

RCA Radiotron Division

RCA MANUFACTURING COMPANY, INC.
STANDARDIZING SECTION
RESEARCH AND ENGINEERING DEPT.

K2cpK

DATE Sept. 4, '42 PAGE 1

STANDARDIZING NOTICE 34-34-16A

SUBJECT BEADING BUTTON CONTACT ASSEMBLY

SUPERSEDED DATE

The purpose of beading a chrome iron button contact is to "wet" the surface with glass, prior to sealing into bulb, to improve adherence of metal to bulb glass.

1. EQUIPMENT

- a. 6 Model #693 American burners arranged in sets of 3 opposing burners 9" apart to provide 6 cross fires of air, gas and oxygen.
- b. Button holder consisting of a rod slotted at the end to grip knob of button contact.
- c. Tweezer, gloves, etc.

2. MATERIAL : Glass cane as specified on assembly.

3. PROCEDURE

- a. Adjust flames to 4" length with 3/4" cone.
- b. Press button contact onto holder and heat former to incandescence in cross fires; heat glass rod and melt onto underside edge of rim by rotating against molten glass rod.
- c. Pull off excess glass with tweezer.
- d. Melt a thin layer of glass onto top of rim, again rotating button in cross fires against molten glass rod.

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