

Release for transferred
Production

D 13 - 27...

THE UNDERSIGNED AGREE TO

RELEASE FOR TRANSFERRED
PRODUCTION (BRIVE)

OF INSTRUMENT CATHODE-RAY TUBE

TYPE D13-27...

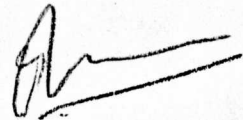
NAME

DEPARTMENT

SIGNATURE

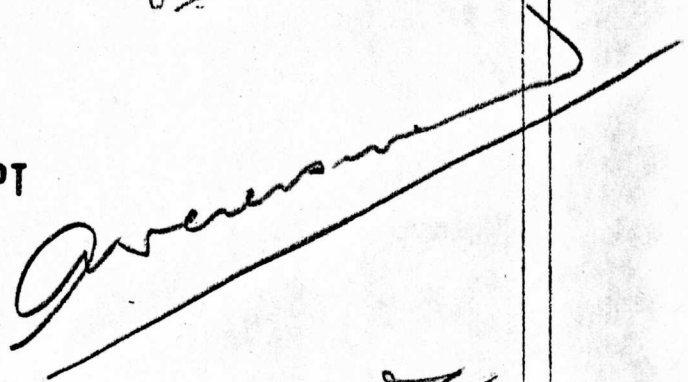
Mr. Modderman

COMMERCIAL DEPT



Mr. Verhoeven

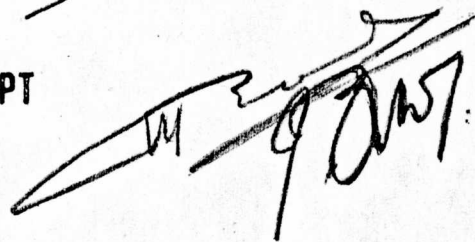
DEVELOPMENT DEPT



Mr. Radstake

MANUFACTURING DEPT

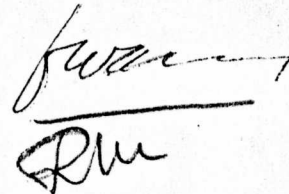
Mr. Bru



Mr. Wassenaar

QUALITY LABORATORY

Mr. Menet



DATE 10.4.1975

ELCOMA

KWALITEITS LABORATORIUM PROFESSIONELE KATODESTRAALBUIZEN

RAR-84/75.070

75.4.11

ONDERWERP : Release for transferred production in Brive of
types D13-27 and D13-27GH/01

The C.R.T. types D13-27 and D13-27GH/01 made in Brive has
been tested in Eindhoven on several parameters according
to the F.L and lifetest specification, to come to a
"Release for transferred production" in Brive.

Annexed reports give test and measuring results of the
above mentioned C.R.T. types.

As can be seen from the results, summarised in report RAR-84/75.070
dated 75-04-10, these types can be given "Release for
transferred production" in Brive.

K. Wassenaar,

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ONDERWERP : release for transferred production D13-27 and D13-27GH/01

- 1) Content:
 - RAH-84/74.14 content test II results batch 1
 - 74.152 content test II results batch 2
 - 75.007 content test II results batch 3 up to and 10(GH) batch 2 and 3(GM)
 - 75.011 content test II results batch 1(GM)
 - 75.005 content test II results batch 1(/01)
 - RAH-84/74.180 content L test results batch 1
 - 75.047 content L test results batch 2
 - 75.003 content L test results batch 3
 - 0149 content lifetest results batch 1
 - 0151 content lifetest results batch 2
 - 0153 content lifetest results batch 3
- résumé of life test results.

2) Summary of test II results

- a. Batch 1 and 2 received 50 pieces
 measured 50 pieces
 good after repair 31 pieces
 rejected 18 pieces
 1 tube reference for Brive with dirt on diaphragm.
 rejected: 1x dirt on diaphragm.
 2x spotcharging Y
- b. Batch 3 up to and 10
 batch 1 up to and 3(GM)
 batch 1 D13-27GH/01
 Received 931 pieces
 Measured 132 pieces
 rejected 2 pieces
 - 1x blanking voltage to high
 (already measured in Brive but forgotten to reject the tube)
 - 1x scratches repair in Eindhoven

In the first 2 batches the tubes had to be rejected for dirt on diaphragm and spotcharging Y.
 In the last 12 batches none of the batches had to be rejected and only 2 tubes were fault.
 After solving the problem in the first 2 batches the general impression is very good.

