

DIS-ASSEMBLY PROCEDURE
(FIGURE 1)

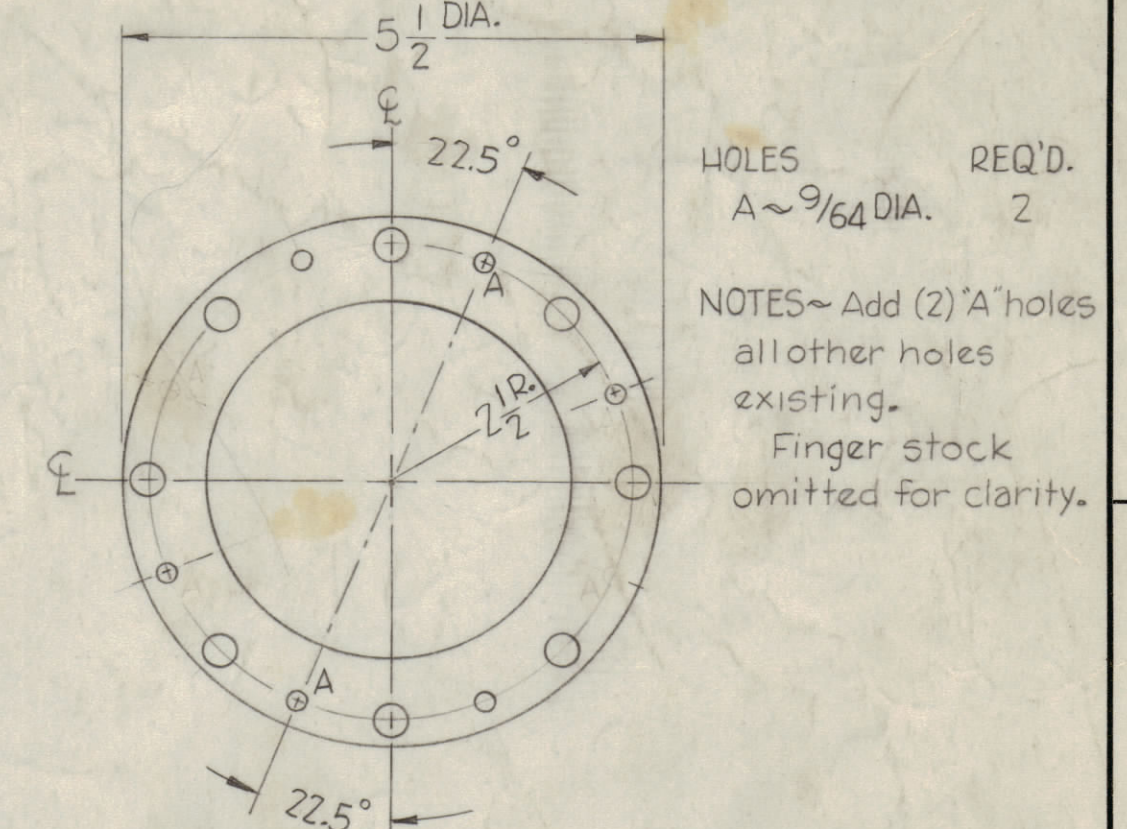
1. Position socket Electron Tube, TS-134 per Fig. 7. Remove Screen Grid Collet (Fig. 1) mounted on spacer (Fig. 1) by (8) 8-32 Rd. Hd. screws. Modify Screen Grid Collet per Fig. 3. (on re-assembly replace spacer, Fig. 1, with item 15).
2. Rotate socket cup (item 1) 180°; Remove control Grid Collet (Fig. 1) mounted on shouldered spacer (Fig. 1) by (8) 8-32 Rd. Hd. screws. (on re-assembly replace shouldered spacer with item 16).
3. Step 2 releases Control Grid Collet (Fig. 1) & contact Brkt. Screen. (Retain same for re-assembly). Modify Contact Bracket Wire lugs by Bending (See Fig. 1). Modify Control Grid Collet Per Fig. 4.

