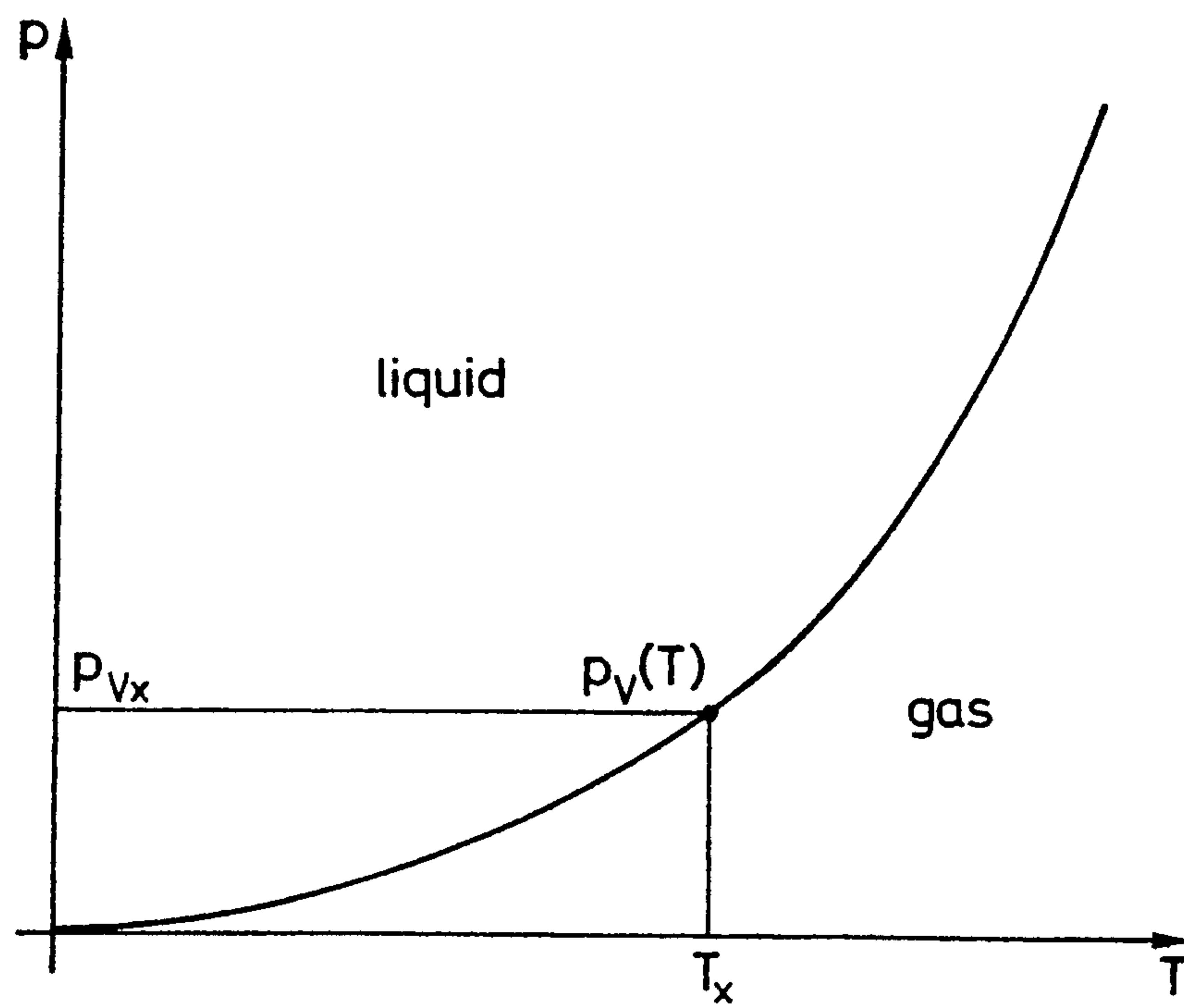


FIG.1

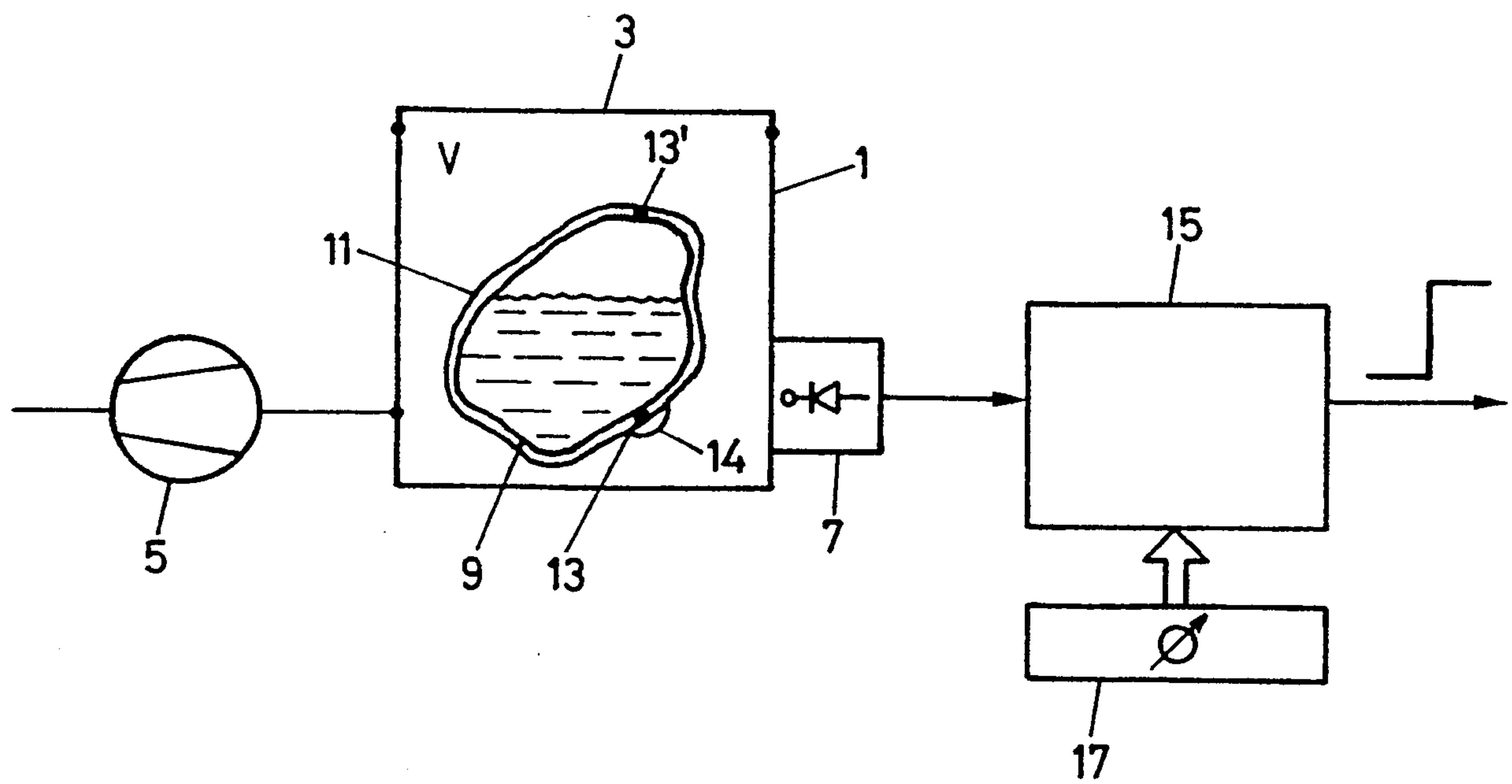


FIG.2

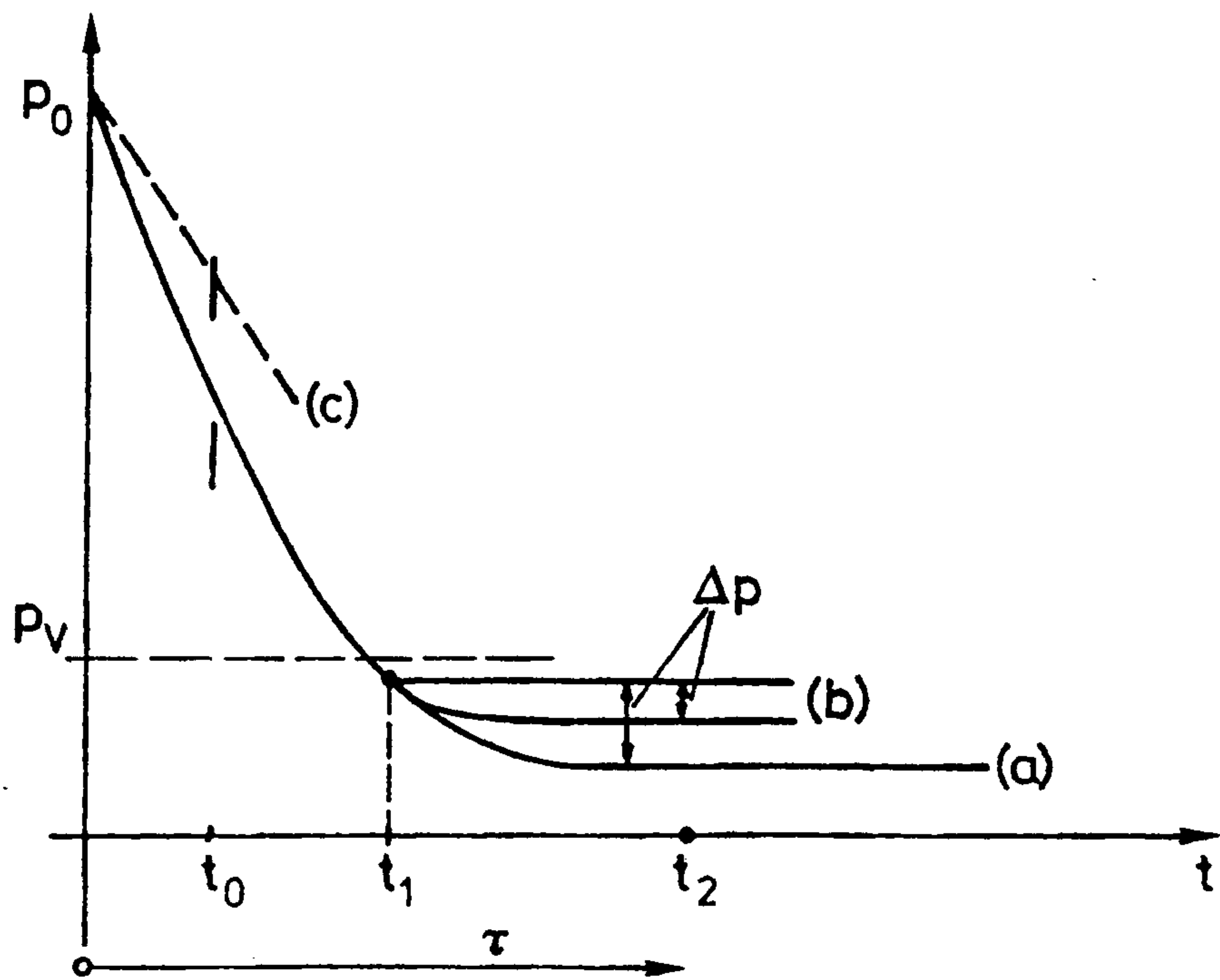


