



SUBJECT: ROLL TEST PROCEDURE FOR HEATERS

Initially used for cathode-ray tube double helical wound heaters to determine for undesirable soft coating.

1. EQUIPMENT

Roll Tester, Model No. L722-AD.
 (Included under this model number are rolling plate No. B-1044 and base plate No. B-1045).

2. PROCEDURE

- a. Using tweezers pick up a heater from the firing boat and examine under a microscope for chips.
- b. Place heater on center of base plate of roll tester as shown in Fig. 1. **However, if leg spread exceeds 3 mm., extend legs over edge of base plate.



Fig. 1

- c. Lower rolling plate over base plate so that ends A and A' touch and are in the same vertical plane: (Fig. 2)
- d. Lower other end of rolling plate until it contacts base plate or the heater.

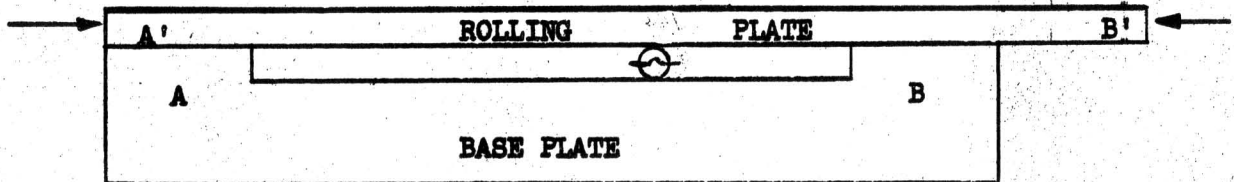


Fig. 2

- e. Slide rolling plate from right to left over base plate until B and B' are in the same vertical plane.
- f. Slide rolling plate from left to right over base plate until A and A' are again in the same vertical plane.

CAUTION: When moving rolling plate over base plate apply pressure only in the direction of rolling as indicated by the arrows in Fig. 2. Do not apply any downward pressure on the rolling plate.

- g. Lift rolling plate off of base plate and set aside.
- h. Check heater under microscope for chips or soft coating.

SCALE—

DIMENSIONS IN

UNLESS OTHERWISE SHOWN. DIMENSIONS SHOWN WITHOUT TOLERANCES ARE DESIGN CENTERS

* CHANGE
 ** ADDITION

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2. PROCEDURE (Cont'd)

1. Repeat the entire roll test procedure (steps a - h incl.) until five heaters from the boat have been well checked. If any of the five are rejectable according to the inspection limits set up in the coated coiled heater specifications (S. N. 14-1-1MCH), the entire boat load shall be roll tested. If any of the five chip, but are not rejectable according to the inspection limits, the heater that chipped must be subjected to a second roll test. If on the second check it chips further, it shall be rejected.

STANDARDIZING SECTION
 ENGINEERING DEPT.

SCALE—

DIMENSIONS IN

UNLESS OTHERWISE SHOWN.

DIMENSIONS SHOWN WITHOUT TOLERANCES ARE DESIGN CENTERS

14-474-21-62

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* CHANGE
 ** ADDITION
 *** DELETION

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13D26-R1

NOTE:- SUPPLY ALL SCREWS, BOLTS, NUTS, RIVETS, WASHERS, DOWELS, TAPER PINS, COTTER PINS & WOODRUFF KEYS WITH THIS PART.

ALL SCREW THREADS TO BE CLASS 2 FIT (AMERICAN STANDARDS) UNLESS OTHERWISE SPECIFIED.

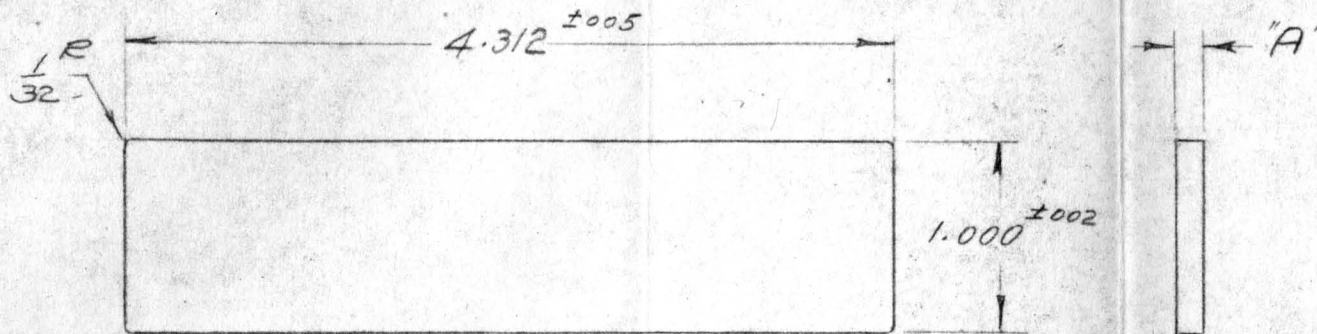
LIMITS ON FRACTIONAL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

