



SUBJECT: CONTACT - COATING CONTINUITY CHECK
Process Specification

SUPERSEDES

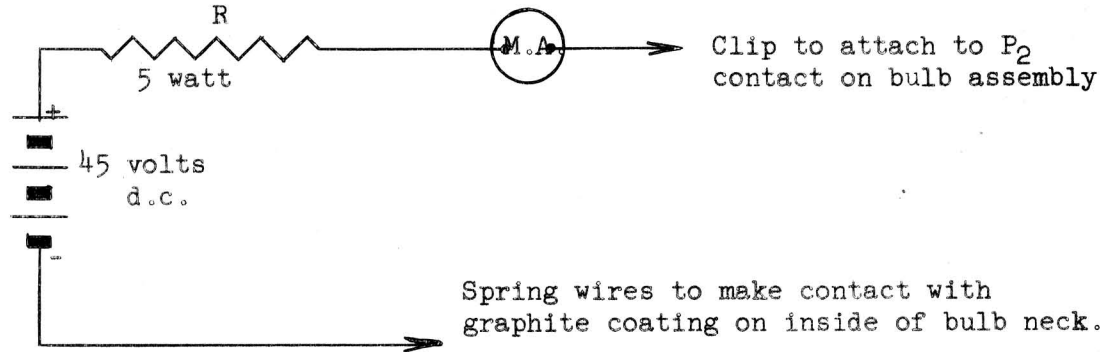
SCHEDULE NO. 1

(Initially for all glass Cathode-Ray Types)
(Marion Only)

MAY 1955

1. PROCEDURE

- a. Continuity from the coating in the bulb neck to the external P₂ contact should be measured using the circuit shown below.



$$R + R (\text{meter}) = 1000 \pm 20 (5 \text{ watts})$$

50 M.A.D.C. Meter - Simpson Model 127 or Equivalent

45 Volt D.C. Battery Supply

- b. With the P₂ contact connected to the button of a glass bulb or the metal shell on a metal bulb and the neck coating contact making good contact with coating, note the meter reading. The meter should read 13 ma or more when a bulb with satisfactory continuity is connected into the circuit.

2. CONTROLS

a. Calibration

1. Twice each shift (at the beginning of the shift and 4 hrs. thereafter) the meter zero shall be checked and the meter properly zeroed. At these same intervals the condition of the batteries shall be checked by connecting the two circuit contacts together. Replace the battery supply if the meter reads less than 40 ma. If meter reads below 44 ma with new batteries the circuit components should be checked.

b. Inspection

1. After lehr bake check continuity between coating and P₂ contact on 100% of the bulb assemblies. Reject bulb if current reads less than 13 ma.

End of Schedule #1

SCALE—

DIMENSIONS IN

UNLESS OTHERWISE SHOWN.

DIMENSIONS SHOWN WITHOUT TOLERANCES ARE DESIGN CENTERS

22-549-24-80

PCM165-802EG

* CHANGE
** ADDITION
*** DELETION

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