

# UNCLASSIFIED

|                                                                                                                                                                                                                                 |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
|                                                                                                                                                                                                                                 |
|                                                                                                                                                                                                                                 |
|                                                                                                                                                                                                                                 |
|                                                                                                                                                                                                                                 |
| AD NUMBER                                                                                                                                                                                                                       |
| AD834987                                                                                                                                                                                                                        |
| NEW LIMITATION CHANGE                                                                                                                                                                                                           |
| TO<br>Approved for public release, distribution unlimited                                                                                                                                                                       |
| FROM<br>Distribution authorized to U.S. Gov't. agencies and their contractors; Critical Technology; 31 DEC 1967. Other requests shall be referred to Army Electronics Command, ATTN: AMSEL-K1-SP, Fort Monmouth, NJ 07703-5601. |
| AUTHORITY                                                                                                                                                                                                                       |
| USAECOM ltr dtd 26 Jul 1976                                                                                                                                                                                                     |

THIS PAGE IS UNCLASSIFIED

AD



AD834987

PRODUCTION ENGINEERING MEASURE  
for

# TYPE CR-(XM-57)/U CRYSTAL UNITS

## SEVENTH QUARTERLY REPORT

*Prepared By*  
*U.S. Army Electronics Command*  
*Philadelphia, Pennsylvania*

Oct 1967 to December 1967

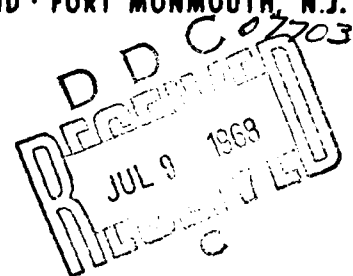
"THIS DOCUMENT IS SUBJECT TO SPECIAL EXPORT CONTROLS AND EACH TRANSMIT-  
TAL TO FOREIGN GOVERNMENTS OR FOREIGN NATIONALS MAY BE MADE ONLY WITH  
PRIOR APPROVAL OF THE INDUSTRIAL ENGINEERING DIVISION, USAECOM".

*attn: AMSEL-KI-SP.*

# ECOM

UNITED STATES ARMY ELECTRONICS COMMAND · FORT MONMOUTH, N.J.  
CONTRACT NO. DA-36-039-AMC-06182(E)  
ORDER NO. FR-36-039-N-6-01409(E)

THE BULOVA WATCH COMPANY  
ELECTRONICS DIVISION  
61-20 Woodside Avenue  
Woodside, New York



28  
36

SEVENTH QUARTERLY REPORT

October 1967 to December 1967

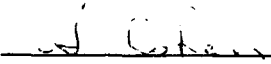
Production Engineering Measure For  
Type CR-(XM-57)/U Crystal Units

Order No. FR-36-039-N-6-01409 (E)  
Contract No. DA-36-039-AMC-06182 (E)

Placed by: U.S. Army Electronics Command  
Philadelphia, Pennsylvania

With: The Bulova Watch Company  
Electronics Division  
61-20 Woodside Avenue  
Woodside, N.Y.

Object of Study: Prepare for quantity production,  
under controlled conditions, on  
the CR-(XM-57)/ Precision  
Crystal Units

Prepared by:   
S. Cohen  
Project Director

"This document is subject to special export controls and each transmittal to foreign governments or foreign nations may be made only with prior approval of the Industrial Engineering Division, USAECOM".

## TABLE OF CONTENTS

| List of Tables                                   | <u>Page</u> |
|--------------------------------------------------|-------------|
| I Abstract                                       | 1           |
| II Purpose                                       | 2           |
| III Narrative and Data                           | 4           |
| A. Environmental Testing of Pre-production Units | 4           |
| B. Data Obtained                                 | 5           |
| C. Equipment Used                                | 17          |
| IV Conclusions                                   | 18          |
| V Program for the Next Interval                  | 19          |
| VI Publications and Conferences                  | 20          |
| VII Manhours Expended                            | 21          |
| VIII Appendix I - Distribution List              |             |

