

Tube Type C730 T (9AP4/1804P4)

Date Compiled _____

Assigned To George Bain

This complete tube type information booklet is available for transfer or developmental purposes, and will not be serviced by the Standardizing Department. Therefore, it should be returned as soon as the purpose for which it was initially compiled has terminated.

STANDARDIZING DIVISION

NOTES:

Walter Kintner
11/11/44

SUBJECT COMPLETE MFG. SPECIFICATIONS
 TUBE TYPE C730T (9AP4)

SUPERSEDED DATE

Mfg. Specifications and Consolidated List of Tube Parts and Materials
 for Tube Type C730T are identical to those for Tube Type C7318K (12AP4)
 Stdg. Notice No. 3-2K-C7318K EXCEPT for the items listed below.

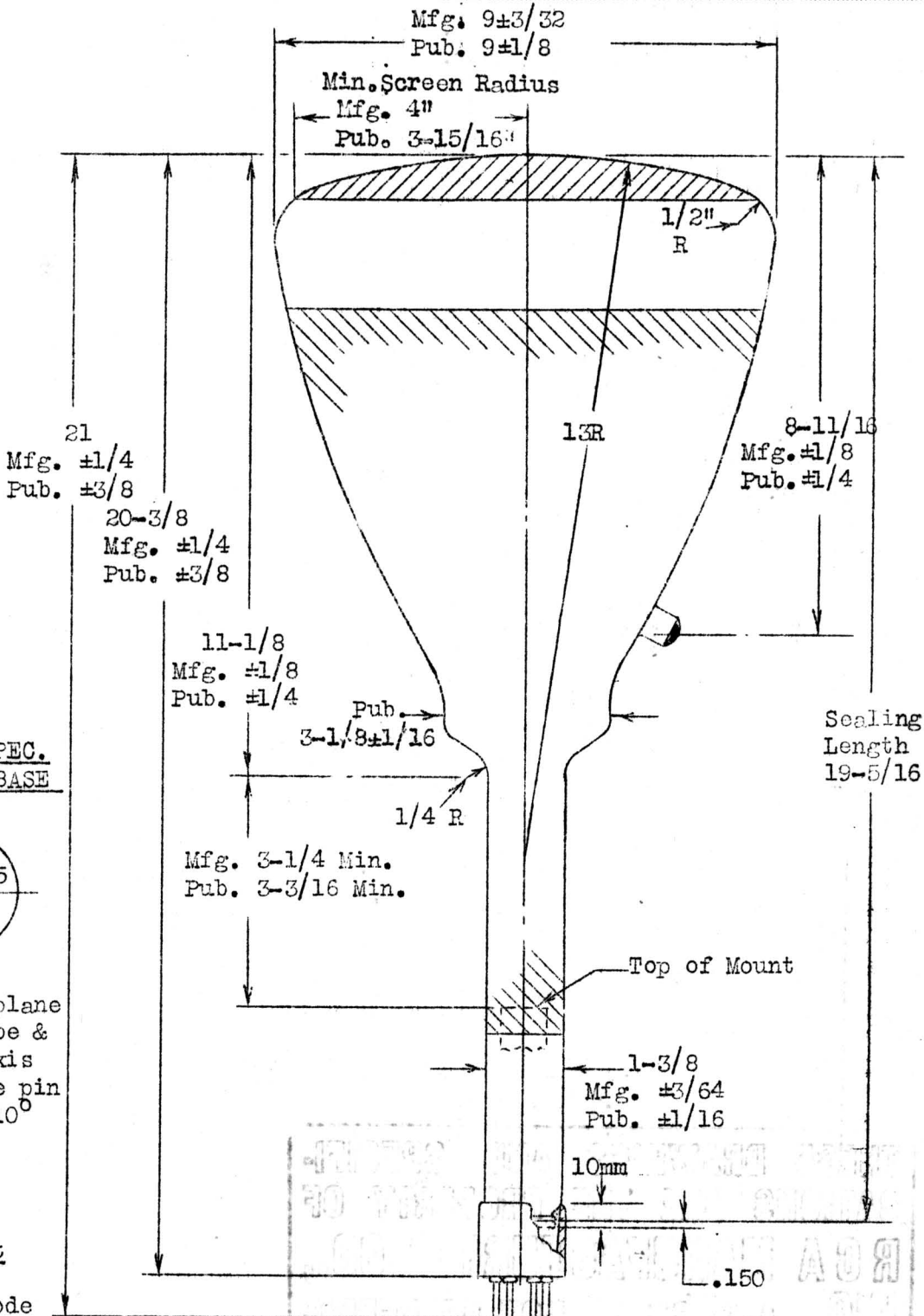
Part Description	Part Designation		N O T E	QTY/ 1000
	STANDARD	DEVIATION TO BE USED BY FACTORY		
Comp. Bulb Assly	FB72-601			
Bulb	J72J2 #774 Glass			M
Flare	FM6211			M
Anode Lead Assly	FW631			M
Lead	FW362			
Bead Glass	Ga.25 No. 1 Glass Tubing (7mm)			
Fluorescent	33-Z-12 (400 ng)			
Coating	33-Z-13 (400 ng)			
Conductive				
Coating	33-G-32			

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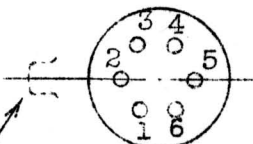
NOV 1 1944

SUBJECT COMPLETE TUBE ASSEMBLY
TUBE TYPE C730T (9AP4)

SUPERSEDED DATE



BASE THREADING SPEC.
BOTTOM VIEW OF BASE



Cap

Variation between plane through axis of tube & cap & plane thru axis of tube and #2 base pin
Mfg. ±5° Pub. ±10°

Pin No.	Element
1	Heater
2	No 1 Anode
3	No 2 Grid
4	No 1 Grid
5	Cathode
6	Heater

Tube Marking - - Stdzg. Notice 27-1-1A

ALL DIMENSIONS IN Inches UNLESS OTHERWISE SHOWN

DIMENSIONS SHOWN WITHOUT TOLERANCES ARE NOMINAL 1-449-22-60

* INDICATES A CHANGE ** INDICATES AN ADDITION SCALE-1:3

4491 0 1 VON
JK-101105gec

SUBJECT: Bill of Materials
Tube Type C7318K (12AP4)

Superseded Date 9/19/44

Part Description	Part Designation		NOTE	QTY. / 1000
	STANDARD	DEVIATION TO BE USED BY FACTORY		
→ Complete Bulb Assly	*TB96-604			M
→ Bulb	*J9602 (4771 Glass)			
→ Neck	FM6211			
→ Anode Lead Assly (Lead) (Eyelet)	FW631 *			
	FW368A			
	RE6B-N7			
→ Fluorescent Coating	Prep. *33-Z-12(700mg)			
→ Conductive Coating	Prep. **33-Z-13(700mg)			
Base	6105B3			M
Cap	3903			M
Stem Assly	FM6173AQ			M
Stem	FSB621-7D600G			
Eyelets	RE602-N7-W612(W614, FCK10) (3/assly)			
Heater	MCF140D-2			M
Cathode	FK120R3-602			M
No. 1 Grid Cylinder	P364J-S48-W612, B1, M6(W614, FCK10)			M
No. 2 Grid Assly	FP364R-2			M
Grid Cylinder	P364R-S48-M6-W612(W614)			
Aperture	RA3-S48-75A-W612(W614)			
Anode Assly	FP364-604			M
Anode Cylinder	P364-S48-M6W612(W614)			
Top Aperture	RA3-S48-250A-W612P2(W614)			
Bulb Spacer Support	R1794A-S48-W612(W614)			
Center Aperture	RA3-S48-75A-W612P2(W614)			
Bottom Aperture	RA3-S48-250A-W612-(W614)			
Thimble	R1550A-S48-W612(W614)			
Complete Getter Assly	FZ6033			M
Getter Assly	FZ6009B			
Retainer	R6104-M14MB6-W612			
Material	Prep. 33-B-76			
Support	W772A-N29-W612(W614)			
Contact	R1725B-N23D-W612(W614)			
Support	R1896-N23-W612(2/assly)			
Support	R7006-N23-W612(2/assly)			
Misc.:				
Grid Aperture	RA3-S48-40A-W612(Y18)			M
G-K Spacer	RE2-S49-M8(W614, FCK10)			M
Ceramic Spacer	I600A-C230C4			M

NOTES: 1. FOR CEMENT, PACKING, SOLDER, ETC. USED, SEE GENERAL STDZG. NOT.
2. FOR REFERENCE TO TUBE PARTS, USE INDEX TO DESIGNATION LETTERS STDZG. NOT. 1-1.

*** Elimination

* INDICATES A CHANGE ** INDICATES AN ADDITION

SUBJECT: Bill of Materials

Tube Type C7318K (12P4)

Superseded Date 2/2/44 Superseded 3-2-C7318K

Part Description	Part Designation		NOTE	QTY. / 1000
	STANDARD	DEVIATION TO BE USED BY FACTORY		
Cathode Collar	RE600-N7-W612(W614,FCK10)			M
Grid Shield	R2008E-N7-W612(W614,FCK10)			M
Cathode Tab	.007"x.030"x13mm-N8G-W612 (W614,FCK10)			M
Ceramic Supports	I625L-C222			2M
Mount Supports	605W1-S49-W612(W614,FCK10)			2M
G ₂ Connector	.005"x.080"x20mm-S49-W612 (W614,FCK10)			M
Bulb Spacers	R2050-N66B-W612(W614)			4M
Node Connectors	.007"x.040"x40mm-S49-W612 (W614,FCK10)			2M
G ₁ Connector	.005"x.080"x15mm-S49-W612 (W614,FCK10)			M

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 2. FOR REFERENCE TO TUBE PARTS, USE INDEX TO DESIGNATION LETTERS STDZG. NOT. 1-1-1.

*General Revision

4-447-22-61

ES-103gec

SUBJECT

SUPERSEDED DATE

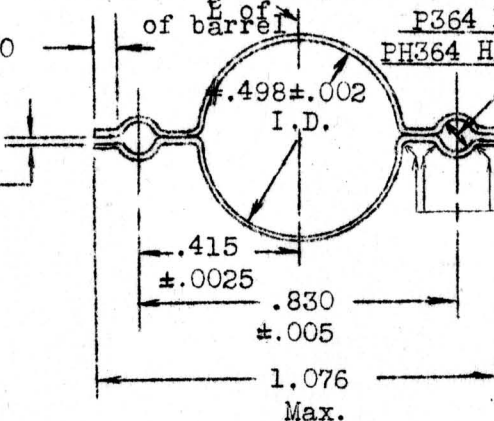
12/15/43

Proposed for 7A4
.045-.060

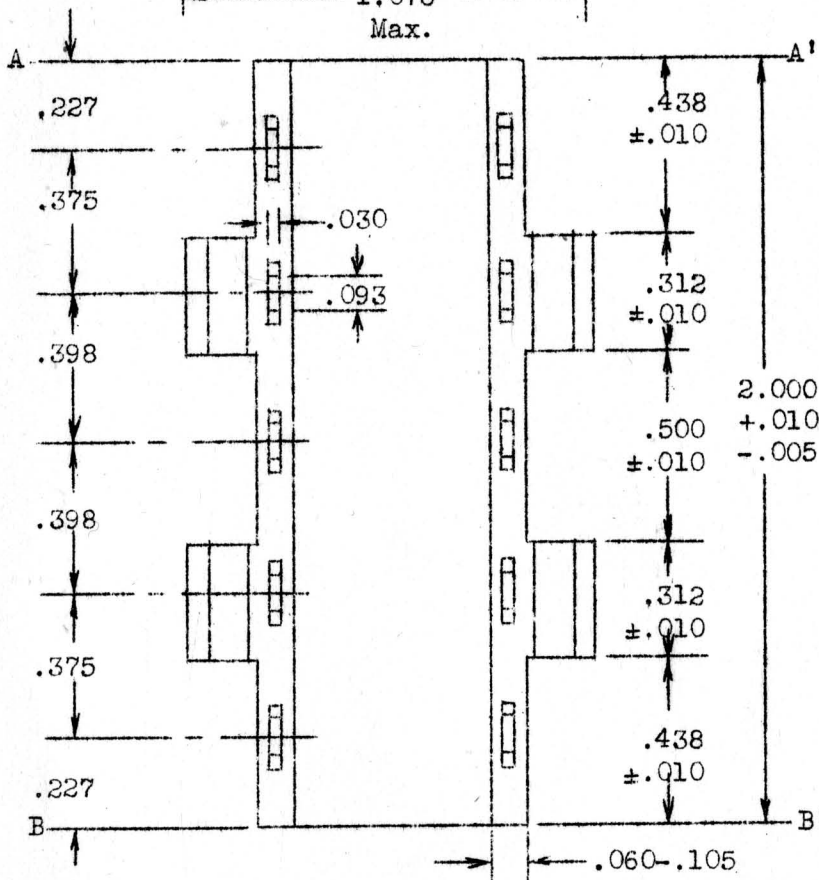
P364 PLATE and
PH364 HALF PLATE

SN-P3-4-51

.005-.015 Clearance
for welding



Similar to P208 & P208I



Notes

1. Max. out of round of barrel .0015
2. Max. offset of barrel of this plate with respect to \bar{L} of any other plate of the P364 series .005" if nickel or .0025" if S48 material.
3. Max. burr .007"
4. Planes AA' and BB' shall be parallel within $\pm .005$ " and each shall be at 90° to the axis of the barrel and to the axis of the channels.

MATERIAL SIZE; .007" x 2.000" (2-3/4" per plate)

#I.D. range throughout the length for any one part $\pm .0005$ ".

Consult Stdzg. Not.9-29-1 for Std. Tool Lubricant

DIMENSIONS IN Inches UNLESS OTHERWISE SHOWN 2-44-9-60

DIMENSIONS SHOWN WITHOUT TOLERANCES ARE NOMINAL

INDICATES A CHANGE

** INDICATES AN ADDITION

SCALE— 2:1

PCL2143-105104HR

NOV 10 1944

SUBJECT

SUPERSEDED DATE 6/9/44

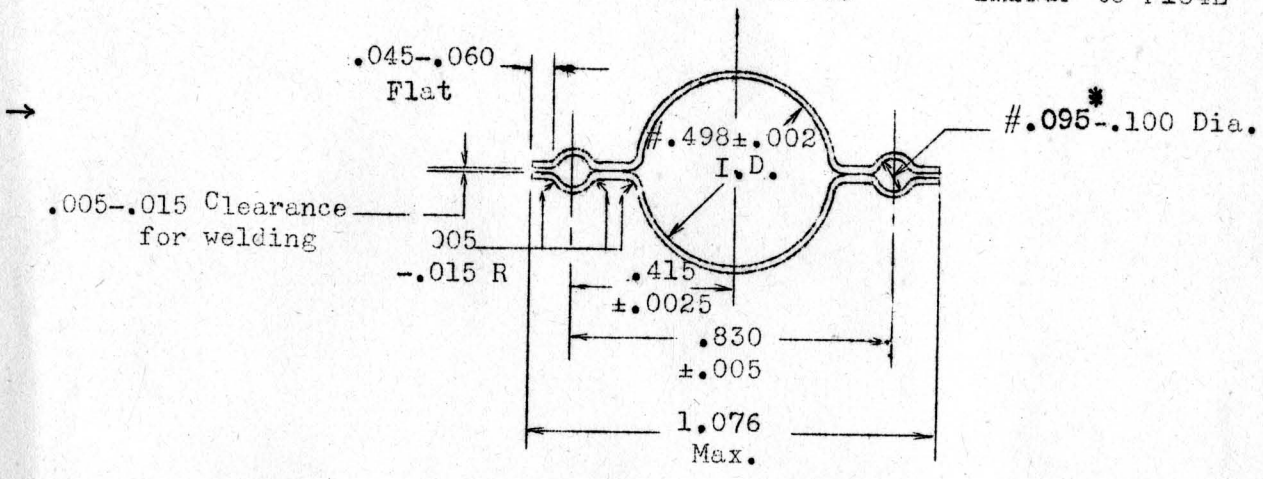
P364J PLATE and
PH364J HALF PLATE

SN-P3-4-51J

Proposed for 5BP4

E of Barrel

Similar to P184L



.005-.015 Clearance
for welding

.045-.060
Flat

#.498 ± .002
I. D.

#.095*.100 Dia.

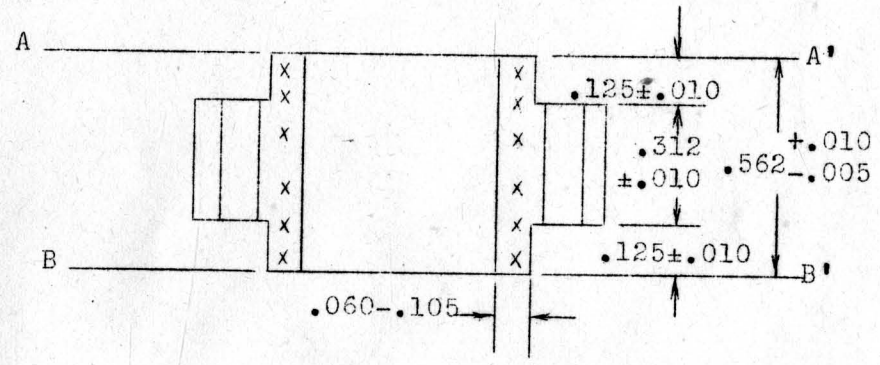
.005
-.015 R

.415
±.0025

.830
±.005

1.076
Max.

x Indicates Weld
(Note 5)



NOTES:

1. Max. cut of round of barrel .0015
2. Max. offset of barrel of this plate with respect to E of channels of any other plate of the P364 series .005 if nickel or .0025 if S48 material.
3. Max. burr .007"
4. Planes AA' and BB' shall be parallel within *.005" and each shall be at 90° ± .5° to the axis of the barrel and to the axis of the channels.
5. Welding Specifications: 8 welds per inch, min.; .040" square, average, or .045" dia. average; either centered or staggered side to side; square welds shall be located with sides at 45° to axis of channels; welds shall show burned marks on both sides indicating complete weld.

MATERIAL SIZE: .007" x .562" (2-3/4" per plate)

I.D. range throughout the length for any one part ±.0005"
Consult Stdg. Not. 9-29-1 for Std. Tool lubricant.

