



SETTLING P11 FLUORESCENT SCREENS
SUBJECT: Process Specifications

SUPERSEDES Jan. 8, 1954

1. EQUIPMENT As specified in 34-17-14. MAY 1955
2. MATERIALS
Z13 Zinc Sulfide Suspension at 10 mg/cc.
P69B 1-N Potassium Sulfate (1/2M)
P264B10% Potassium Silicate
W7K Distilled, W7J Distilled, or W60D Deionized Water
(at room temperature $\pm 2^{\circ}\text{C}$)
H7 Hydrofluoric Acid



HYDROFLUORIC ACID SAFETY PRECAUTIONS: See 33-2-7A.

3. PROCEDURE
- a. Rinse bulbs with distilled or deionized water.
b. Place bulbs on dispensing table on blocks or trays.
c. Apply screen material (See Part 4).
1. Add cushion layer, if any, to bulb through an open funnel with 325-mesh stainless steel strainer insert.
 2. Prepare settling suspension as given for specific bulb type.
 3. Add settling suspension to bulb through appropriate funnel fitted with 325-mesh strainer.
 4. Allow screen to settle specified time.
Caution - If settled for more than 3 hours an objectionable silicate ring will form on bulb wall.
 5. Pour off clear solution - pouring time 6-8 minutes.
 6. Wash neck with tap water.
 7. Air dry 3-4 minutes.
 8. Wash neck and face with 0.5-1.0% hydrofluoric acid, wipe with wet sponge.
 9. Alternate bulb cleaning process 34-17-4P.

* Data Rearranged (Cont'd on Page 2)

SCALE—

DIMENSIONS IN UNLESS OTHERWISE SHOWN. DIMENSIONS SHOWN WITHOUT TOLERANCES ARE DESIGN CENTERS

* CHANGE
** ADDITION
*** DELETION

2-542-2-60 1.33AS
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4. SCREEN APPLICATION SPECIFICATIONS

| Tube Type | Fluorescent Material mg. | Screen Weight mg./cm ² | Cushion Water cc. | Z13 at 10mg/cc. cc. | Silicate*16% cc. | Sulfate I-N cc. | Suspension Water cc. | Total Susp. Volume cc. | Suspension/Bulb cc. | Funnel Type | Settling Time hr. |
|---------------------------|-----------------------------|--------------------------------------|----------------------|------------------------|---------------------|--------------------|-------------------------|---------------------------|------------------------|-------------|----------------------|
| 2BP11 | 40 | 2 | 0 | 160 | *160 | 250 | *1430 | 2000 | 50 | Open | 2-3 |
| 5CP11A 5UP11 5ABP11 | 280 | 2 | 0 | 140 | *152 | 315 | *1893 | 2500 | 500 | Open | 2-3 |
| 3KP11 | 82 | 2 | 0 | 131 | *192 | 300 | *977 | 1600 | 100 | Open | 2-2.5 |
| 5WP11 | 190 | 3 | 0 | 228 | *192 | 335 | *1645 | 2400 | 400 | Open | 12-16 |
| C73550A | 1380 | 3 | 1100 | 69§ | *160 | 250 | *490 | 2010 | 2010 | Open | 4 |

§ Z13 Zinc Sulfide Suspension is at 20 mg/cc for the C73550A.

ENGINEERING SECTION
STANDARDIZING

SCALE—

DIMENSIONS IN

UNLESS OTHERWISE SHOWN.

DIMENSIONS SHOWN WITHOUT TOLERANCES ARE DESIGN CENTERS

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** ADDITION
*** DELETION

22-552-2-64 PCL26696-126JD

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