# LIST OF TABLES

| <u>Table No.</u> |                                                                               | <u>Page No.</u> |
|------------------|-------------------------------------------------------------------------------|-----------------|
| I                | Crystal Parameter Data - Results of Thermal Shock Testing                     | 6               |
| II               | Crystal Parameter Data - Results of Salt Spray Testing                        | 8               |
| III              | Crystal Parameter Data - Results of Moisture Resistance Testing               | 10              |
| IV               | Crystal Parameter Data - Results of Life Test for 5.000000 MHZ Crystal Units  | 14              |
| V                | Crystal Parameter Data - Results of Life Test for 7.5000000 MHZ Crystal Units | 15              |
| VI               | Crystal Parameter Data - Results of Life Test for 10.000000 MHZ Crystal Units | 16              |
| VII              | Equipment Used                                                                | 17              |

I ABSTRACT

Results obtained from the "Group 2" and "Group 3" environmental testing per MIL-C-39020 are presented.

## II PURPOSE

To establish a design for CR-(XM-57)/U Crystal Units which will be adaptable to moderate and large quantity production. To establish overall test and measurement techniques for these units including the setup of aging test and measuring equipment, to prepare a Q. C. Manual covering these techniques as adapted to our pilot line. To establish pilot line equipment and the flow of material. To make a production type run to demonstrate the capability of the pilot line to fabricate 800 units per month meeting the applicable specification per 8 hour shift. To make a complete aging and reliability study of these units.

Crystals Under Study

| <u>Items</u> | <u>Nominal Frequency</u> | <u>Type</u>  | <u>Quantities</u>  |                                 |
|--------------|--------------------------|--------------|--------------------|---------------------------------|
|              |                          |              | <u>Engineering</u> | <u>Preproduction Production</u> |
| 1-2-1        | 5.000000 MC              | CR-(XM-57)/U | 12                 | 10 200                          |
| 1-2-2        | 6.000000 MC              | CR-(XM-57)/U | 12                 | 200                             |
| 1-2-3        | 7.500000 MC              | CR-(XM-57)/U | 12                 | 10 200                          |
| 1-2-4        | 9.000000 MC              | CR-(XM-57)/U | 12                 | 200                             |
| 1-2-5        | 10.000000 MC             | CR-(XM-57)/U | 12                 | 10 200                          |

### III - Narrative

#### A. Completion of Environmental Testing of the Preproduction Units

The purpose of this report is to record the progress made during the seventh quarterly interval of the project. This period was devoted to the completion of the pre-production testing. Group 3 and Group 4 Testing of Table III of MIL-C-39020 were done at this time.

As reported in the last quarterly report, the only exception to the military specification has been in regards to sample size. Due to the limited number of pre-production samples (30) it was decided to place twenty units through "Group 1" testing, seven of the 5 MHZ units, seven of the 7.5 MHZ units and six of the 10 MHZ units. Of these twenty units, ten of them (3 at 5 MHZ, 3 at 7.5 MHZ, and 4 at 10 MHZ) were placed into "Group 2" testing for evaluation along with the remaining ten units.

The other ten units having been exposed to "Group 1" testing were subjected to "Group 3" testing. All thirty units were then subjected "Group 4" testing which is the life test.

The data collected shall now be presented in the order listed in the applicable military specification

B. Data

1. "Group 3" Testing

a. Thermal Shock - units were subjected to an immersion in boiling water for  $15 \pm 1$  seconds and immediately thereafter in ice water for  $5 \pm 1$  second.

The units were then placed under a strong light and exposed to ten power magnification. All glass parts were then carefully examined. In no instance was there evidence of cracking, chipping, or breaking in any part of the crystal units. Measurements were then taken of frequency and Q at  $85^{\circ}\text{C}$ . Results of this test are presented in Table I.

TABLE I

Crystal Parameter - Data  
Results of Thermal Shock Testing

5.000000 MC

| <u>Freq. at + 85° C</u><br><u>After Thermal Shock (cps)</u> | <u>Q at +85° C</u><br><u>After Thermal Shock</u> |
|-------------------------------------------------------------|--------------------------------------------------|
| 5.000022                                                    | 1,037,000                                        |
| 5.000001                                                    | 1,070,000                                        |
| 5.000007                                                    | 1,006,000                                        |
| 5.000000                                                    | 1,020,000                                        |

7.500000 MC

|          |           |
|----------|-----------|
| 7.499970 | 1,030,000 |
| 7.500018 | 1,050,000 |
| 7.500034 | 1,050,000 |
| 7.499989 | 1,027,000 |

10.000000 MC

|           |           |
|-----------|-----------|
| 10.000033 | 1,020,000 |
| 10.000017 | 1,043,000 |

Requirements - The frequency and Q shall be within  
the frequency tolerance ( $\pm 0.0005\%$  at  $85^{\circ}\text{C}$ )  
and minimum Q (1,000,000) requirements

$C_L = 50\text{pf} \pm .5\text{pf}$  Drive level  $2.0 \pm 50\%$  microwatts

b. Salt Spray - The crystal units were tested in accordance with method 101, test condition B, of MIL-STD-202.

