



SUBJECT COILED HEATER COATING
 Process Specification

SUPPERSEDED DATE

Initially used for coating heaters for types
 5691 and 5692.

Note - Each spool of wire used in this coating process must be tube tested for heater current before being used.

1. PROCEDURE FOR APPROVAL OF SPOOL

- a. Make 5 weight checks on each spool of base wire. Reject spool if one or more checks is out of limits.
- b. Make up 150 bare coils from each spool and then check the weights of 5 bare coils. All checks must be within specifications. Note - Do not cut up remainder of spool until approval has been received from tube factory.
- c. Spray 100 heaters by process as outlined below. Inspect as outlined in 34-14-13D and in addition check the coating weight on 5 heaters. Coating weight of each heater must be above minimum specified.
- d. Label heaters and spool from which they were made and deliver heaters to tube factory for heater current test.
- e. When approval is obtained, manufacture heaters from remainder of spool.

2. SPRAYING PROCEDURE

All conditions for applying coating to these heaters are the same as specified in 34-14-13D, except.

1. Spray heaters up to approximately 50% of weight to spray texture #1 indicated in 34-14-13D for 12 volt heaters.
 2. Fire as specified in 34-14-13D.
 3. Respray up to coating weight to spray texture #1 and refire again as specified in 34-14-13D.
- Inspect and pack as specified in 34-14-13D.

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ACCORDINGLY FUTURE REVISIONS
 WILL NOT FOLLOW.

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