FIG. 3

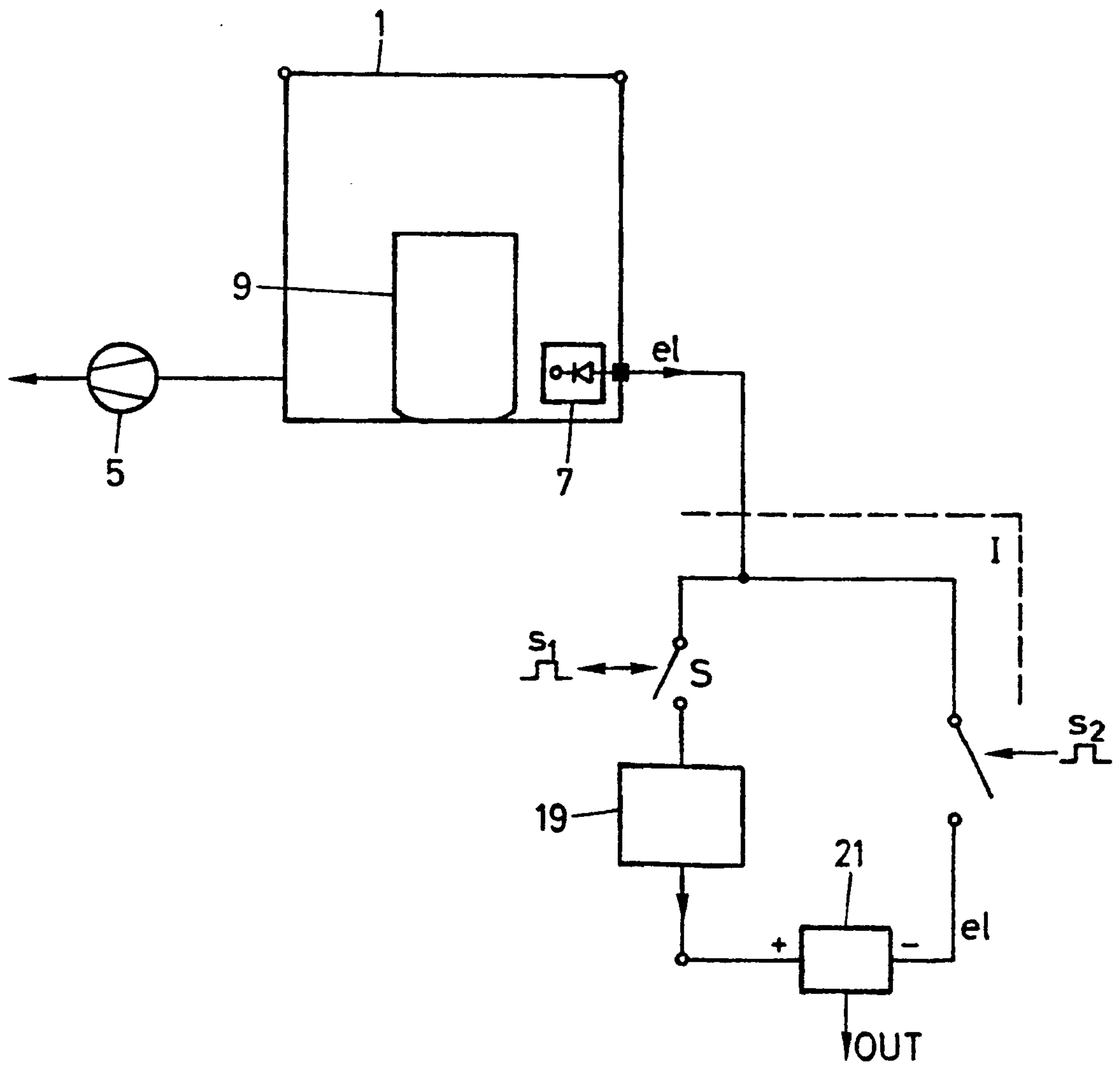


FIG. 4

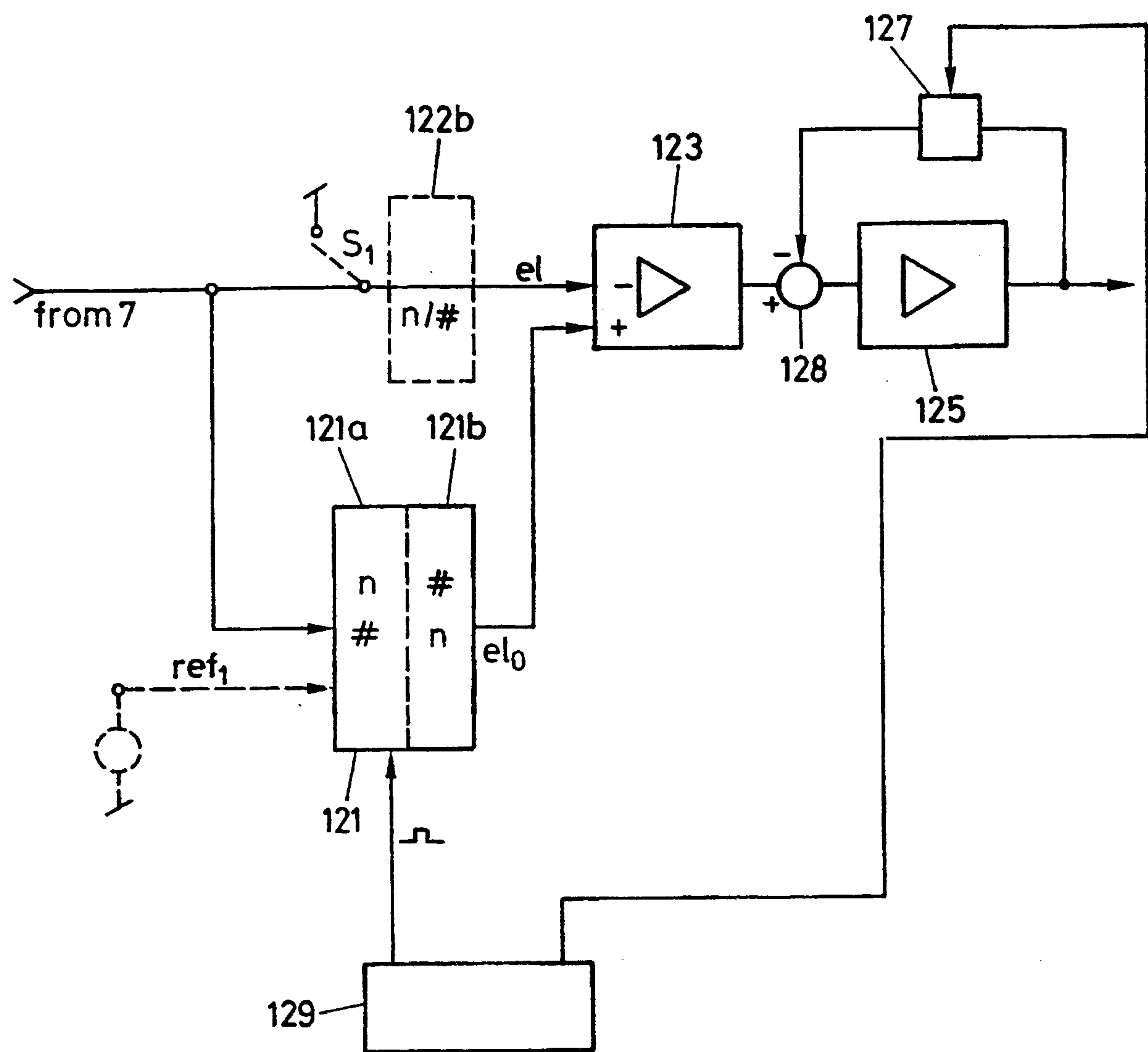


FIG.5

