



RADIO CORPORATION OF AMERICA

RCA VICTOR DIVISION
TUBE DEPT. STANDARDIZING

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SUBJECT WIRE-BRUSHING ANODE CONTACT AREA
Process Specification

DATE Aug. 4, 1949 PAGE 1

STANDARDIZING
NOTICE 34-17-72

SUPERSEDED DATE 6/3/49

This specification covers the process for wire-brushing the sealing rim of metal kinescopes to remove oxides in order to insure a good electrical connection for the anode high voltage. A corrosion resistant finish is uncovered which does not require an application of conductive coating.

1. EQUIPMENT

- a. Brushing Unit Turntable equipped with timer, turntable motor, brushing motor and exhaust-filter unit for debris and exhaust pump.
- b. 8" Stainless Steel wire brushes, approximately 0.015" wire.

*NOTE: Before brushes are installed on unit, a wire should be clipped from each brush and dipped in a dilute acid solution of copper sulfate. No reaction indicates stainless steel. Copper will plate out of solution on iron or carbon steel wire. Solution used: 3% by volume concentrated hydrochloric acid, 10% by volume saturated water solution of copper sulfate, and 87% by volume additional water.

2. PROCEDURE

- a. Place bulb on turntable.
- b. Center the bulb by raising the centering jig and moving rim of bulb against jig.
- c. Open vacuum clamp, close air clamp.
- d. Set timer to 1/2 minute.
- e. Press switch to start brushing unit.
- f. When machine stops, examine rim. If not clean, recycle.

Brushes can be used until about 1 inch of the 2 inches of bristle length has been worn off.

Caution: Do not use carbon steel brushes for this operation.
Brass may be used in emergency only.

ENGINEERING SECTION
STANDARDIZING

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