ALL DIMENSIONS IN Inches UNLESS OTHERWISE SHOWN

DIMENSIONS SHOWN WITHOUT TOLERANCES ARE NOMINAL

★ INDICATES A CHANGE

☆☆ INDICATES AN ADDITION

10-118-22-62

SCALE 2:1

*Correction

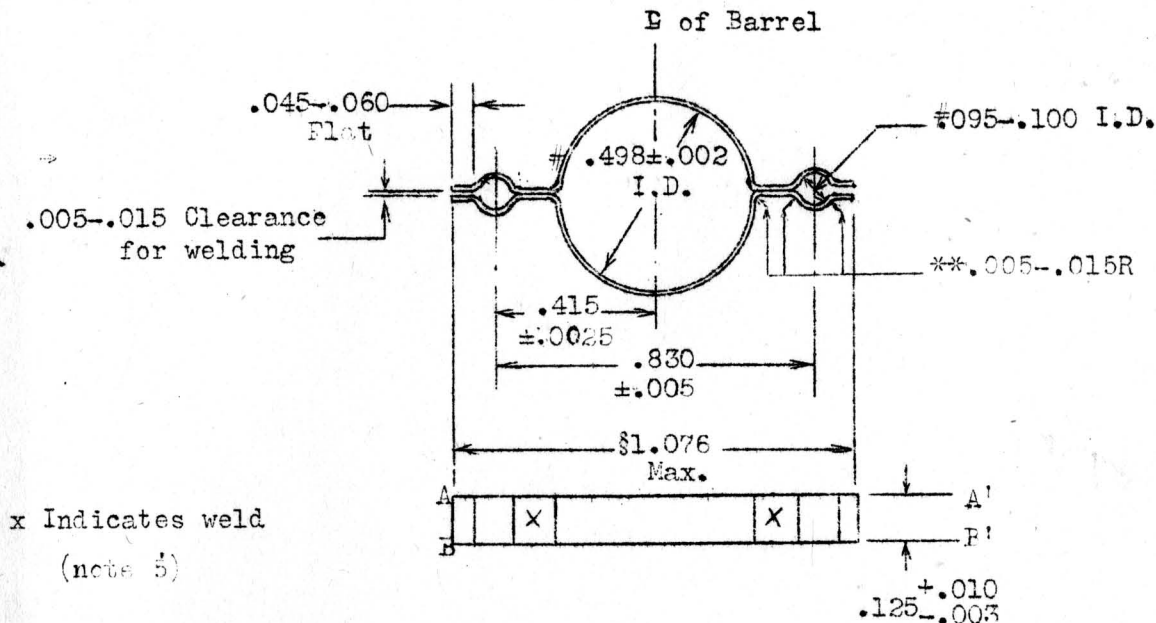
JP-107goc

APR 10 1944

SUBJECT

SUPERSEDED DATE 3/14/44

SN-P3-4-51R

P364R PLATE and
PH364R HALF PLATE
**NOTES:**

1. Out of round barrel .0015" max.
2. Max. offset of barrel of this plate with respect to \bar{E} of channels of any other plate of the P364 series .005 if nickel or .0025 if S48 material.
3. Max. burr .007"
4. Planes AA' and BB' shall be parallel within $\pm .005$ " and each shall be at $90^\circ \pm .5^\circ$ to the axis of the barrel and to the axis of the channels.
5. Welding Specifications: 8 welds per inch, min.; $.040$ " square, average, or $.045$ " dia. average; either centered or staggered side to side; square welds shall be located with sides at 45° to axis of channels; welds shall show burned marks on both sides indicating a complete weld.

MATERIAL SIZE: $.008$ " x $.125$ " (2-3/4" per plate)

#I.D. range throughout the length for any one part $\pm .0005$ "

Consult St. Nat. 9-29-1 for Std tool lubric nt.

ALL DIMENSIONS IN Inches UNLESS OTHERWISE SHOWN
 DIMENSIONS SHOWN WITHOUT TOLERANCES ARE NOMINAL

21-446-9-60

X INDICATES A CHANGE

** INDICATES AN ADDITION

SCALE 2:1

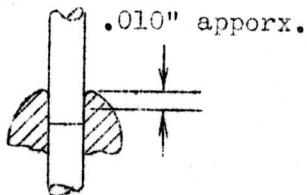
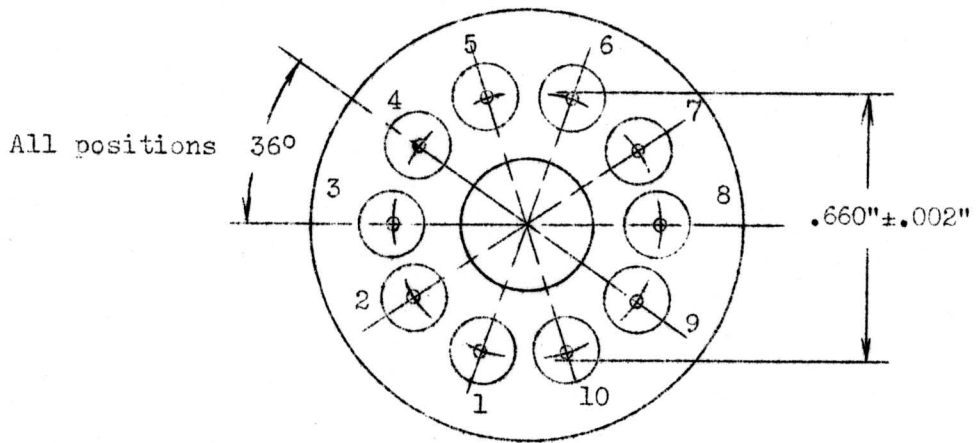
PCL2143-105104RBS

SUBJECT

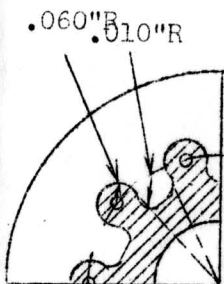
SUPERSEDED DATE 5/2/44

FSB621 STEM ASSLY

Similar to FSB602D
except glazing and
sandblasting added.



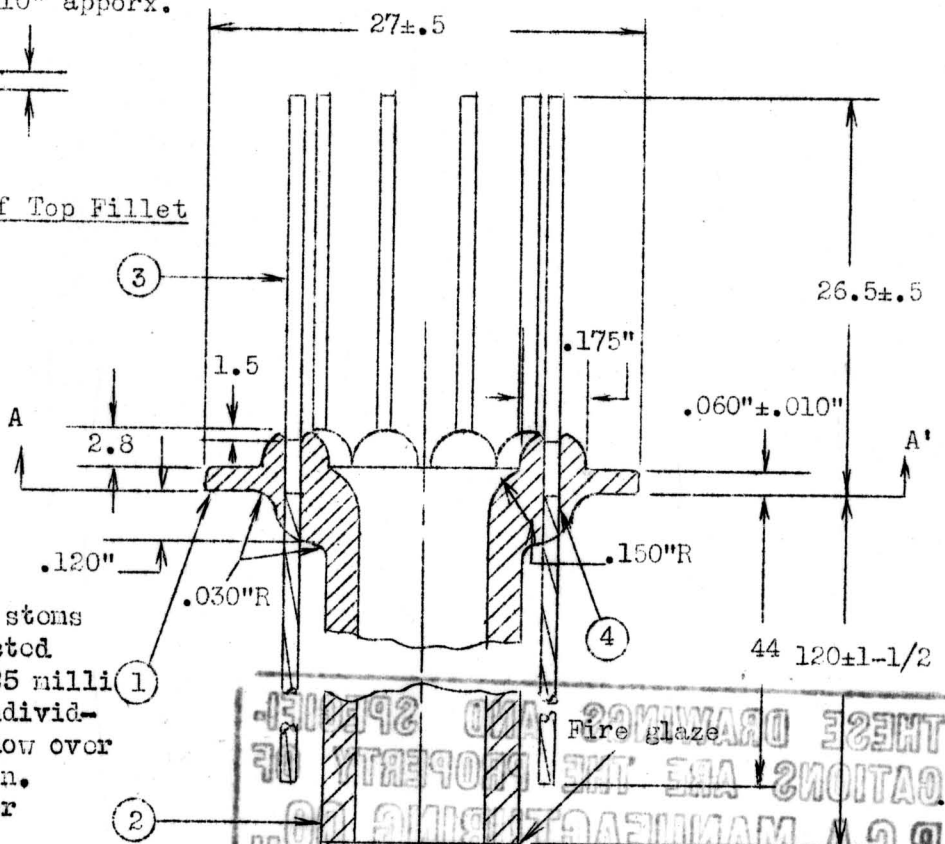
Detail of Top Fillet



Section AA'

Detail of Bottom Fillets

****Note:** A sample lot consisting of 1% of all stems supplied, randomly selected shall not average over 25 millimicrons strain and no individual stem in lot shall show over 40 millimicrons of strain. Desired condition is 0 or neutral strain.



- MATERIAL:**
- #1 Ga.48 (772 Glass) Outer Tubing (9mm)
 - #2 FM6082 Exh. Tubing (125mm)
 - #3 FW619A Comp. Lead Assly. (10)
 - #4 Ga.12 (772 Glass) Sleeve for stranded lead (3mm)
- OPERATIONS:**
- #1 Glaze bottom end of exhaust tubing
 - #2 Mould Stem
 - #3 Sandblast inner leads
 - #4 Wash in warm tap water for 30 sec. the oven dry.

Stdz. Not.
10-1-1(772)
13-1-2
13-1-2
10-1-1

ALL DIMENSIONS IN

DIMENSIONS SHOWN WITHOUT TOLERANCES ARE NOMINAL

INDICATES A CHANGE

UNLESS OTHERWISE SHOWN

** INDICATES AN ADDITION

21-418-22-62

SCALE--2:1

PCL2549-107goc

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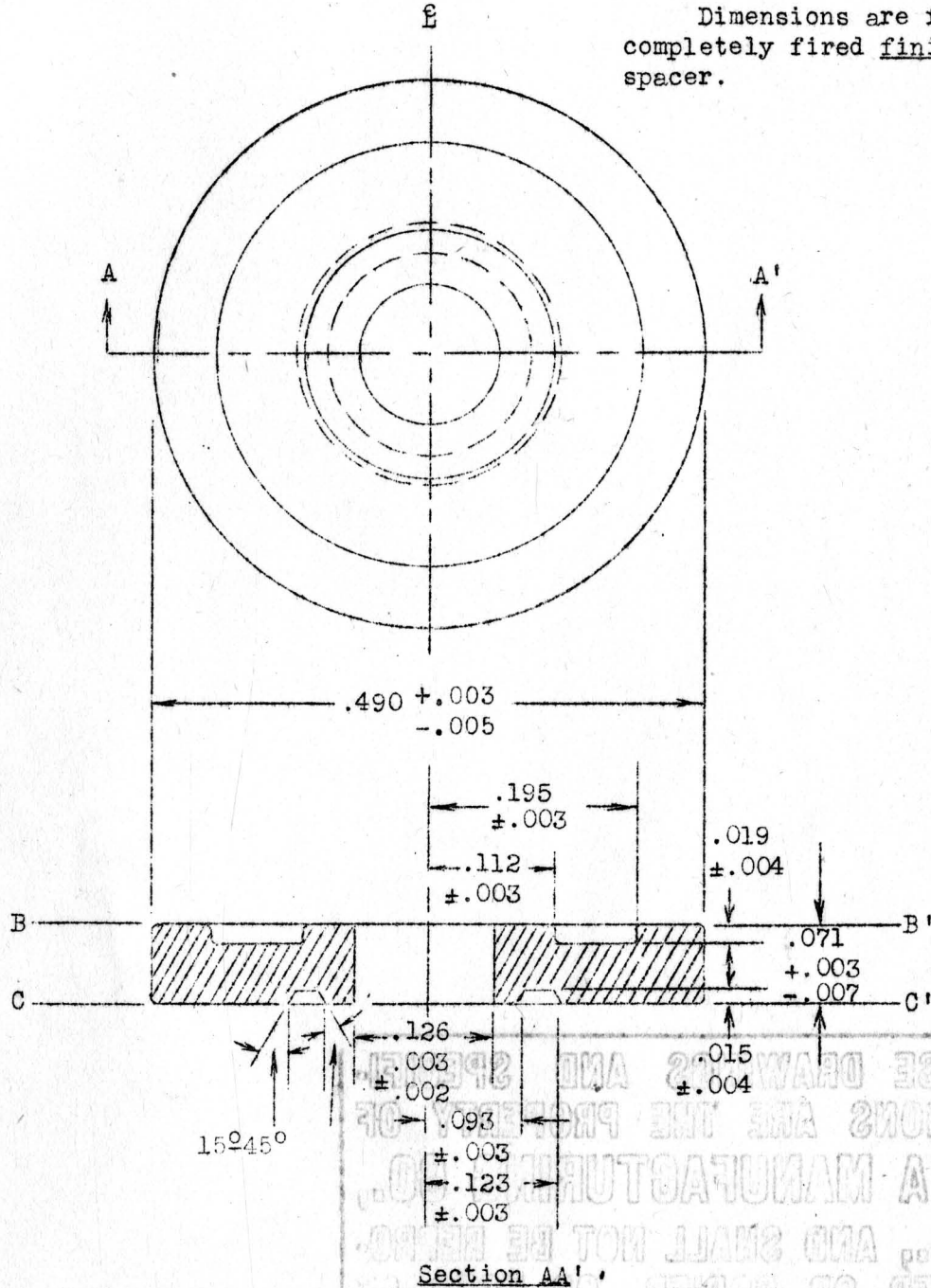
SUBJECT

SUPERSEDED DATE

I 600A SPACER

IMPORTANT

Dimensions are for completely fired finished spacer.



- NOTE:
1. Radius of all corners .004" Max.
 2. Max. variation between surfaces B-B' and C-C' in any one part not to exceed .005".
 3. No burr permitted on surface B-B'
 4. Max. burr on surface C-C' .005"
 5. Max. camber on surface B-B' .002"

DIMENSIONS IN inches UNLESS OTHERWISE SHOWN **For inspection data see supplementary page

DIMENSIONS SHOWN WITHOUT TOLERANCES ARE NOMINAL

1-446-5-62

AMPCL1631-105goc

INDICATES A CHANGE

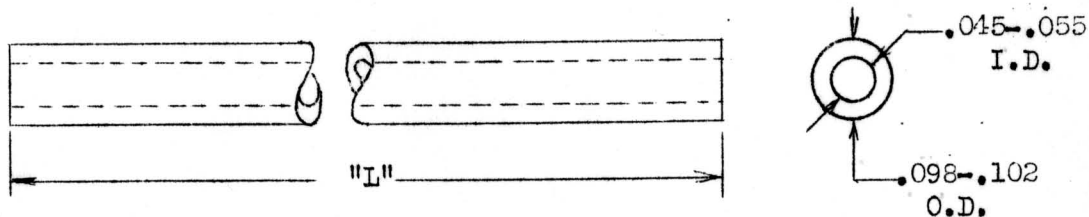
** INDICATES AN ADDITION

SCALE--6:1

SUBJECT

SUPERSEDED DATE

8/21/44

Proposed for Cathode Ray I625 MOUNT SUPPORT CERAMICSIMPORTANTDimensions are for completely
fired finished part.

Part No.	Length (Note 1)
I625A	36
I625B	39
I625C	43
I625D	60
I625E	65
I625F	70
I625G	50
I625H	57
I625J	52
I625K	12
I625L	63
I625M	77
**I625N	34

- NOTES: 1. Length tolerance $\pm .020$ " unless otherwise noted.
 2. Straightness Specification: Stdzg. Not. 34-13-10A
 Aperture Height: "A", = $6-1/2$ ".
 3.**Chips which continue through tubing wall at ends shall be no more than 1mm long.
 4.**Chips which do not penetrate more than $1/2$ the wall thickness must not be over 5mm long and must not exceed a width of $1/2$ the tubing diameter.

ALL DIMENSIONS IN mm UNLESS OTHERWISE SHOWN

DIMENSIONS SHOWN WITHOUT TOLERANCES ARE NOMINAL

★ INDICATES A CHANGE

☆☆ INDICATES AN ADDITION

SCALE---

8-449-10-60

PCL2717-107HB

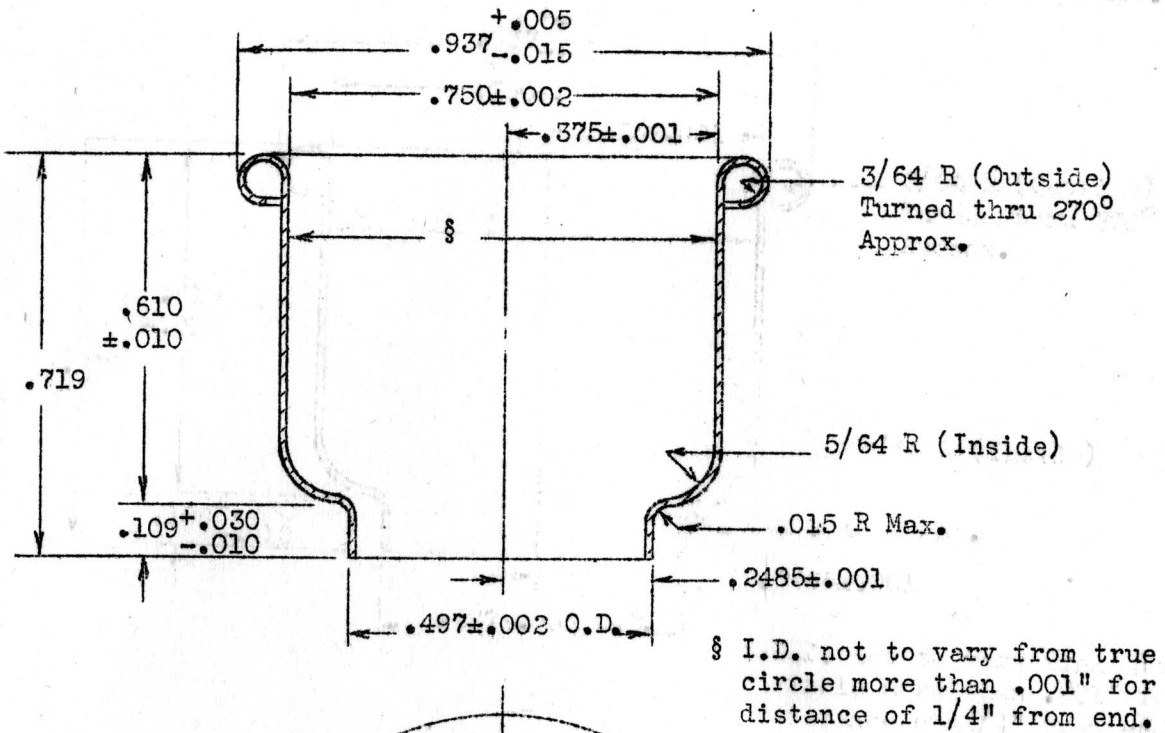
SUBJECT

SUPERSEDED DATE 10/31/39

R1550A ANODE THIMBLE

Proposed for 7AP4, C-7381

Similar to R1550
except skirt.



