

NOTE REGARDING FACTORY CALIBRATION PROCEDURES

AND TEST SPECIFICATIONS

Factory Calibration Procedures and Test Specifications are intended for use at the factory as a general guide for calibrators and quality control men. Most of the tolerances listed in these sheets are closer than advertised specifications. This is done purposely in order to insure that the instrument will meet or exceed advertised specifications when it reaches the customer.

These calibration procedures and test specifications should be used, therefore, as a guide only.

Some of the test equipment referred to in the calibration procedures is not available commercially; the Tektronix field engineer will be glad to suggest alternate approaches.

FACTORY CALIBRATION PROCEDURE

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INTRODUCTION:

This isn't a field recalibration procedure as is the procedure in your instruction manual. This is a guide in calibrating brand-new instruments, just assembled instruments that have never been turned on before. Therefore it calls out many procedures and adjustments that are rarely required for subsequent recalibration.

Even though we wrote this procedure primarily for our own factory test department, it's valuable to others also if used with some caution:

1. Special test equipment, if mentioned, is not available from Tektronix unless it's listed also in our current catalog. This special equipment is used in our test department to speed calibration. Usually you can either duplicate its function with standard equipment in your facility, devise alternate approaches, or build the special test equipment yourself.
2. Factory circuit specifications are not guaranteed unless they also appear as catalog or instruction manual specifications. Factory circuit specs usually are tighter than advertised specs. This helps insure the instrument will meet or exceed advertised specs after shipment and during subsequent field recalibrations over several years of use. Your instrument may not meet factory circuit specs but should meet catalog or instruction manual specs.
3. Presetting internal adjustments, if mentioned, usually is unnecessary. This is helpful for "first-time" calibration only. If internal adjustments are preset, you'll have to perform a 100% recalibration. So don't preset them unless you're certain a "start-from-scratch" policy is the best.

In this procedure, all front panel controls for the instrument under test are in capital letters (SENSITIVITY) and internal adjustments are capitalized only (Gain Adj).

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For 53/54L and L,
all serial numbers.



ABBREVIATIONS:

a	amp	mid r	midrange or centered
ac	alternating current	min	minimum
approx	approximately	mm	millimeter
b	base	mpt	metalized, paper tubular (capacitor)
bulb	light, lamp, etc.	msec	millisecond
c	collector	mt	mylar, tubular (capacitor)
ccw	counterclockwise or full counterclockwise	mv	millivolt
cer	ceramic	μ	micro (10^{-6})
cm	centimeter	μ f	microfarad
comp	composition (resistor)	μ h	microhenry
cps	cycles per second	μ sec	microsecond
crt	cathode ray tube	n	nano (10^{-9})
cw	clockwise or full clockwise	nsec	nanosecond
db	decibel	Ω	ohm
dc	direct current	p	pico (10^{-12})
div	division	pbt	paper, "bathtub" (capacitor)
e	emitter	pcc	paper covered can (capacitor)
emc	electrolytic, metal cased (capacitor)	pf	picofarad ($\mu\mu$ f)
emt	electrolytic, metal tubular	piv	peak inverse voltage
fil	filament	pmc	paper, metal cased (capacitor)
freq	frequency	poly	polystyrene
gmV	guaranteed minimum value (capacitor)	pot	potentiometer
gnd	chassis ground	prec	precision (resistor)
h	henry	pt	paper, tubular (capacitor)
hv	high voltage	ptm	paper, tubular molded (capacitor)
inf	infinity	ptp	peak-to-peak
int	internal	sec	second
k	kilo (10^3)	sn	serial number
k	kilohm	term	terminal
m	milli (10^{-3})	tub	tubular (capacitor)
ma	milliamp	unreg	unregulated
max	maximum	v	volt
mc	megacycle	var	variable
meg	megohm	w	watt
mh	millihenry	WW	wire wound
		x-former	transformer

FACTORY CIRCUIT SPECIFICATIONS

SPEC QUALIFICATION

Factory circuit specifications are qualified by the conditions specified in the main body of the calibration procedure. The numbers listed beside the specs correspond to the factory calibration procedure steps where the check or adjustment is made. Instruments may not meet factory circuit specs if calibration or check-out methods and test equipment differ substantially from those in this procedure.