HAL-84/75.070

ONDERWERP :

3) Summary of I-test results

Batch 1: 3x dirt in diaphragm (borderline)
 1x stain in powder (borderline)
 1x gasvalue rather high
 The remaining electrical and mechanical measurements are good.

Batch 2: 1x borderline at mod.Vg1 (but within limits)
 1x alignment PDA contact rather high (but within limits)
 The remaining electrical and mechanical measurement are good.

Batch 3: 1x deviation of alignment PDA contact rather high but within limits.
 1x blanking rather high but within limits
 The remaining electrical and mechanical measurements are good.

Remark: The general impression is good.

4) Summary of life test results

Batch 1 The results are satisfactory

Batch 2 a. 0 hours 1 tube modulation too high (after 10 hours good)
 b. 1000 hours 2 tubes modulation just outside limits.

Batch 3 The results are satisfactory

Remark: The general impression is good

5) Conclusion

From the results we conclude that there is no objection on against release of the C.R.T. type D13-27GH for production and measuring in Brive.

The release of the C.R.T. D13-27GM is possible after life test (5 tubes are needed for this purpose, suitable rejects may be used, to be sent to us by Brive.

G. Gevers

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 Vandenkamp
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RAK-84/74.145

1

74-29-10

ONDERWERP : D13-.7GH release for production batch 1

Received : 76 pieces

marked $\frac{KW1}{E4I}$

Measured : 5 pieces

Results : 3x good

1x spotcharging (dirt on diafragma)

1x " " " borderline good

batch is rejected.

Afterwards 21 pieces measured on spot quality and emission.

Total result : 10 pieces.

1x good

1x spotcharging (dirt on diafragma)

1x spotcharging " (borderline good
return to Brive as reference tube)

1x spot charging Y

4x modulation too high (repair in Eindhoven)

3x spotcharging will be put on life test

1x good will be measured on L-test.

G. leeuvers

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RAR 84/74.152

1

6-11-'74

ONDERWERP : Release for production D13-27GH batch 2

Received 24 pieces marked KW1
Good 9 pieces E4J
rejected 13 pieces dirt on diaphragm (return to Brive)
" 2 pieces spotcharging Y (return to Brive)

The packing was not correct

The cardboard assembly of the screenside was placed on the footplate and reverse.

No L-test has been taken.

Two tubes for repair to factory.

After repair both tubes are still bad.

One tube stays in Eindhoven for inquiry.

G.Geevers

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WAR-84/75.067

1

75-04-04.

ONDERWERP : Summary of test II results D13-27' of the period
Dec. '74 - April '75

	type	batch nr	received	code	measured	rejected	batch is:
Dec	D13-27GH	3	48	E4K	8	0	good(5x L test)
Jan	D13-27GH	4	55	E4L	20	0	good(5x L test)
Febr.	D13-27GH	5	75	E5A	20	0	good
	D13-27GH	6	70	E5A	20	0	Good
March	D13-27GH	7	180	E5B	20	0	good
	D13-27GM	2	10	E5B	5	0	good
April	D13-27GH	8	108	E5C	8	0	good
	D13-27GM	3	36	E5C	2	0	good
	D13-27GH	9	186	E5C	13	1	good
	D13-27GH	10	120	E5C	8	0	good
			<u>688</u>		<u>124</u>	<u>1</u>	

G. Geevers

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RAR-84/75.051

2-1

75-03-11

ONDERWERP : Release for transferred production D13-27 GM

Batch 1: Received 7 pieces

Measured on test II specifications 7 pieces

Results of screenquality, colourpoint and
brightness values are given on attached sheet.

Conclusion: Test II results are good.

Screen quality is good.

Colour point is good.

Brightness is borderline.

Remark: Colour point: Measured according point 4 test 2
of testshedule: KV 2-1-52/439.

Measuring condition of point 4 test 1

haster 10 x 10 mm, focus, current 10 uA, Vg2 = 2 KV,
V nav = 4 KV causes burn in of the screen and there-
fore not carried out.

Measuring condition of point 4 test 2

haster 40 x 40 mm, defocus, current 10 uA, Vg2 = 2 KV,
Vnav = 4 KV

Batch 2: Received 10 pieces

Measured 5 pieces

Test II results are satisfactory.

Screen quality and colour point is equal to the
previous batch (nr 1)

Brightness is also borderline.

Remark: Due to delivery orders of the commercial Department
the burning in and life test will be measured on a
sample from a larger batch.

