



This specification applies to the process of final mask insertion and alignment check prior to the faceplate cone welding operation on the color kinescope.

MAY 1955

SCHEDULE NO. 1
 (Initially for C73685 Series.)

1. EQUIPMENT
 - a. Mask insertion table
 - b. Mask and faceplate storage cabinet
 - c. Three mask insertion keys
 - d. Light house (mercury arc)
 - e. Tenpower hand lens
 - f. Microscope (20X with scale graduated in 1 mil div.)
 - g. Safety glasses for U.V. light
 - h. Flash light

2. MATERIALS
 - High pressure air

3. PROCEDURE
 - a. Clean mask with high pressure air.
 - b. Visually check the mask for dents.
 - c. Check the mask and faceplate numbers to see that the numbers correspond.
 - d. Align the top of the aperture mask with the top of the faceplate assembly and insert mask assembly in faceplate.
 - e. Insert the keys between the mask frame and the springs and rotate 1/4" turn.
 - f. Secure the mask by rotating the keys. Start at the top and move in a clockwise direction.
 - g. Check visually to make sure the support springs are seated properly.
 - h. Place the assembly on a lighthouse with the light source in the 1st exposure position.
 - i. Adjust the assembly for the best line-up of the light beam and the 1st printed dot in the unaluminized areas using a hand lens.
 - j. Check the misregistry of the beam landing on the dot with a calibrated 20X microscope.
 - k. If the misregistry is 3mils or less the faceplate is passable. If more than 3 mils misregistry still prevail, scrap the assembly.
 - l. Send approved assemblies to welding

SCALE—

DIMENSIONS IN

UNLESS OTHERWISE SHOWN.

End of Schedule No. 1

DIMENSIONS SHOWN WITHOUT TOLERANCES ARE DESIGN CENTERS

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* CHANGE
 ** ADDITION
 *** DELETION

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