



1. EQUIPMENT

- a. Compression tank (see diagram on page 2).
- b. Rolling shielded carriage sections
- c. Rubber expansion stoppers.

2. PROCEDURE

a. Tubes

1. Place tubes in carriage sections and roll into tank. Throw on power to safety relay. A tube above 7" in diameter must have a protective covering over top.
2. Tighten door safety release of relay until Red indicator lights.
3. Close tank outlet, open air inlet, raise pressure 1 minute to value specified in page 2 of 3-1K-0 for the tubes under test.
4. Close inlet valve, hold tube under specified pressure 1 minute unless otherwise specified. CAUTION - Gate to 35 lb. safety valve must be locked open when testing evacuated tubes.
5. After one minute at the maximum pressure, open outlet valve and allow the air to escape. Allow pressures to equalize before opening door, not higher than 5 lb., then remove car.

b. Bulbs

1. Pressure test is to be made after the P<sub>2</sub> contact is inserted, and neck spliced, but previous to washing or screening.
2. Insert the correct sized stopper in the bulb neck securely.
3. Place bulbs vertically in carriage sections of tank car. Record bulb numbers for test information and then cover each bulb or add protective cap in the case of bulbs above 7" in diameter.
4. Run car in tank, close door and tighten past safety release of relay until the Red indicator lights.
5. Unlock and close valve to "35 lb. safety valve".
6. Turn on line switch, close tank outlet valve, and open air inlet valve.
7. Raise pressure to desired value over a period of 2 minutes, and hold at specified pressure for 1 minute unless otherwise specified. (Test pressures are shown \* on the individual bulb assemblies.)
8. Record all breakage according to failing pressures and time lapses.
9. After one minute at the maximum pressure, open outlet valve and allow air to escape. Allow pressures to equalize before opening door, not higher than 5 lb., then remove car.
10. Remove stoppers from bulbs, noting any rush of air. If this occurs, the test is invalid and the bulbs will have to be re-tested. When these bulbs are re-tested and a surge of air is still noted, the bulb should be held for leakage inspection.
11. Open shut off valve to "35 lb. safety valve" and lock. Turn off line switch.

MAY 1955

SCALE—

DIMENSIONS IN

UNLESS OTHERWISE SHOWN.

DIMENSIONS SHOWN WITHOUT TOLERANCES ARE DESIGN CENTERS

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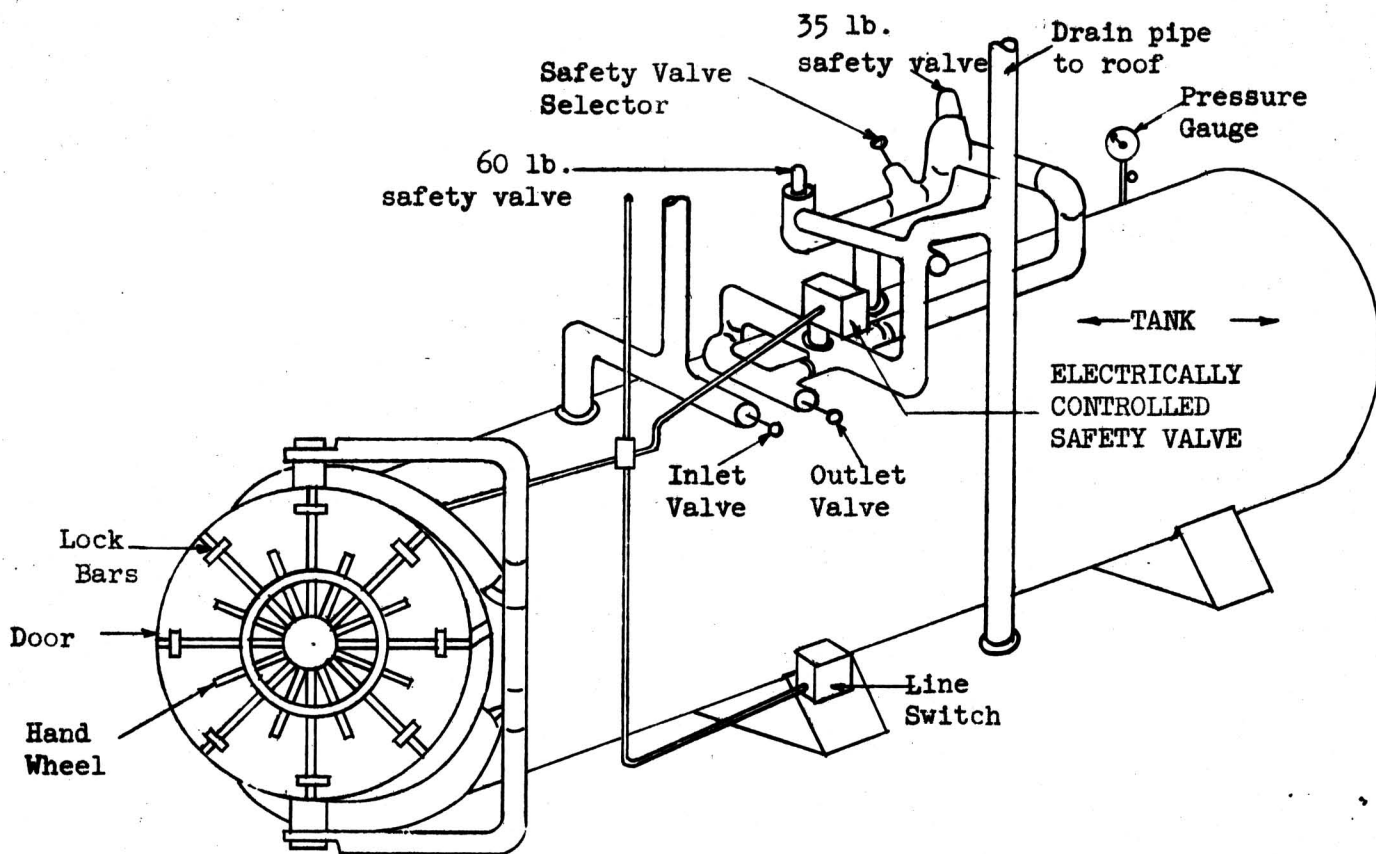
\* CHANGE  
 \*\* ADDITION  
 \*\*\* DELETION

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SUBJECT: CATHODE RAY TUBES & BULBS  
 PRESSURE TESTING

SUPERSEDED DATE



COMPRESSION TANK

STANDARDIZING SECTION  
 ENGINEERING DEPT.

SCALE—

DIMENSIONS IN

UNLESS OTHERWISE SHOWN.

DIMENSIONS SHOWN WITHOUT TOLERANCES ARE DESIGN CENTERS

\* CHANGE  
 \*\* ADDITION  
 \*\*\* DELETION

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