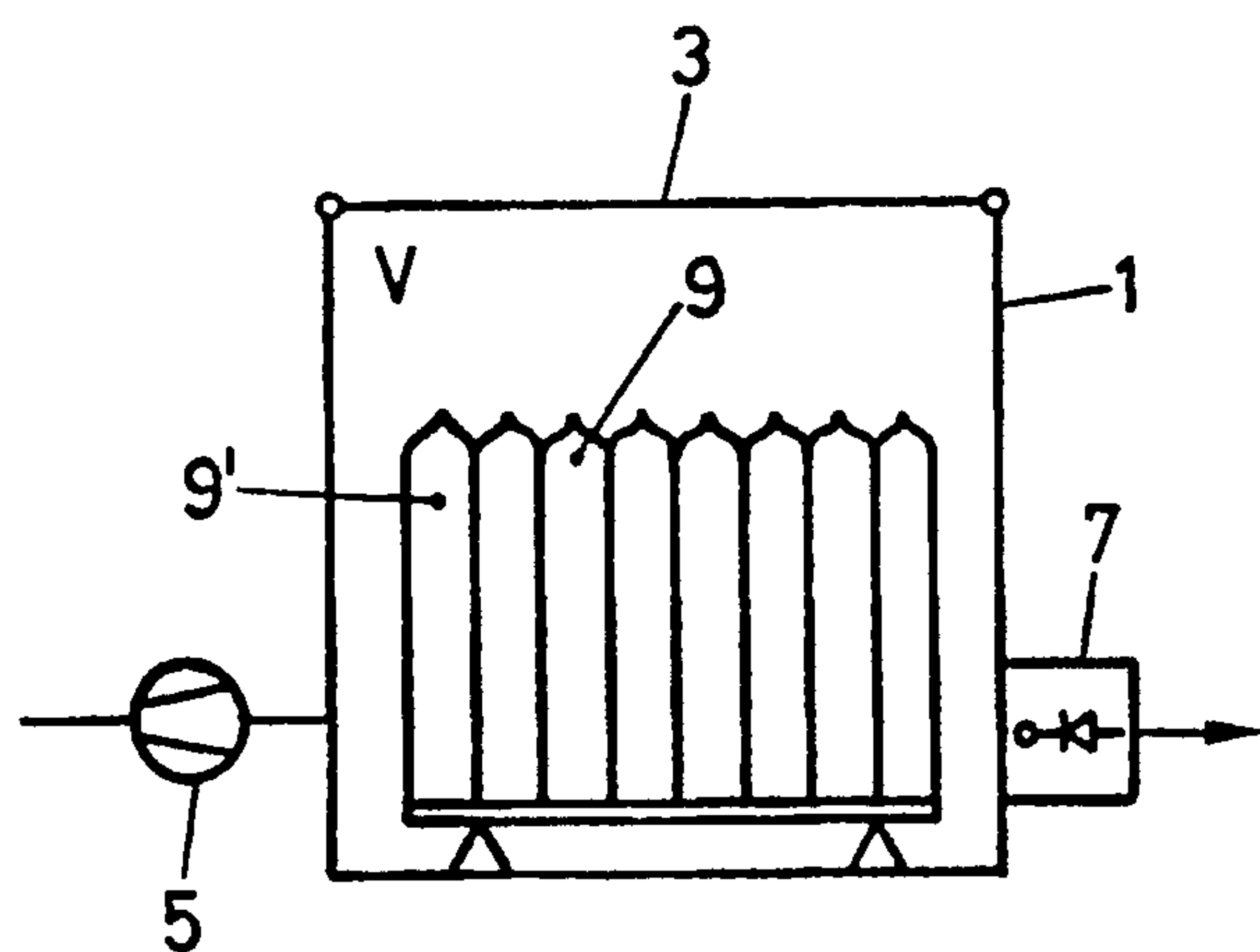


FIG.6

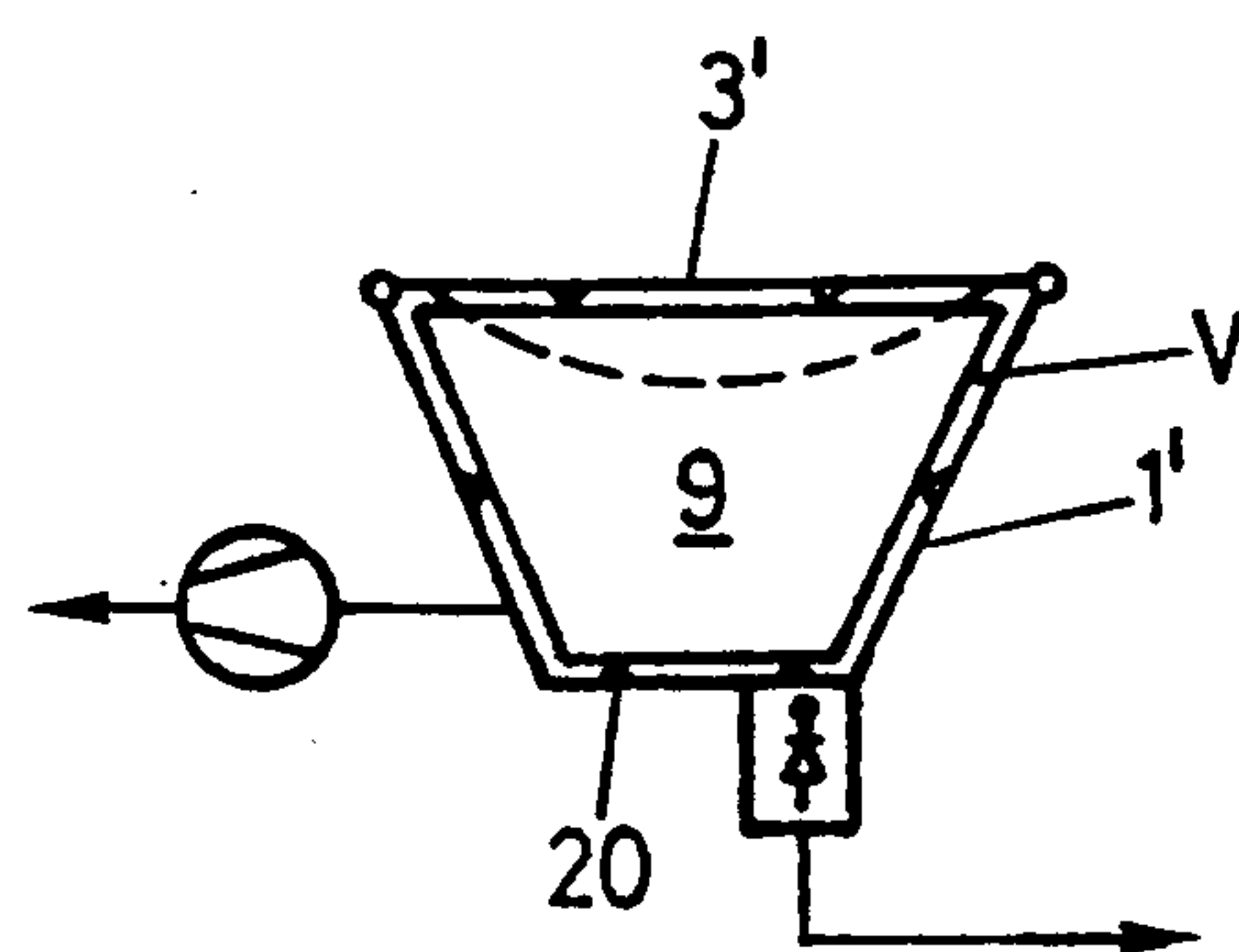


FIG.7

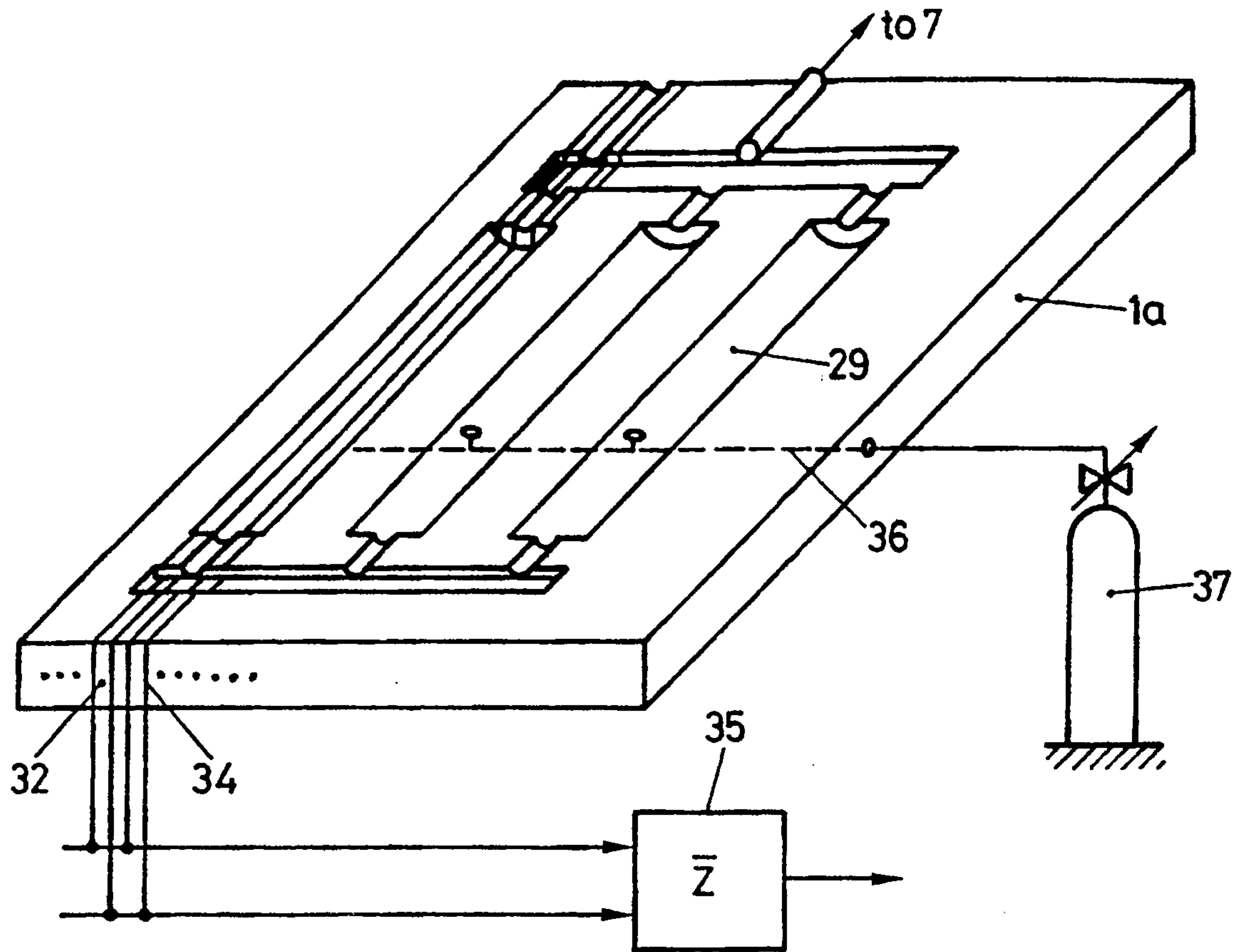