NOT INTENDED FOR INCOMING INSPECTION

We initially calibrate the instrument to factory circuit specifications. These specs usually are tighter than advertised specs, thus helping to insure the instrument will meet or be within advertised specs after shipment and during subsequent recalibrations. Instruments that have left our factory may not meet factory circuit specs but should meet catalog or instruction manual specs.

1. EQUIPMENT REQUIRED

2. PRELIMINARY INSPECTION

3. L PRESETS

4. RESISTANCE CHECKS

5. SETUP

6. OUTPUT DC LEVEL

6a. 67.5 v: ± 2.5 v, max.

7. VARIABLE ATTEN BAL

7a. Mid r: $\pm 90^\circ$, max.

8. GAS AND MICROPHONICS

8a. Gas: 2 mm, max.

8b. Microphonics: .5 mm, max; no ringing type.

9. VERT POS RANGE

9a. Mid r: $\pm 90^\circ$, max.

10. VARIABLE ATTEN BAL X10

10a. Mid r: $\pm 90^\circ$, max.

11. X10 AC MICROPHONICS

11a. Microphonics: .5 cm, max; no ringing type.

12. CATHODE-CURRENT ADJ

12a. +100 v

12a. Mid r: $\pm 90^\circ$, max.

13. GAIN ADJUST

13b. Range: $\pm 10\%$, min.

13c. VARIABLE range: 2.5 to 1, min.

14. AC-DC

15. GAIN ADJUST X10

15b. Range: $\pm 10\%$, min.

16. VOLTS/CM

16a. Accuracy: $\pm 2\%$, max.

17. INPUT CAPACITY

18. VOLTS/CM COMPENSATION

19. LOW FREQ ADJ

19b. Mid r: $\pm 105^\circ$, max.

20. HF PEAKING

20b. Not against stop.

21. PREAMP HF COMP

22. FREQUENCY RESPONSE

- 22b. DC: dc to 30 mc (-3 db point).
- AC: 2 cps (-3 db point) to 30 mc (-3db point).
- 22c. X10 GAIN AC: 3 cps to 24 mc (-3 db point).

23. THE END.

FACTORY CALIBRATION PROCEDURE

CALIBRATION

NOTES

1. EQUIPMENT REQUIRED

- | | | |
|----------------------------|---|--|
| a. Plug-in scope | | 1a. Plug-in scope |
| 1 540 series | Tektronix type scope | (1) Determine condition of delay line (front corner). Use P unit or known good K unit. A badly tuned delay line will affect appearance of high frequency waveform. |
| b. Test equipment | | 1b. Equipment substitutes |
| 1 105 | Tektronix type square-wave generator | (1) TU-40 may be substituted for 105 or 190B. |
| 1 107 | Tektronix type square-wave generator | (2) TU-50 may be substituted for 105, 107, and 190B. |
| 1 190B | Tektronix type constant amplitude sine-wave generator | |
| c. Test accessories | | |
| 2 012-001 | 52 Ω 42" cables, uhf connectors | |
| 1 011-031 | 50 Ω 10:1 attenuator | |
| 1 011-045 | 50 Ω termination | |
| 1 011-022 | 20 pf input time-constant standardizer | |
| 1 013-019 | Plug-in extension | |
| d. Miscellaneous equipment | | |
| 1 630 | Triplet meter; 20,000 Ω /v dc | |
| or 262 | Simpson meter; 20,000 Ω /v dc | |
| 1 special | Standard calibrator | |

2. PRELIMINARY INSPECTION

- a. Check for unsoldered joints, rosin joints, lead dress, and long leads. Check for loose hardware and protruding parts. Check controls for smooth mechanical operation, proper indexing, and spacing of knobs from front panel.

3. L PRESETS

a. External controls

VERTICAL POSITION	mid r
VOLTS/CM VARIABLE	.05 CALIBRATED
input	DC
GAIN ADJUST GAIN ADJUST X10	cw cw
VARIABLE ATTEN BAL VARIABLE ATTEN BAL X10	mid r mid r

b. Internal adjustments

All coil slugs	just below bottom of windings
All other internal adjust- ments	mid r

c. Leave controls and adjustments, for any step, as they were in the step preceding, unless noted otherwise.