After the test, the units were visually examined for evidence of excessive corrosion. There was no evidence of excessive corrosion visible. Excessive corrosion was construed as any type of corrosion that will interfere in any way with the electrical or mechanical performance of the units. Measurements were then taken for frequency and Q at 85° C. Results of this test are presented in Table II.

TABLE II  
Crystal Parameter Data  
Results of Salt Spray Testing

5.000000 MC

| <u>Freq. at +85°C</u><br><u>After Salt Spray (cps)</u> | <u>Q at 85° C</u><br><u>After Salt Spray</u> |
|--------------------------------------------------------|----------------------------------------------|
|--------------------------------------------------------|----------------------------------------------|

|          |           |
|----------|-----------|
| 5.000024 | 1,030,000 |
| 5.000002 | 1,065,000 |
| 5.000007 | 1,010,000 |
| 5.000002 | 1,020,000 |

7.500000 MC

|          |           |
|----------|-----------|
| 7.499969 | 1,030,000 |
| 7.500015 | 1,035,000 |
| 7.500034 | 1,040,000 |
| 7.499990 | 1,020,000 |

10.000000 MC

|           |           |
|-----------|-----------|
| 10.000032 | 1,010,000 |
| 10.000017 | 1,043,000 |

Requirements - The frequency and Q shall be within  
the frequency tolerance ( $\pm 0.0005\%$  at 85°C)  
and minimum Q (1,000,000) requirements

$C_L = 50\text{pf} \pm .5\text{pf}$       Drive level  $2.0 \pm 50\%$  microwatts

c. Moisture Resistance - Crystal units were tested in accordance with method 106 of MIL-STD-202. The following details and exceptions were applied as per paragraph 4.7.13 of MIL-C-39020.

- (a) Initial Measurements - Not applicable
- (b) Subcycle, step 7b, the vibration subcycle, shall be omitted
- (c) Polarization and loading voltage - Not applicable
- (d) Final measurements - After the drying period, frequency, equivalent resistance, and insulation resistance shall be measured.

Insulation resistance was measured in accordance with method 302 of MIL-STD-202, using a test potential of 50 volts. The measurement was made between the pins.

All of the units tested exhibited an insulation resistance more than the requirement specified in paragraph 3.21 of MIL-C-39020 (500 megohms). Measurements were then taken for frequency and Q at 85° C. Results of this test are presented in Table III.

TABLE III  
Crystal Parameter Data  
Results of Moisture Resistance Testing

5.000000 MC

| <u>Freq. at +85°C</u><br><u>After M.R. (cps)</u> | <u>Q at +85°C</u><br><u>After M.R.</u> |
|--------------------------------------------------|----------------------------------------|
| 5.000022                                         | 1,037,000                              |
| 5.000001                                         | 1,075,000                              |
| 5.000008                                         | 1,024,000                              |
| 5.000001                                         | 1,024,000                              |

7.500000 MC

|          |           |
|----------|-----------|
| 7.499968 | 1,026,000 |
| 7.500016 | 1,030,000 |
| 7.500033 | 1,035,000 |
| 7.500088 | 1,015,000 |

10.000000 MC

|           |           |
|-----------|-----------|
| 10.000034 | 1,020,000 |
| 10.000018 | 1,040,000 |

Requirements - The frequency and Q shall be within in  
frequency tolerance ( $\pm 0.0005\%$  at  $85^{\circ}\text{C}$ )  
and minimum Q (1,000,000) requirements.  
The insulation resistance shall not be less  
than 500 megohms.

$C_L = 50\text{pf} \pm .5\text{pf}$  Drive level  $2.0 \pm 50\%$  microwatts

d. Terminal Pull - The crystal units were tested in accordance with method 211, test condition A, of Standard MIL - STD-202. A force of 4 pounds were applied to the pin terminals of each crystal unit.