FIG. 8

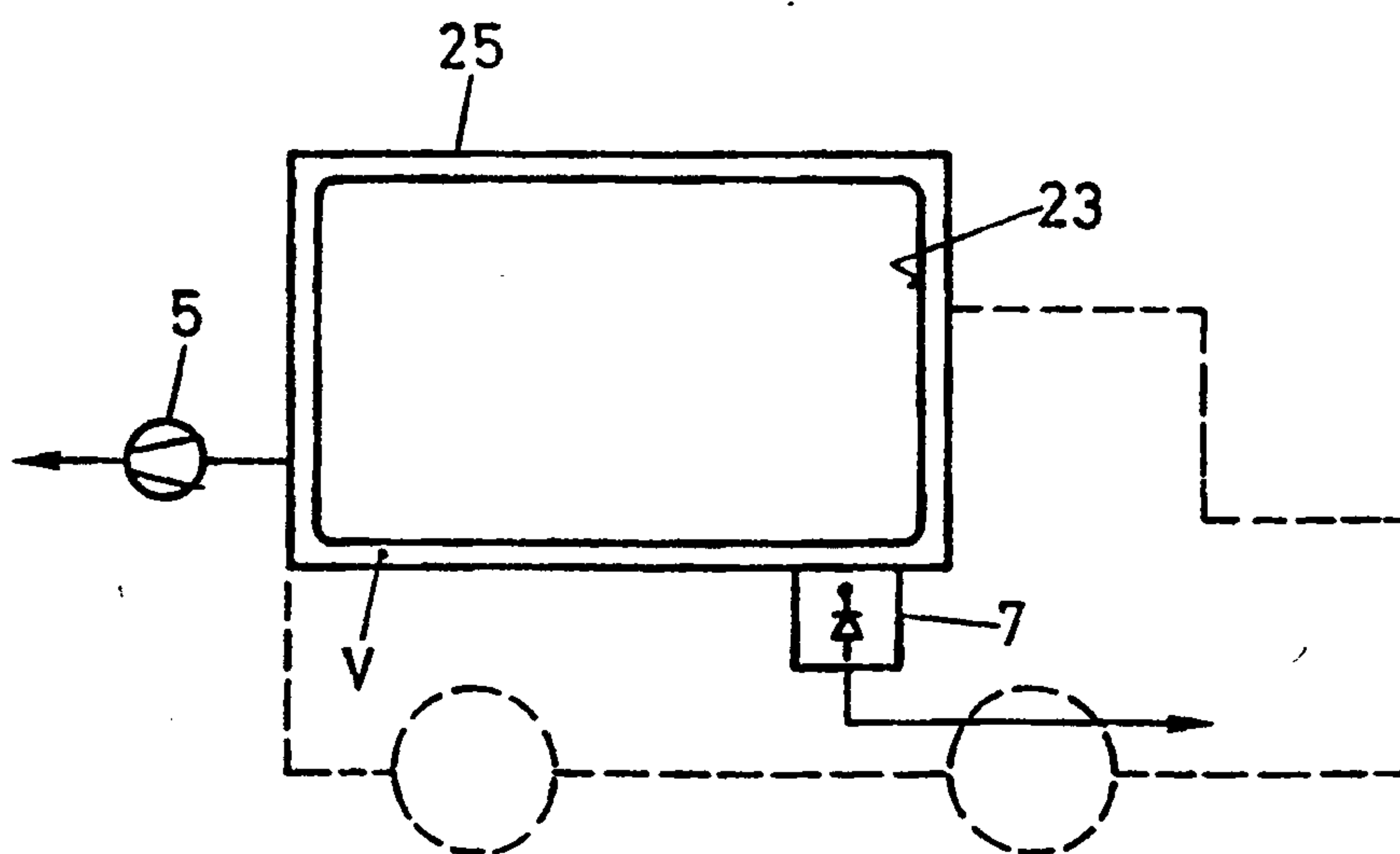


FIG. 9

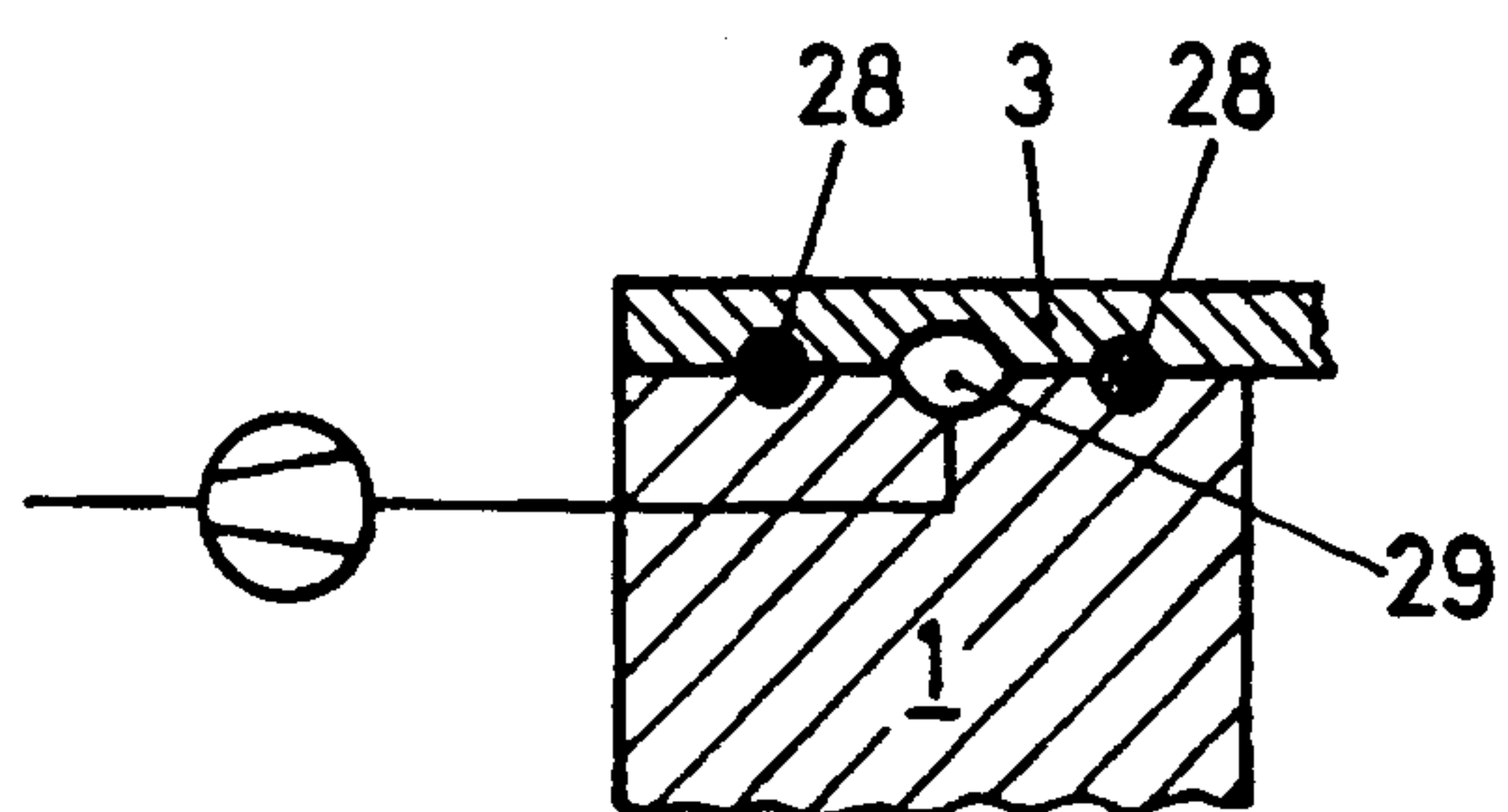


FIG. 10