MATERIAL: $.0125$ " x 1.812 " (1.875" per part)

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* Material reference eliminated

ALL DIMENSIONS IN Inches UNLESS OTHERWISE SHOWN
DIMENSIONS SHOWN WITHOUT TOLERANCES ARE NOMINAL 21-429-14-1
★ INDICATES A CHANGE ☆☆ INDICATES AN ADDITION SCALE— 3:1

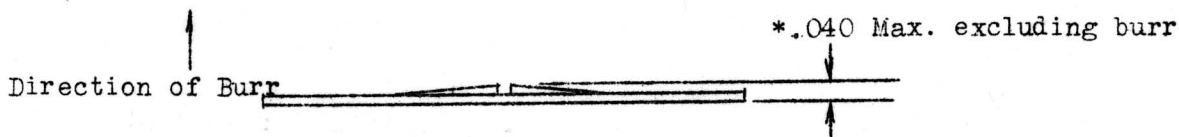
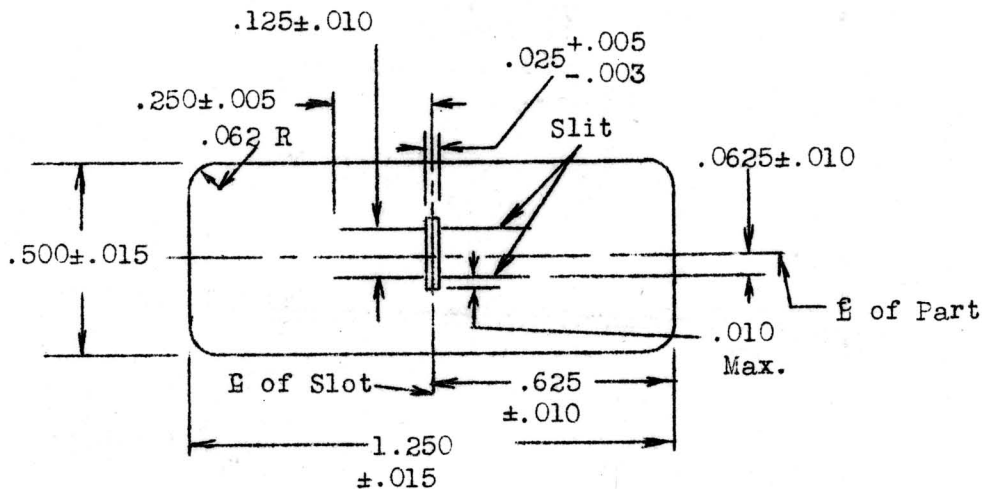
NOV 10 1942

SUBJECT

SUPERSEDED DATE 11/15/43

R1725B BULB CONTACT

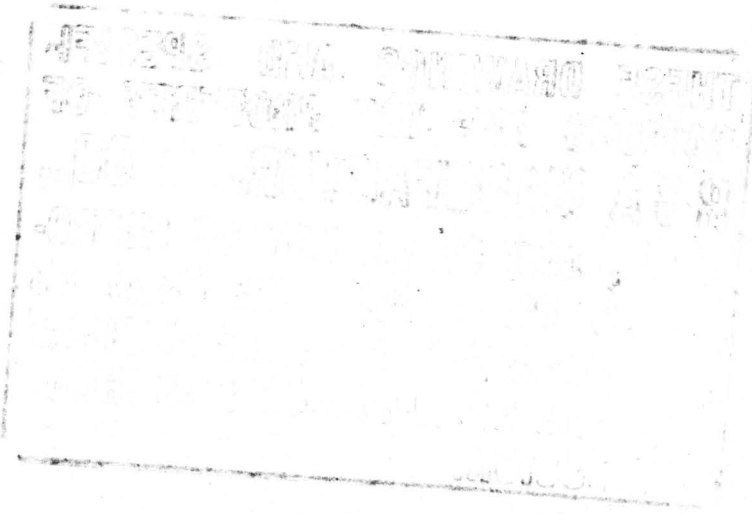
Proposed for Cathode Ray Tubes



Notes

- 1. Max. burr = .010"
- 2. Max. camber = .030" Max.

MATERIAL: .008" x .625"



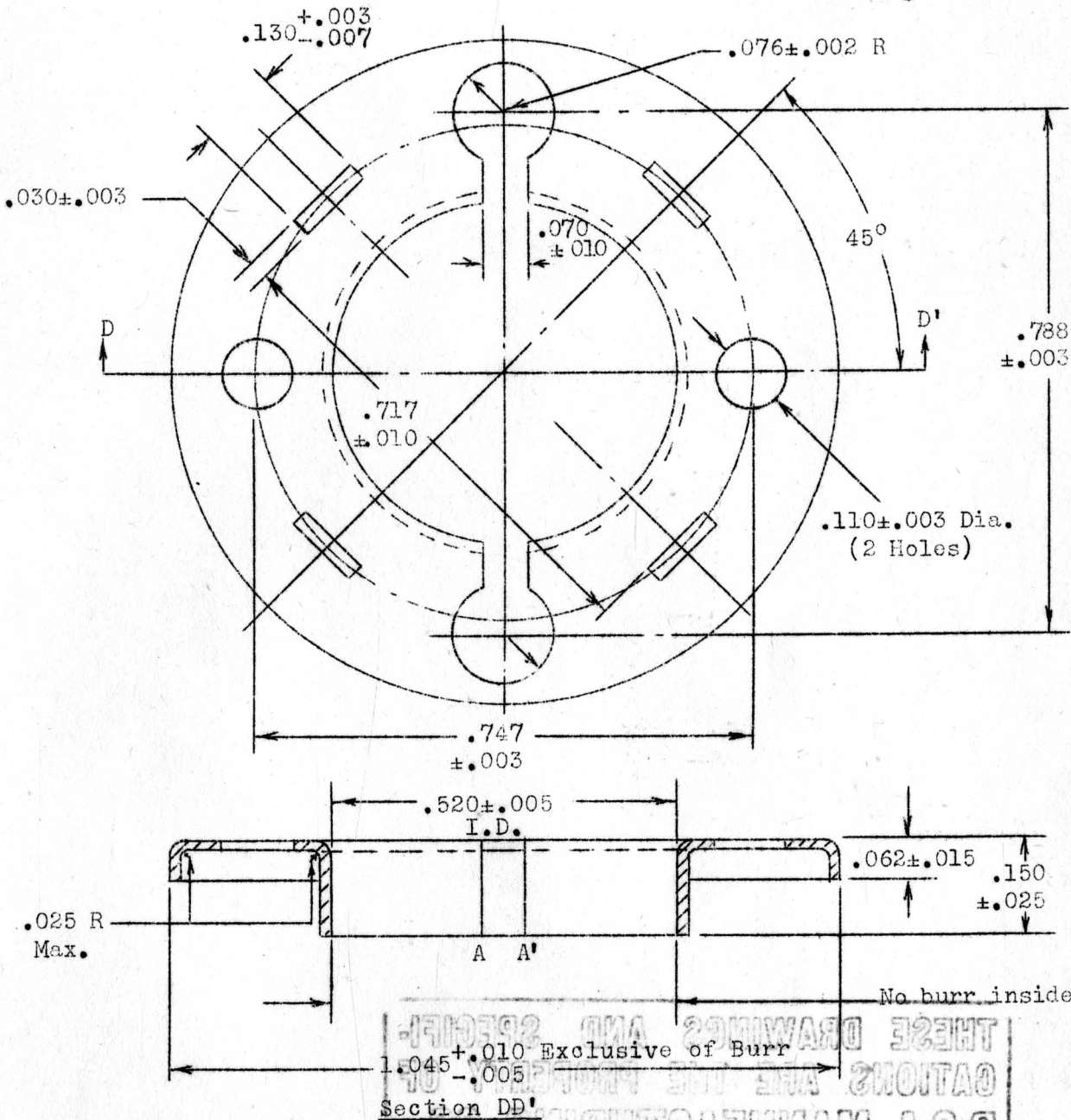
SUBJECT

SUPERSEDED DATE 12-31/41

Proposed for 7AP4

RL794A BULB SPACER

Similar to RL794
except two holes
enlarged.



- NOTES: #1 Variation between ϕ of holes and slots and ϕ of $.520$ " dia. = $.005$ " max.
 #2 Burr on AA' $.025$ " max. Max. burr any place else $.010$ " unless otherwise specified.
 #3 Max. camber $.020$ ".
 #

MATERIAL: RA12 Spacer

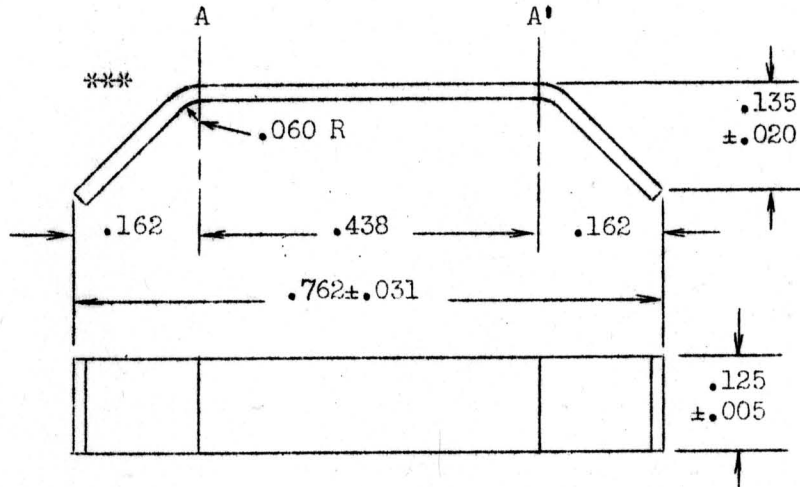
Stdz. Not.
13-1-1RA

SUBJECT

SUPERSEDED DATE 7/16/41

R1896 GETTER STRAP

Proposed for Cathode Ray Tubes



Camber over area AA' = .010" max.

MATERIAL: .015"x.125" (.856"/part)

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***Elimination

ALL DIMENSIONS IN Inches UNLESS OTHERWISE SHOWN

DIMENSIONS SHOWN WITHOUT TOLERANCES ARE NOMINAL

★ INDICATES A CHANGE

★★ INDICATES AN ADDITION

SCALE—4:1

3-445-4-61

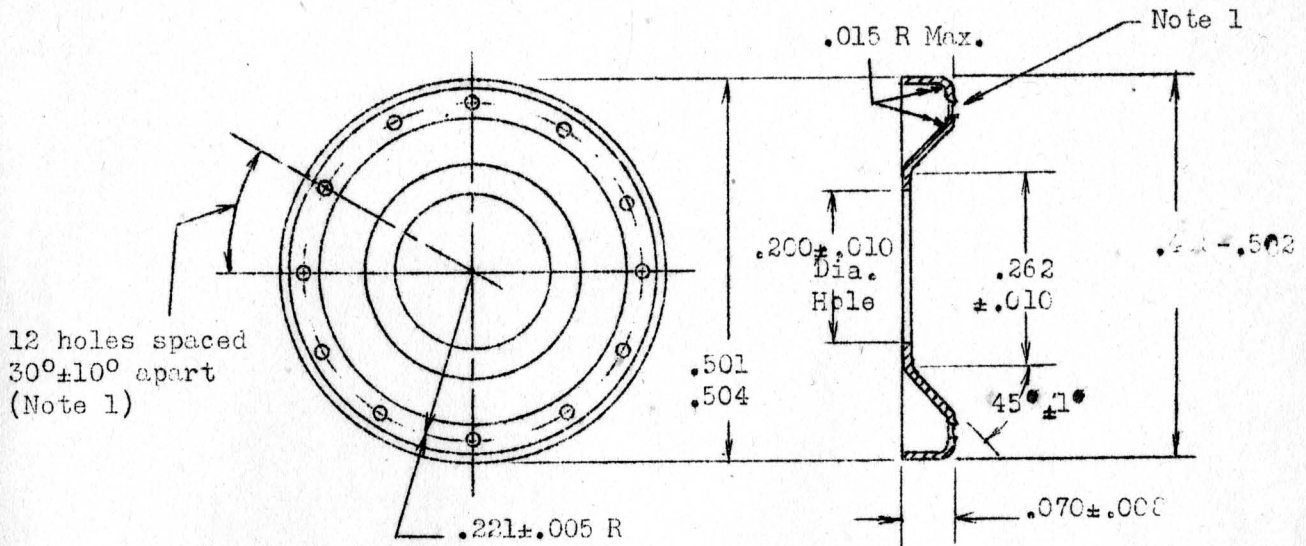
PCL1818-105104RBS

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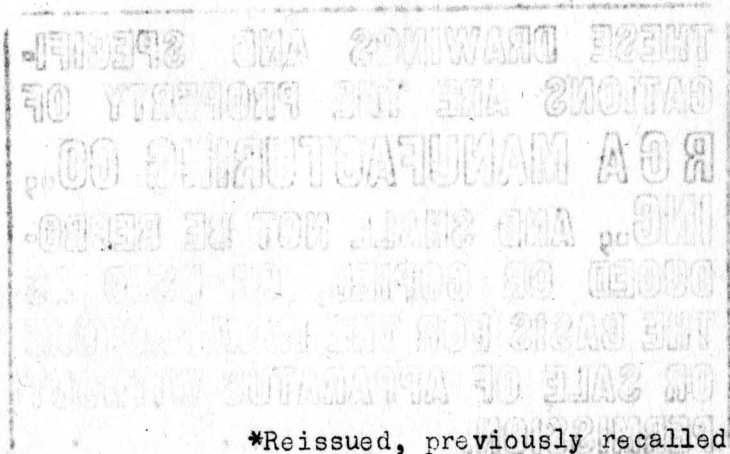
SUBJECT

SUPERSEDED DATE 4/25/14

R2008B SHEILD

**NOTES:**

1. The twelve holes on the upper landing shall have a burr of .010"-.025". The burr shall be on the top side. The diameter at the break-thru point shall be .020"-.030".
2. Max. Burr = .007" unless otherwise shown.
3. Max. variation between E of hole or E of depression and E of part = .010"
4. Top land AA' to be flat within .010".
5. Bottom of skirt to bottom of draw .008" max. but never less than length from bottom of draw to top of part.
6. The outside walls must not be deformed by more than .001" and the Burr on end of skirt shall not extend outward more than .001".



*Reissued, previously recalled
in error.

ALL DIMENSIONS IN Inches UNLESS OTHERWISE SHOWN

DIMENSIONS SHOWN WITHOUT TOLERANCES ARE NOMINAL

INDICATES A CHANGE

★ INDICATES AN ADDITION

18-447-8-60

SCALE— 4:1

PCL2365-105104RBS

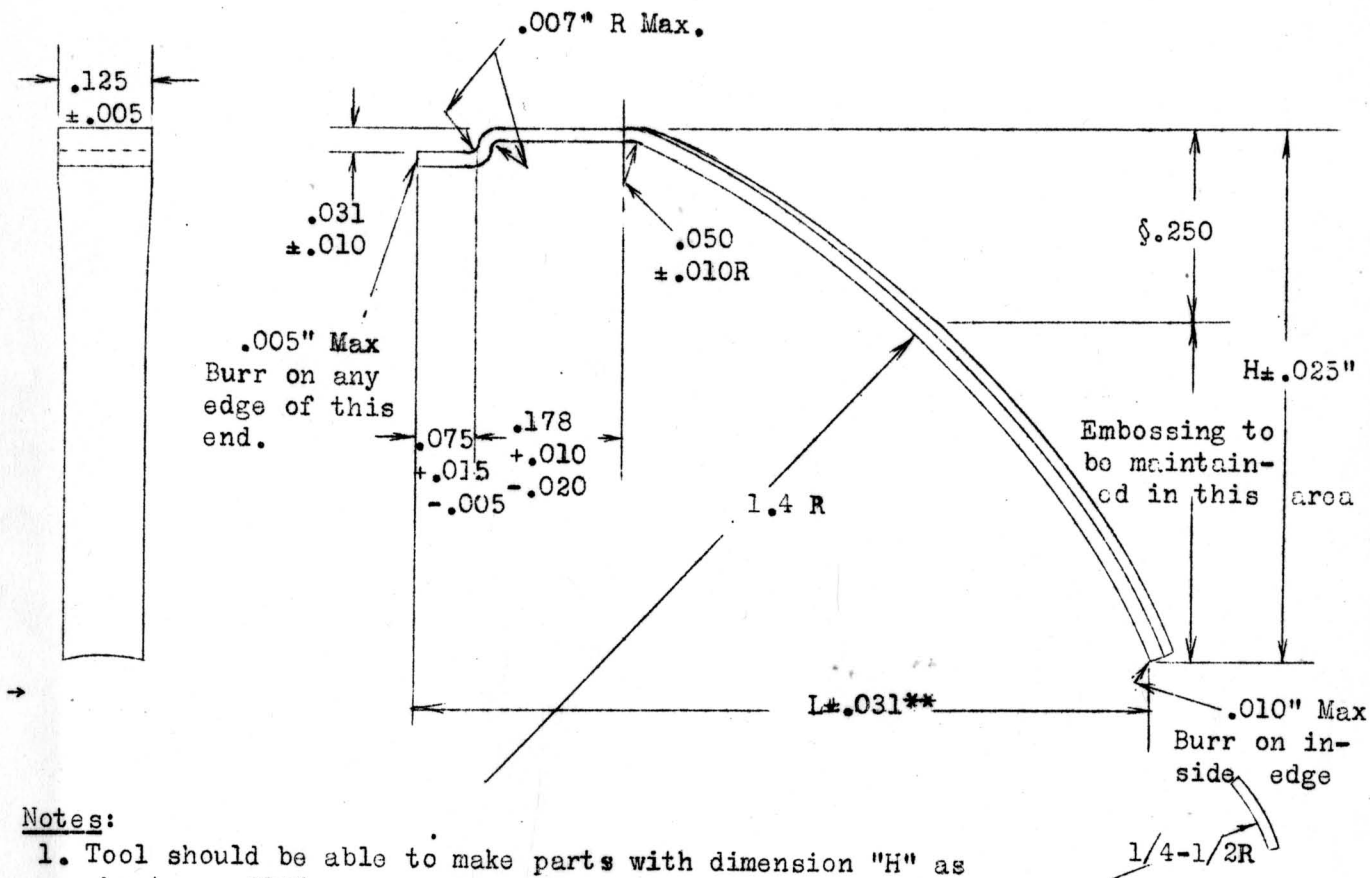
SUBJECT

SUPERSEDED DATE

8/5/44

Proposed for Cathode Ray

R2050 BULB SPACER



Notes:

1. Tool should be able to make parts with dimension "H" as short as .500".

Embossing to wash out gradually over this area.