Each terminal withstood the applied pull force, without any of damage or relative movement at the point of sealing between the terminals and the base.

e. Seal - Crystal units were subjected to three heat cycles, each cycle consisting of the following; the temperature of each unit was raised to + 100° C for thirty minutes, then allowed to cool to room temperature at a rate not exceeding 2° C per minute.

Twenty-four hours after the heat cycling took place an energized Tesla Coil was brought into proximity of each unit. All exhibited the characteristic blue glow of a vacuum seal. The units were then placed under a strong light and exposed to ten power magnification. All glass parts were then carefully examined. In no instance was there evidence of cracking, chipping, or breaking in any part of the crystal units.

2. "Group 4" Testing

a. Life Test (1,000 hours) - The units were stored at a temperature of 85° C in the reliability test ovens for a continuous period of 1,000 hours. Measurements of frequency and resistance were made at the following intervals: 24 hours, 100 hours, 250 hours, and 500 hours and 1,000 hours. Results of this test are presented in IV, V and VI.

TABLE IV  
Crystal Parameter Data  
Results of Life Test

5.000000 MC

| S/N | Deviation<br>24 hrs. to 100 hrs.<br>@ 85°C |                 |  | Deviation<br>24 hrs. to 250 hrs.<br>@ 85°C |                 |  | Deviation<br>24 hrs. to 500 hrs.<br>@ 85°C |                 |  | Deviation<br>24 hrs. to 1000 hrs.<br>@ 85°C |                 |  |
|-----|--------------------------------------------|-----------------|--|--------------------------------------------|-----------------|--|--------------------------------------------|-----------------|--|---------------------------------------------|-----------------|--|
|     | $\Delta F$<br>PP 10 <sup>-8</sup>          | $\Delta R$<br>% |  | $\Delta F$<br>PP 10 <sup>-8</sup>          | $\Delta R$<br>% |  | $\Delta F$<br>PP 10 <sup>-8</sup>          | $\Delta R$<br>% |  | $\Delta F$<br>PP 10 <sup>-8</sup>           | $\Delta R$<br>% |  |
| 500 | +2                                         | 0               |  | +5                                         | +1              |  | +7                                         | +3              |  | +8                                          | +2              |  |
| 501 | +3                                         | +2              |  | +7                                         | +2              |  | +9                                         | +2              |  | +11                                         | +1              |  |
| 502 | -5                                         | +1              |  | -3                                         | +2              |  | -1                                         | +2              |  | +3                                          | 0               |  |
| 503 | -5                                         | +1              |  | -2                                         | 0               |  | -4                                         | +1              |  | -8                                          | -1              |  |
| 504 | +4                                         | 0               |  | +8                                         | -1              |  | +10                                        | -1              |  | +7                                          | +1              |  |
| 505 | -2                                         | 0               |  | 0                                          | +1              |  | +1                                         | +1              |  | +4                                          | +2              |  |
| 506 | -3                                         | -1              |  | +1                                         | 0               |  | +3                                         | -1              |  | +7                                          | -3              |  |
| 507 | +2                                         | 0               |  | +7                                         | -1              |  | +9                                         | +1              |  | +13                                         | +3              |  |
| 508 | -6                                         | -1              |  | -9                                         | +1              |  | -5                                         | +2              |  | -1                                          | +2              |  |
| 509 | +9                                         | 0               |  | +13                                        | +2              |  | +14                                        | +2              |  | +17                                         | +2              |  |

Note: The following units were subjected to the 500 hour aging test prior to the life test.