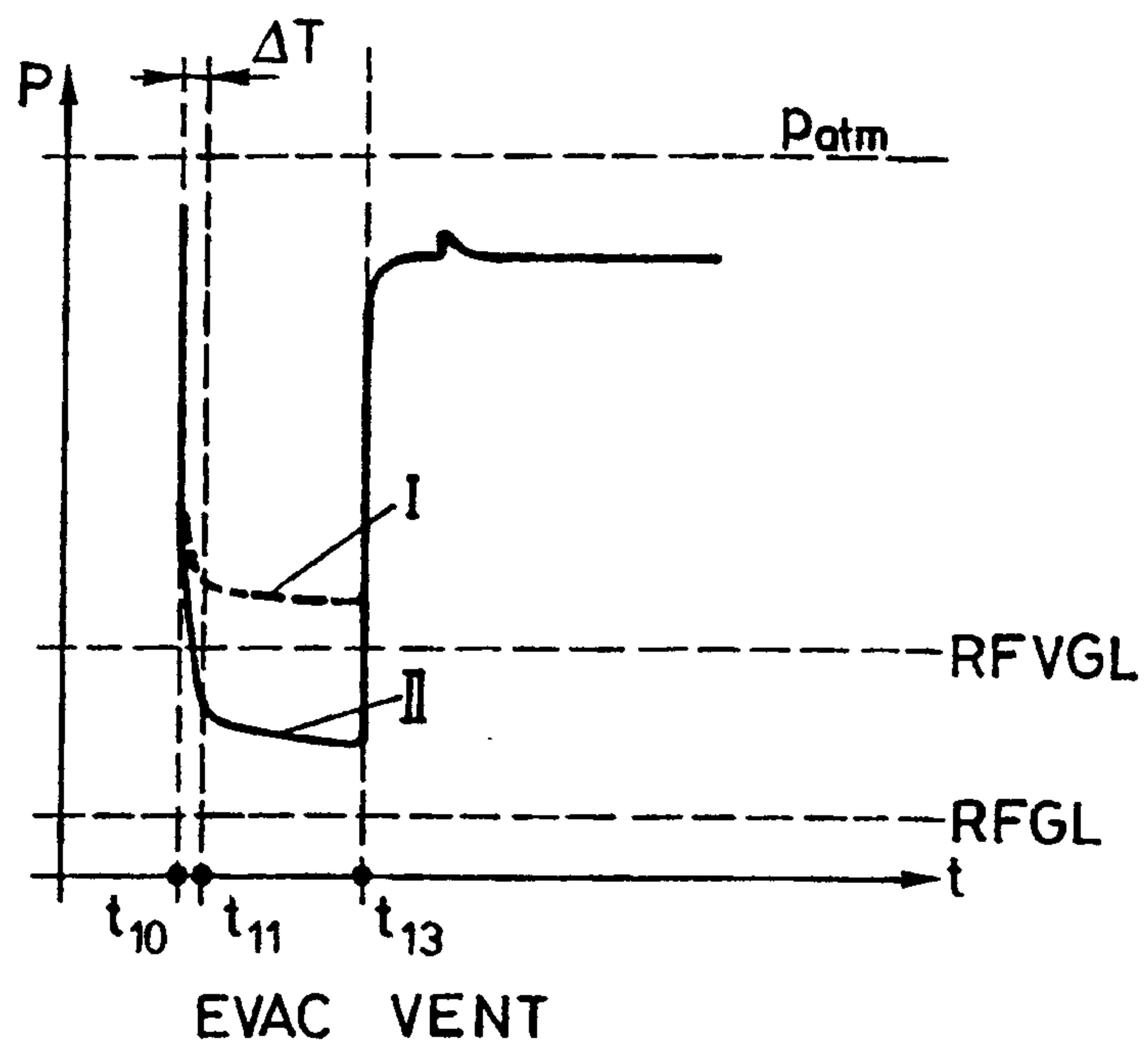


FIG. 11a

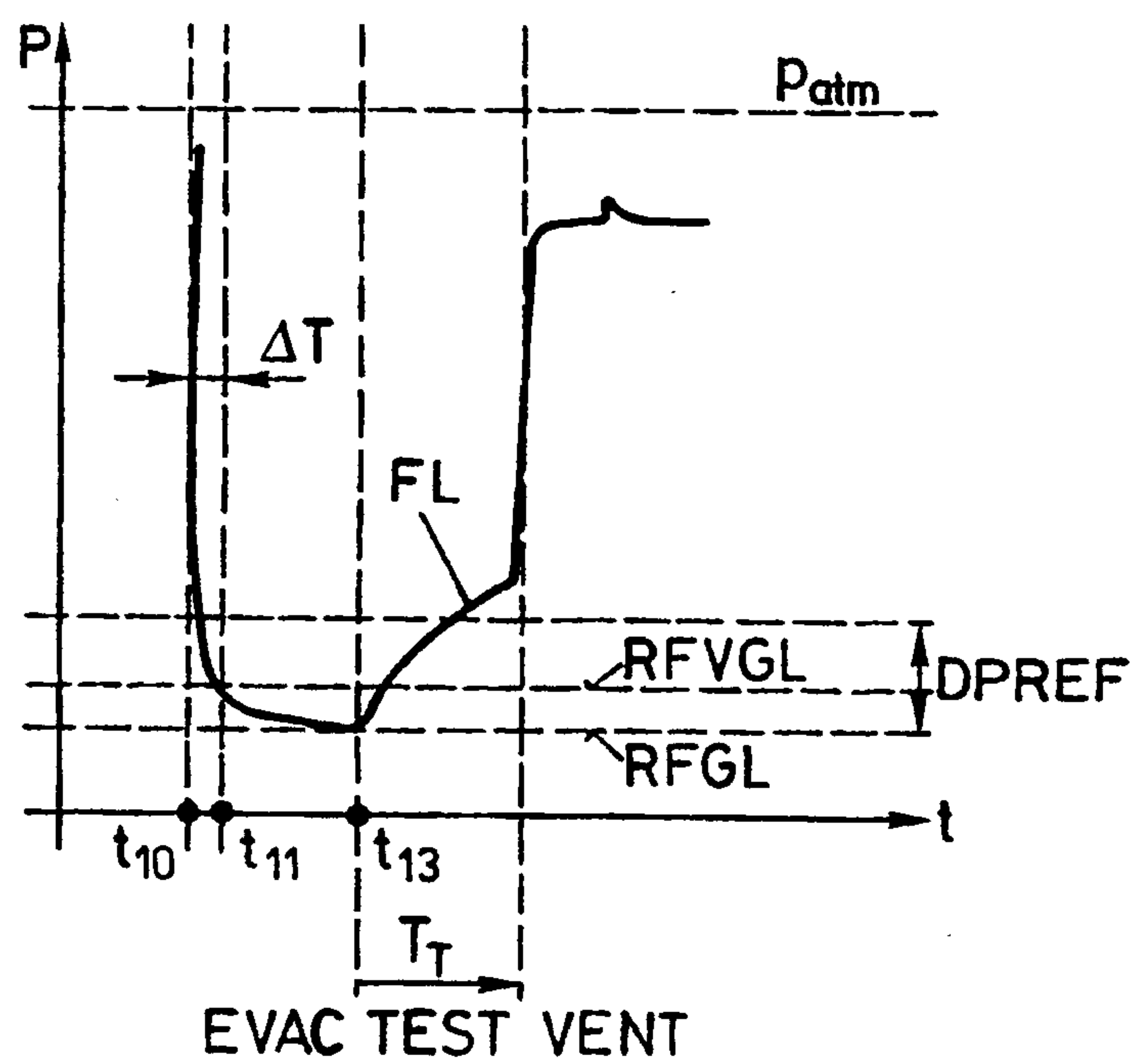
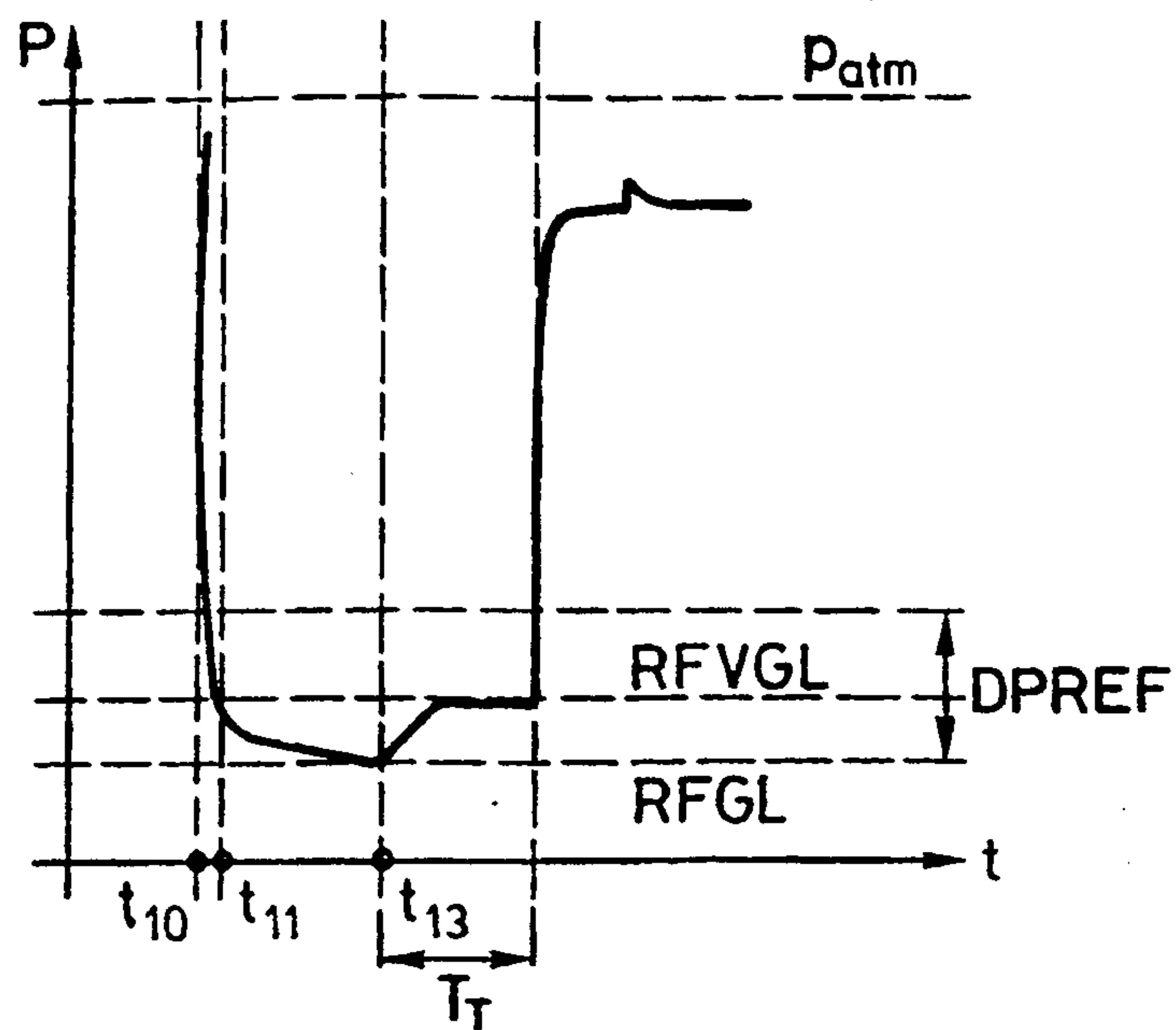


