



SUBJECT:

MOLDING & SINTERING MATRIX CATHODES
 Process Specification

SUPERSEDED DATE Aug. 16, 1952

Initially for 5946

1. EQUIPMENT
 - a. Molding jig, Model L717WW, Part AX45.
 - b. Scoop.
 - c. Camels hair brush, No. 2 Osborne.
 - d. Hydrogen furnace.
 - e. Rayon gloves.
 - f. Small steel mallet.

2. MATERIALS
 - a. Cathode
 - b. Nickel Powder
) - As specified in tube construction data.

3. PROCEDURE
 - a. Insert cathode in jig making sure cathode is seated in lip at bottom of jig.
 - b. Holding cathode centered with fingers pour *** of nickel powder around cathode using scoop.
 - c. Holding cathode centered tap jig *** with mallet.
 - d. Brush off any excess powder or if there is a deficiency, of powder pour more powder around cathode using scoop and repeat tapping and brushing operations.
 - e. Fire cathode and jig in hydrogen for 15 minutes at *1100°C.
 - * f. Remove cathode from jig by tapping side of jig with mallet until cathode falls out.
 - g. Fire cathode in dry hydrogen for 30 minutes at 1200°C.
 - h. Always wear a glove when touching cathode and then never touch nickel matrix.

ENGINEERING SECTION
 STANDARDIZING

8-546-30-60 PCL24788-126JD

* CHANGE
 ** ADDITION
 *** DELETION

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