- Attached to Collet are (4) metal standoffs, Fig. 1, remove same discard (4) including HARDWARE EXCEPT RETAIN (1) NUT & (1) WASHER. If Control Grid Spring is Removed for any Reason, Retain and re-assemble.
4. Remove Outer Filament Contact Brackets and Outer Filament Retaining Ring; this disengages Outer Filament Collet also (4) Outer Filament Collet retaining screws, discard retaining screws and ring.
 5. Remove Inner Fil. Contact Brkts., Ring and collet; discard Ring and Insulator; Replace Insulator with Item 11

ASSEMBLY PROCEDURE
(FIGURES 5, 6 & 7)

1. Starting with Inner Filament Collet Re-assemble in reverse order making sure to position items as shown in Figs. 5, 6 & 7, also that Insulator Washers are re-assembled.

CONTROL GRID COLLET MODIFICATION



SCREEN GRID COLLET MODIFICATION

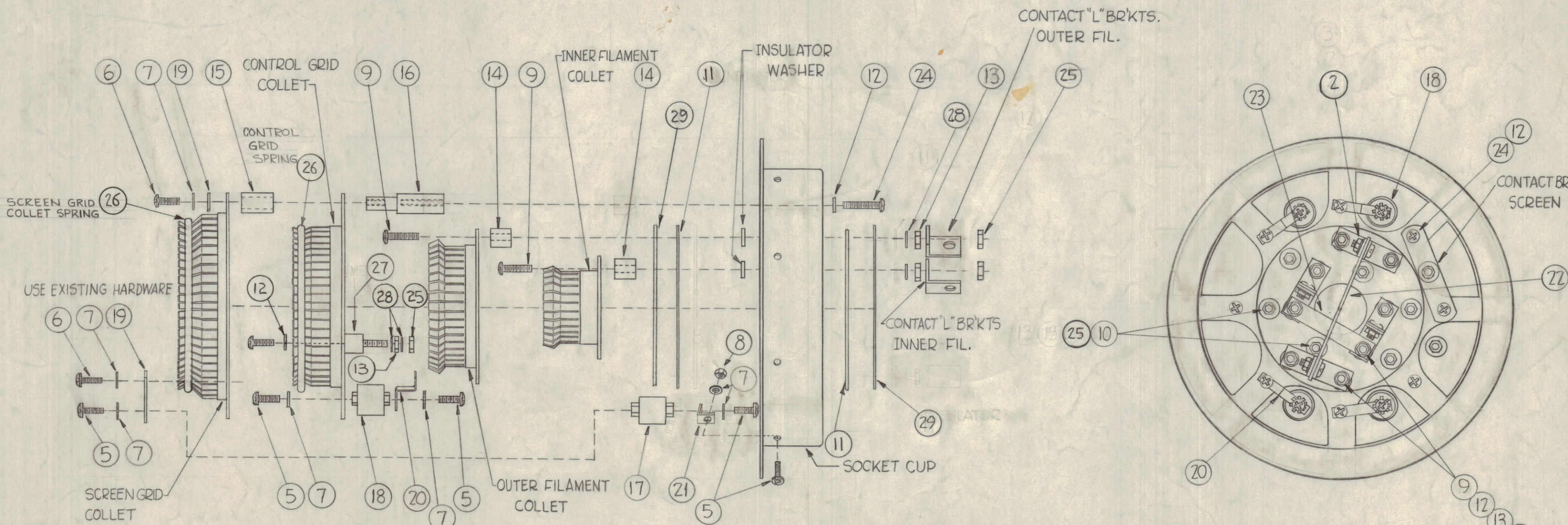
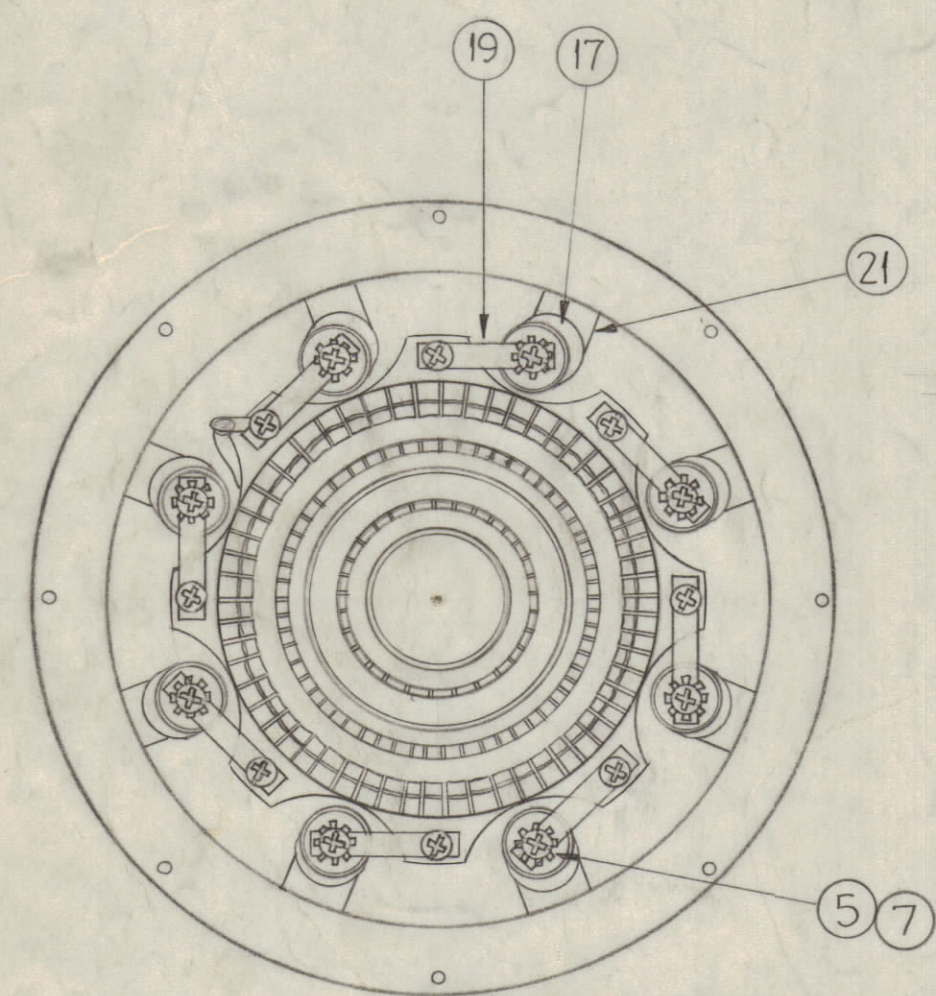
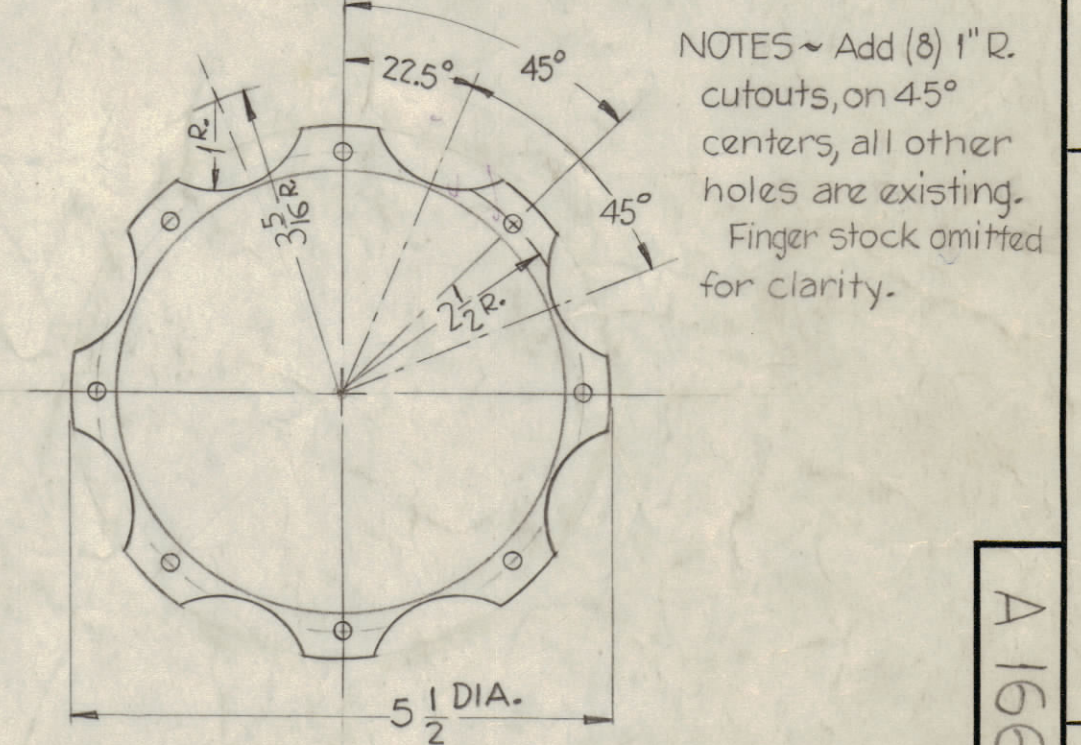