FIG. 11b



EVAC TEST VENT

FIG.11c

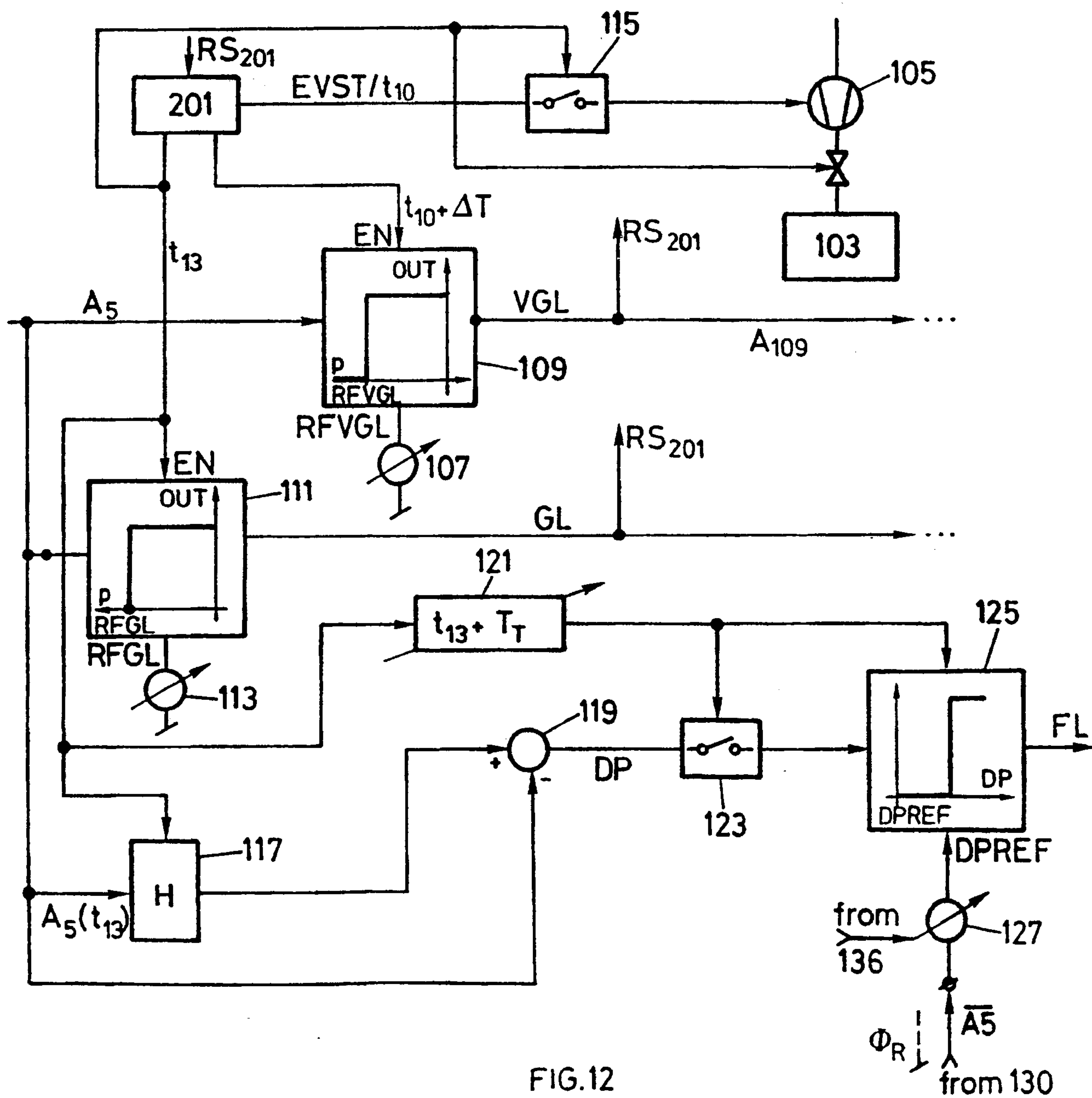


FIG.12

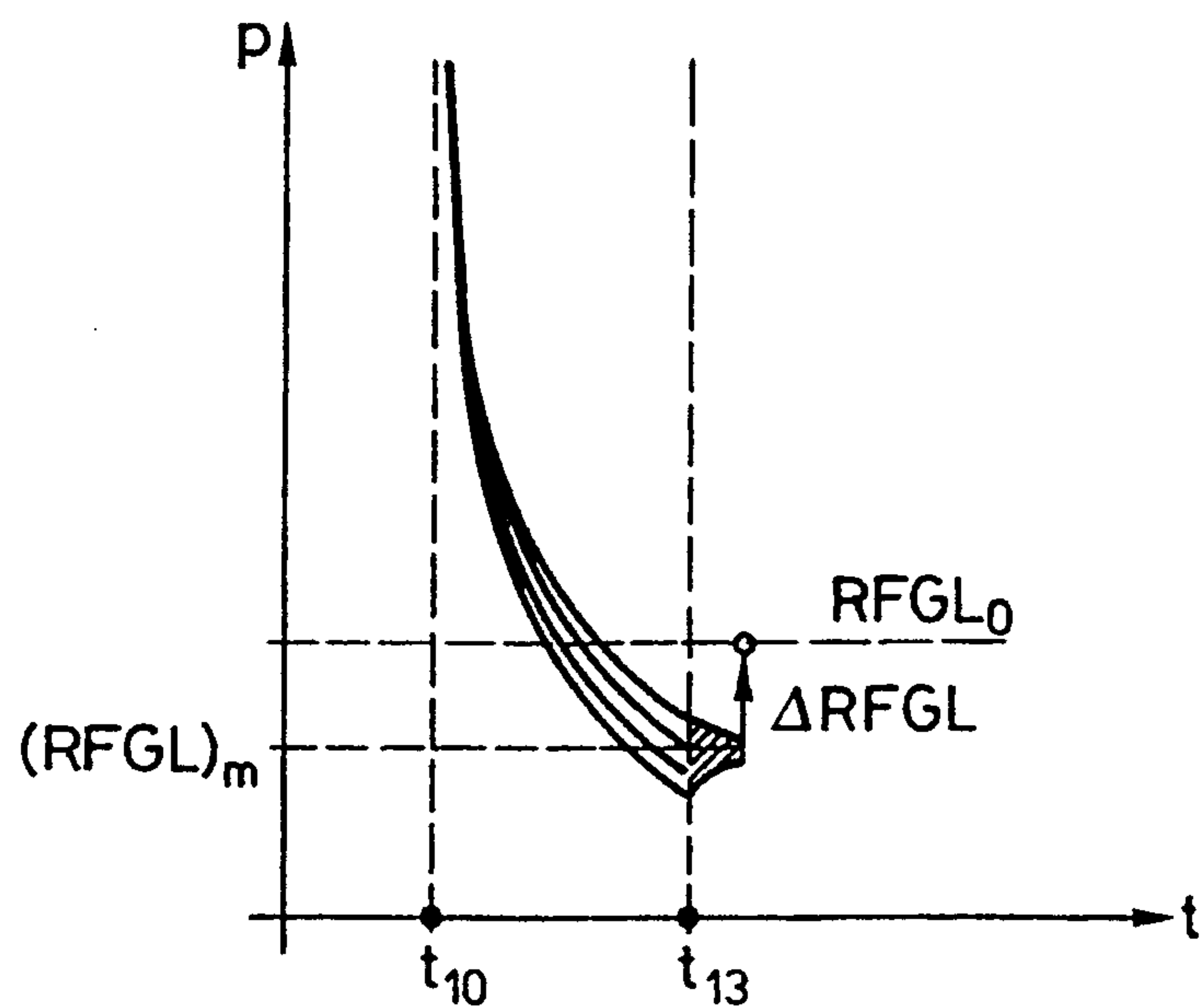


FIG.13

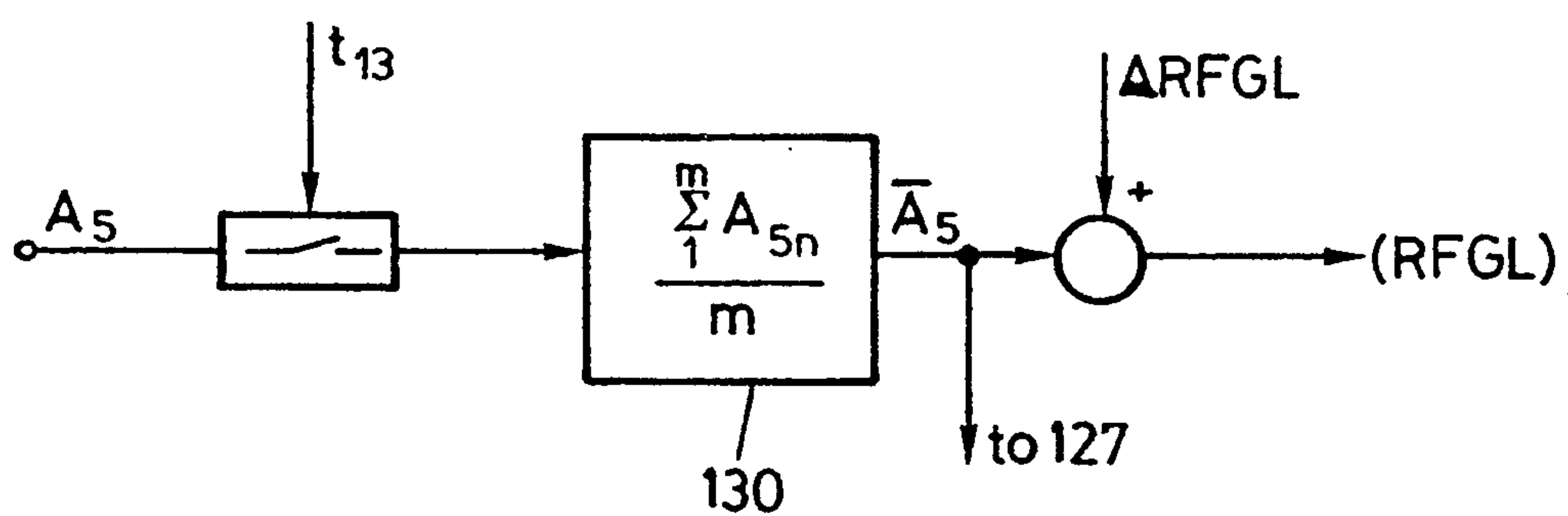


FIG.14

