

SUBJECT SPEED NUT GETTER ASSLY INSERTION  
On Contact Button

SUPERSEDED DATE

Initially used for getter assly such as FZ402K & FZ402L.

### 1. EQUIPMENT

"Locating fixture RL725" CR Tubes. (Serial #P.O.80968) which consists essentially of a horizontal bulb support and speed nut tongs on a shaft permitting insertion of getter assly through neck and pressing over anode lead by means of this lever operated tongs.

### 2. PROCEDURE

- a. Place bulb in support with button contact on the bottom, then clamp speed nut-getter assly in tongs of fixture.
- b. While looking through space between fluorescent screen and conductive coating, move assly in holder into bulb positioning over anode lead. CAUTION: Do not insert too far into bulb so as to damage screen.
- c. Press down on long central clip over anode lead locking it securely in place. If clips to one side, getter loop becomes difficult to align with bulb anode coil when flashing. Getter loop must be in a plane parallel to that of button contact in order to receive maximum energy from HF field.
- d. Cautiously withdraw holder, remove bulb, and tap to make sure speed nut will not loosen. Inspect through space between fluorescent screen and conductive coating, also through uncoated windows left in conductive coating to see that clips of speed nut have a firm grip on anode lead.

### 3. WHEN NECESSARY TO REMOVE GETTER

- a. Replace clamp on fixture with a two prong fork which can be hooked under clips of speed nut to release it from 2nd anode lead.
- b. After thus unlocking speed nut cautiously lift and remove from bulb.

EXTREME CAUTION MUST BE EXERCISED IN ORDER TO PREVENT DAMAGING SCREEN with speed nut or with conductive coating loosened during this operation.

STANDARDIZING SECTION  
RESEARCH & ENGINEERING DEPT.