FIG. 7

ASSEMBLY FIG. 6

FIG. 5

FIG. 4

FIG. 3

NOTE ~ Use hardware furnished where ever possible for in plant modification.

SOCKET CUP MODIFICATION

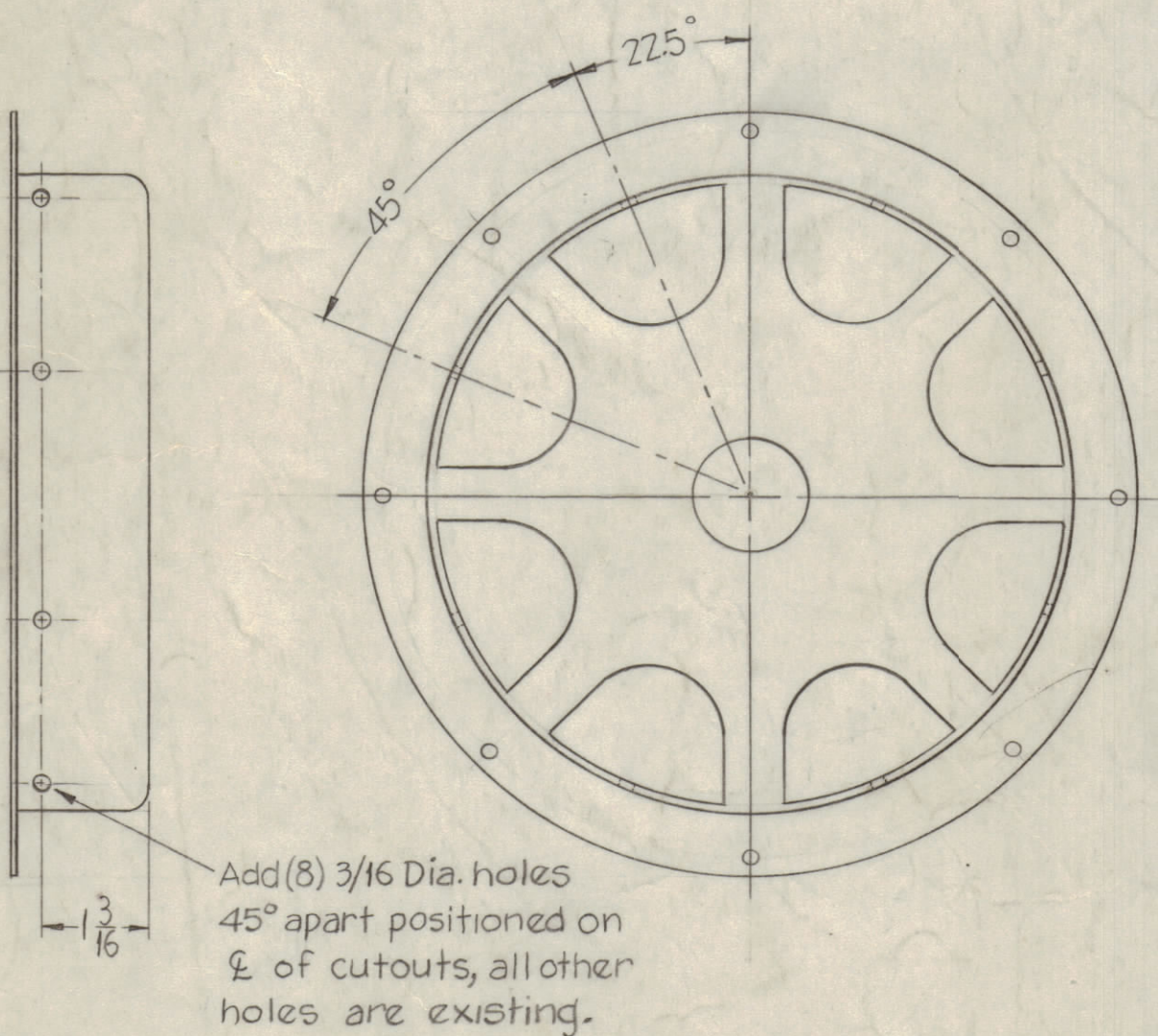
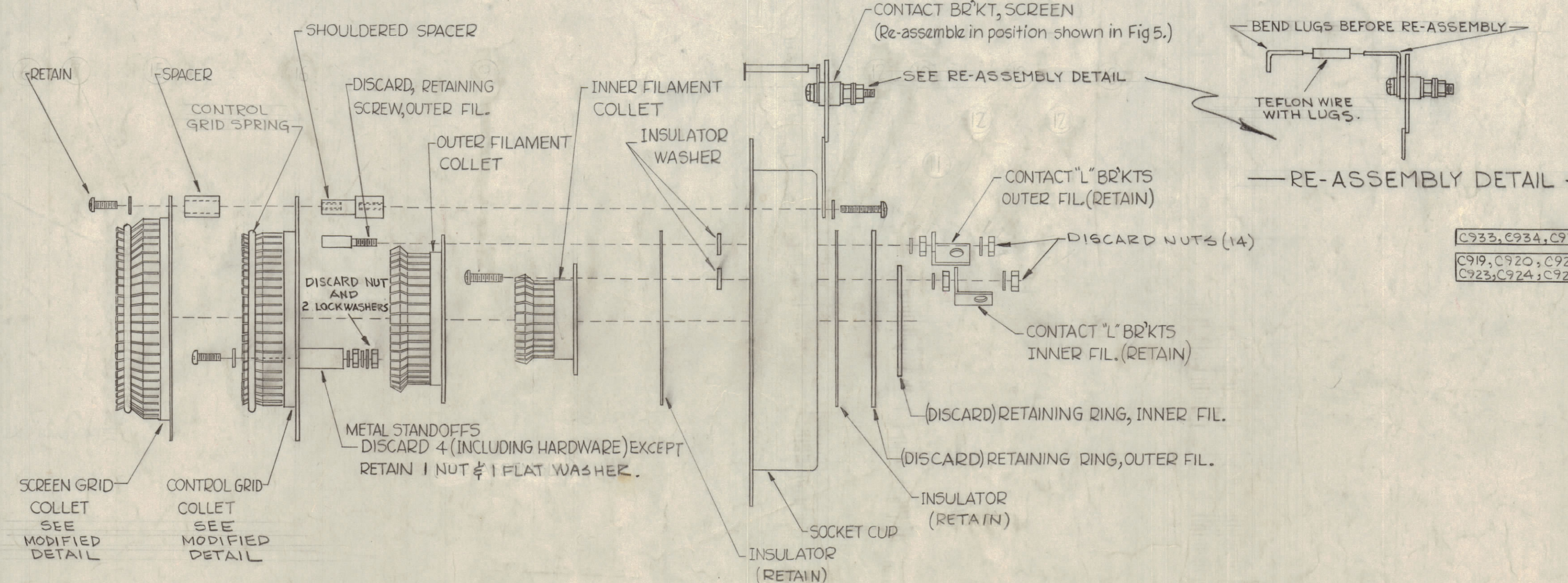


