

Micro-Bulk Purifiers

Long-Lasting Gas Purifiers for Moderate Flow Rates

At ARM Purification, we know that longevity matters when it comes to your moderate flow rate applications. That's why we are committed to delivering a full suite of micro-bulk purifiers that meet your precise requirements and maximize life span.

ARM's micro-bulk purifiers offer moderate flow rates, serving high purity and permanently installed gas delivery systems.

Whether a micro-bulk gas purifier, pressure regulator station, or flow control panel, ARM's cost-effective micro-bulk purifier solutions are designed to meet the specific requirements of any gas delivery system by allowing for customization of critical features.

Our Suite of Micro-Bulk Gas Purifiers

Vessels

Operate without requiring heat to remove impurities.

Advantage™ Micro-Series

Require a heated technology or automated regeneration.

- Heated Getter
- Heated Catalyst
- Dual Vessel



Micro-Bulk purifiers typically offer a moderate flow rate serving a lab or production work cell through high purity, permanently installed plumbing to each point-of-use. This brochure outlines the features, benefits, and performance of ARM's Micro-Bulk purifiers.

ARM purifiers are categorized into three groups. The primary distinction is based on flow rate of the gas being purified. The following is offered as a general rule:

At-a-Glance

FEATURES

- Nominal flow rates from 100 to 1200 slpm
- Powder coated steel enclosure
- 316L stainless steel construction
- Pressure to 20.5 MPa
- Full integrated PLC control
- Touchscreen HMI

OPTIONS

- Flow indication
- Bypass valve
- Inlet/outlet connections
- Air-operated or manual valve options
- 100-120/220-240VAC 50/60Hz input power options

APPLICATIONS

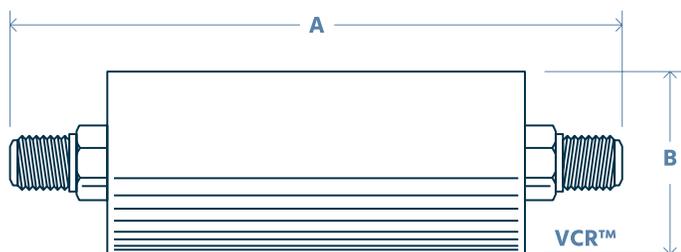
- High production rate weld gas/purge gas
- Pharmaceutical production
- Glove box purge gas
- Additive manufacturing
- Annealing cover gas
- Moderate volume high and ultra high purity applications

Category	Flow Rate
Point-of-Use	0.1-100 slpm
Micro-Bulk	100-1200 slpm
Bulk	60->5000 nm ³ /hr

Vessels Only

Many gas/impurity combinations can be effectively purified with an ambient temperature purifier. In these applications, it can be very cost effective to simply have an ambient temperature purifier upstream of the use point.

Suitable vessel size is based on the anticipated flow rate of the gas being purified, input impurity load, and desired lifetime between regeneration or replacement. In some cases, it is desirable to oversize the vessel to enhance purity or lifetime performance. The chart at right lists nominal flow rates at 150 psi line pressures to achieve specified impurity removal to <100 PPT for a nominal one year service life. Max flow rates listed are based on filtration option specified, FP=0.003µm, CR=0.1µm.



		DIMENSIONS		FLOW SLPM		
MODEL	UNITS	A	B	NOMINAL	MAX FP	MAX CR
975	mm	202.0	76.0	7.0	60.0	100.0
	inch	7.94	3.0			
977	mm	254.0	76.0	10.0	120.0	200.0
	inch	10.0	3.0			
05K	mm	462.0	76.0	43.0	200.0	400.0
	inch	18.20	3.0			
07K	mm	440.0	102.0	60.0	500.0	700.0
	inch	17.30	4.0			
08K	mm	864.0	102.0	120.0	560.0	850.0
	inch	34.0	4.0			
50K	mm	701.0	152.0	225.0	1000.0	1500.0
	inch	27.60	6.0			

- Nominal flow rates are based on providing 1-year service life at 5Ns inlet purity.
- Max flow rates are at 150 psig gas pressure.
- Weights range from 1 to 10 lbs based on size and fill material.

Fill Class

Designations for the fill material required to remove specific impurities from specific gas streams are listed in the chart below. This is not a comprehensive list of every possible impurity that can be removed from every possible gas. If the gas to be purified, or impurities are not listed, contact ARM for assistance.

