

Contents

I.	History of Glass	.1
	The Beginning of Glass Manufacture5
	Glass Manufacture in Modern Periods5
	Glassmaking in America6
	The Glass Age7
II.	Glass and its Working Characteristics	.10
	Definition of Glass10
	Composition of Glass10
	Fused Quartz10
	Commercial Glasses11
	Colored Glasses13
	Soft Glass13
	Pyrex Brand Glass14
	Lead Glass14
	Nonex No. 772015
	Vycor Brand Glass No. 790015
	Vycor Brand Glass No. 791015
	Other Vycor Brand Glasses15
	Lamp Working Properties of Vycor16
	Corning No. 728017
	Uranium Glass No. 332117
	Pyrex Glass, Corning No. 799117
	Pyrex Brand Ignition Tubing Glass No. 17217
	Physical Properties of Glass18
	Working Point18
	Annealing Point18
	Flame Annealing Point19
	Strain Point20
	Bloom in Soft Glass20
	Devitrification in Old Glass20
	Devitrification from Overheating21
	Coefficient of Expansion21
	Collapsing Temperature of Glass21
	Strength of Glass22
	Bursting Pressure of Pyrex23

III. Glassblowing Equipment	.24
Introduction	.24
Permanent Equipment	.26
Glassblowing Bench	.26
Pressure Regulator	.26
Glass Storage Bins	.27
Glassblowers Goggles	.27
Goggles for Blowing Quartz	.28
Glass-Marking Pencil	.28
Diamond Pencil	.28
Polariscope	.28
Bench-Type Glassworking Rollers	.30
Transite Stand Support	.31
Miscellaneous Equipment	.31
Support for Hot Glass	.31
File	.32
Glass-Cutting Knives	.32
Asbestos Tape	.32
Asbestos Cloth Tape	.33
Flask Holders	.33
Calipers	.33
Glass Tubing Tapered Gage	.33
Calipers not Calibrated	.33
Reaming Tools	.34
Carbon Reaming Tools	.34
Carbon Paddles	.34
Carbon Rods	.35
Pencil Sharpener	.35
Forceps	.35
Tungsten Needle	.35
Rubber Policemen	.36
Asbestos Mittens or Gloves	.36
Blow Tube	.36
Swivel	.36
Water Pot	.37
Corks	.37
Rubber Stoppers	.37
Motorized Rollers	.37
Cutting Jig	.37
Glass Handles S/T	.37
Box for Storing Short Lengths of Tubing	.38
Electrically Heated Hot Wire	.38
Copper Screen Supports	.38
Glassblowing Burners and Flames	.39

Bunsen Burner39
National Hand Torch39
Buffalo Blowpipe40
Victor Welding Torch.41
Litton Annealing Burner41
Single-Tip Crossfires41
Premixer for Gas-Oxygen Burner42
Multiple-Tip Crossfires43
Ribbon Burner.44
Power Tools45
Glass-Grinding Wheels45
Spot Welder45
Annealing Oven45
Glassblowing Lathe46
High-Frequency Induction Heating Unit47
Drill Press48
Bench Grinder48
IV. Basic Operations52
Identification of Different Glasses52
Soft Glass52
Pyrex Glass52
Drawing of Two Rods.53
Immersion in Liquid53
Cleaning of Glass Tubing54
Cleaning Apparatus to be Repaired54
Cutting Glass Tubing54
Cutting Glass Tubing with a File54
Cutting Small Tubing with a File56
Cutting Short Pieces with a File57
Cutting Glass with a Hot Rod58
Hot Wire Cutting of Pyrex58
Hot Wire Cutting of Soft Glass60
Cutting Bottles with a Flame60
Glass-Cutting Saw62
Fire Cutoff62
Cutting Glass with Scissors63
Rotation of Glass Tubing64
Points to Remember in Rotating65
Practice Pieces for Rotating65
Diameter and Wall Thickness Guide65
Choice of Glass for Practicing66
Preliminary Glassblowing Operations66
Fire-Polishing and Flared Ends66
Flares by Spinning66
Flaring Short Pieces of Tubing67

