

Section 12

BASE AND CAP ADHESION TESTS

12.1. Assembled valves with bases or caps shall be tested for adhesion of bases, caps and inserts as specified below. At intervals of two months, ten samples, selected at random by the Inspectorate from the types listed below, shall be subjected to the following tests in the order as specified.

12.2. Torque and Pull Torque shall be applied gradually between the elements specified in accordance with Table 1. After application of torque and pull, there shall be no loosening of cemented joints or loosening by more than 1/32" movement of mechanical joints.

12.3. The valves shall be subjected to the Climatic Test, Section 10.1 and 10.2.

12.4. Torque and Pull shall be repeated after the Climatic Test.

12.5. Valves may be selected from the following types and should be mechanically sound, but failures on electrical tests may be used for this test. In the case of cathode ray tubes, necks only may be accepted for testing.

<u>Base Only</u>	<u>Base and Cap</u>
CV 391	CV 265
CV 394	CV 375
CV 420 (CRT)	CV 2109
CV 429 (CRT)	CV 2125
CV 1530	CV 2180
CV 2175 (CRT)	CV 2520
CV 2244 (CRT)	CV 2659
CV 2253	CV 2904 (CRT)
CV 2296	CV 254 (CRT)
CV 2415 (CRT)	CV 262 (CRT)
CV 2464 (CRT)	CV 464 (CRT)
CV 1868	CV 2328 (CRT)
CV 2162	
CV 2108	

12.6. These tests will normally be carried out by the manufacturer but where facilities do not exist reference should be made to the relevant Inspection Authority.

12.7. After completion of all tests the results shall be examined and details of any failures reported to the Qualification Approval Authority.

TABLE 1

Element Size	Torque	Pull
Bases having maximum overall diameter not greater than 16.5 mm	12 in. lb	
Bases having maximum overall diameter between 16.5 mm and 38 mm	20 in. lb	
Bases having maximum overall diameter greater than 38mm	40 in. lb	
Caps having maximum overall diameter not greater than 15 mm	1.5 in. lb	
Caps having maximum overall diameter greater than 15 mm	3 in. lb.	
B8G and B9G	-	35 lbs