Class	Gases Purified	Impurities Removed ¹	Removal Efficiency ¹	Regen Capable
C	Ar, He, Kr, Ne, Xe, N ₂ , H ₂	CO, CO ₂ , H ₂ , H ₂ O, NMHC, O ₂	<100 PPT	Yes
CA	Ar, He, Kr, Ne, Xe, N ₂ , H ₂	CO, CO ₂ , H ₂ , H ₂ O, NMHC, O ₂	<100 PPT	Yes
F	C ₂ F ₆ , C ₃ F ₈ , C ₄ F ₈ , CClF ₃ , CCl ₂ F ₂ , CCl ₄ , CF ₄ , CHClF ₂ , CHF ₃ , CH ₃ F	CO, CO ₂ , H ₂ , H ₂ O, NMHC, O ₂	<100 PPT	No
OX	CDA, O ₂	CO ₂ , H ₂ O, NMHC, Amines, NOx	<100 PPT	Yes
T	BCl ₃ , BF ₃ , Cl ₂ , ClF ₃ , F ₂ , HBr, HCl, HF, NF ₃ , SF ₄ , WF ₆	H ₂ O	<100 PPT	No
W	Ar, He, Kr, Ne, Xe, H ₂ , N ₂	H ₂ O	<100 PPT	Yes
Y	AsH ₃ , B ₂ H ₆ , CH ₄ , D.C.S.(SiH ₂ Cl ₂), Ge ₂ H ₆ , GeH ₄ , H ₂ Se, NH ₃ , PH ₃ , SF ₆ , SiH ₂ , SiH ₄ , Si ₂ H ₆ , DMHZ, Hydride/Carrier Gas Mix	CO ₂ , H ₂ O, O ₂	<100 PPT	Yes

¹ <100 PPT removal efficiency is based on 5N5 (99.9995%) inlet gas purity at nominal flow and rated pressure.

Inlet/Outlet Connections

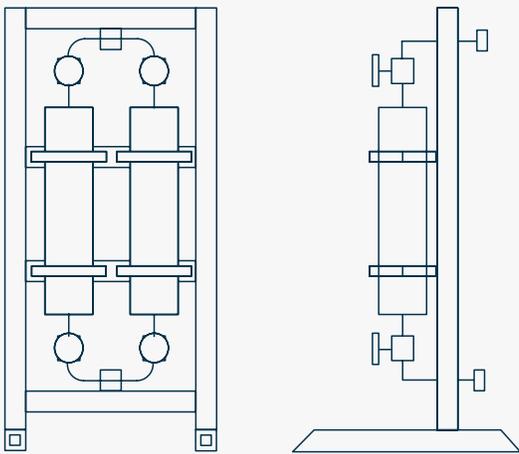
The standard inlet/outlet connections are 1/2" VCR™ face seal fittings. Other connection types are optional. Contact ARM for a quote.

Open Frames

When only vessels that operate at ambient temperature are required, typical installation is on a structural square tube frame that can hold just a vessel. In some cases, a pair of vessels and plumbing are used to allow for removal of a vessel for factory regeneration, and will include isolation valves with appropriate purge ports to ensure a clean installation of the regenerated vessel.

Open frame plumbing can include pressure gauges, sample ports, flow meters, or any other additional indication or features required.

Frames are typically constructed of 2" square stainless steel structural tubing.



Filtration

All purifiers include an integral filter. Two standard options are available: CR-0.1 micron and FP-0.003 micron. These filter particles down to the size specified to less than 1 particle per cubic foot of gas.

Specification Common to All	
Max Operating Pressure	200 PSIG (17.24 BAR)
Max Operating Temperature ¹	400°C
Nominal Flow Rate ²	0.3 slpm to 20.0 slpm
Maximum Flow Rate ²	4.5 slpm to 300.0 slpm
Pressure Drop ²	<1 ATM typical
Filtration	0.1 µm standard, optional 0.003 µm
Wetted Surfaces	Electro-polished, <10Ra, 316L stainless steel
Typical Inlet Gas Purity	99.999% ⁴
Outlet Purity	<100 PPT
Input Power	100VAC, 120VAC, 230VAC, 50/60Hz, 600W (max)
Inlet/Outlet Fittings	VCR™ standard, optional Swagelok™ or tube stub
Operating Air Supply ³	60-90 psig CDA

¹ Applicable to heated vessels in Nova™ Series and Pro-Panel™ Series only.

² Dependent on vessel size.

³ Only applicable with air operated valve option.