S/N 500, 501, 502, 503, 504, 505, 506

TABLE V  
Crystal Parameter Data  
Results of Life Test

7.5000000 MC

| S/N | Deviation<br>24 hrs. to 100 hrs.<br>@ 85°C |                 | Deviation<br>24 hrs. to 250 hrs.<br>@ 85°C |                 | Deviation<br>24 hrs. to 500 hrs.<br>@ 85°C |                 | Deviation<br>24 hrs. to 1000 hrs.<br>@ 85°C |                 |
|-----|--------------------------------------------|-----------------|--------------------------------------------|-----------------|--------------------------------------------|-----------------|---------------------------------------------|-----------------|
|     | $\Delta F$<br>PP 10-8                      | $\Delta R$<br>% | $\Delta F$<br>PP 10-8                      | $\Delta R$<br>% | $\Delta F$<br>PP 10-8                      | $\Delta R$<br>% | $\Delta F$<br>PP 10-8                       | $\Delta R$<br>% |
| 700 | +2                                         | 0               | +4                                         | 0               | +2                                         | +1              | +5                                          | +2              |
| 701 | +6                                         | -2              | +8                                         | -3              | +9                                         | 0               | +7                                          | +2              |
| 702 | +1                                         | +1              | +3                                         | +2              | +4                                         | +3              | +6                                          | +3              |
| 703 | -1                                         | +1              | +2                                         | +1              | +4                                         | +3              | +5                                          | +2              |
| 704 | -3                                         | +1              | -6                                         | +1              | -4                                         | +1              | -3                                          | +2              |
| 705 | -5                                         | +2              | -3                                         | +1              | 0                                          | +2              | -1                                          | +2              |
| 706 | +4                                         | 0               | +6                                         | -1              | +7                                         | +1              | +9                                          | +1              |
| 707 | +3                                         | 0               | +7                                         | +1              | +10                                        | +1              | +8                                          | +3              |
| 708 | +5                                         | -1              | +10                                        | +1              | +14                                        | +2              | +12                                         | +3              |
| 709 | +6                                         | -1              | +11                                        | 0               | +13                                        | +2              | +17                                         | +2              |

Note: The following units were subjected to the 500 hour aging test prior to the life test.

S/N 700, 701, 702, 703, 704, 705, 706.

TABLE VI  
Crystal Parameter Data  
Results of Life Test

10.000000 MC

| S/N | Deviation<br>24 hrs. to 100 hrs.<br>@ 85°C |                 | Deviation<br>24 hrs. to 250 hrs.<br>@ 85°C |                 | Deviation<br>24 hrs. to 500 hrs.<br>@ 85°C |                 | Deviation<br>24 hrs. to 1000 hrs.<br>@ 85°C |                 |
|-----|--------------------------------------------|-----------------|--------------------------------------------|-----------------|--------------------------------------------|-----------------|---------------------------------------------|-----------------|
|     | $\Delta F$<br>PP 10-8                      | $\Delta R$<br>% | $\Delta F$<br>PP 10-8                      | $\Delta R$<br>% | $\Delta F$<br>PP 10-8                      | $\Delta R$<br>% | $\Delta F$<br>PP 10-8                       | $\Delta R$<br>% |
| 100 | +3                                         | +2              | +6                                         | +2              | +5                                         | +2              | +15                                         | +7              |
| 101 | -1                                         | +1              | +2                                         | 0               | +3                                         | +2              | +5                                          | +2              |
| 102 | +3                                         | 0               | +3                                         | +2              | +6                                         | +3              | +7                                          | +2              |
| 103 | -3                                         | 0               | -5                                         | 0               | -1                                         | -3              | 0                                           | +1              |
| 104 | -1                                         | +1              | -4                                         | +2              | -1                                         | -1              | +3                                          | +3              |
| 105 | +1                                         | -1              | +4                                         | +1              | +6                                         | +4              | +7                                          | +2              |
| 106 | +4                                         | -2              | +7                                         | -1              | +9                                         | +1              | +12                                         | -1              |
| 107 | +4                                         | -1              | +7                                         | 0               | +11                                        | +1              | +14                                         | 0               |
| 108 | +1                                         | +2              | +3                                         | +1              | +4                                         | +2              | +7                                          | +1              |
| 109 | +5                                         | +1              | +7                                         | +1              | +10                                        | -1              | +15                                         | +1              |

Note: The following units were subjected to the 500 hour aging test prior to the life test.  
S/N 100, 101, 102, 103, 104, 105