3b. Presetting internal adjustments

(1) Presetting internal adjustments is helpful for "first-time" calibration but is usually unnecessary for recalibration. If you preset, you'll have to perform a 100% recalibration. Don't preset them unless you're certain a "start-from-scratch" policy is the best.

4. RESISTANCE CHECKS

a. Check resistances to ground

use	Amphenol pin	approx resistance
output	1	9 k
gnd	2	0 Ω
output	3	9 k
not used	4 to 8	inf
-150 v	9	14 k
+100 v	10	1.2 k
+225 v	11	8.5 k
+350 v	12	inf
not used	13, 14	inf
+75 v filament	15	90 Ω
not used	16	inf

9. VERT POS RANGE

a. Vert Pos Range R6572

Momentarily short Amphenol connector pins 1 and 3 together and note trace vertical position (electrical center).

Recheck VARIABLE ATTEN BAL. Set VERTICAL POSITION to mid r. Adjust Vert Pos Range R6572 to move trace to plug-in scope's electrical center.

b. R6572 mid r, $\pm 90^\circ$, max

Vert Pos Range R6572 must be within $\pm 90^\circ$ of mid r after adjustment.

10. VARIABLE ATTEN BAL X10a. VARIABLE ATTEN BAL X10 mid r: $\pm 90^\circ$, max

Set input to X10 GAIN AC. Return trace to electrical center with VARIABLE ATTEN BAL X10. VARIABLE ATTEN BAL must be within $\pm 90^\circ$ of mid r after adjustment.

11. X10 AC MICROPHONICS

a. Microphonics .5 cm, max; no ringing type

Rotate VOLTS/CM through range and note microphonics: .5 cm, max; no ringing type.

11a. Ringing or excessive micro

(1) Select V5832, V5942, V6042, and V6132.

12. CATHODE-CURRENT ADJa. Cathode-Current Adj R5922 +100 v
mid r: $\pm 90^\circ$, max

Connect voltmeter from V6042, pin 6 to V6042, pin 2 or 7. Adjust Cathode-Current Adj R5922 for +100v. Remove meter. R5922 must be within $\pm 90^\circ$ after adjustment.

13. GAIN ADJUST

a. Setup

accurate +100v--52Ω cable--cal in, standard cal
L INPUT--52Ω cable--output, standard cal

L presets

input	DC
VOLTS/CM	.05
VARIABLE	CALIBRATED

b. GAIN ADJUST range: ±10%, min

Apply .1v from standard calibrator to INPUT. Set GAIN ADJUST cw; note 2.2 cm deflection, min. Change GAIN ADJUST to ccw; note 1.8 cm deflection, max. Adjust GAIN ADJUST for exactly 2 cm deflection.

c. VARIABLE range: 2.5 to 1, min

Set VARIABLE to max atten. Note deflection: .8 cm, max. Note any noise or open spots during rotation of VARIABLE. Return to CALIBRATED.

14. AC-DC

a. Waveform shift

Move bottom of calibrator waveform to center graticule line with VERTICAL POSITION. Change input to AC. Waveform must shift so it's approximately centered about center graticule line.

15. GAIN ADJUST X10

a. GAIN ADJUST X10 range: ±10%, min

Apply 10 millivolts from standard calibrator to INPUT. Set input to X10 AC. Set GAIN ADJUST X10 cw; note 2.2 cm deflection, min. Change GAIN ADJ X10 ccw; note 1.8 cm deflection, max. Adjust GAIN ADJUST X10 for exactly 2 cm deflection. Reset input to DC.

13a. Known accurate +100v

- (1) A good source is the test scope:
- (2) Connect the standard calibrator cal in connector to the test scope cal out connector.
- (3) Connect the standard calibrator output to the test scope input.
- (4) Remove the output section of the test scope amplitude calibrator's multivibrator and set the amplitude calibrator control to 100 volts.
- (5) Connect an accurate voltmeter (John Fluke type 803 differential voltmeter) to the cal out connector and adjust the Cal Adj for exactly +100v on the voltmeter.
- (6) Remove the meter.