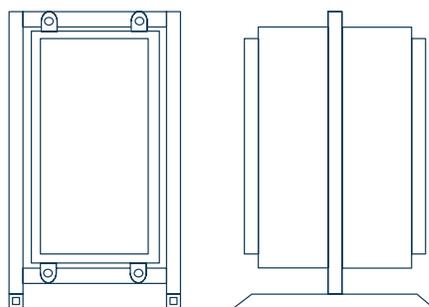
⁴ 50 PPM maximum

With Enclosures

When removal for factory regeneration is not desirable, regeneration heaters and controls can be added to facilitate in-situ regeneration with a level of automation from simple timers with manual valves, to a completely automated regen schedule with electro-pneumatic valve operation.

These enclosed designs can include pressure gauges, sample ports, flow meters, or any other additional indication or features required.

Frames are typically constructed of 2" square stainless steel structural tubing.



Features	Vessel Only	Pro-Panel™ Series
Heated Operation	No	Yes
Optional Inlet/Outlet/Bypass Valves	Yes	Yes
Optional Pneumatic Inlet/Outlet Valves	N/A	Yes
Power Status Indication	N/A	Yes
Ready (for Operation) Indication	N/A	Yes
Thermocouple Fault Indication	N/A	Yes
Process Indication	N/A	Yes
Alarm Indication	N/A	Yes
Valves Open Indication	No	Yes

Advantage™ Micro Series

When a heated technology is required or automated regeneration for uninterrupted gas flow is required, ARM's Advantage™ Micro Series purifier is the answer.

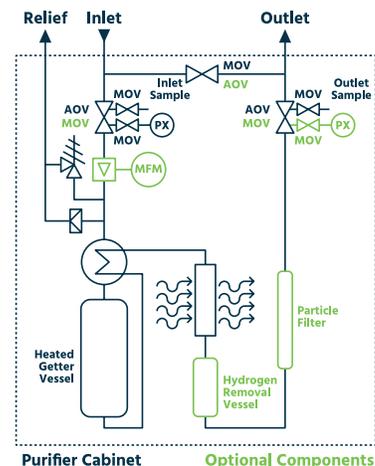
The Advantage™ Micro Series is a modular design, with fully automated control, and configurable to meet your specific requirements. The three basic technologies used are described below, which are selected based on the gas to be purified and the impurities to be removed.

Getter

Getter purifiers use getter material, sometimes at elevated temperatures, to remove impurities that react with the getter and chemically bond to it. This chemical bond, once made, survives for the life of the purifier.

For overall thermal efficiency, a gas-to-gas heat exchanger is incorporated to use the cold gas entering the getter vessel to cool the gas leaving the getter vessel. For added protection of downstream components, additional air or optional water cooling of the outlet gas stream is incorporated into the design.

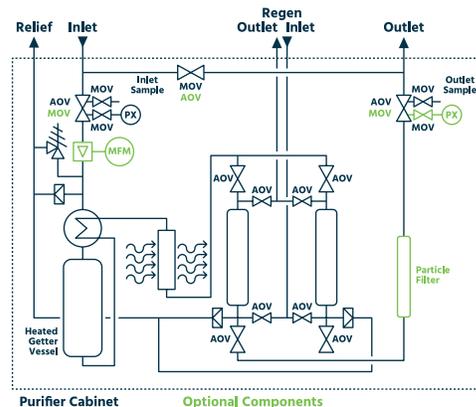
Gases Purified	Impurities Removed to <100 PPT
N ₂ , N ₂ /Noble gas mix	CH ₄ , CO, CO ₂ , H ₂ , H ₂ O, O ₂
H ₂	CO, CO ₂ , H ₂ O, N ₂ , O ₂
Hydrides	CO ₂ , H ₂ O, O ₂



Catalyst

Catalyst purifiers use true catalytic materials that react with hydrocarbons and other impurities, converting them to gas molecules that are then removed by an downstream adsorber stage. The adsorber stage is actually a parallel dual column arrangement allowing for regeneration without interrupting purified gas flow.

Gases Purified	Impurities Removed to <100 PPT
O ₂ , CDA	CH ₄ , CO, CO ₂ , H ₂ , H ₂ O, THC
N ₂	CH ₄ , CO, CO ₂ , H ₂ , H ₂ O, O ₂ , THC
X	

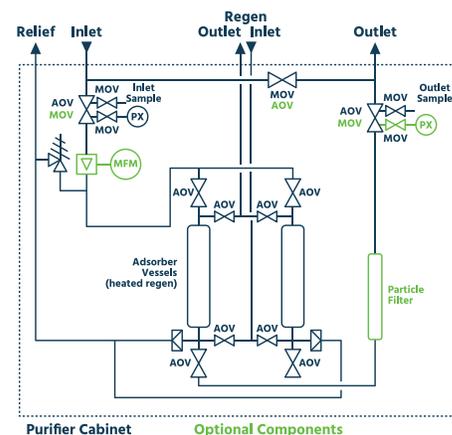


Adsorber-Reactive Catalyst

Adsorber-Reactive Catalyst purifiers use adsorber material, or in certain instances a reactive catalyst, to remove impurities from a wide variety of gases.

