



APPLICATION OF IRIDESCENT COATING
 SUBJECT: Process Specification

This specification covers a process for applying transparent electrical conductive 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



IRIDESCENT COATING SOLUTION SAFETY PRECAUTIONS: See 33-2-11A

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 10cf/h through sprayer.
- d. Observe interference colors and shut off air when second yellow appears. The order 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—

DIMENSIONS IN

UNLESS OTHERWISE SHOWN.

DIMENSIONS SHOWN WITHOUT TOLERANCES ARE DESIGN CENTERS

** End of Schedule #1.

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* CHANGE
 ** ADDITION
 *** DELETION

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