16. VOLTS/CM

a. VOLTS/CM accuracy $\pm 2\%$, max

VOLTS/CM	calibrator volts	deflection cm $\pm 2\%$
.05	.1	*2 , $\pm .4$ mm, adjustable
.1	.2	2 , $\pm .4$ mm
.2	.5	2.5, $\pm .5$ mm
.5	1	2 , $\pm .4$ mm
1	2	2 , $\pm .4$ mm
2	5	2.5, $\pm .4$ mm
5	10	2 , $\pm .4$ mm
10	20	2 , $\pm .4$ mm
20	50	2.5, $\pm .5$ mm

*Adjusted previously

17. INPUT CAPACITY

a. Setup

105--50 Ω term--52 Ω cable--20 pf stand--L INPUT
 or TU-50, 105 gen--special atten head--20 pf
 stand--L INPUT

L presets

VOLTS/CM	.05
VARIABLE	CALIBRATED
input	DC

b. C5732

Set 105 for about 3.5 cm deflection of 1 kc signal.
 Adjust C5732, input capacitor, for best square wave.

18. VOLTS/CM COMPENSATION

a. Setup

Use an EP54 plug-in extension to connect L plug-in to plug-in scope. Place special shield over L plug-in atten.

b. Adjust compensation

Keep 3.5 cm, 1 kc 105 deflection and adjust for best square wave as follows:

VOLTS/CM	spike	adjustment level
.05	--	C5732*
.1	C5102	C5072
.2	C5162	C5142
.5	C5222	C5202
1	C5292	C5272
2	C5362	C5342
5	C5432	C5412
10	C5522	C5502
20	C5622	C5602

*Adjusted previously

19. LOW FREQ ADJ

a. Setup

Set plug-in scope to 5 msec/cm.

L presets

VOLTS/CM	.05
VARIABLE	CALIBRATED
input	AC

b. Low Freq Adj R6182 mid r: $\pm 105^\circ$, max

Set 105 to 100 cps. Adjust 105 for 3.5 cm deflection. Note top slanting of square wave. Set input to X10 AC.

Readjust 105 for 3.5 cm deflection.

Adjust Low Freq Adj R6182 for same slant of waveform noted in AC. R6182 must be within $\pm 105^\circ$ of mid r after adjustment.

Remove 105 signal. Remove extension from L unit and insert L unit into scope.

20. HF PEAKING

a. Setup

107--52 Ω cable--50 Ω term--L INPUT

L presets

VOLTS/CM	.05
VARIABLE	CALIBRATED
AC-DC	DC

Set plug-in scope to .2 μsec/cm.

b. HF Peaking R6692

Set 107 for about 3 cm deflection of approx 450 kc.
Adjust HF Peaking R6692 for best square wave.
R6692 must not be against stop after adjustment.

20b. Excessive peaking or rolloff

- (1) Select V5832.
- (2) Select V6242, V6342 (selected pair).

21. PREAMP HF COMP

a. Setup

107--52 Ω cable--10:1 atten--50 Ω term--L INPUT

Leave scope preset as before.

L presets

VOLTS/CM	.05
VARIABLE	CALIBRATED
input	X10 GAIN AC

b. L5902, L5942, L6012

Set 107 for about 3 cm deflection of approx 450 kc.
Adjust L5902, L5942, and L6012 for best square
wave. Remove 107 signal.

21b. Excessive peaking

- (1) Select V5942, V6042.

22. FREQUENCY RESPONSE

a. Setup

Plug-in scope presets

Trigger	ac
Time/cm	.1 msec
Stability	cw

L presets

VOLTS/CM	.05
VARIABLE	CALIBRATED
input	DC

b. Response-DC input dc to 30 mc (-3 db point)

Attach a $50\ \Omega$ termination to 190B output and connect to L INPUT. Set 190B to 50 kc. Adjust 190B for exactly 3 cm deflection.

Increase 190B to 30 mc. Note deflection: 2.1 cm, min.

c. Response-X10 GAIN AC input
3 cps to 24 mc (-3 db point)

190B--10:1 atten-- $50\ \Omega$ term--L INPUT

Set input to X10 GAIN AC. Set 190B to 50kc. Adjust 190B for exactly 3 cm deflection.

Increase 190B to 24 mc. Note deflection: 2.1 cm, min.

23. THE END.

