RADIO CORPORATION OF AMERICA

RCA VICTOR DIVISION

TUBE DEPT. STANDARDIZING S-2p-Kp

LANCASTER, PA.

APPLICATION OF IRIDESCENT COATING

subject: Process Specification

DATE Jan. 5, 1954 PAGE

STANDARDIZING 34-17-12B NOTICE

MAY

1955

Oct. 17, 1952 SUPERSEDED DATE transparent electrical conductive

This specification covers a process for applying coating to glass bulbs.

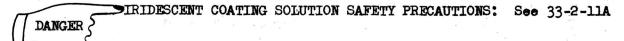
SCHEDULE NO. 1

(Initially for Tube Types C73162 and C73262)

1. EQUIPMENT

- a. Oven with regulator or temperature indicator and manual control for heating face plate and about 3" of adjacent part of bulb to 530°C.
- b. Jig for holding bulb and glass sprayer.
- c. Low pressure air filter, flow gauge and regulator.
- d. Light source for observing interference colors.
- e. Side tube plugs (ceramic or graphite).
- f. Hood or other means of carrying off fumes.
- 2. MATERIALS

I603 Iridescent Solution



3. PREPARATION

a. Sprayer should be clean and dry. Pour Iridescent solution from original container carefully to avoid including any settled crystals which would clog sprayer. Filter only if absolutely necessary.

4. PROCEDURE

- a. Mask areas which are not to be coated as specified on the bulb assembly specification.
- b. With bulb on jig and side tube plugged, raise entire unit into oven so that oven covers about 4-1/2" of bulb.

Note: When putting bulb on jig and when removing it the masked areas must not scrape against the sprayer since masking compound will rub off.

- c. As soon as temperature in oven near face plate returns to 530°C., slowly open air valve to give a flow of approximately 10c1/h through sprayer.
- d. Observe interference colors and shut off air when second yellow appears. of appearance of colors is as follows:

White

1st Yellow

Red

Violet

Blue

Green

2nd Yellow

e. Lower bulb immediately 1-1/2" and thereafter in 1-1/2" steps every 3 minutes until out of oven.

SCALE-

** End of Schedule #1.

DIMENSIONS IN

UNLESS OTHERWISE SHOWN.

DIMENSIONS SHOWN WITHOUT TOLERANCES ARE DESIGN CENTERS

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