SCHEDULE NO. 1

(Initially for Tube Types 7NP4 & 7WP4) MAY 1955

1. EQUIPMENT:
   a. Basing Heater, Model No. L785AS
   b. Safety shield for 2 tubes

2. MATERIALS:

C259A	Cement	
P258A	Putty - - - - - - - - - - - -	5.7 gms./tube
R252A	Tubing - - - - - - - - - - - -	.030" I.D. x .110" O.D. x .562"
S132M1	Solder	
C268A	Base Cement	
F9	Liquid Flux	

3. PROCEDURE:

   a. Wash oil (from spotknocking) off the stem of tube with carbon tet.
   b. Straighten and position the stem leads.
   c. Put two drops of C259A cement on the fillet around the G_3 lead. Allow to dry.
   d. Place putty (P258A) around the G_3 lead and an area surrounding it of approximately 1" x 3/8".
   e. Place rubber (R252A) over G_3 lead and push one end into 2.
   f. Place a ball of putty (P258A) (approximately 1/4" D) on G_3 lead and push down against rubber (R252A).
   g. Place base on tube.
   h. Put bead of cement C268A on the top inside edge of base.
   i. Press base against stem and align with neck of tube.
   j. Place tube in basing heaters and position safety shield.
   k. Heat the base to cure the basing cement and the insulating putty.
   l. Trim excess leads and solder the leads in the base pins.

→ *General Revision

** End of Schedule #1

SCHEDULE NO. 2
(Initially for Tube Type 1855)

MAY 1955

1. EQUIPMENT: a. Basing Heater, Model No. L785AS

2. MATERIALS:
R252A Tubing - - - - - - - - - - - .030" I.D. x .110" O.D. x .562"
S132M1 Solder
C268A Base Cement
F9 Liquid Flux

3. PROCEDURE

a. Straighten and position the stem leads. Clean ends of leads with emery cloth.
b. Slide rubber (R252A) over the 3 G_1 leads and the cathode lead tight against stem fillet.
c. Thread leads thru base pins.
d. Put bead of cement C268A on the top inside edge of base.
e. Press base against stem and align with neck of tube.
f. Place tube in basing heaters.
g. Heat the base to cure the basing cement.
h. Trim excess leads and solder the leads in the base pins.

NOTE: This schedule applies to both the reading and writing basing of the 1855.

End of Schedule No. 2

SCHEDULE NO. 3
(Initially for 5ZP16, 5WP11, 5TP4, and 5AUP24)

1. EQUIPMENT
   a. Basing reel.
   b. Stiff brush.

2. MATERIALS
   C259A Silicone cement
   P258A Silicone putty
   C268A Basing cement
   A55 Acetone

3. PROCEDURE

   a. Straighten and position the stem leads.
   b. Clean stem with acetone using brush.
   c. Place silicone cement around both G3 leads.
   d. Place silicone putty around both G3 leads covering dead pins to either side.
   e. Fill by hand with base cement leaving gap of about 1/2" corresponding to putty position
   f. Place base on tube
   g. Heat base on basing reel.
   h. Trim excess leads and solder leads in base pins

End of Schedule No. 3

SCHEDULE NO. 4

(Initially for C73394A Tube Type)

1. MATERIALS

A55 Acetone
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P270C Plastic Coating
* P275A Plastic Insulation Compd.
---- DuPont Cement
F258A Flux
S163ML Solder

2. PROCEDURE

a. Clean glass and stem in acetone.
b. Thread base.
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***
e. Fill vacant pin holes in base with DuPont Cement.
f. Trim and solder leads (use flux sparingly).
g. Pour plastic insulation compd* P275A over the glass tip off in the base until the glass is just covered. Allow to set for 2 hours.
h. Fill base pinch off cavity with plastic coating P270C. Allow to harden over night.

End of Schedule No. 4.