

SUBJECT PRESSURE TESTING OF 12DP7  
CLEAR GLASS BULBS

SUPERSEDED DATE

Test to be made after bead inserted and neck spliced, but before washing and screening

1. EQUIPMENT:

- a. Compression tank
- b. Rolling shielded carriage sections
- c. Rubber Expansion stoppers

<u>Approx Bulb Neck Size</u>	<u>Tapered Stopper Diam.</u>	
	<u>Small End</u>	<u>Large End</u>
1.25	1.175	1.75
1.5	1.4	2.5
2.0	1.9	2.75
2.5	2.4	3.5
3.0	2.8	4.0

2. PROCEDURE:

1. Insert No. 8 stopper securely in necks of clear glass bulbs. Place bulbs in racks of pressure tank car, record number and cover each bulb with protective cap. (Cap made up of one PT98A & one PL98)
2. Unlock & close shut off valve of 30 lb. safety valve.
3. Run car in tank, close door securely, close salenoice blow off valve and run pressure up to 60 lbs. If any bulbs break before 60 lb pressure attained-record pressure.
4. Hold 60 lbs for 1 minute. Record breakage and time elapse.
5. After one minute open outlet & salenoice, allow air to escape. Allow pressure to equalize before opening door, & removing car.
6. Remove stoppers from bulbs noting outrush of air in which case test is invalid. Hold for leakage inspection if a surge of air is felt. Record failures.
7. Open shut-off on 30 # safety valve, lock open.

*Cancel*

STANDARDIZING SECTION  
ENGINEERING DEPT.