<u>Designation</u>	<u>Length "H"</u>	<u>Material Size</u>	<u>L</u>
R2050	.766"	.010"x.125"	.851"
R2050A	.557"	.010"x.125"	.770"
R2050B	.688"	.010"x.125"	.825"
R2050C	.430"	.010"x.125"	.699"

Testing

Parts made from 33-N-66B material requiring quality check.
 Stiffness tester #719H (Stdg. Not. 44-4-9).
 600 gr.cm. load applied to convex side, end of leg inserted even with bottom of chuck.
 45° max. deflection (average of 10 samples).

***Elimination

ALL DIMENSIONS IN Inches UNLESS OTHERWISE SHOWN

DIMENSIONS SHOWN WITHOUT TOLERANCES ARE NOMINAL

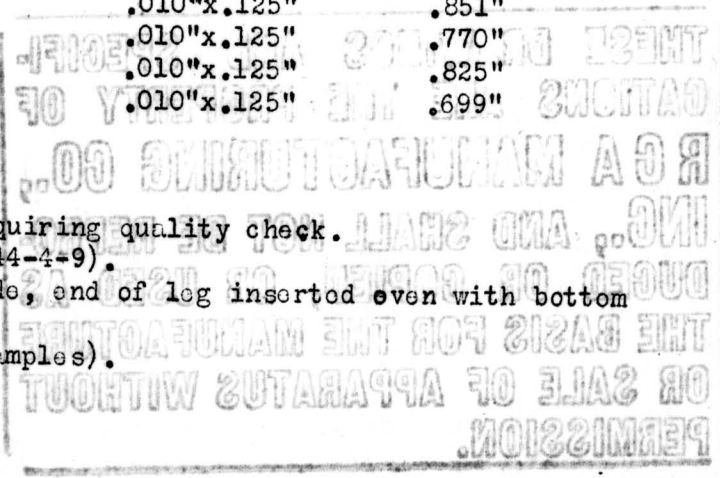
* INDICATES A CHANGE

** INDICATES AN ADDITION

SCALE— 4:1

14-448-11-60

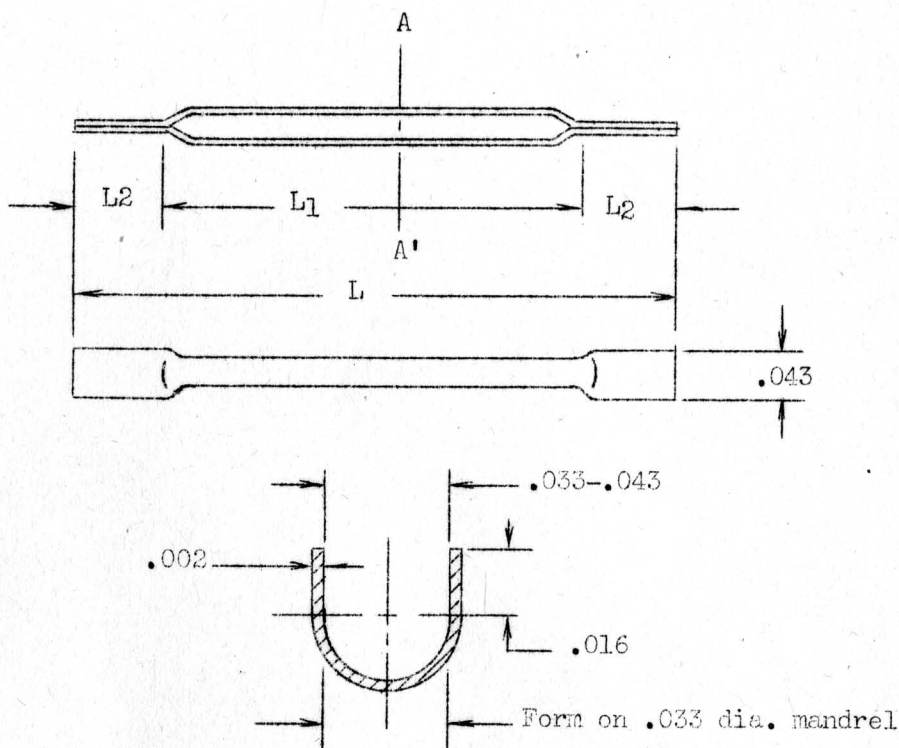
J.P.-105RBS



SUBJECT

SUPERSEDED DATE

R6104 GETTER RETAINER



Section at A-A'
 Scale 20:1

Retainer No.	Dimension (mm)		Material Length
	<u>L1</u>	<u>L2</u>	<u>L (mm)</u>
R6104	30	3	36

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SUBJECT

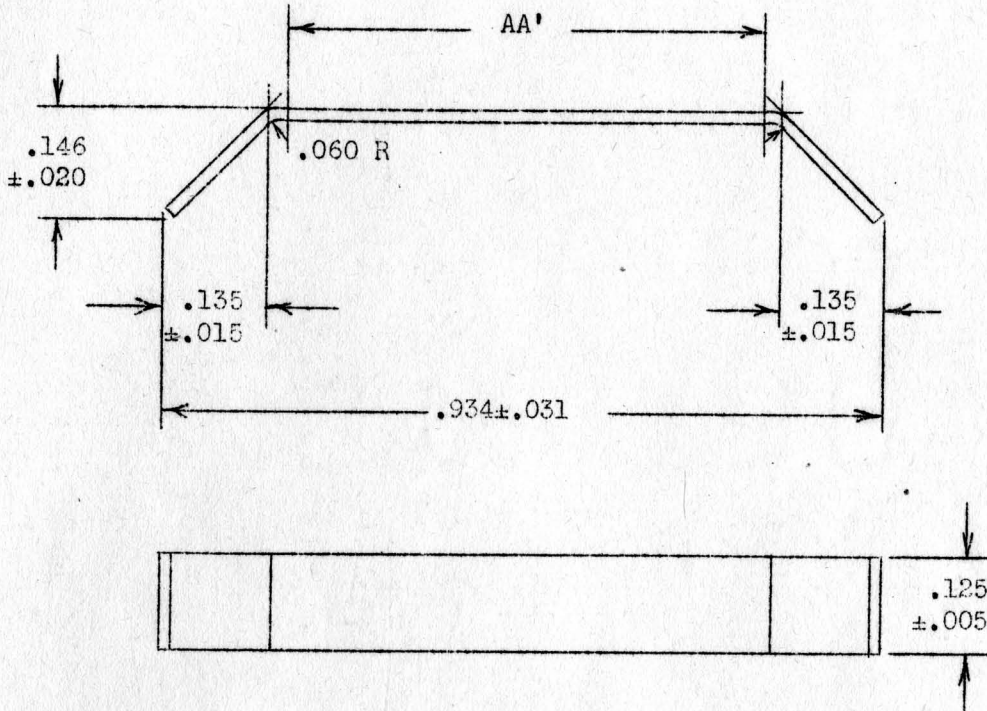
SUPERSEDED DATE

R7006 GETTER STRAP

Similar to R1896

TENTATIVE

Permanent tools must not
be ordered from this
specification.



Camber over area AA' = .010" Max.

MATERIAL: .015" x .125"

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ALL DIMENSIONS IN Inches UNLESS OTHERWISE SHOWN

DIMENSIONS SHOWN WITHOUT TOLERANCES ARE NOMINAL

15-444-25-61

PCL1849-103105RBS

* INDICATES A CHANGE

☆ INDICATES AN ADDITION

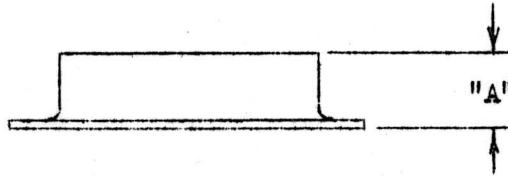
SCALE—4:1

SUBJECT

SUPERSEDED DATE 2/23/44

RE2 SPACER

Proposed for Cathode Ray Tubes



MATERIAL: See Tabulation

Note: The designation RE2 only followed by material & treatment suffixes will be shown on parts list. The designations shown below will be used for stocking purposes only, since the varying heights are needed to match a varying dimension in the cathode assembly.

Designation	Dimension "A"	Material
→ RE2(95) - Material Suffix	.095 ±.001*	RELAP
→ RE2(96) - " "	.096 ±.001*	"
→ RE2(97) - " "	.097 ±.001*	"
→ RE2(98) - " "	.098 ±.001*	"
→ RE2(99) - " "	.099 ±.001*	"
→ RE2(100) - " "	.100 ±.001*	"
→ RE2(101) - " "	.101 ±.001*	"
→ RE2(102) - " "	.102 ±.001*	"
→ RE2(103) - " "	.103 ±.001*	"
→ RE2(104) - " "	.104 ±.001*	"
→ RE2(105) - " "	.105 ±.001*	"
→ RE2(106) - " "	.106 ±.001*	"
→ RE2(107) - " "	.107 ±.001*	"
RE2(108)§- Material Suffix	.108 ±.0010	RELAR
RE2(109)§- " "	.109 ±.0010	"
RE2(110)§- " "	.110 ±.0010	"
RE2(111)§- " "	.111 ±.0010	"
RE2(112)§- " "	.112 ±.0010	"
RE2(113)§- " "	.113 ±.0010	"
RE2(114)§- " "	.114 ±.0010	"
RE2(115)§- " "	.115 ±.0010	"
RE2(116) - " "	.116 ±.0010	RELAQ
RE2(117) - " "	.117 ±.0010	"
RE2(118) - " "	.118 ±.0010	"
RE2(119) - " "	.119 ±.0010	"
RE2(120) - " "	.120 ±.0010	"

§ Max. Buckling & Eccentricity = .050"

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ALL DIMENSIONS IN Inches UNLESS OTHERWISE SHOWN

DIMENSIONS SHOWN WITHOUT TOLERANCES ARE NOMINAL

☆ INDICATES A CHANGE ★ INDICATES AN ADDITION SCALE-

13-429-12-60

PC12736-107HE

NOV 1 1944

SUBJECT Punching Schedule For Cathode
 Ray Aperture Discs.

SUPERSEDED DATE 12/8/43

SCHEDULES

Schedule	Center Hole "C" Dia. Tolerance	#Max. Variation between <u>E & E</u> of Center Hole	Center Hole Tolerance	
			Out of Round	<u>§Burr</u>
A	±.001	±.001	.0005	No burr in direction of skirt. Max. burr opposite direction .001"
C (Same as A, Note 1)				
E (" " " " ")				
**F	±.001	§§ ±.007	§§ .001	Same as A

- Notes: #1 Schedules C and E will be removed from the Stdzg. Notices and replaced by schedule A.
 #2 For parts which have center recess, the center hole variation is measured from E of recess.
 § When parts are out of specification due to tool wear they shall be tumbled to bring them within specifications.

**§ For present tools only.

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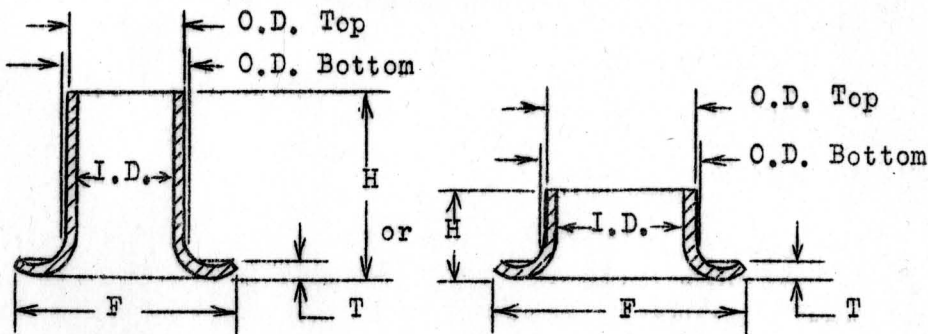
SUBJECT

SUPERSEDED DATE 12/21/42

RE6 EYELET OR SPACER

STENATIVE

Do not order permanent tools on this specification.



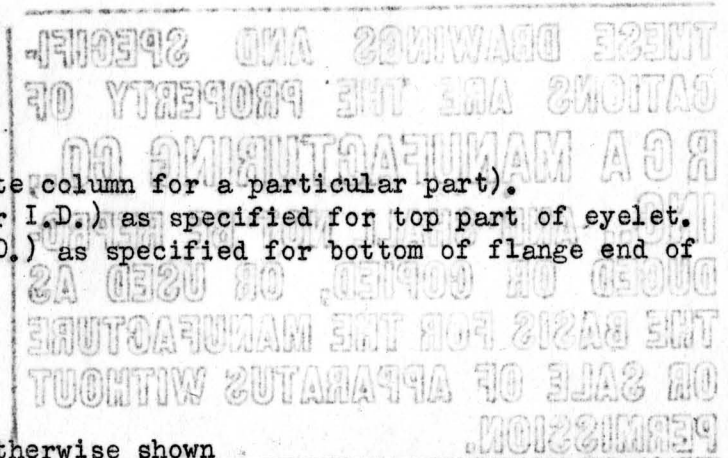
General Notes

1. Max. allowable burr = thickness of material unless otherwise shown.
2. O.D. include out-of-round unless otherwise shown.

Eyelet	O.D.	I.D.	F	H	T	Material		Notes
						Size(In.)	Length(In)	
RE6A	Top .056±.003 Bot .058±.003	.046±.003	.115±.005	.095±.005	.010	.005x	-	-
RE6B	-	.048±.003	.118±.003	.100±.005	.010	.005x	-	-
RE6C	-	.068±.002	.156±.005	.125±.005	.015	.005x	-	-
RE6D	(Note 2)	.051±.003	.115±.003	.130±.005	.010	.005x	-	2
RE6E§	-	.051±.003	.115±.003	.100±.005	.010	.005x	-	-
**RE6F	Top .050±.003 Bot .052±.003	.040±.003	.109±.005	.075±.005	.010	.005x	-	-

Notes (Apply when referred to in note column for a particular part).

1. "Top" refers to diameter (O.D. or I.D.) as specified for top part of eyelet.
 "Bot" refers to dia. (O.D. or I.D.) as specified for bottom of flange end of eyelet.
2. Issued to consume stock.



All dimensions in Inches unless otherwise shown

15-446-13-1

SUBJECT

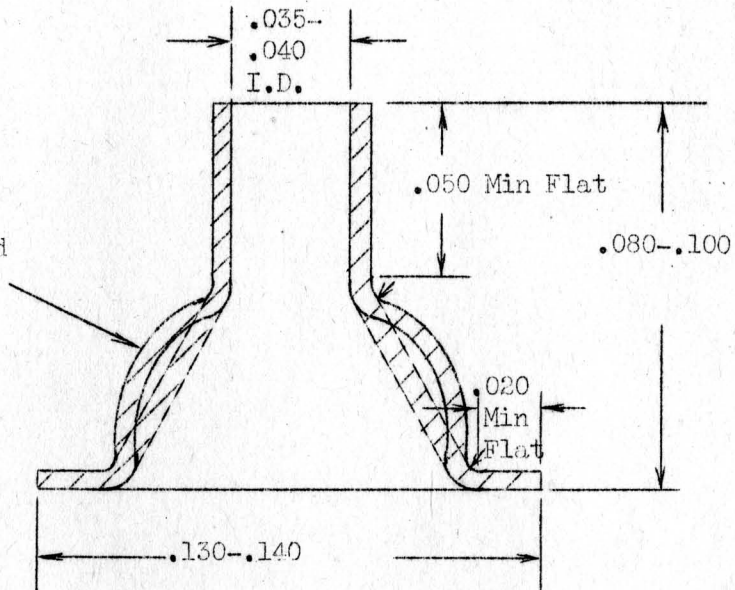
SUPERSEDED DATE

RE602 EYELET

TENTATIVE

Permanent tools must not be ordered from this specification.