The impurities are either absorbed into the material, adsorbed to the surface of the material, or reactive catalysts, form compounds on the surface of the material. To ensure uninterrupted purified gas flow, dual columns are arranged in parallel with the PLC control system performing the automatic switching and regeneration.

Gases Purified	Impurities Removed to <100 PPT
Ar, He, Kr, Ne, Xe, N ₂ , H ₂	CO, CO ₂ , H ₂ , H ₂ O, NMHC, O ₂
CDA, CO ₂ , N ₂ O, O ₂	CO ₂ , H ₂ O, NMHC, Amines, NOx
Ar, CO, H ₂ , He, Kr, N ₂ , Ne, Xe	H ₂ O



Standard Features/Options

There are a variety of options with the Advantage™ Micro Series micro-bulk purifiers. The table below lists most of the common standard and optional features with the Advantage™ Micro Series purifiers.

Instrumentation & Controls	Standard	Optional
Inlet Pressure Transducer	✓	
Outlet Pressure Transducer		✓
Captured Overpressure Exhaust	✓	
Emergency Shutdown	✓	
PLC Control of Automatic Functions	✓	
Microprocessor Control of Automatic Functions		✓
Remote Internet Access for Control, Upgrades		✓
Touchscreen HMI	✓	
Remote Internet Access for Troubleshooting		✓

Hardware	Standard	Optional
316L Stainless Steel Tubing, Fittings, Components	✓	
Wetted Surfaces Electro-Polished	✓	
Steel and Aluminum Enclosures, Powder Coated	✓	
Manually Operated Bypass Valves		✓
Pneumatic/Electric Operated Valves	✓	
Industry Standard Inlet/Outlet Connections	✓	
Gas-to-Gas Heat Exchangers	✓	
Air Cooled Heat Exchangers	✓	
Water Cooled Heat Exchanges		✓
Flow Meter/Flow Totalizer		✓
Overpressure Relief Protection	✓	
Particle Filtration		✓

Common Specifications

The Advantage™ Micro Series micro-bulk purifiers have been designed to be modular to meet the specific needs of the application. When quoted, the exact specifications will be defined and can include:

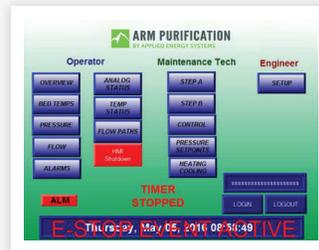
Specifications	Range	Specifications	Range
Maximum Allowable Working Pressure	150 to 250 PSI	Pressure Drop	1 ATM or less
Inlet/Outlet Tube Diameters	1/2" to 1"	Outlet Purity	Down to <100 PPT
Flow Rate	100 to 1200 slpm	Input Power	100 to 240 VAC 50/60 Hz

Control & Instrumentation

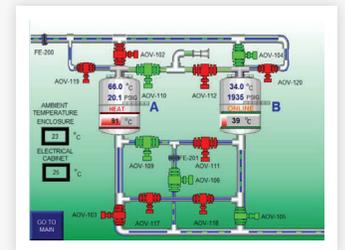
The Advantage™ Micro Series micro-bulk purifiers come standard with PLC controls and touchscreen HMI. For process flow and any automated routines, such as regeneration, electropneumatic valves are controlled by the PLC. Manual valves are used for isolation of instruments, such as pressure transducers and for sample or test ports as required.

The Advantage™ Micro Series indication and control software provides three separate password controlled access levels:

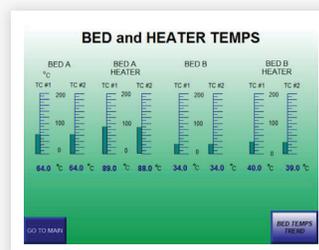
- **Operator** level allows access to all indications necessary to verify proper operation.
- **Maintenance Tech** level allows access to control a number of subroutines designed for care and maintenance of the purifier.
- **Engineer** level allows access to all operator and maintenance tech screens as well as the ability to set up all parameters, limits, alarms, etc.
- **REMOTE ACCESS** options allows ARM remote access to the purifier control program for both updates and factory assistance with operation or troubleshooting, should that become necessary.