FIG. 2



DIS-ASSEMBLY
(ITEM 1 - TS-134)
FIG. 1

2	29	EIMAC 149127	INSULATOR, FILAMENT COLLET (ADDED)
16	28	FW08HBN	FLAT WASHER (ADDED)
1	27	EIMAC 001829	CONTROL GRID CONNECTOR (ADDED)
2	26	EIMAC 115500	SCREEN GRID COLLET SPRING (ADDED)
15	25	SM-127BN832	NUT, SELF LK, 832 (ADDED)
8	24	SCBP0832BN1Z	Screw, Machine (use hardware furnished)
1	23	MS 202-22-2.31	Lead, Connecting 7/16 Wide (added)
1	22	MS 202-22-3.56	Lead, Connecting 7/16 Wide (added)
8	21	MS 202-21-1.00	Lead, Connecting 7/16 Wide (added)
4	20	MS 203-6-1.68	Lead, Connecting 1/4 Wide (added)
8	19	MS 203-6-1.25	Lead, Connecting 1/4 Wide (added)
4	18	CC 109-19	Capacitor, Fixed, Ceramic (added)
8	17	CC-109-36	Capacitor, Fixed, Ceramic (added)
8	16	TE-187	Spacer, Shouldered (replaces hardware furnished)
8	15	TE-176-2	Standoff, G7 (replaces hardware furnished)
14	14	TE-176-1	Standoff, G7 (8) added
9	13	NTH0832BN10	Nut, Hex. (8) added
9	12	LWS08MRN	Lockwasher, SPLIT (16) added
2	11	IM 198	Insulator, Filament Collet (added)
6	10	SCBP0832BN16	Screw, Machine (replaces hardware furnished)
8	9	SCBP0832BN20	Screw, Machine (replaces hardware furnished)
8	8	NTH0632BN8	Nut, Hex. (added)
40	7	LWS06MRN	Lockwasher, SPLIT (32) added
8	6	SCBP0632BN10	Screw, Machine (use hardware furnished)
32	5	SCBP0632BN4	" " (added)
4	4	SCBP1032BN6	Screw, Machine (added)
	3		DELETED
4	2	SM-127BN1032	NUT, SELF LK, 1032 (ADDED)
1	1	TS-134	Socket, Electron Tube

THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
STOCK SIZE			
AX-130 ASS'Y (POWER AMPL. TUBE SOCKET, V900)			
MATERIAL			
DRAWN: [Signature] CHECKED: [Signature] FINAL APPROVAL: [Signature]			
TYPE & TEMPER HEAT TREAT. SPEC.			
FINISH & SPEC. NO.			
ELEC. DES. APP. MECH. DES. APP. SHEET OF			
A 1663			

1	GPT-40K	AX-238			
1	GPT-10K	AX-236			
REQ. PER UNIT	MODEL	SECTION	ASSY. NO.	DATE	USED ON

SYMBOL	ZONE	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
G		ADDED SYM. TO ITEM 17 & 18	3-1-67	17871	RME	[Signature]	[Signature]
F		DWG REVISED & CLARIFIED PER EMN 10109	10/1/63	10109	[Signature]	[Signature]	[Signature]
E	52	ITEMS (C) WAS SCBP0832BN10 (C) WAS SCBP0832BN16 HOWE CLARIFIED.	4-23-63	8857	[Signature]	[Signature]	[Signature]
D	49	ON DIS-ASSEMBLY PROCEDURE, STEP #3 CLARIFIED CONTROL GRID SPRING & RE-ASSEMBLY DETAIL ADDED	12-5-62	7770	[Signature]	[Signature]	[Signature]
C		ITEM 6 WAS SCBP0832BN16	10/11/61	5696	[Signature]	[Signature]	[Signature]
B		Revised & Redrawn	4/25/61	4791	[Signature]	[Signature]	[Signature]

UNLESS OTHERWISE SPECIFIED: SCALE 5401-23 (Y309)

DIMENSIONS ARE IN INCHES

TOLERANCES ON FRACTIONS ± 1/64 DECIMALS ± .005 ANGLES ± 1/2°

MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS & SHARP EDGES

TMC FORM NO. 111

A 1663 G

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