Sides may be curved or straight



NOTES: #1 Radius of all bends optional

MATERIAL: .005"-.007"

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DIMENSIONS SHOWN WITHOUT TOLERANCES ARE NOMINAL 2-445-1-62

J.P.-103104RBS

★ INDICATES A CHANGE

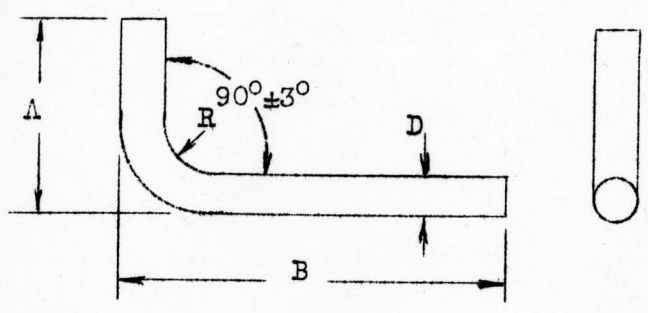
★★ INDICATES AN ADDITION

SCALE— 20:1

SUBJECT FORMED WIRE SUPPORTS
(RIGHT ANGLE FORMED IN ONE PLANE)

SUPERSEDED DATE 9/13/44

WL FORMED WIRE SUPPORTS



Designation Example: 600WL-N5C
600 (Prefix)-First line below
W-Indicates "Wire" part
l-Indicates Right Angle formed.
- Used as separator in support designation.
N5C-Indicates N5C material as per Stdg. Not. 33-N-5C

MANUFACTURING SPECIFICATIONS

Pre fix No.	Dimensions			R Non. (nils)	Approx Undev Lenth (mm)	Pre fix No.	Dimensions			R Non. (nils)	Approx. Undev. Lenth. (mm)
	D (nils)	A (mm)	B (mm)				D (nils)	A (mm)	B (mm)		
600	30	5.0±.5	82.0±.5	30	85.2						
601	30	5.0±.5	65.0±.5	30	68.8						
602	30	4.0±.5	55.0±.5	30	57.2						
603	30	5.0±.5	19.0±.5	30	22.8						
604	30	5.0±.5	40.0±.5	30	44.8						
605	30	5.0±.5	76.0±.5	30	79.8						
606	30	5.0±.5	15.0±.5	30	18.4						
607	60	8.5±.5	18.0±.5	60	28.5						
608	60	16.5±.5	15.0±.5	60	39.5						
609	20	9.0±.5	106.0±.5	20	114.2						
610	30	8.0±.5	42.0±.5	30	48.8						
611	30	2.5±.5	28.0±.5	30	29.2						
612	30	2.5±.5	20.0±.5	30	21.2						
613	30	7.5±.5	7.5±.5	30	13.8						
614	30	5.0±.5	33.0±.5	30	37.0						
**615	30	14.0±.5	18.0±.5	30	31.5						

General Notes

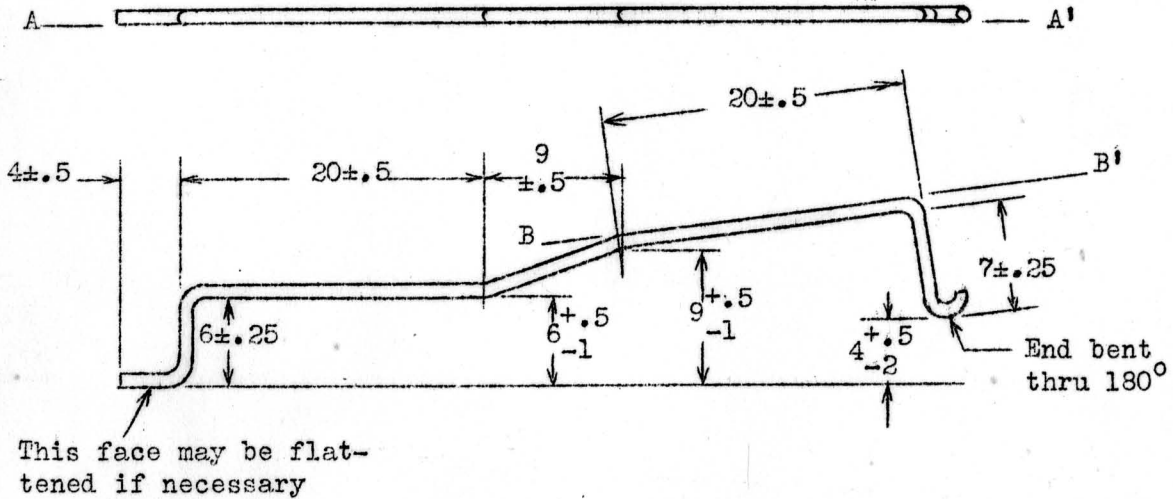
- Max. camber along length -
0.5mm for lengths 0-50mm
1.0mm for lengths 51-100mm
1.5mm for lengths 101-150mm
- .010" max. burr

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SUBJECT

SUPERSEDED DATE 10/ 3/41

W772A GETTER SUPPORT



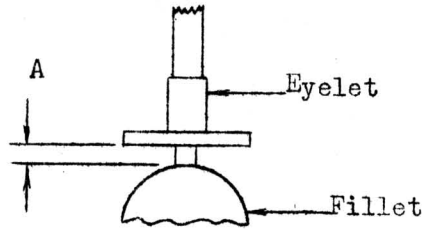
NOTE:- Radius of all bends = .060" max.
 Max. camber along AA' = .060"
 Max. camber along BB' = .020"
 ** Max. burr = .010"

MATERIAL SIZE: .040" Dia. x 68.0mm

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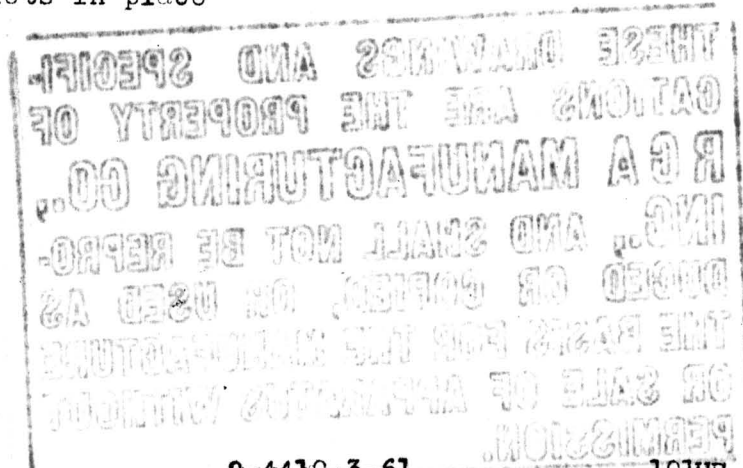
SUBJECT

SUPERSEDED DATE 9/13/44

FM6173 STEM ASSEMBLIES

<u>Stem Assly</u>	<u>Stem</u>	<u>Forming</u>	<u>Eyelet</u>	<u>Dimension A (mm)</u>	<u>Eyelets on Leads No.</u>
FM6173AJ	FSB622	10B601G	RE602-N7-W612 (W614,FCK10)	.0-.5	1,6,8
FM6173AK	FSB622	10B601G	RE6A-N7-W612 (W614,FCK10)	.0-.5	1,6,8
FM6173AL	FSB621	8E600G	RE602-N7-W612 (W614,FCK10)	.0-.5	2,6
FM6173AM	FSB1B	10B600G	"	.0-.5	2,5,6,7,10
FM6173AN	FSB622	10B603G	"	.0-.5	1,10
FM6173AP	FSB622A	10D600G	"	.0-.5	2,6
FM6173AQ	FSB621	7D600G	"	.0-.5	5,7,9
FM6173AR	FSB622A	9C601G	"	.0-.5	3,5,7
FM6173AS	FSB622A	8E600G	"	.0-.5	2,6
FM6173AT	FSB620	10D601G	"	.0-.5	3,8
FM6173AU	FSB622A	10B603G	"	.0-.5	1,10
FM6173AV	FSB622A	10D601G	"	.0-.5	2,6
FM6173AW	FSB622A	8E602G	"	.0-.5	2,6
FM6173AX	FSB621	8E601G	"	.0-.5	2,6
FM6173AZ	FSB616	8G600G	"	.0-.5	1,10
FM6173BA	FSB15	9A600G	"	.0-.5	2,5,6,7,10
FM6173BB	FSB622A	9G600G	"	.0-.5	2,6
FM6173BC	FSB622A	8E603G	"	0.0-0.5	2,5
FM6173BD	FSB621	8E604G	"	0.0-0.5	2,5
→ **FM6173BE	FSB622B	7F600G	"	0.0-0.5	2,3

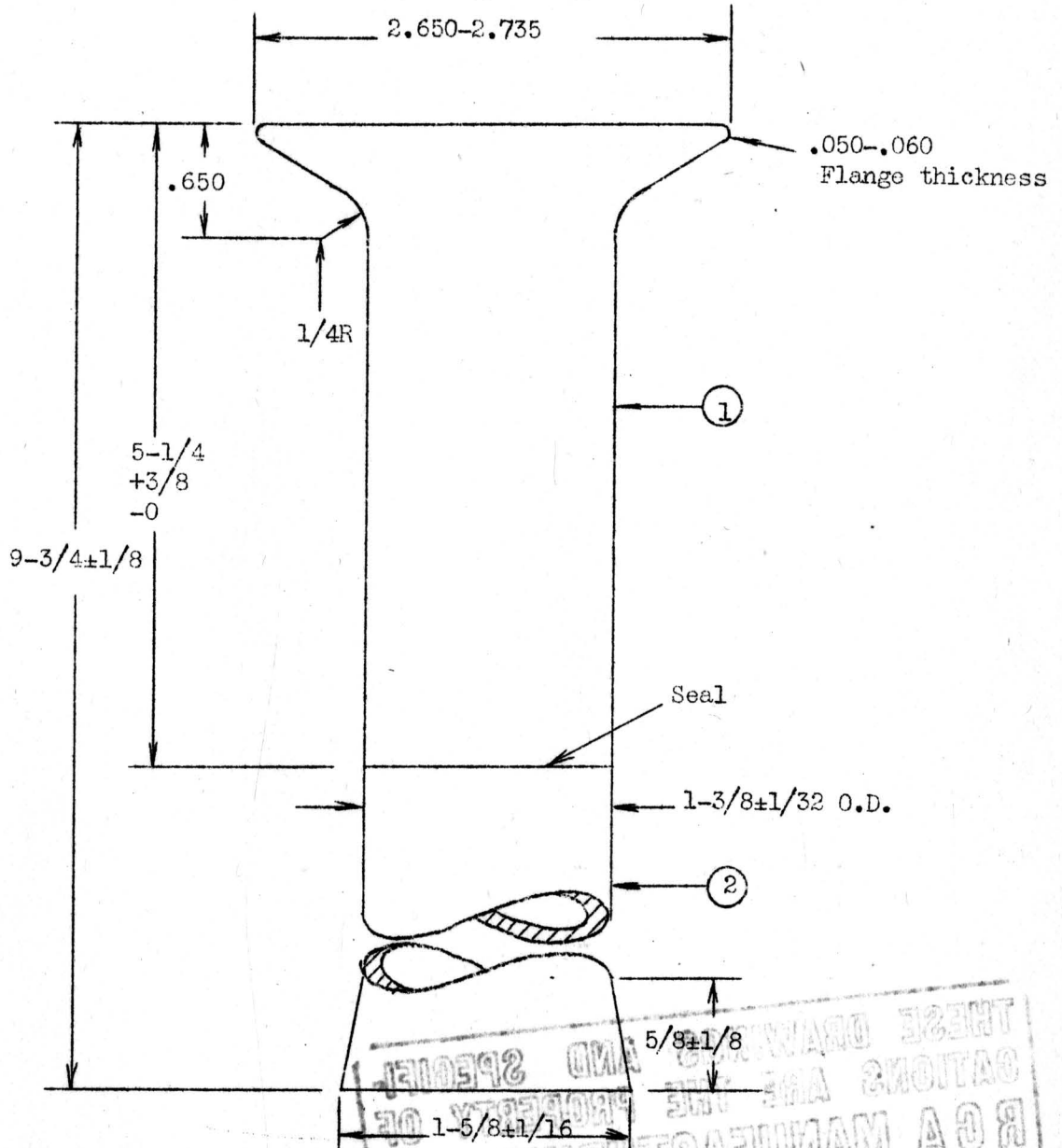
MATERIAL: As given above
 OPERATIONS: #1. Place eyelets on leads.
 #2. Form leads
 #3 Weld eyelets in place



SUBJECT

SUPERSEDED DATE

FM6211 NECK ASSEMBLY



MATERIAL: #1 1-3/8" Dia. (774 Glass) Tubing (6")
(.050"-.100" Wall)

#2 1-3/8" Dia. (772 Glass) Tubing (4-5/8")
(.050"-.100" Wall)

TREATMENT: #1 After splicing check 100% for
neck OD with gauge of I.D.=1.420"
and length=3"

#2 Wash

Stdzg. Not.
10-1-1(774)
10-1-1(772)

34-17-4A, Sched. #2

ALL DIMENSIONS IN Inches UNLESS OTHERWISE SHOWN

DIMENSIONS SHOWN WITHOUT TOLERANCES ARE NOMINAL

* INDICATES A CHANGE

** INDICATES AN ADDITION

3-445-12-61

SCALE--

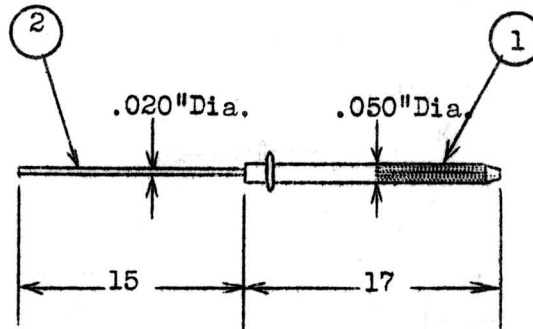
E.S.-103104RBS

SUBJECT

SUPERSEDED DATE

FW362 LEAD

Proposed for Cathode Ray Tubes



MATERIAL: #1 W749A-C72 Lead (W1, FCK5)
 #2 2015A1-N5C Lead
 TREATMENT: Schedule FBK7

Stdz. Not.
 13-1-1W
 13-1-1
 34-1-1

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DIMENSIONS SHOWN WITHOUT TOLERANCES ARE NOMINAL

☆ INDICATES A CHANGE

☆☆ INDICATES AN ADDITION

3-406-12-1

SCALE— 2:1

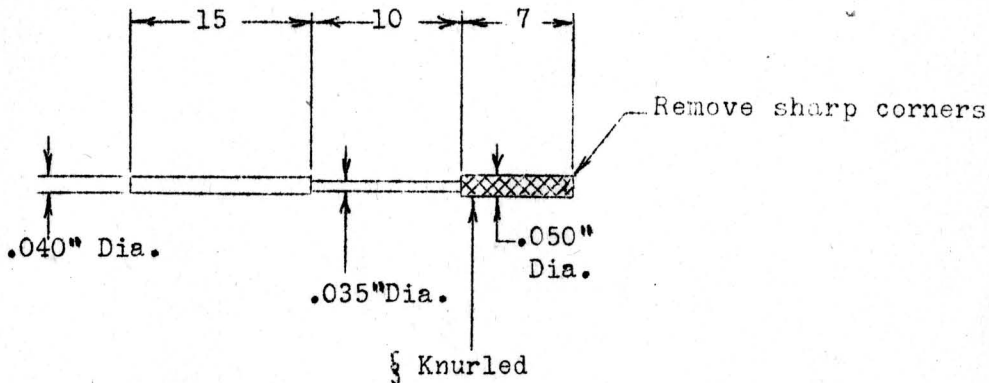
NOV 10 1940

SUBJECT

SUPERSEDED DATE 2/24/44

FW368A LEAD

Proposed for Cathode
Ray Tubes



MATERIAL: §4015 Ni-3510T-507 Ni

Stdzg.Not.

33-L-22

§ Depth of knurl not to be less than .0045" and not greater than .010".
Reject if 5% or more do not meet the above specifications.

All Dimensions in mm Unless otherwise shown

*Nomenclature changed

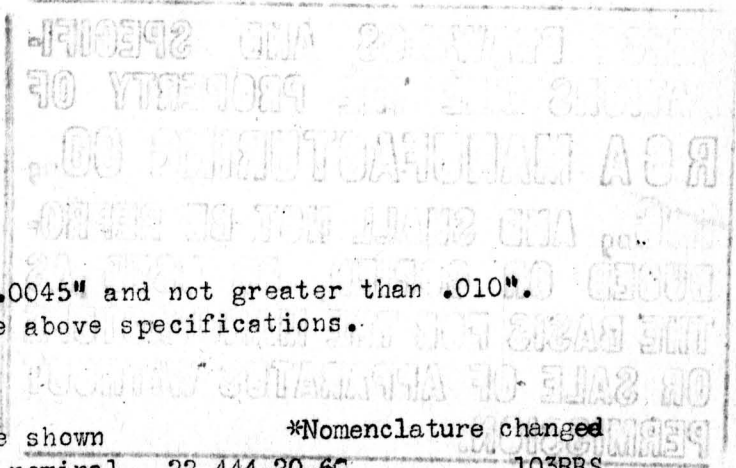
Dimensions shown without tolerances are nominal 22-444-20-65

103RBS

★ INDICATES A CHANGE

★★ INDICATES AN ADDITION

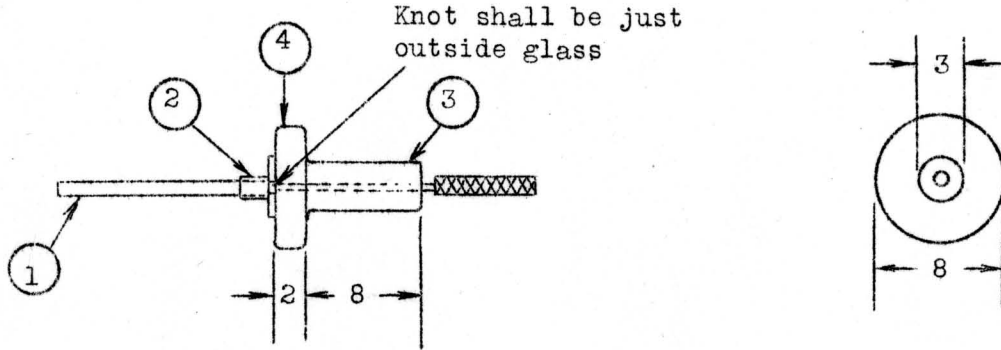
Scale 2:1



SUBJECT

SUPERSEDED DATE

FW631 LEAD ASSLY



- MATERIAL:**
- | | |
|--------------------------------------|--------|
| #1 FW368A Lead | (1) |
| #2 RE6B-N7 | (1) |
| #3 Ga.14,15,16(No.7051) Glass Tubing | (10mm) |
| #4 Ga.25(No.7051) Glass Tubing | (13mm) |

Stdzg. Not.

(1)	13-1-2
(1)	13-1-RE
(10mm)	10-1-1
(13mm)	10-1-1

- PROCEDURE:**
- #1 Bead Material #1 with material #3
 - #2 Apply material #4 and mold complete bead.
 - #3 Weld on material #2.