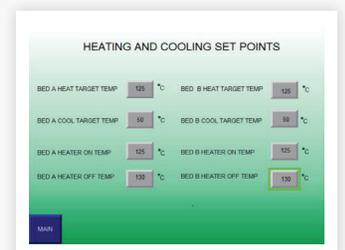
Main entry screen, with options for three levels of password protected operation.



Main status screen, with valve condition, pressures, and temperatures displayed.



Typical indication screen, with graphic display of bed temperatures.



Typical set point input screen (Engineer level access).

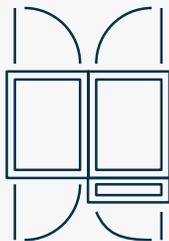
Enclosures

- There are three common enclosure sizes for protected area installation, which are shown below. The door clearance required is 20.0" (508 mm) and is typical for all doors shown.
- Hinge locations are as shown unless otherwise specified. Opposite hinge locations are optional (specify when ordering).
- Enclosures are constructed of steel and are powder coated standard ARM colors.
- All metal enclosure components are properly grounded and access to electrical control and instrumentation is protected with EMO interlocks.
- All user control and indication displays/interfaces are accessible without removing panels or opening doors.
- Locking casters are standard, leveling pads and seismic tie-downs are optional.
- Contact ARM for detail on optional weatherproof enclosures for unprotected gas pad type installations.



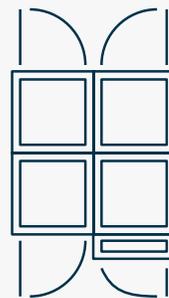
SF Enclosure

Dimensions are:
21.0" (533 mm) wide
42.0" (1066 mm) deep
42.0" (1066 mm) tall



MF Enclosure

Dimensions are:
42.0" (1066 mm) wide
42.0" (1066 mm) deep
42.0" (1066 mm) tall



LF Enclosure

Dimensions are:
42.0" (1066 mm) wide
58.0" (1473 mm) deep
42.0" (1066 mm) tall



NEMA Enclosures

When the installation has to be outside a protected area, exposed to the elements, ARM can furnish the micro-bulk purifiers in a suitable NEMA rated cabinet. For specific details, contact ARM Purification.

A Different Approach from Inquiry to Commissioning

The typical purifier manufacturer will present a number of standard systems with available options and specifications for flow rate, output purity, etc. via its website or printed brochure. It is up to the customer to sift through the specs and determine which model is best suited for their application. Customers must then call to verify the suitability of their choice, define desired options, and request a quote. Many times flexibility is limited to specific model/size/option selections that the manufacturer's marketing group has determined are the most popular.

At ARM, we are the experts when it comes to our products, and we understand the customer may not be intimately familiar with the technologies and configuration flexibility that ARM offers. Your time is valuable, and we have proven over the years that the shortest time between RFQ and quotation, with the least amount of customer time required, is via verbal communication. At ARM, we approach micro-bulk purifier inquiries with a level of customer service that leads little doubt regarding performance, price, and total cost of ownership.



Confirm Spec

Depending on the customer's preference, this can be as simple as a call or as involved as an in-person visit to relay the critical requirements: gas, impurities, flow, pressure, and desired features. Regardless, our objective is to review the pure gas needs and work together to develop a detailed statement of work, hardware descriptions, and performance specs.



Generate a Quote

If the need matches an existing Advantage™ Micro Series configuration, a firm fixed price quote referencing a specific model number is generated. Alternately, we will generate a statement of work with a listing of specific configuration data. The quote can include ARM Purification performing the installation and startup, or managing the installation and startup using local contractors.



Receive the Order

Any order resulting from a quote is reviewed to make sure it matches the proper specifications. An order acknowledgment is then sent. This begins the process that results in your pure gas requirements being met.



First Deliverables

The first deliverables include a detailed P&ID drawing for the specific Pro-Panel™ Series configuration purchased, along with a fully documented facilities drawing so you can begin to prep the location to receive the purifier.



Acceptance Testing

Acceptance testing is conducted at the ARM Purification factory. If quoted, we can accommodate the customer witnessing final assembly testing, including Helium leak checking, pressure decay testing, particle testing, and purity testing.



Delivery, Installation & Startup

All ARM Purification micro-bulk purifiers come with a detailed user manual defining installation, startup, operation, and service procedures to support the customer or contractor completing the installation and startup of the purifier. If purchased, ARM personnel will perform installation and startup or manage the project using local contractors.