UP TO 6" $\pm 1/64$ "

ABOVE 6" TO 18" $\pm 1/32$ "

ABOVE 18" $\pm 1/16$ "

S. O.



"A" = .100 ±0.01
 .105 "
 .117 "

HARDEN ROCK. 58-60
& GRIND

FOR CATH RAY TYPE

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NOTE REFERENCES	INITIAL	DATE	MATERIAL	PATT. NO.	PATTERN CHECKED	INITIAL	DATE	No. Req'd PER UNIT	ONE EACH (3)	No. Req'd PER ORDER
			B & S. GROUND ST. 1/8 x 1" x 4 7/16							
			FILAMENT TESTING FIXTURE							
			PART NAME ROLLING PLATE							
			DRAWN J. H. Keong				DATE 3-6-47		MODEL NO. L-722-AD	
			CHECKED J. J. C.				DATE 3-14-47			
			APPROVED [Signature]						PART NO. B-1044	
			SCALE 1:1				ASSY			

NOTE:- SUPPLY ALL SCREWS, BOLTS, NUTS, RIVETS, WASHERS, DOWELS, TAPER PINS, COTTER PINS & WOODRUFF KEYS WITH THIS PART.

ALL SCREW THREADS TO BE CLASS 2 FIT (AMERICAN STANDARDS) UNLESS OTHERWISE SPECIFIED.

LIMITS ON FRACTIONAL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

UP TO 6"

$\pm 1/64$ "

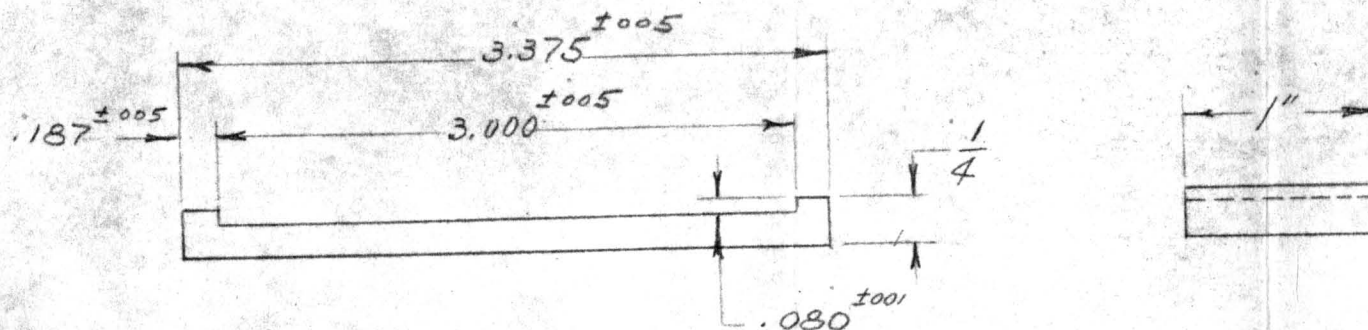
ABOVE 6" TO 18"

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HARDEN ROCK. 58-60 AND GRIND

FOR CATH. RAY TYPE

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KEY	NOTE REFERENCES	INITIAL	DATE	MATERIAL	PATT. NO.	PATTERN CHECKED	INITIAL	DATE	NO. REQ'D PER UNIT	NO. REQ'D PER ORDER
				B&S GROUND ST. 1/4 x 1" x 3 1/2					1	
									FILAMENT TESTING FIXTURE	
									PART NAME BASE PLATE	
									DRAWN J.H. ROEMER	DATE 3-6-47
									CHECKED J.R.	DATE 3-14-47
									APPROVED [Signature]	DATE "
									SCALE 1:1	ASS'Y
									MODEL NO. L-722-AD	
									PART NO. B-1045	
									RCA RADIO CORPORATION OF AMERICA RCA VICTOR DIVISION TUBE DIVISION EQUIPMENT DEVELOPMENT DEPT. LANCASTER, PA.	