



This specification applies to the process of applying an antiglare coating to the face plate of cathode ray tubes.

SCHEDULE NO. 1

MAY 1955

(Initially for metal kinescopes)

1. EQUIPMENT:
  - a. Spray booth having a blower with sufficient suction to remove all dust, fumes, and vapors from the hood; equipped with a water curtain in the back of the hood.
  - b. DeVilbiss spray gun with F fluid tip.
  - c. A source of high pressure air and all necessary connections, agitators, etc. circulating hot air oven or other means of heating the faceplate to 120°C.
  
2. MATERIAL:
  - L255 - Anti-Glare Coating
  - A55 - Acetone
  
3. PROCEDURE:
  - a. The tube face is to be cleaned well with acetone and must be free of all grease, dirt, dust, etc. that might cause specks or a poor coating.
  - b. When the tube is cleaned place it in the spray booth face out, resting on the long side of the lip for a rectangular tube.
  - c. Make sure spray gun is absolutely clean before using. Use 20 lbs. air pressure and set the gun up for a medium wet spray.
  - d. Coat the face of the tube with antiglare coating (L255). Spray one pass only over the entire face. This coat must be the thinnest possible and still be continuous.
  - e. Examine the coating for defects. Numerous specks of dirt, dry areas, or sag marks are cause for rejection and the face should be cleaned and recoated.
  - f. The coating must now be baked to cure it for 20 minutes at 120°C (250°F approx.) Care must be taken that no dust or dirt falls into the coating while baking.
  - g. After baking the coating should again be checked for discontinuity and dirt and rejected if any is present.
  - h. Once the coating has been cured it is very abrasion resistant and scratch resistant and the tube may be handled and packed in normal procedure.

ENGINEERING SECTION  
 STANDARDIZING

SCALE—

DIMENSIONS IN UNLESS OTHERWISE SHOWN. DIMENSIONS SHOWN WITHOUT TOLERANCES ARE DESIGN CENTERS  
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\* CHANGE  
 \*\* ADDITION  
 \*\*\* DELETION

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