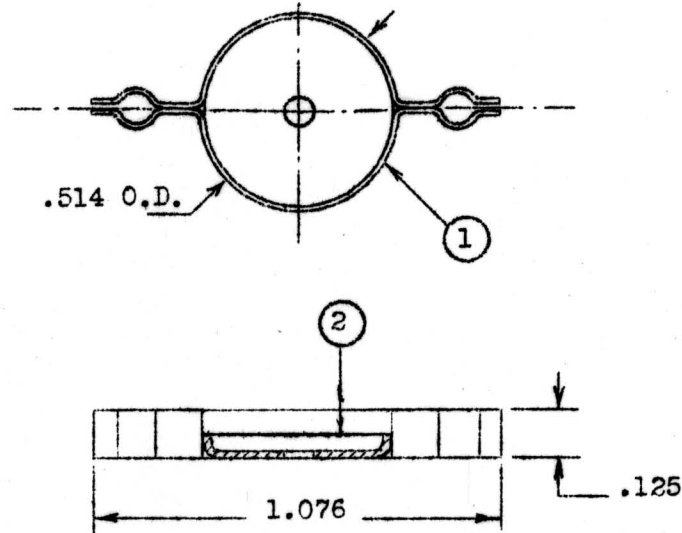
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SUBJECT

SUPERSEDED DATE 6/27/44

FP364R-2 GRID ASSEMBLY

Proposed for 3EP1



MATERIAL:	<u>(#1) Anode</u>	<u>(#2) Aperture Disc</u>
Qty:	1	1
Stdzg.Not:	9-1-1	13-1-1RA

Assly Treatment
Stdzg.Not.34-1-1

Assly Desig.
FP364R-2

*P364R-S48-M6W612(W614) RA3-S48-75A-W612, *W614,FCJ10
(W614)

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DIMENSIONS SHOWN WITHOUT TOLERANCES ARE NOMINAL

8-447-22-61 8-107RBS

★ INDICATES A CHANGE

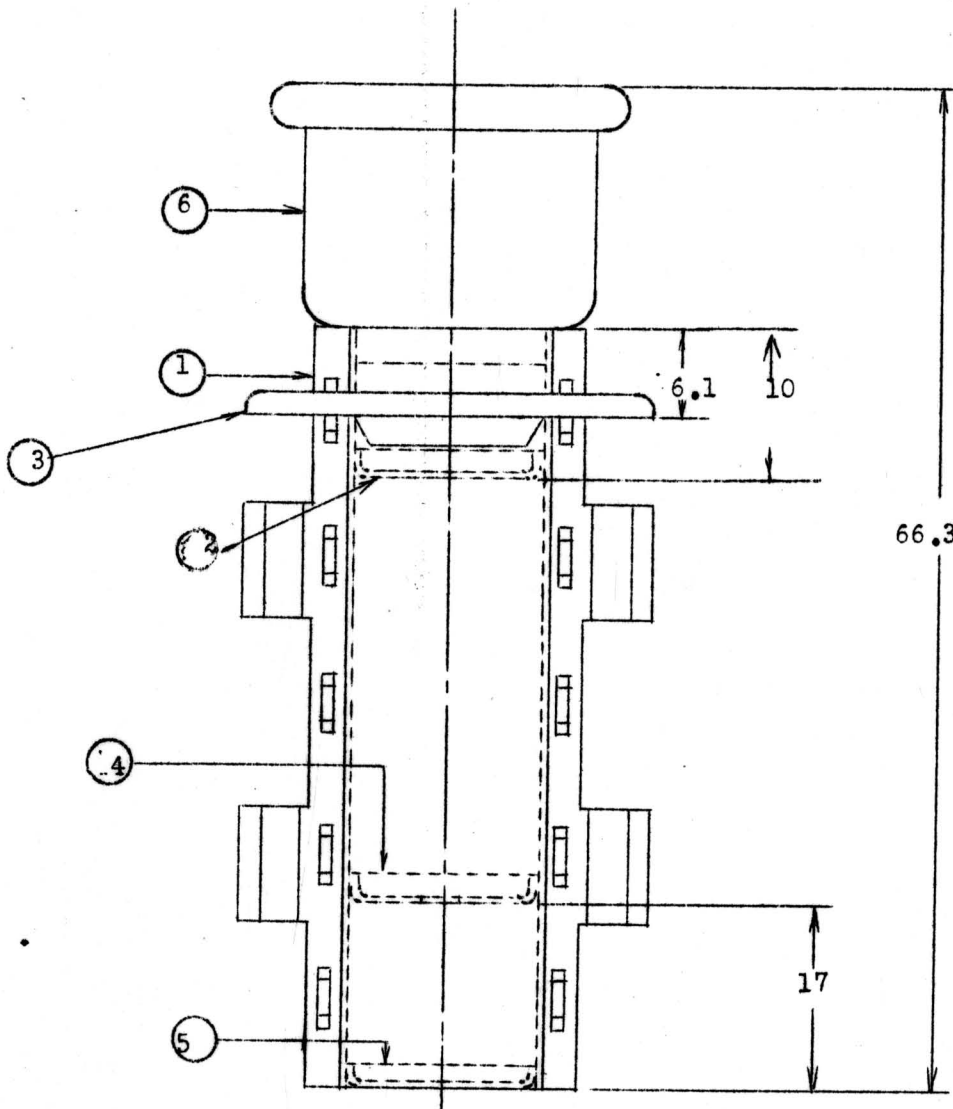
★★ INDICATES AN ADDITION

SCALE-- 2:1

SUBJECT

SUPERSEDED DATE

FF364-604 ANODE ASSEMBLY



- MATERIAL:
- #1 F364-S48-W6W612 Anode Cylinder (W614) (1)
 - #2 RA3-S48-250A-W612P2 Top Aperture (W614) (1)
 - #3 R1794-S48-W612 Bulb Spacer Support (614) (1)
 - #4 RA3-S48-75A W612P2 Center Aperture (W44) (1)
 - #5 RA3-S48-250A-W612 Bottom Aperture (1)
 - #6 R1550A-S48-W612 Thimble (W614) (1)

Stdzg. Not.
9-1-1

TREATMENT: Schedule FCK10

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DIMENSIONS SHOWN WITHOUT TOLERANCES ARE NOMINAL

INDICATES A CHANGE

☆ INDICATES AN ADDITION

9-447-22-61

SCALE—

2:1

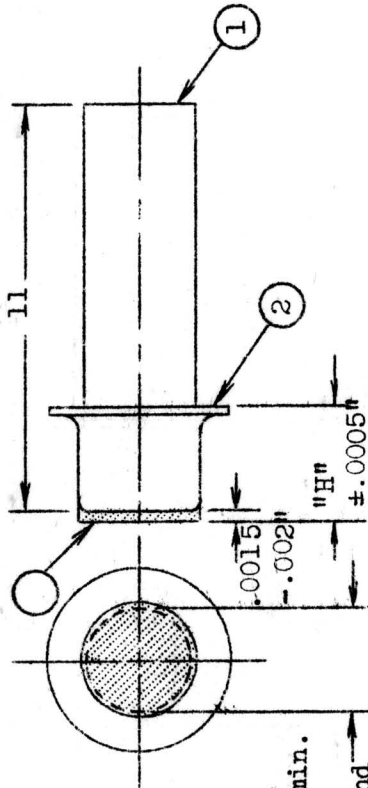
E.S. 103104 JIW

SUBJECT

SUPERSEDED DATE

FK12OR3-602 COATED CATHODE ASSEMBLY

Proposed for 2.5V
Cathode Ray Tubes

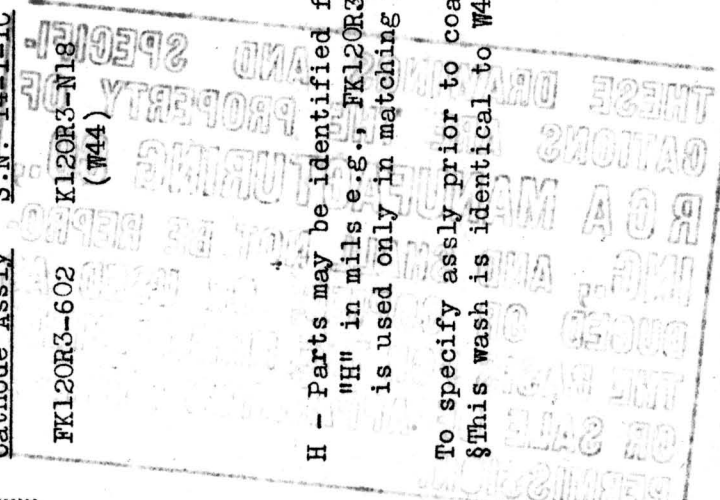


Flat area .115" dia. min.
Any injury to edge of
coating must not extend
inside .105" min. dia.
circle.

Coated Cathode Assy	(1) Cathode S.N.	(2) Cap S.N.	Uncoated Cath. Assy Treat. S.N.	(3) Coating Prep. S.N.	Assly Process S.N.
FK12OR3-602	K12OR3-N18 (W44)	R1485B-N34A (W44, FCF10, FAH10)	W448, FAH10	33-C-131 (.5mg)	34-14-5F

H - Parts may be identified for stocking purposes only by adding a suffix indicating dimensions "H" in mils e.g., FK12OR3-602 (105). This suffix will not appear on any parts list since it is used only in matching parts for assly.

To specify assly prior to coating, prefix designation with "U", such as UFK.
§This wash is identical to W44 except cathodes are oven dried between steps "A" & "B".

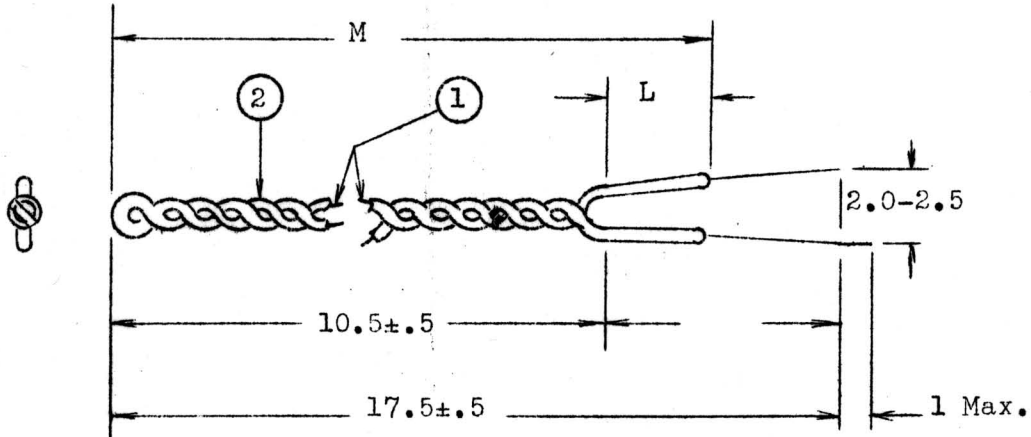


SUBJECT

SUPERSEDED DATE 5/12/44

Proposed for C.R. and
Licencees

MCF140D COATED DOUBLE HELICAL FIL
and
CF140D DOUBLE HELICAL FIL



Manufacturing Specifications

1. Mandrel Diameter - - - - - .070"
2. T.P.I. (Theoret. Finished) - - - - - 12
3. Cut Length of Wire (mm) - - - - - 71
4. Weight Limits (cut length of wire) mg - - - - - 26.6(26.0-27.2)
5. Weight Limits (Uncoated Coil) - - -mg- - - - - 26.6(25.9-27.3)

Material Specifications

1. Wire - - - - - D18 Dowmo (2-30)
 - (a) Wire Weight (mg/200mm) - - - - - 75.0±1.50 (2%)
 - (b) Equivalent Diameter (mils) - - - - - 7.5
 - (c) Material Reference - - - - - Stdzg. Not. 33-D-18

Coating Specifications

MCF Suffix	Preparation	Wgt.	Application & Firing		L (mm)	M	Coated O.D.No
	Stdzg.Not.	Coating (mg)	Stdzg. Not.				
140D-1	13C-46-9	19-21.5	34-14-13D		2	-	-
140D-2	33-C-203	19-21.5	34-14-13D		1.5-3.5	-	**2
140D-3	13C-46-9	19 min.	34-14-13D		4	-	.108" Max. 1

Notes 1. Coils not to have flooded turns or be paired.
Coating not to be chipped.

**2. All filaments shall be submitted to a microscopic inspection for chips, foreign bodies, heavy sprayed legs, paired turns and rough coating.

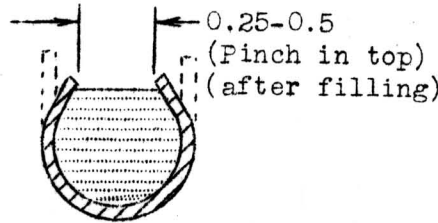
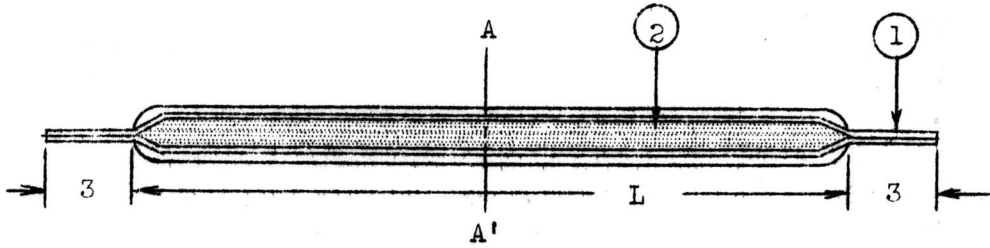
SUBJECT

SUPERSEDED DATE 8/8/44

FZ6009 GETTER ASSEMBLY

Proposed for 813, etc.

Similar to FZ393 except
retainer.



Section at A-A'
Scale 20:1

MATERIAL: (#1) Retainer

(#2) Getter Material

Qty.: 1
Stdzg. Not. 13-1-1R

- See below
See below -

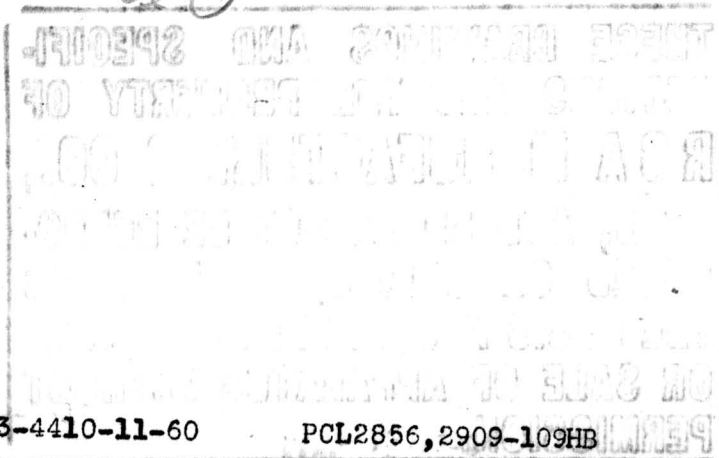
Getter Assly	Prep.	Dimension	Treatment
FZ6009	R1460H-M14MB 6-W614"	30-40 mg.	14
FZ6009A	R1460K-M14MB 6- W616*, FCK10*	" "	24
FZ6009B	R6104-M14MB 6-W612	" 35-40 mg.	30

1:2.4
B₂O₃: BeO

ALL DIMENSIONS IN mm UNLESS OTHERWISE SHOWN
DIMENSIONS SHOWN WITHOUT TOLERANCES ARE NOMINAL
INDICATES A CHANGE ** INDICATES AN ADDITION

13-4410-11-60

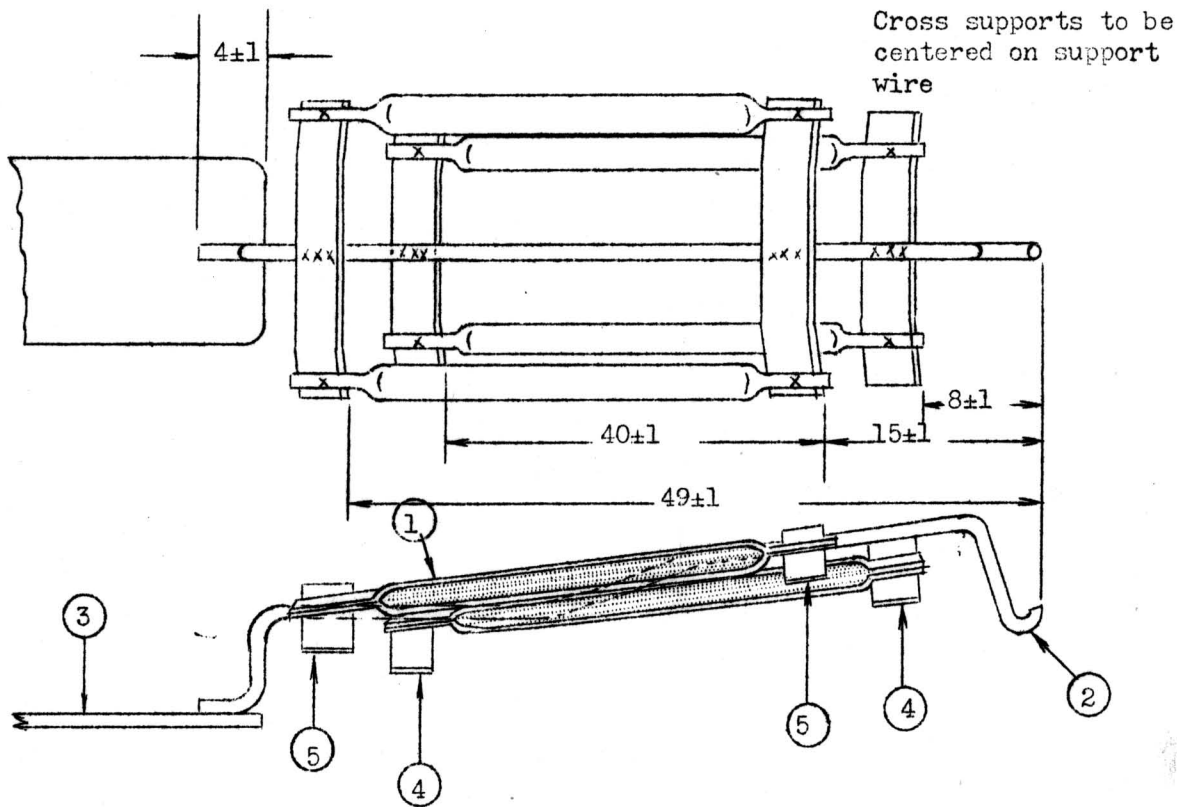
PCL2856, 2909-109HB



SUBJECT

SUPERSEDED DATE 5/8/44

FZ6033 COMPLETE GETTER ASSLY

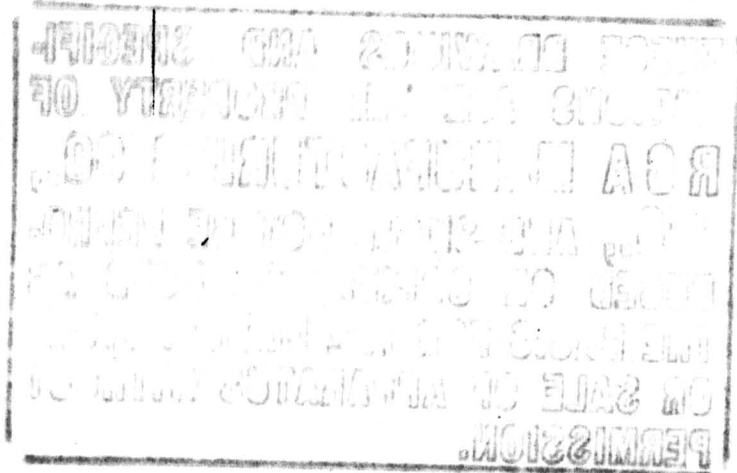


NOTES: #1 Getter assly welded to supports with silver or tungsten-moly electrodes.