TABLE VII  
Equipment Used

| <u>Nomenclature</u>                                           | <u>Manufacture/Model</u>                           | <u>Use</u>                          |
|---------------------------------------------------------------|----------------------------------------------------|-------------------------------------|
| Reliability Oven                                              | Winslow Tele-Tronics<br>Model #PTO-1045            | Life Test                           |
| Capacitance Bridge                                            | Boonton, 74C                                       | Measurement of<br>Shunt Capacitance |
| Crystal Impedance<br>Meter TS-330                             | Radio Frequency Labs<br>Model 459                  | Oscillator                          |
| High Temperature-<br>Low Temperature<br>Humidity Test Chamber | Associated Testing Lab<br>Model ELHH-8-MRLC-3      | Moisture Resistance<br>Test         |
| High Temperature-<br>Low Temperature<br>Test Chamber          | Associated Testing Lab<br>Model 2LH-8-LC           | Moisture Resistance<br>Test         |
| Salt Spray Chamber                                            | Industrial Filter &<br>Pump Mfg. Co.<br>Model CA-3 | Salt Spray Test                     |

#### IV CONCLUSIONS

Qualification testing was completed on the preproduction samples. The units have passed all the required tests of SCS-242 and MIL-C-39020 Table III.

V PROGRAM FOR NEXT INTERVAL

1. Present quality control manual based on the techniques used in the fabrication of the preproduction samples.
2. Establish pilot line equipment and flow of material.

VI PUBLICATIONS AND CONFERENCES

No conferences were held during the reporting period of  
October to December.

VII MANHOURS EXPENDED

|                |           |
|----------------|-----------|
| S. Cohen       | 130 hours |
| S. Greenzeig   | 80 hours  |
| T. Gregory     | 100 hours |
| S. Wong        | 20 hours  |
| R. Carbonaro   | 70 hours  |
| J. Colindreler | 100 hours |

Unclassified

Security Classification

JND PPSO 13152

| DOCUMENT CONTROL DATA - R&D                                                                                                                                                                                                                                                            |                                                                             |                                                    |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------|----------------------------------------------------|
| (Security classification of title, body of abstract and indexing annotation must be entered when the overall report is classified)                                                                                                                                                     |                                                                             |                                                    |
| 1. ORIGINATING ACTIVITY (Corporate author)<br>Bulova Watch Company, Inc.<br>Electronics Division<br>61-20 Woodside Ave., Woodside, N. Y. 11377                                                                                                                                         |                                                                             | 2a. REPORT SECURITY CLASSIFICATION<br>Unclassified |
|                                                                                                                                                                                                                                                                                        |                                                                             | 2b. GROUP                                          |
| 3. REPORT TITLE<br>Production Engineering Measure for Type CR-(XM-57)/U Crystal Units                                                                                                                                                                                                  |                                                                             |                                                    |
| 4. DESCRIPTIVE NOTES (Type of report and inclusive dates)<br>Seventh Quarterly Report, Oct. 1967 to December 1967                                                                                                                                                                      |                                                                             |                                                    |
| 5. AUTHOR(S) (Last name, first name, initial)<br>Cohen, S.                                                                                                                                                                                                                             |                                                                             |                                                    |
| 6. REPORT DATE<br>December 31, 1967                                                                                                                                                                                                                                                    | 7a. TOTAL NO. OF PAGES                                                      | 7b. NO. OF REFS                                    |
| 8a. CONTRACT OR GRANT NO.<br>DA-36-039-AMC-061S2 (E)                                                                                                                                                                                                                                   | 9a. ORIGINATOR'S REPORT NUMBER(S)                                           |                                                    |
| b. PROJECT NO.                                                                                                                                                                                                                                                                         |                                                                             |                                                    |
| c.                                                                                                                                                                                                                                                                                     | 9b. OTHER REPORT NO(S) (Any other numbers that may be assigned this report) |                                                    |
| d.                                                                                                                                                                                                                                                                                     |                                                                             |                                                    |
| 10. AVAILABILITY/LIMITATION NOTICES This document is subject to special export controls and each transmittal to foreign governments or foreign nationals may be made only with prior approval of Commanding General U.S. Army Electronics Command for Fort Monmouth, N. J. AMSEL-K1-SP |                                                                             |                                                    |
| 11. SUPPLEMENTARY NOTES                                                                                                                                                                                                                                                                | 12. SPONSORING MILITARY ACTIVITY                                            |                                                    |
| 13. ABSTRACT<br><br>Results obtained from the "Group 3" and "Group 4" environmental testing per Mil-C-39020 are presented.                                                                                                                                                             |                                                                             |                                                    |

DD FORM 1473

11A 0101 807 6800

Unclassified

Security Classification