

In order to avoid loose caps on Iconoscopes or other tubes which require baking after basing to activate the cesium, such tubes shall be capped in the herein described manner. When applicable, this process may also be employed for capping tubes other than tubes classed as television pick-up tubes.

SCHEDULE #1

(Initially used for 1840)

1. MATERIALS

* S13 Solder
F9 Liquid Flux

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2. EQUIPMENT

Cap Heater (American Electrical Heater Co. - Cat. No. 3158) - Horizontally mounted 200w electric soldering iron with soldering tip replaced by a hollow holder (7/8" O.D. copper rod recessed at one end) with inside dimensions such as to assure a snug fit around a cap when it is inserted into the holder. A rack and pinion operated plunger on a stand permits the elevation of the heating device to be varied.

Electric Soldering Iron - vertically mounted with soldering tip.

3. PROCEDURE

- a. Make sure cap heater has been turned on sufficiently long enough to reach its maximum temperature.
- b. Place cement filled cap on seal of tube and position the tube so that the cap fits into the cylinder of the heater in perfect alignment.
(NOTE: - In all cases the cement used must be fresh and filled caps must not be allowed to stand more than 30 min. before use).
- c. Allow cap to heat for approximately 30 sec.; then withdraw cap being careful not to disturb setting; allow it to cool in air.
- d. Cut off lead wire protruding beyond cap and solder cap to lead.

SCHEDULE #2

(Initially used for 1850A)

This schedule is the same as Schedule #1 except that the cap is heated uniformly for 1 min. with a hand torch instead of the cap heater.

STANDARDIZING SECTION
ENGINEERING DEPT.

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