MATERIAL: #1 FZ6009B Getter Assly (4)
 #2 W772A-N29-*W612 Support (W614) (1)
 #3 R1725B-N23D-*W612 Bulb Contact(W614)(1)
 #4 R1896-N23-*W612 Support (W614) (2)
 #5 R7006-N23-*W612 Support (2)

Stdzg. Not.

15-1-1
 13-1-1W
 13-1-1R
 13-1-1R
 13-1-1R

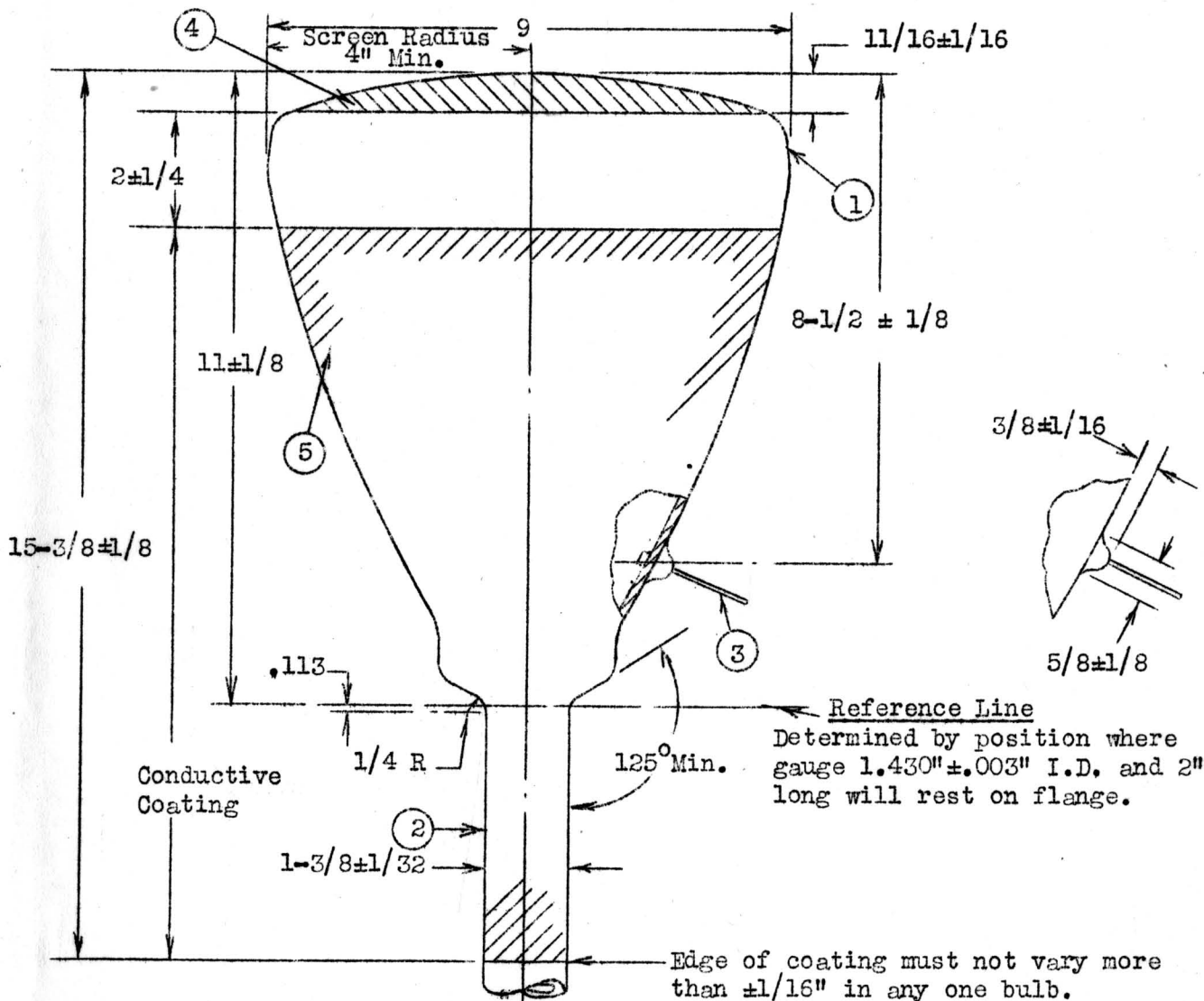


SUBJECT

SUPERSEDED DATE

Proposed for C730T

FB72-601 BULB ASSEMBLY



MATERIAL:			<u>Stdg. Not.</u>
#1	J72J2 (774 Pyrex Glass) Bulb	(1)	17-7-2
#2	FM6211 Flare	(1)	13-1-2
#3	FW631 Anode Lead Assly	(1)	13-1-2
#4	Fluorescent Coating Area 400 sq. cm. (2mg/sq. cm.)		
	Prep 33-Z-12 (400mg)		
	& 33-Z-13 (400mg)		
#5	Prep 33-G-32 Conductive Coating		

OPERATIONS:			
#1	Clean Bulbs	Sched. #14	34-17-4A
#2	Seal in Anode Lead		34-18-8A
#3	Apply Fluorescent Screen		34-17-14
#4	Apply Conductive Coating		34-17-11
#5	(a) Bake 1 hour at 385° ± 15°C with 3-3/4 min. index period		
	(b) Air jet 4psi		
	(c) Air jet 3-1/2" from screen		

ALL DIMENSIONS IN Inches UNLESS OTHERWISE SHOWN
DIMENSIONS SHOWN WITHOUT TOLERANCES ARE NOMINAL 3-449-22-60
* INDICATES A CHANGE ** INDICATES AN ADDITION SCALE- 1:3

101105gec

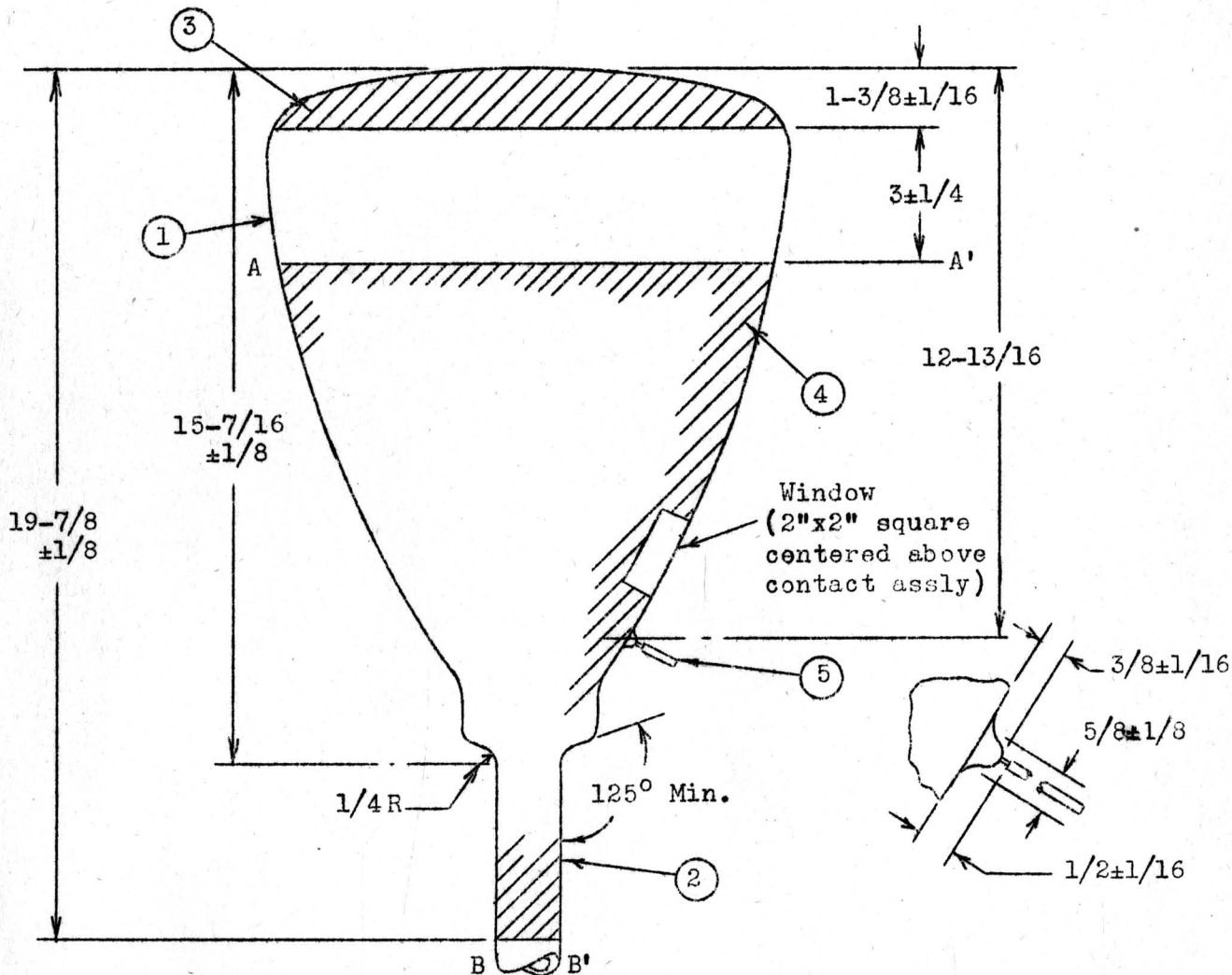
SUBJECT

SUPERSEDED DATE

Proposed for
12AP4

FB96-604 BULB ASSEMBLY

Similar to
FB96-603



- MATERIAL:**
- #1 J96C2 Bulb (#774 Glass) (1)
 - #2 FM6211 Neck (1)
 - #3 Fluorescent Coating 33-Z-12 (700mg)(700sq. cm)
 - 33-Z-13 (700mg)
 - #4 33-G-32 Conductive Coating
 - #5 FW631 Anode Lead Assly (1)

Stdzg. Not.

17-7-2
13-1-2

OPERATIONS:

- #1 Seal bulb to neck Sch. #17A
- #2 Clean bulbs
- #3 Seal in anode lead
- #4 Application of fluorescent screen
- #5 Apply conductive coating AA' to BB'

13-1-2

34-17-4A

34-18-8A

34-17-14&15A

34-17-11

- (a) Bake 1 hr. at 385° ± 15°C with 3-3/4 min. index period.
- (b) Air pressure 4 psi.
- (c) Air jet 3-1/2" from screen.

ALL DIMENSIONS IN INCHES UNLESS OTHERWISE SHOWN

DIMENSIONS SHOWN WITHOUT TOLERANCES ARE NOMINAL

* INDICATES A CHANGE

** INDICATES AN ADDITION

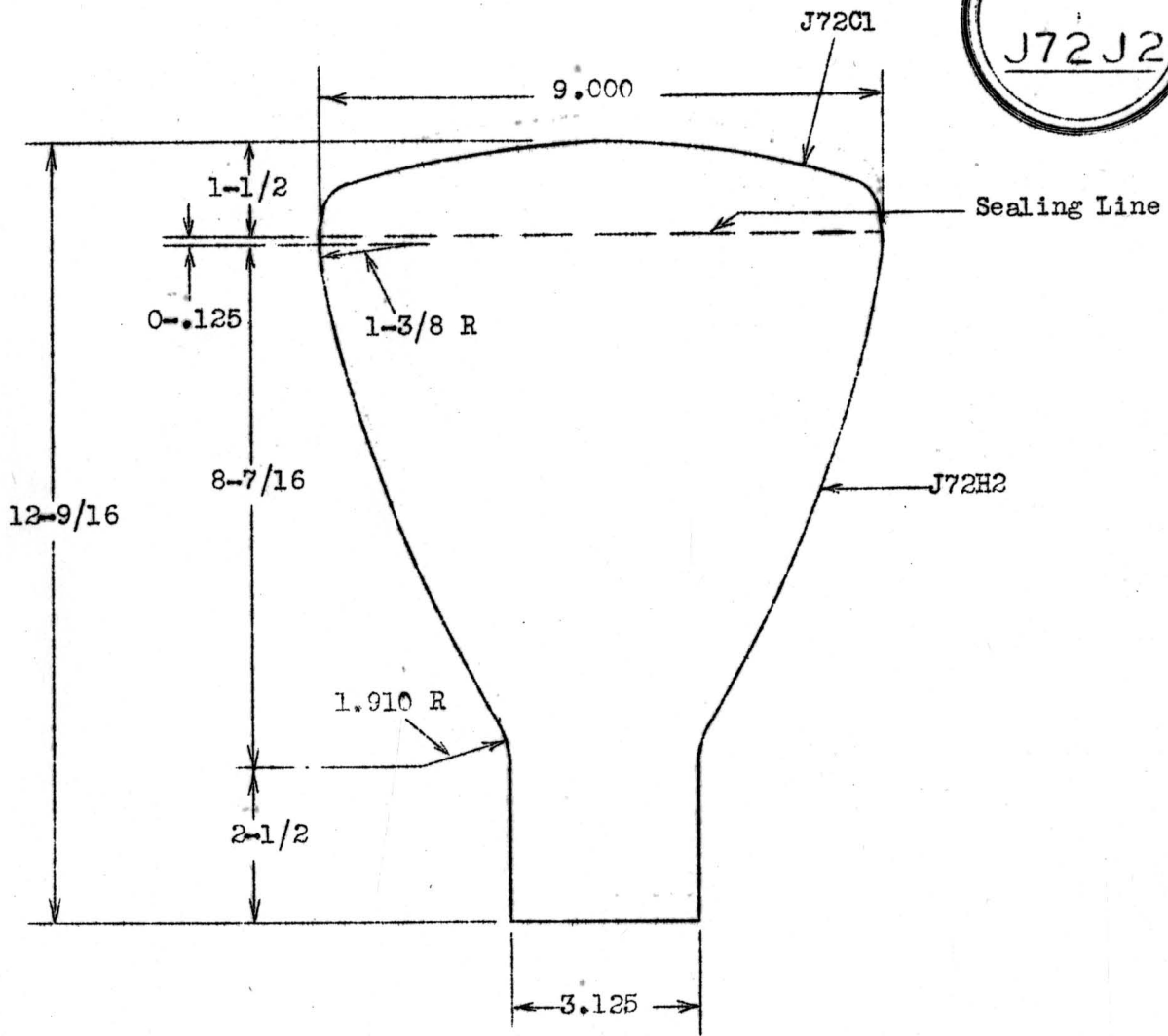
SCALE-- 1:4

10-4410-4-61

101105HE

SUBJECT

SUPERSEDED DATE



NOTES

All dimensions are outside measure & for finished bulb. For detail specifications see Stdzg. Not. 17-8-3, page J72J2.

Note: This bulb is made by joining the J72C1 top and J72H2 body as shown.

ALL DIMENSIONS IN Inches UNLESS OTHERWISE SHOWN

DIMENSIONS SHOWN WITHOUT TOLERANCES ARE NOMINAL

★ INDICATES A CHANGE

★★ INDICATES AN ADDITION

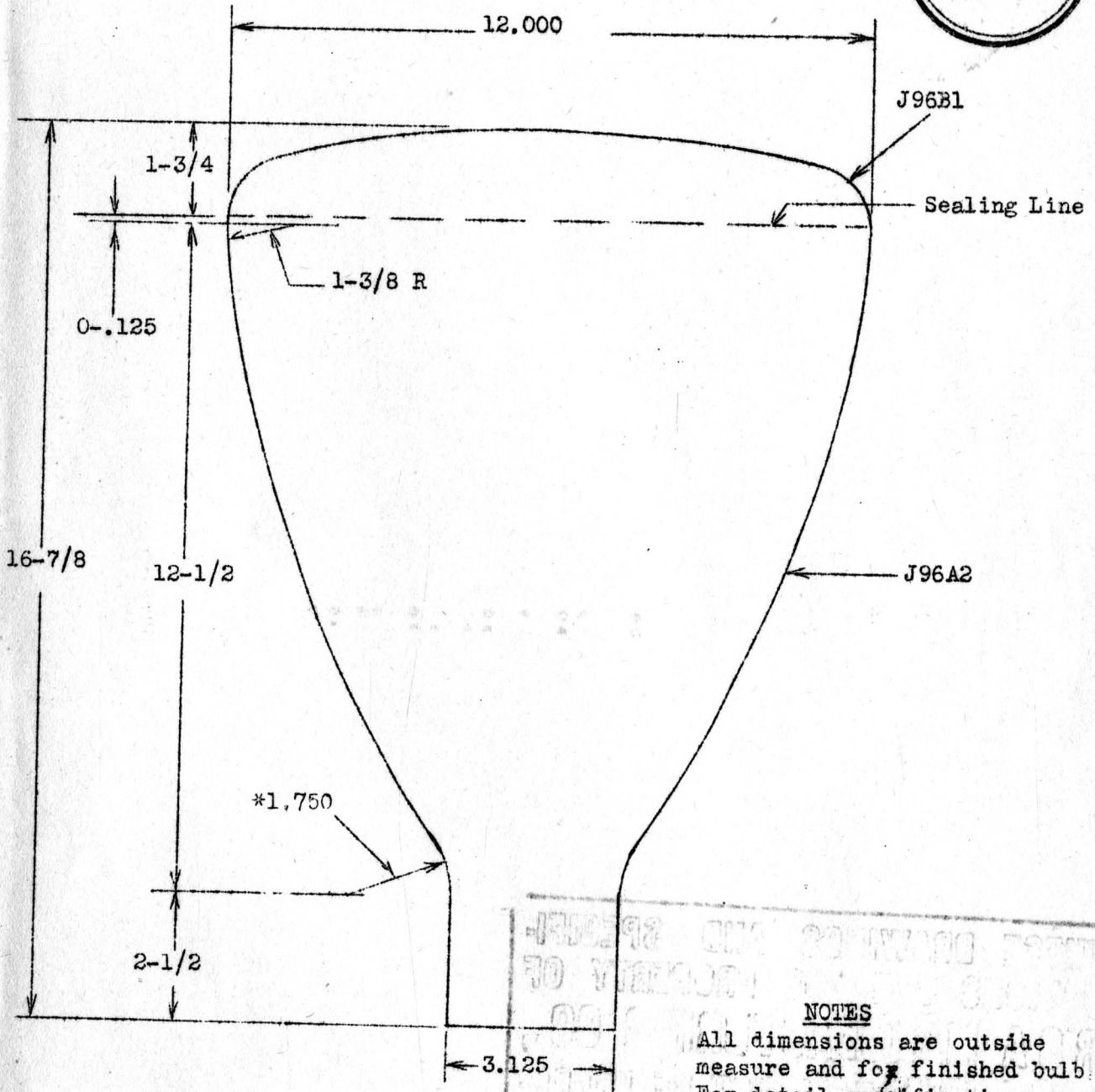
2-428-3-1

SCALE- 1/3:1

1110

SUBJECT

SUPERSEDED DATE 8/5/48



NOTES

All dimensions are outside measure and for finished bulb. For detail specifications see Stdzg. Not. 17-8.3, p. J96C2.

