

Color television final assembly: quality and quantity

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Simultaneous quality and quantity in manufacturing is a difficult task, but RCA has done it. A lengthy approval cycle and arduous product testing make this high-reliability, high-production operation possible.

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Authors **George Laskaris**, **Bob Veit**, and **Gib Apple** (left to right) and a GD835R color television receiver.



Millions of RCA color television sets are in use throughout the United States and the world. Since the early 1950s, when RCA pioneered color television, many "state-of-the-art" improvements have taken place in circuitry design, performance, and reliability. During this period, manufacturing techniques have kept pace with the design engineers, making many improvements in the assembly and test techniques used to manufacture color television sets. This article discusses these current assembly and test methods.

RCA's color television Final Instrument Assembly Plant (Fig. 1), located in Bloomington, Indiana, employs 500 salaried and 2400 hourly workers. The final-assembly plant at RCA Bloomington, commonly referred to as Plant 2, has 450,000 square feet of space, and is totally devoted to color television final-assembly and material-support functions. The plant has ten television assembly lines; each line is capable of producing 300 color television sets on a single shift.

Historically, color-television assembly lines have been structured into the following groups for better supervisory and quality control—Cabinet, Tube, Chassis, Final Test, Prepack, Final Acceptance, and Packing.

Production starts at the Cabinet Section. There, cabinets from RCA's cabinet plants or from outside vendors are unpacked and assembled. Over 90% of our cabinets come from RCA's Indianapolis and Monticello Plants. Next, the cabinet goes to the Tube Section, where the picture tube is assembled in the cabinet. The set then goes to the Chassis Section, where the chassis is installed and all connections made. After the set is tested and aligned in the Final Test Section, it is prepared for shipment in

Tv Production Manual

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Table of Contents Tv Production Manual

1. Understanding the eBook Tv Production Manual
 - The Rise of Digital Reading Tv Production Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Tv Production Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Tv Production Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Tv Production Manual
 - Personalized Recommendations
 - Tv Production Manual User Reviews and Ratings
 - Tv Production Manual and Bestseller Lists
5. Accessing Tv Production Manual Free and Paid eBooks
 - Tv Production Manual Public Domain eBooks
 - Tv Production Manual eBook Subscription Services
 - Tv Production Manual Budget-Friendly Options
6. Navigating Tv Production Manual eBook Formats

- ePub, PDF, MOBI, and More
- Tv Production Manual Compatibility with Devices
- Tv Production Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Tv Production Manual
 - Highlighting and Note-Taking Tv Production Manual
 - Interactive Elements Tv Production Manual
- 8. Staying Engaged with Tv Production Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Tv Production Manual
- 9. Balancing eBooks and Physical Books Tv Production Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Tv Production Manual
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Tv Production Manual
 - Setting Reading Goals Tv Production Manual
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Tv Production Manual
 - Fact-Checking eBook Content of Tv Production Manual
 - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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