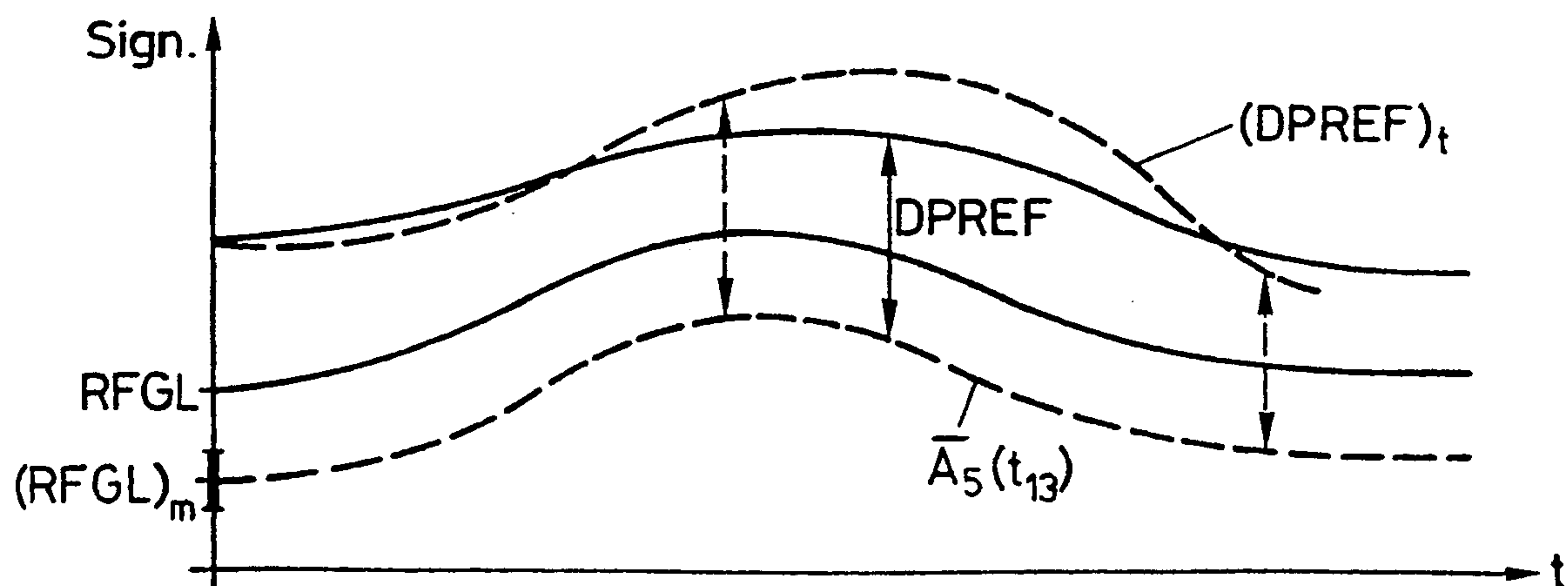


FIG.15

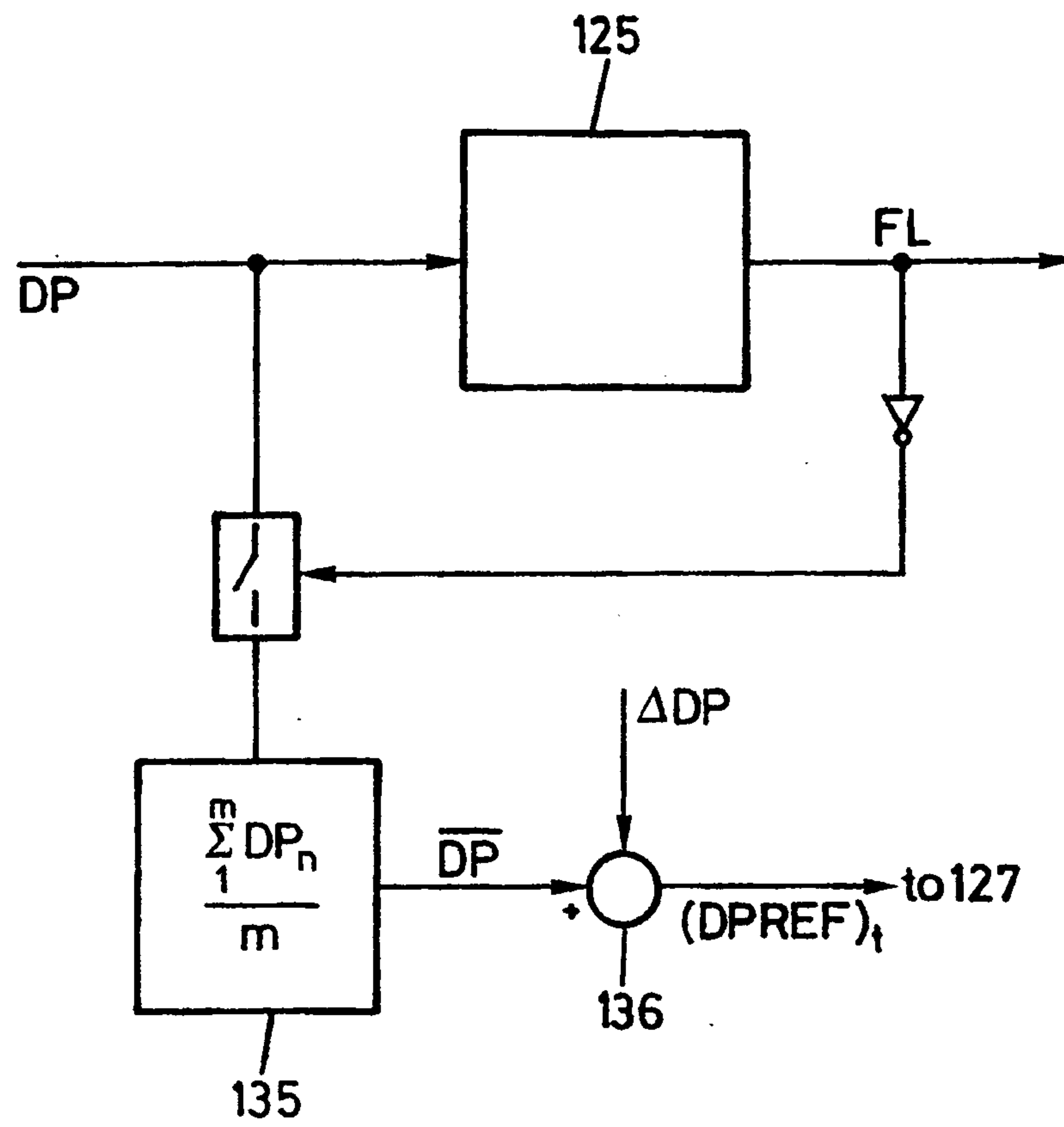


FIG.16

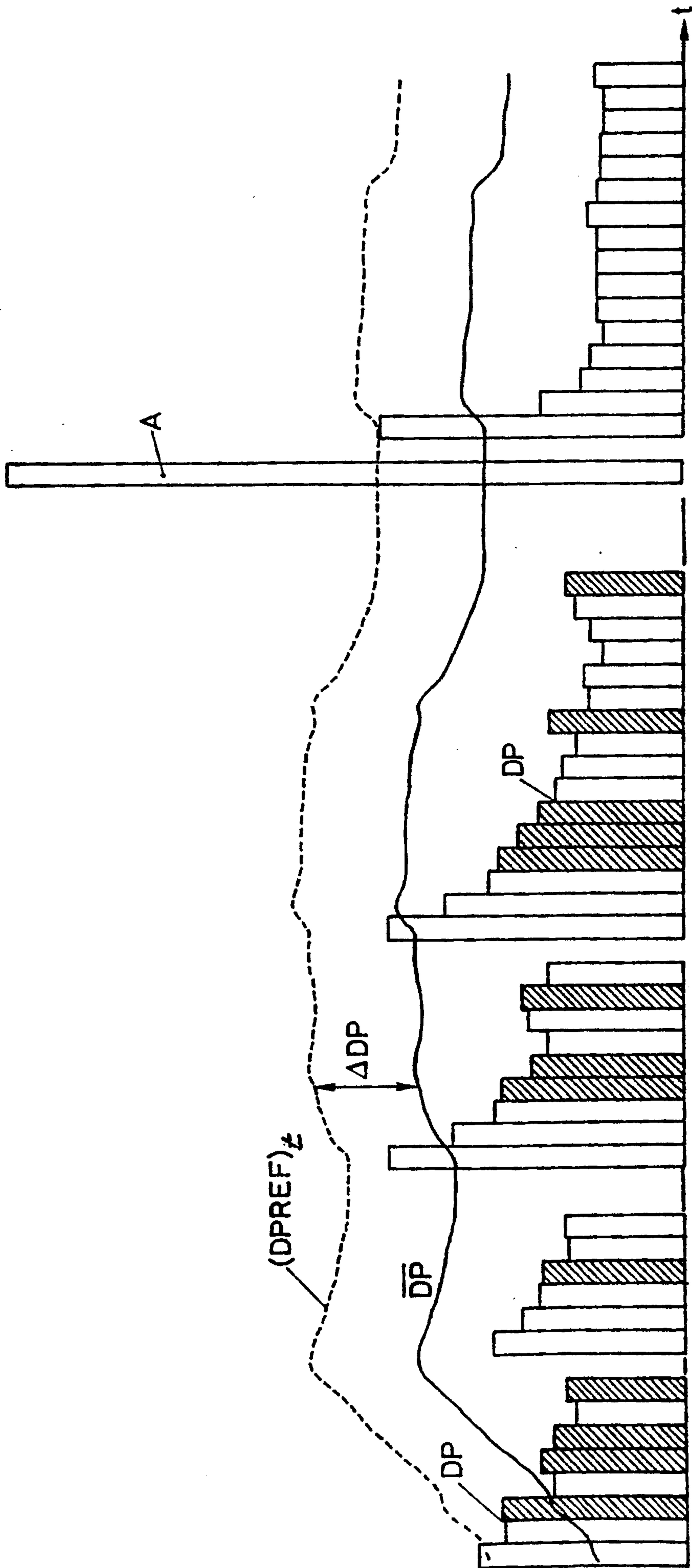


FIG.17

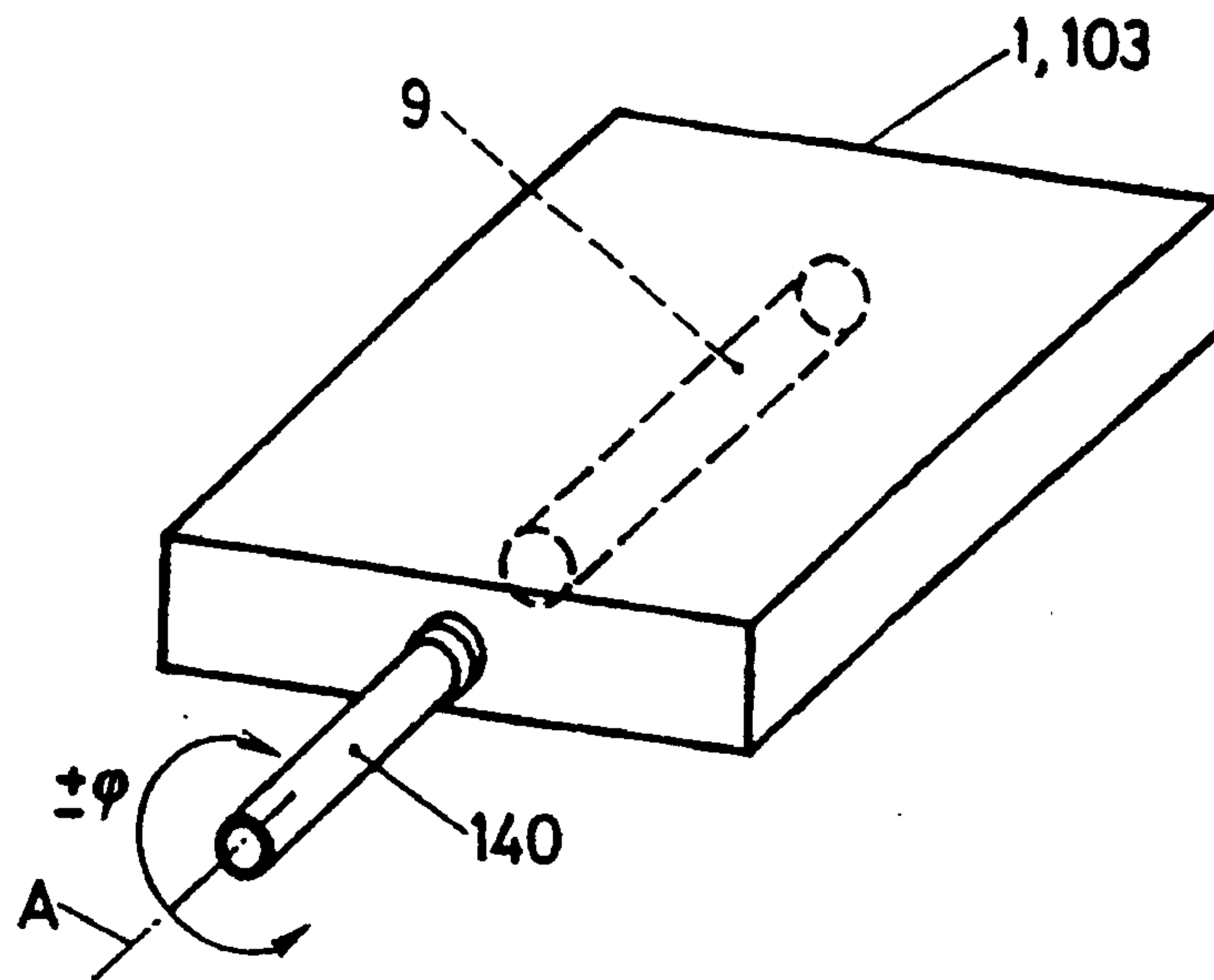