Note: This bulb is made by joining the J96B1 top and J96A2 body as shown.

*To agree with bulb after enlarging neck.

ALL DIMENSIONS IN INCHES UNLESS OTHERWISE SHOWN
DIMENSIONS SHOWN WITHOUT TOLERANCES ARE NOMINAL
INDICATES A CHANGE * INDICATES AN ADDITION
1-414-25-61
SCALE-- 1/3:1

H.S.L.-105RBS

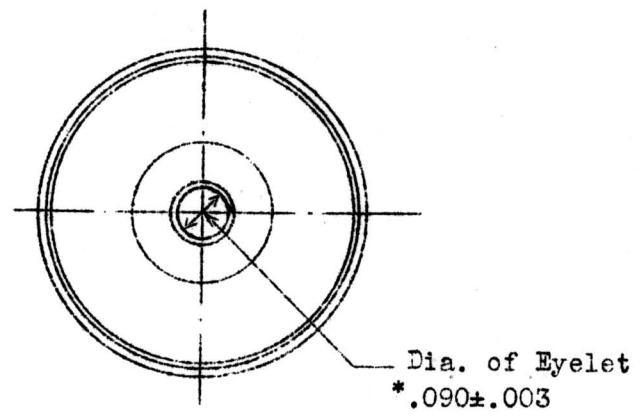
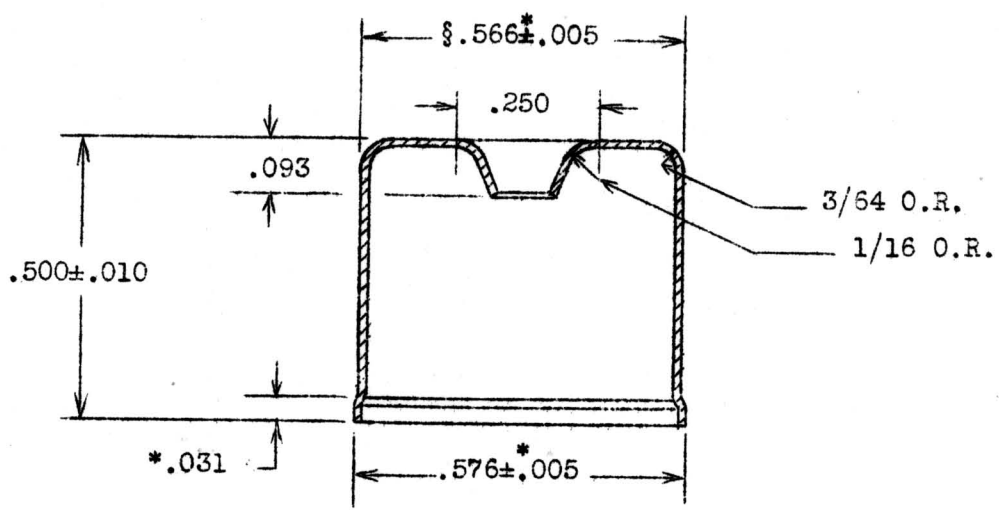
7/21/43

STANDARDIZING NOTICE 24-1-1

SUBJECT BASE MFG. DIMENSIONS

SUPERSEDED DATE 12/10/37

NO. 3903 BASE



Material - - - - - .014" Brass
 Finish - - - - - *Bright Nickel

§ Old Tool Tolerance $.566 + .010$
 $-.016$

ALL DIMENSIONS IN Inches UNLESS OTHERWISE SHOWN
 DIMENSIONS SHOWN WITHOUT TOLERANCES ARE NOMINAL

* INDICATES A CHANGE

☆ INDICATES AN ADDITION

SCALE-- 3:1

APR 0 1 1939

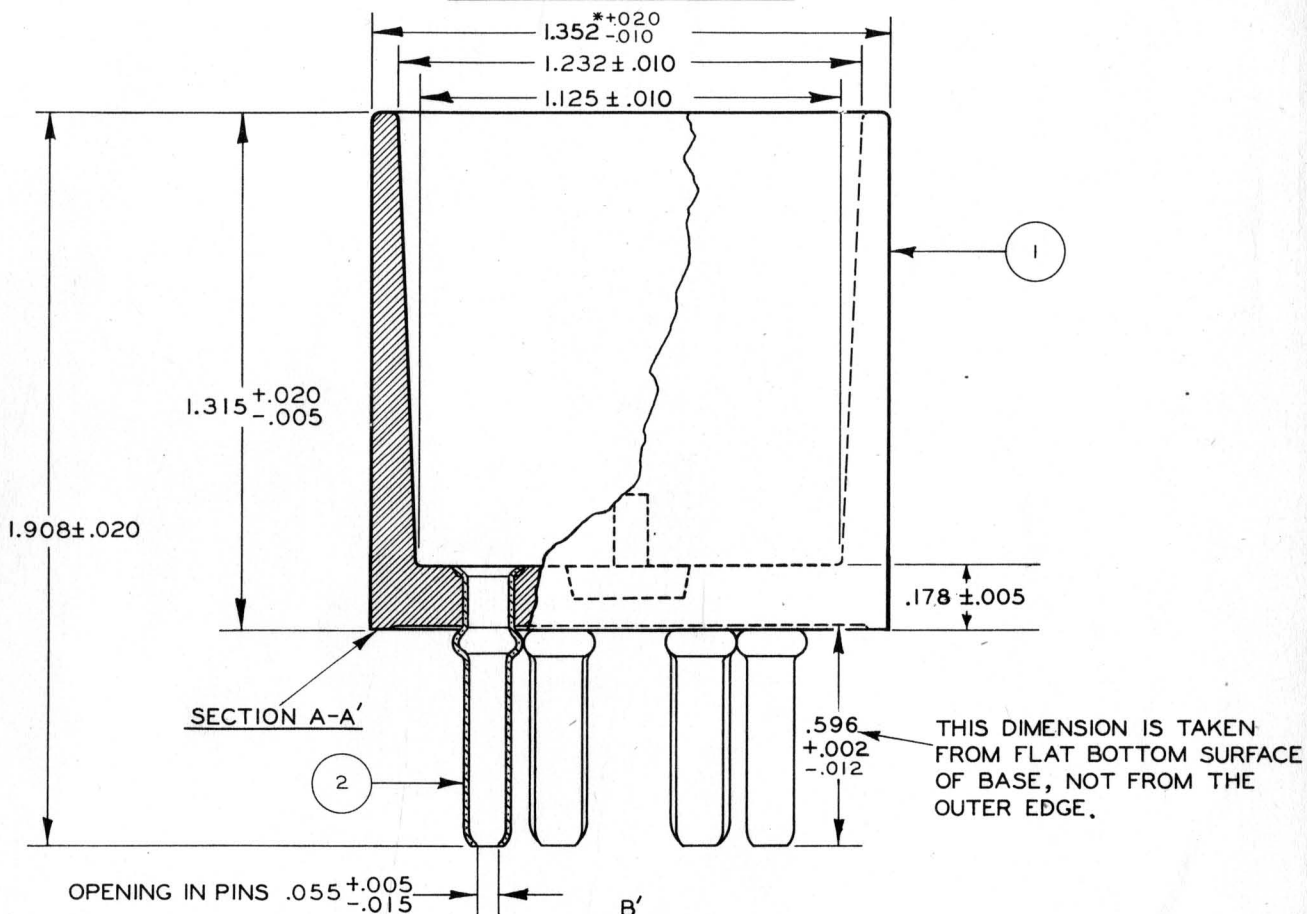
SUBJECT N^o 6105 -B3 BASE -MFG. DIMENSIONS

STANDARDIZING NOTICE 24 - 1 - 1.

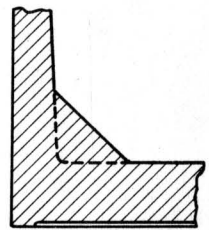
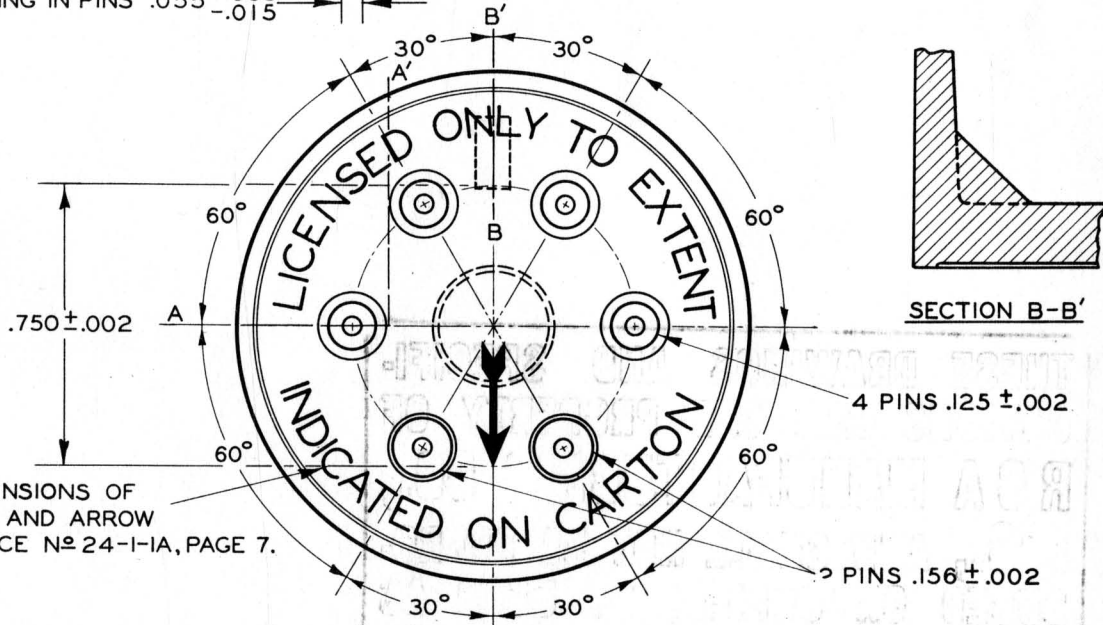
SUPERSEDED DATE 12-12-35

N^o6105 - B3 BASE

MEDIUM 6-PIN (LONG)



OPENING IN PINS $.055^{+.005}_{-.015}$



SECTION B-B'

MATERIAL SPECIFICATIONS

- 1.- SHELL-----RESIN COMPOUND.
- 2.- CONTACT PINS-----BRASS, BRIGHT NICKEL FINISH.

*INDICATES A CHANGE
 ALL DIMENSIONS IN INCHES
 UNLESS OTHERWISE SHOWN
 5-428-7-1

SCALE-2:1

* R2-O.D. TOLERANCE INCREASED.
 DRAWING No. 925-6041R2
 1130

SUBJECT 33-B-76 BARIUM GETTER COATING
Material Handling Specifications

SUPERSEDED DATE 3/27/44

1. USE Channeled ribbon getter.
2. ORDER As "33-B-76 Barium Getter Coating"
from Factory #8, made by Process 15C-B-76.

*Except at Lancaster order ingredients as given
in 15C-B-76 and prepare coating as specified
in 15C-B-76.
3. SHIPPING UNIT 4 oz. bottle.
4. INSPECTION None
5. FACTORY TEST None. The getter powder used in this coating is tested
and approved in this or some other preparation as detailed
in the material handling specifications for the powder.
6. LABORATORY TEST At Harrison-none. See under Factory Test. At Lancaster-
see page 2.
7. STORING & HANDLING Keep coating in cool place and out of direct sunlight.
At temperature above 30°F and at relative humidities
above 70%, particular care should be taken to keep the
coating from being exposed to the air any more than
absolutely necessary.

The coating in the cup of a getter coating machine shall be renewed every 8 hr
Pack ribbon getters and seal with metal tape as specified in 29-0-9 p.30-2.
Packing containers shall be opened only for removing getter assemblies which
are to be used immediately.

Ribbon getters assembled with a support bar shall be packed in a snap cover
can, kept tightly covered except when taking out assemblies.

The cans should not be reused for getters.

The getter must not be on mounts when they are washed in water since it ruins
the getter action. If mounts are washed they must be thoroly dried in
heated carrier before the getter assembly is mounted.

PRECAUTIONS should be taken to remove all moisture from exhaust tubes.
Gettered mounts held overnight must be kept in a heated carrier as it is
preferable that they be welded to the bulbs. On this occasion moisture
on mounts or in exhaust tubes is particularly undesirable. The doors on
the carriers should be as tight as practical to minimize air circulation.
Bad coating in the ribbon has a glossy, wet appearance.

(Cont'd on page 2)

SUBJECT 33-B-76 BARIUM GETTER COATING
Material Handling Specifications

SUPERSEDED DATE 12/15/43

(Cont'd from page 1)

8. LANCASTER APPROVAL PROCEDURE

Material Control shall send getter *powders & binder as received to *Parts Prep. for compounding whereupon one bottle shall be sampled from each lot, or 10% of bottles if there are more than 10 bottles in lot.

Parts Prep. after milling powders & mixing with binder according to 15C-B-76, shall prepare 2 or 3 RL460H channel getters per bottle. These samples, properly labeled to identify the bottles from which they were made, are to be sent together with all bottles back to LAB.

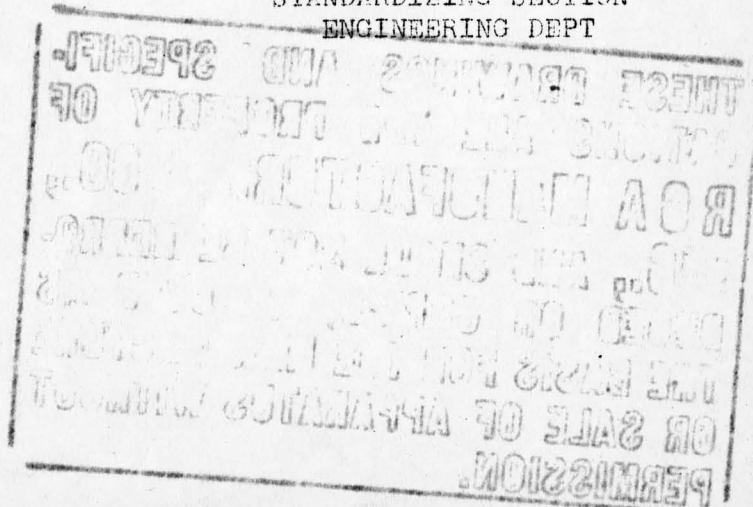
Laboratory shall check samples for gas and barium content and shall reject getter if gas content is over 750 liter microns or if barium content is less than 3.2 mg per getter. Bottles of each lot shall then be properly labeled and returned to Material Control. In case of rejected material, reason for rejection shall be noted on each label. Laboratory shall maintain the following log:

Lot number	Date of Test
Bottle number	Gas & barium content
Date of bottling	Signature of tester.

Storing and Handling Precautions to be observed in addition to those listed under item 7 on page 1.

1. Use only approved getter preparation for the manufacture of getter asslys, filling them not more than 2 days before delivery to factory in moisture-resistant containers.
2. Store containers of asslys in clean dry cabinets.
3. Mark outside of container with type of getter contained and date of filling.

STANDARDIZING SECTION
ENGINEERING DEPT



RCA VICTOR DIVISION
RADIO CORPORATION OF AMERICA
STANDARDIZING SEC., ENG. DEPT.
HARRISON, N. J., U.S.A.

DATE

PAGE

STANDARDIZING NOTICE

33-G-32

SUBJECT

Material Handling Specifications

SUPERSEDED DATE

- 1. USE Conductive bulb coating in high voltage tubes.
- 2. ORDER As "33-G-32 Graphite Coating" from Laboratory Dept. 675 or Fact. 2 where it will be made by Process 34C-G-32.
- 3. SHIPPING UNIT Pint Mason jar.
- 4. INSPECTION None.
- 5. FACTORY TEST None.
- 6. LABORATORY TEST None.

STANDARDIZING SECTION
RESEARCH & ENGINEERING DEPT.

APR 1953

JLQ, CT-2

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HARRISON, N. J., U.S.A.

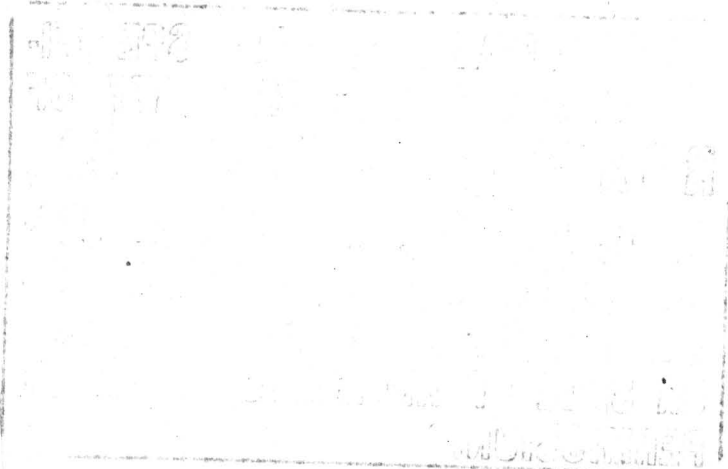
STANDARDIZING NOTICE 33-Z-13

SUBJECT ZINC SULPHIDE SUSPENSION
Material Handling Specifications

SUPERSEDED DATE

- 1. USE Fluorescent screens.
- 2. ORDER As "33-Z-13 Suspension"
 from Factory No. 2 or made by Process 34C-2-13.
- 3. SHIPPING UNIT 1 liter bottle.
- 4. INSPECTION None.
- 5. FACTORY TEST None. The suspended material has been approved as specified
 in its material handling notice.
- 6. LABORATORY TEST None.

STANDARDIZING SECTION
ENGINEERING DEPT.



APR 6 1 1941