G. Ceeveris

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8



Gegevens

Buistype D 13-278M.

Proefnr.

Cod.nr. poeder

Fabr.dat.

Opmerkingen

10 productie Avinc.

Meting helderheid

Held. in NIT

Buisnr. 2 kv 4 kv 6 kv 8 kv

1	26.7.	16.5
2	27.4.	17.0.
3	30.4.	20.5.
4	23.0.	16.9.
5	26.4.	17.0.
X	26.9.	17.9.
R	6.6.	40.
Eis min	27	10.
Eis max		

Schermkwaliteit

Buisnr.	
1	Some stain, good.
2	"
3	"
4	"
5	"

Nalichten blauw - geel

Nalichttijd in m. sec.

Buisnr. 10% 1% 01%

1			
2			
3			
4			
5			
X			
R			

Eis min 0 20 2 700 10 4000

Eis max 2 250 25 4000 250 30000

Kleurpunt 2 kv - 4 kv

Buisnr. X1 Y1 X2 Y2

1			0.206	0.357.
2			0.201	0.342
3			0.290.	0.339.
4				
5				
X			0.206	0.246.
R			0.009	0.018.

Eis min

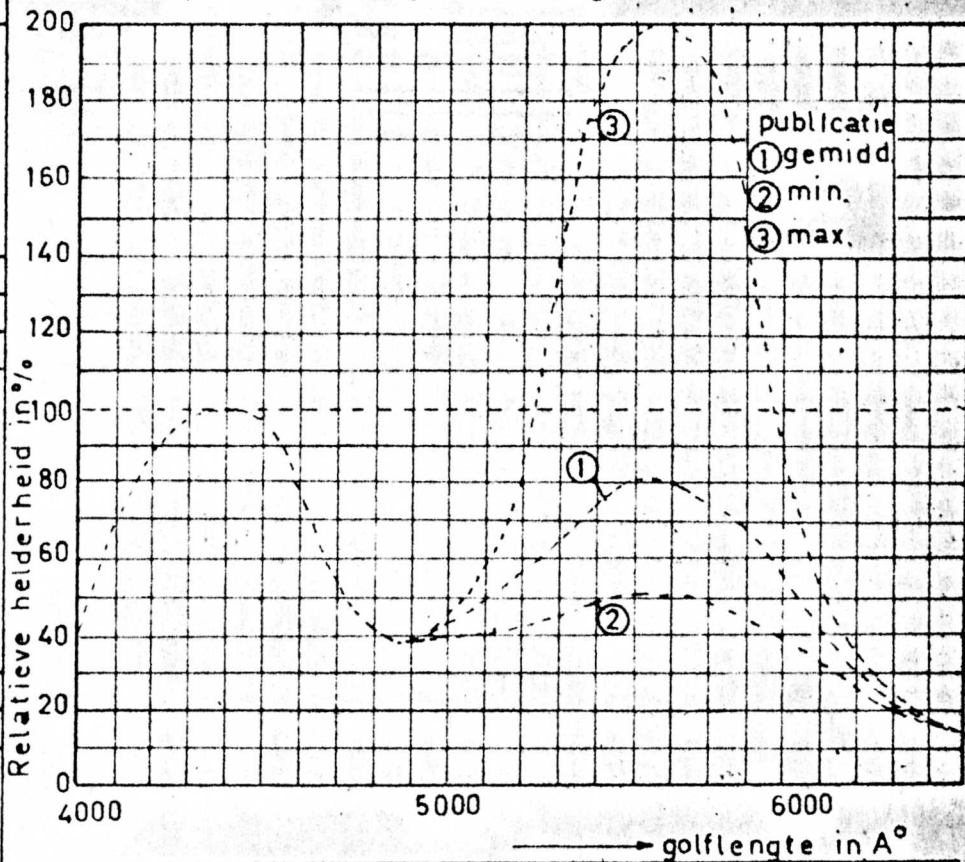
Eis max

coörd. A B C D

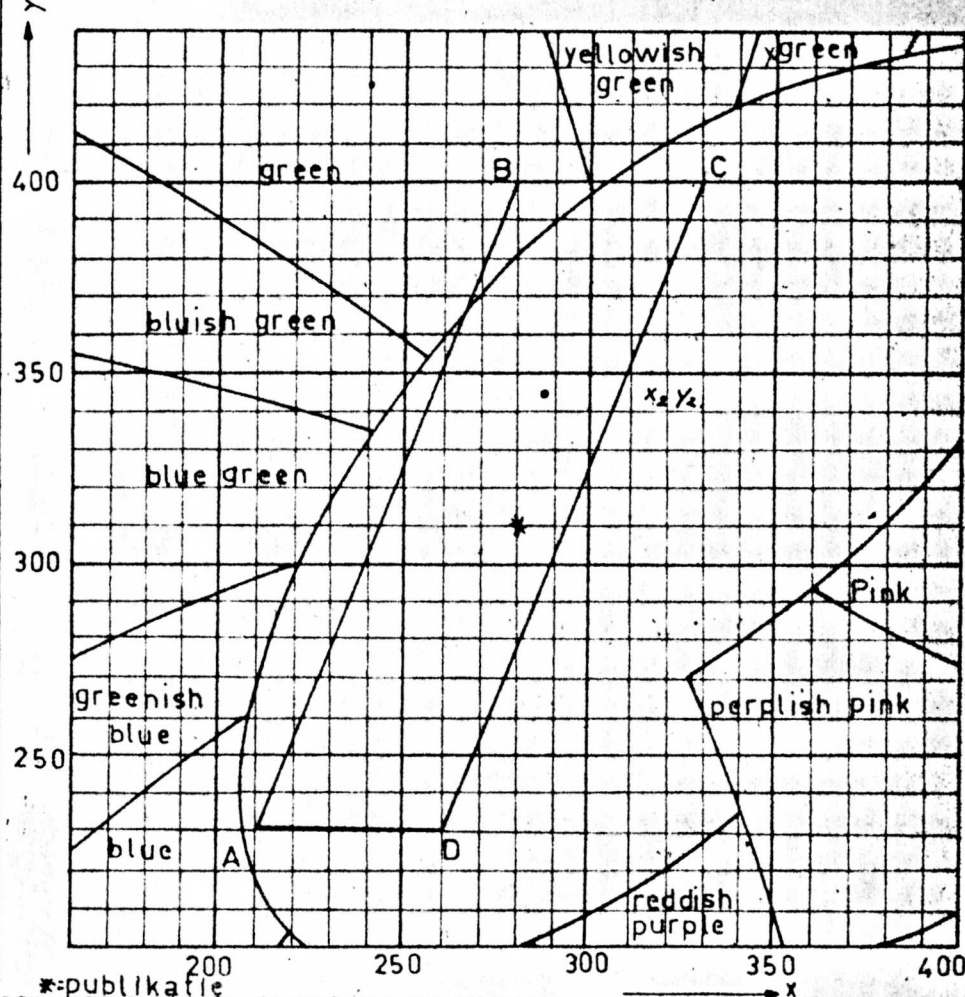
X 0,210 0,280 0,330 0,260

Y 0,230 0,400 0,400 0,230

Spectrale energie verdeling



kleurpunt



*:publicatie

N.V. PHILIPS' GLOEILAMPENFABRIEKEN, EINDHOVEN, NEDERLAND.

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RAA-84/75.065

1

75-04-07

ONDERWERP : Release for transferred production D13-27GH/01
batch 1

Received: 36 pieces

Measured: 2 pieces

Good : 2 pieces

Conclusion: Batch is good.

Remark 1: The value of the electrical and mechanical measurements of Brive noted on the included testsheets are about the same as the values measured in Eindhoven.

Remark 2: We inspected the values noted in Brive on the testsheets of each tube.
Of one tube no value was given for test 32 alignment FDA contact/internal graticule.

We measured this value and completed the testsheet.

The tube is delivered to the store.

Of another tube a value was given for test 17.

Blanking voltage of + 66.9V

This value corresponds with the measurements of Eindhoven but is outside the limits(58V max)

This tube must be rejected(already in Brive).

The tube will be sent back to Brive.

G.Geevers

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RAR-84/74.180

11-1

74-12-10

ONDERWERP : Release for transferred production D 13-27 GH batch 1
Results L-test and life test.

Batch nr 1

Test results are given on attached sheets.

no 2 up to and 8 incl. L-test sheets

no 9 up to and 11 incl. life test sheets

Conclusion

0 hours results: 3 tubes have dirt in diaphragm. (borderline)
1 tube has stains in powder (borderline)
1 tube gasvalue rather high.

The remaining electrical and mechanical
measurements are good.

1000 hours: The results are satisfactory.

See also RAR-84/74.145

G. Geervers.

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