MAY 1955

SCHEDULE NO. 2
(Initially for C73685 Series.)

1. EQUIPMENT
   a. Silicate spraying booth equipped with three-position rack for caps.
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   c. DeVilbiss spray gun, Model CV.
   d. Drying turntable equipped with 6 - 250 watt infra-red lamps.

2. MATERIALS
   P264B Potassium silicate
   - - - High pressure air
   W60D Demineralized water

3. PROCEDURE

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   b. Mixing silicate spray solution.
      1. Prepare a 2% solution of potassium silicate for screen spraying as follows:
         P264B Potassium silicate - 1 part by volume
         W60D Demineralized water - 4 parts by volume
      2. The spray solution should be prepared fresh at least once per shift.
   c. Spray booth set-up
      1. Turn "exhaust" lever to the "on" position.
      2. Turn on the high pressure air valve.
      3. Adjust the air pressures as follows:
         a. Spray gun - 15 to 20 psi gauge.
         b. Left drying line - 5 to 8 psi gauge
         c. Right drying line - 7 to 10 psi gauge
      4. Fill spray gun solution container with 2% potassium silicate.
      5. Adjust the spray gun discharge by closing the spray adjustment knob and then opening one full turn.
   d. Spraying silicate solution.
      1. Position the faceplates in the rack with the top of the cap in the "up" position.
      2. Test the spray from the gun for a misty uniform spray.
      3. Rotate the rack so that the faceplate to be sprayed is positioned directly in front of the booth.
      4. Holding the spray gun 15 to 18 inches from the screen, spray the faceplate using a spiral motion, commencing with the periphery and ending at the center. Sufficient silicate should be sprayed to wet the screen thoroughly being careful to prevent an excess which will drip or run on the screen.

3. PROCEDURE (Cont'd)

d. Spraying silicate solution. (Cont'd)
   5. Rotate the rack in a clockwise direction thus positioning the sprayed faceplate in front of the left drying position and the next faceplate in the spraying position. Repeat step 4.
   6. Repeat the spraying and drying operations until each faceplate has been sprayed with three layers of silicate. Faceplates should be dry prior to spraying with the next coat of silicate.
   7. Remove the faceplates when dry and replace with the next faceplate to be sprayed. Repeat the spraying and drying operations on all faceplates.

e. Infra-red screen drying.
   1. Position the faceplate on the turntable with the screened surface facing the infra-red source.
   2. Adjust the timer for 5 minutes and depress the "start" switch.
   3. After the drying cycle has been completed, remove the faceplate and place in the "ready to be filmed" rack.
   4. Repeat the infra-red drying on all faceplates.

f. Spray booth shutdown.
   1. Discard silicate spray solution remaining in the spray gun container.
   2. Thoroughly wash the container with water, flush the spray gun with water, and permit the spray gun to stand with water in the solution container.
   3. Turn off the high pressure air line.
   4. Turn "exhaust" lever to the "off" position.

End of Schedule No. 2