



SUBJECT: PRESSURE LEAK TEST OF RECESSED
CAVITY CAPS (CONTACT BUTTONS)

SUPERSEDED DATE

Formerly 34-37-66

This specification applies to the pressure leak test of recessed cavity caps (contact buttons) initially used on 39003 and 39004 caps as Cathode Ray Tube Factory Test on incoming caps. The caps are initially sampled according to Stdzg. Not. 25-3-9.

1. EQUIPMENT
 - a. Button Leak Tester, Model #722EE.
 - b. Rubber Washers for Button Leak Tester.
 - c. Small thumb pressure oil can, or rubber bulb syringe (ear syringe size) for dispensing alcohol.
 - d. Sweep second timer.
2. MATERIAL
 - A⁴ Denatured Alcohol
3. PROCEDURE
 - a. Check air pressure shown on gauge which should be 200 psi. Do not test at lower pressures.
 - b. Place the button on the center of the rubber washer in the leak test fixture.
 - c. Press the latch over the button and lock with the cam.
 - d. Cover the button with alcohol.
 - e. Depress the foot pedal which operates the gas control valve, and hold for 6 seconds. Watch for gas bubbles in the alcohol over the button. Bubbles indicate leaks.
 - f. Remove foot from foot pedal.
 - g. Disengage the cam and lift the latch.
 - h. Remove the button from the fixture.

ENGINEERING SECTION
STANDARDIZING

SCALE—

DIMENSIONS IN

UNLESS OTHERWISE SHOWN.

DIMENSIONS SHOWN WITHOUT TOLERANCES ARE DESIGN CENTERS

3-539-2-61

PCL21814-133LG

* CHANGE
** ADDITION
*** DELETION

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