



SUBJECT:

APPLICATION OF EXTERNAL COATING
Process Specification

SUPERSEDED DATE Aug. 4, 1953

This specification applies to the method of application of Decorative Coating L608 and Conductive Coating *C276B initially to the cold rolled steel shell.

SCHEDULE NO. 1

MAY 1955

1. EQUIPMENT

- a. Spray booth connected to blower or suction system having sufficient capacity to immediately remove any odor, vapor, or dust originating from spraying operations.
- b. DeVilbiss spray gun.
- c. 5 gal. capacity pressure spray tanks with built in air-driven agitator.

2. MATERIAL

- L608 External Decorative Coating
- *C276B External Conductive Coating

3. PROCEDURE

a. Preparation of metal cone

- 1. Wire brush sand-blasted area to remove loose scale where necessary.

b. Apply decorative coating (L608).

- 1. Spray tank (if used) for insulating paint to be thoroughly cleaned with clean acetone and clean rags before adding insulating paint.
- 2. Hose of spray gun (when using tank) to be thoroughly cleaned.
- 3. DeVilbiss CV type to be taken apart and fluid needle (No. G), fluid tip (No. G) and air cap (No. 904) to be thoroughly cleaned with acetone and a clean rag each day before spraying.
- 4. Adjust air pressure at gun to 25 lbs.
- 5. Adjust gun to give oval pattern with the major axis vertical, i.e. setting-18.
- 6. Open gun to give slightly wet spray when holding gun 4-1/2" from tube.
- 7. Mask glass neck and funnel of tube. (This area has already been coated with silicone).
- 8. While bulb is rotating, spray metal cone with decorative coating (L608).

c. Apply conductive coating *(C276B)

- 1. Thoroughly clean shadow mask before starting days production and at start of each shift.
- 2. Apply mask, masking so that rim is sprayed as per diagram I.
- 3. Regulate the pressure on the air gun to 20-25 lbs./sq. in. and adjust fluid needle to give perceptibly wet spray when holding the gun at the required distance from the work.
- 4. For coating, a DeVilbiss size No. G fluid tip needle and air cap may be used and the spray gun held approximately 4" from the item being sprayed.
- 5. Do not spray lacquer so thick that it runs. Inspect coating for scratches & damage. Reclean and recoat any that are rejected.
- 6. Place tubes on rack face down.
- 7. Tubes should dry tack free in 4 minutes.

d. Apply decorative coating to rim

- 1. Place tube in holder face up.
- 2. Apply decorative coating (L608) to rim using roller.

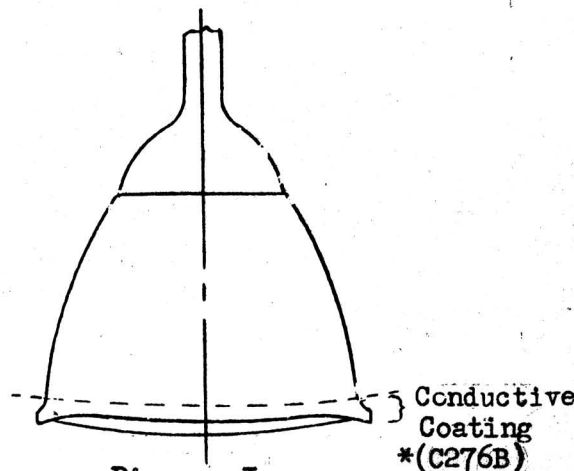


Diagram I

SCALE—

DIMENSIONS IN

** End of Schedule No. 1

UNLESS OTHERWISE SHOWN.

DIMENSIONS SHOWN WITHOUT TOLERANCES ARE DESIGN CENTERS

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* CHANGE
** ADDITION
*** DELETION

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