FIG. 18

FIG. 19a

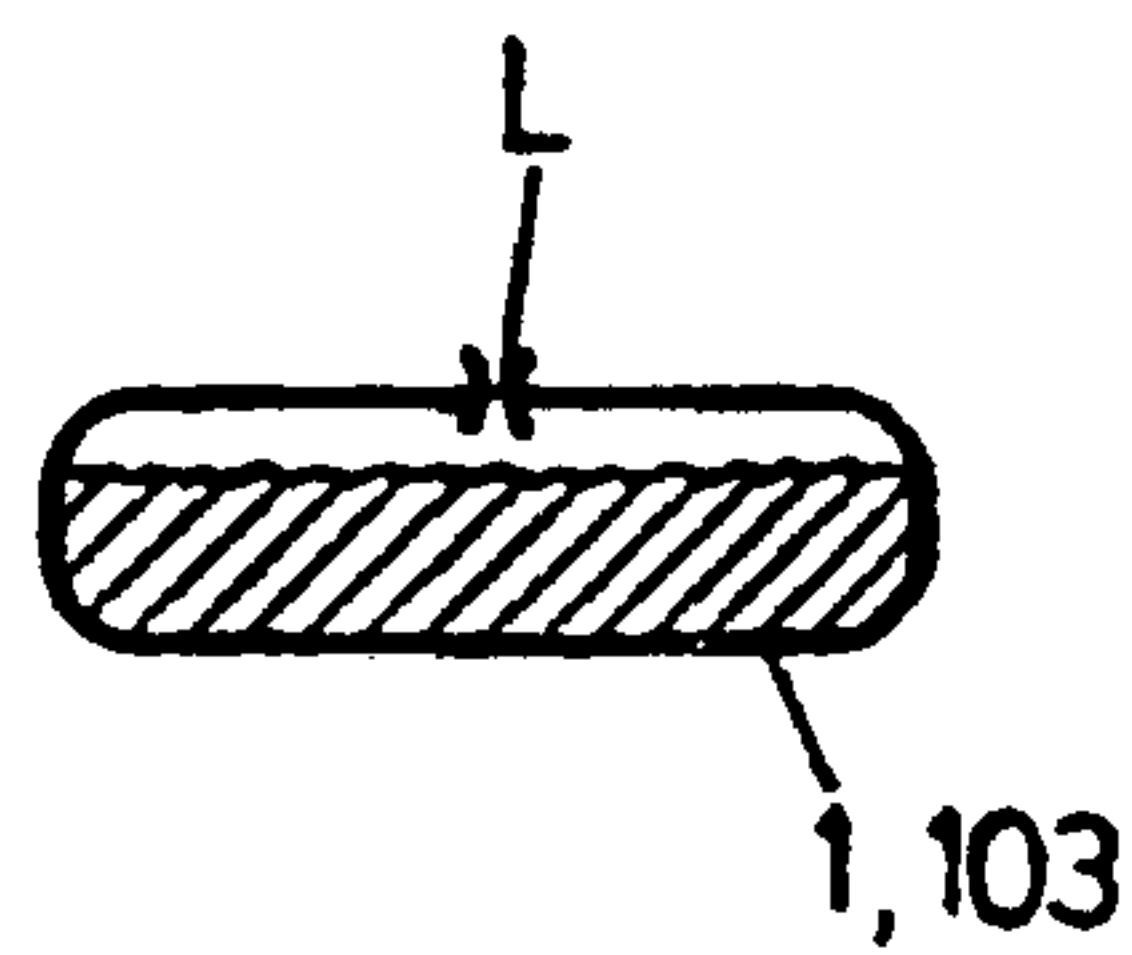


FIG. 19b

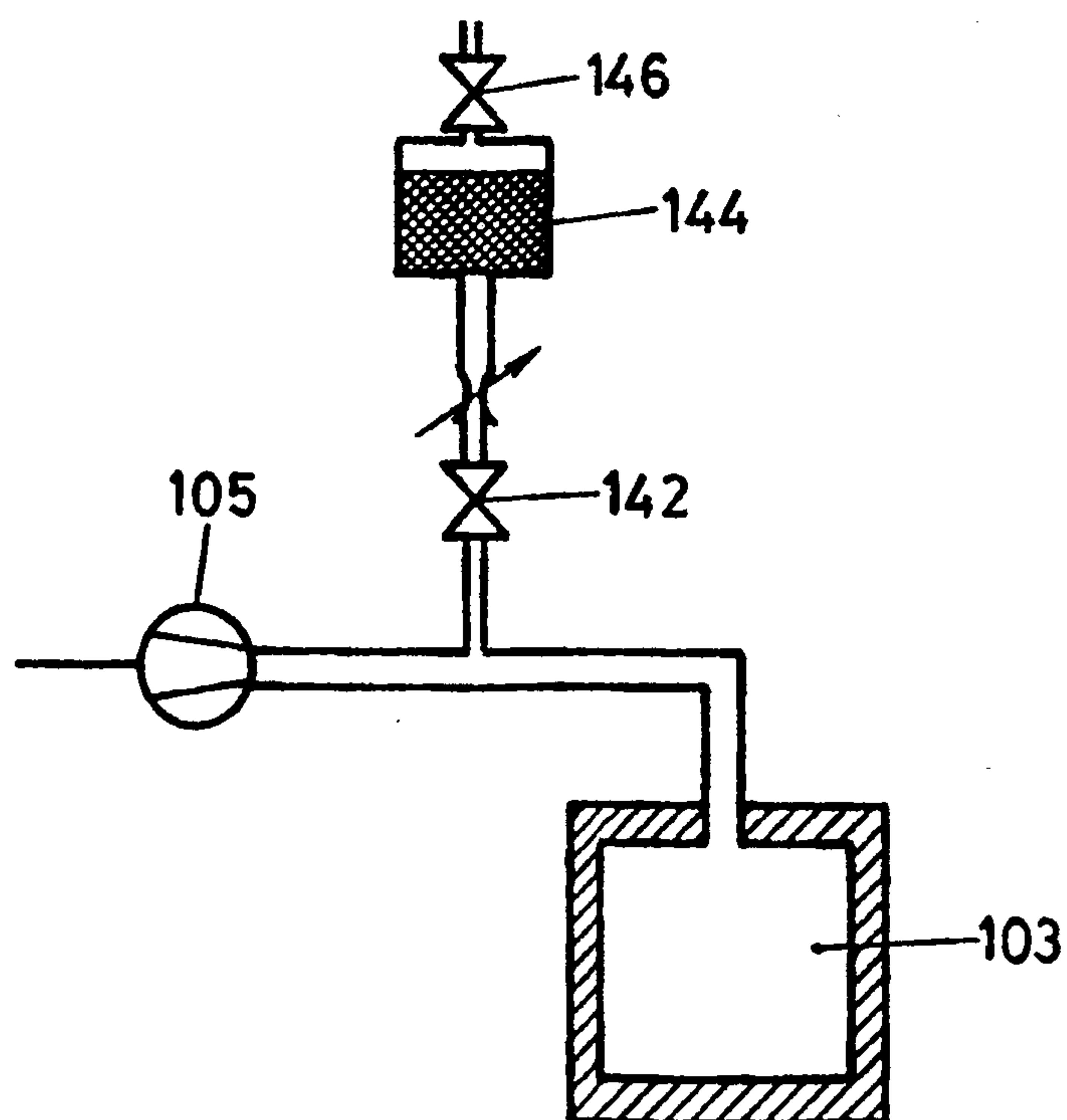
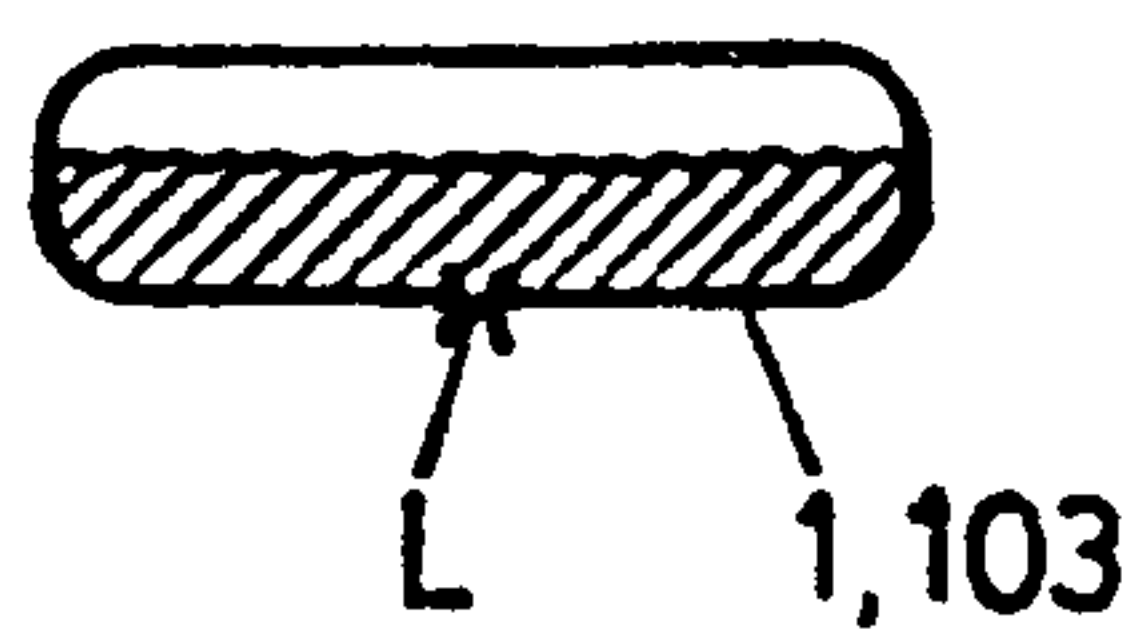


FIG. 20
SUBSTITUTE SHEET (RULE 26)

