



In general, there are basically only two types of caps used; viz, the 3907B small cap and the 3903 large cap; the small caps are used usually on deflection plate leads and the large as P2 contacts.

There are two methods of curing employed at present; viz, the element heated cylinder and the infra-red ray types; the element heated cylinder type can be used for all tubes having hard glass bulbs, but for tubes employing soft glass bulbs the infra-red ray method has to be used in order to prevent implosions. Implosions would occur on soft glass bulbs if a heated cylinder were used because the concentrated external heat from the iron cylinder introduces high strain and bulb failures result.

SCHEDULE NO. 1

(Initially for types using hard glass bulbs)



CAUTION: F9 is corrosive and should be applied with brush only. Avoid contact and guard eyes from any splash or sputter.

1. EQUIPMENT

- a. Conventional soldering iron
- b. Timer
- c. 6 A.C. outlets
- d. Adjustable cap curing jig with one heated element cylinder for curing P2 caps.
- e. Adjustable cap curing jig with four heated element cylinders for curing deflection plate caps and four bulb holding cradles: one 5", one 9", and two 12" cradles.
- f. Table equipped with bracket for holding cradles and curing iron jigs.

2. MATERIALS

- S13 - Solder
- ***
- F9 -- Flux, Liquid

3. PROCEDURE

- a. With tube in an inverted position, face down, in the curing jig, adjust iron cylinder for a centered fit about the cap.
- b. Set heating iron VARIAC (type 200C) to setting of approximately 100. Place irons around caps and cure for approximately one minute. (The correct curing temperature is indicated by the cement turning a light tan. If the caps fail and the cement is noted to be green, it indicates too low a temperature. On the other hand, if the cement turns a dark brown, an excessive temperature is indicated.)
- c. Remove tube from curing jig and place horizontally in the holding cradle for soldering cap leads.
- d. Leads are then soldered to the caps. ***

** End of Schedule #1

SCALE—

DIMENSIONS IN

UNLESS OTHERWISE SHOWN. DIMENSIONS SHOWN WITHOUT TOLERANCES ARE DESIGN CENTERS

8-539-15-67

PCL21920-133LG

* CHANGE
 ** ADDITION
 *** DELETION

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SCHEDULE NO. 2

(Initially for types using soft glass bulbs)



CAUTION: 33-F-9 is corrosive and should be applied with brush only. Avoid contact and guard eyes from splash or sputter.

1. EQUIPMENT

- a. Adjustable stand equipped to operate six 250 watt lamps and extend over any type tube tray.
- b. Six 250 watt reflector type Westinghouse infra-red drying lamps.
- c. Timer
- d. Conventional soldering iron.

2. MATERIALS

- S13 Solder
- F9 Flux, Liquid

3. PROCEDURE

- a. Tubes are positioned horizontally across the tray and then are moved directly under the lamp stand.
- b. The stand should be adjusted so that 2 tubes may be cured simultaneously using 3 lamps for each tube; the lamps should be focused and adjusted approximately 12 inches away from the surface of the tube.
- c. Caps should be cured in this manner for approximately 12 minutes.

Note: This method has proven very satisfactory, but if loose caps are encountered it is advisable to degrease and sandblast the inside surface of the caps before any changes are made in temperature or time.

- d. Leads are then soldered to the caps. ***

** End of Schedule #2

SCALE—

DIMENSIONS IN

UNLESS OTHERWISE SHOWN. DIMENSIONS SHOWN WITHOUT TOLERANCES ARE DESIGN CENTERS
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SUBJECT:

CAPPING PROCESS
 Process Specifications

SUPERSEDED DATE

SCHEDULE NO. 3

(Initially for 7NP4)

1. EQUIPMENT a. Hand torch.
 b. Electric Soldering Iron.

2. MATERIALS S132 Solder
 F9 Liquid Flux
 C6 Basing Cement.

3. PROCEDURE

- a. Place cement filled cap over wire lead.

Note: In all cases the cement used must be fresh and filled caps must not be allowed to stand more than 30 minutes before use.

- b. Heat cap uniformly for 1 minute with a hand torch.
 c. Allow it to cool in air.

- d. Cut off lead wire protruding beyond cap and solder cap to lead.

SCALE—

DIMENSIONS IN

UNLESS OTHERWISE SHOWN.

DIMENSIONS SHOWN WITHOUT TOLERANCES ARE DESIGN CENTERS

* CHANGE
 ** ADDITION
 *** DELETION

16-516-27-60

PCL1537-126JK

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