



SUBJECT:

This specification applies to the precautions that shall be observed in order that cathode-ray tube mounting operations may be performed satisfactorily and under proper conditions with respect to cleanliness of equipment, floors, etc.

1. PROCEDURE

- a. Work places shall be kept free from surface dust and dirt.
- b. Points for welders shall be filed at places away from the mounting benches, to keep the latter free from copper particles. Also clean welder points after filing by brushing or with filtered compressed air.
- c. Do not sweep the floor of mounting department; use a vacuum cleaner.
- d. Use extreme care when handling stem leads during mounting and inspection. Do not bend at junction of fillet. Keep as straight as possible.
- e. Operator must wear face shield, when welding new wires on stems of finished tube for salvage purposes.
- f. Clean welding shields should always be in position.
- g. Mount assemblies should be kept in a dry dust free coverage at all times. They must be kept away from drafts or open windows.
- h. Cathode assemblies must be kept clean in all operations of assembly.
- i. Lint-free fabric gloves and/or finger cots to be used by Mounting Dept. when handling all metal gun parts and ceramics.
- j. Color kinescope mount and mount parts storage:
 - 1. Maximum time allowed for sub-assemblies and parts to be held between hydrogen firing and assembly into guns is to be two (2) weeks. If this period elapses, all parts are to be refired at 1000°C for five (5) minutes (FNJ5) before using. Parts are to be stored in closed clean boxes.
 - * 2. Maximum time allowed for gun assemblies and completed mounts (less getters) is to be four (4) weeks. If this time expires the mounts or sub-assemblies are to be scrapped and parts refired before using again. Getters are only to be mounted prior to selling mount to mount sealing. Completed mounts are to be stored in closed heated cabinets. Temperature to be 45-70°C. (116-158°F) in cabinets.
 - * 3. Maximum time allowed to elapse between opening vacuum container of getters and exhaust is to be two weeks. If this time limit is exceeded, the mounts are to be scrapped by the Department directly concerned at the time of expiration. Mounts are to be stored in closed heated cabinets before sealing and covered when in bulb assembly. Temperature to be 45-70°C (116-158°F) in cabinets.

ENGINEERING SECTION
 STANDARDIZING

SCALE _____

DIMENSIONS IN UNLESS OTHERWISE SHOWN. DIMENSIONS SHOWN WITHOUT TOLERANCES ARE DESIGN CENTERS

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* CHANGE
 ** ADDITION
 *** DELETION

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