	Flares in Stationary Glass Tubing68
	Points68
	Handles from Glass Tubing68
	Round-Bottom Tubes70
	Flat-Bottom Tubes70
	Making Constrictions72
	Healing Cracks in Glass73
	Peeling or Wiping74
	Use of Glass Cane or Patch Rod75
V.	Fundamental Glassblowing Seals76
	Introduction76
	Basic Operations76
	Straight Seals76
	Points to Remember in Making Glass Seals77
	Seals between Tubing of Different Diameters77
	T-Seals with Small Tubing78
	T-Seals by Rotation79
	T-Seals with Large Tubing80
	Suck Seal81
	Ring Seals82
	Insertion Seals83
	Dewar Seals84
	Bulbs at the End of Glass Tubing Tubing87
	Bulbs in the Center of a Section of Tubing88
	Sealing Capillary Tubing to Standard-Wall Tubing90
	Capillary T or Side Seals91
	Sealing Two Pieces of Capillary Tubing92
	Bends92
	Coils Tubing93
	Side Ring Seals97
	Closed Circuits of Tubing98
	Braided Glass Coils99
	Hand Torch Seals100
	Repair to Vacuum Systems101
	Sealing Glass Rods Together102
VI.	Practice Pieces to Make103
	Planning the Work103
	Working Instructions103
	Cold Trap103
	Cold Trap with S/T Joints104
	Standard Condenser105
	Bulb Condenser106
	Coil Condensers107

Kjeldahl Traps108
Gas Flowmeter110
Thermometer Wells in Boiling Flasks111
Manometers111
Liquid Air Traps112
Double Condenser115
Spherical Condensers117
Inverted Ring Seals119
Glass Turbines120
Glass Expansion Bellows122
Distillation Receivers127
Addition Funnels130
Vacuum Jacketed Transfer Tubes130
Notes on Glassblowing Lathe Operations132
Cells with Optically Clear End Windows135
Electronic Welding of Glass138
VII. Grinding Glass140
The Manufacture of Glass-Ground Joints in America140
Specifications for Interchangeable S/T Glass-Ground Joints141
Use of S/T Glass-Ground Joints in Modern Research141
Grinding Tools Made from a Joint143
Sets of Metal Grinding Tools144
Selection of Abrasives for Grinding146
Grinding Equipment146
Grinding Procedure147
Testing Reground Surfaces for Leakage147
Spherical Ball and Socket Joints147
Glass Check Valves148
Glass Ball Check Valves150
Glass Ball Check Valves on Stems150
Regrinding Stopcocks152
Drilling Small Holes in Glass154
Grinding Holes in Glass154
Grinding Small Holes in Glass154
Grinding Large Holes in Glass155
VIII. Glass to Metal Seals157
Procedure for Sealing Glass to Metal158
Tungsten to Pyrex No. 7740158
Tungsten to Pyrex No. 7720 (Nonex)161
Tungsten to Pyrex No. 7991162
Tungsten to Pyrex No. 3321162
Copper to Glass Seals162
Platinum to Soft Glass Seals168

	Platinum to Pyrex Seals169
	Kovar to Glass Seals170
	Nickel-Iron to Glass Joints175
	Dummet to Glass Seals176
	Chrome-Iron to Glass176
	Platinized Glass to Metal Joints177
	Copper to Glass by Electroplating178
	Metal to Silica Seals178
	Invar to Quartz179
	Molybdenum Foil to Quartz179
	Wrung Joints180
	Ceramic to Metal181
	Hard Solder to Ceramic Joints181
IX.	Graded Seals183
	Pyrex to Soft Glass183
	Pyrex to Nonex185
	Pyrex to Corning No. 705AJ (Kovar)185
	Pyrex to Silica185
	Miscellaneous Seals187
	Quartz Windows to Pyrex Tubes187
	Mica to Glass188
	Ceramic to Glass189
X.	The Coating of Glass and Metal Surfaces	
	With a thin film of Metal191
	The Chemical Silvering of Glass191
	Choosing Glass to be Silvered191
	Checking Glass for Open Striations191
	Cleaning Glass to be Silvered1192
	Silvering Solution for the Brashear Process194
	Silvering Procedure196
	Partial Removal of Silver197
	Strip Silvering197
	Cleaning Glass Preparatory to Working199
	Cleaning Glass for Mirrors199
	Silvering Small Mirrors by the Brashear Process199
	Silvering Large Mirrors200
	Rochelle Salt Process200
	Lacquering Silver Surfaces201
	Painting Glass Mirrors201
	Platinizing Glass202
	Platinizing Solutions202
	Chemical Plating of Gold203
	Gold Plating Solutions and Procedures203
	Cleaning the Glass Surface to be Copper-Plated204

Chemical Plating of Copper205
Copper Plating Solutions and Procedures205
Thickening Copper Film by Electroplating207
Cleaning the Glass Surface to be Copper-Plated207
Plating by Evaporation208
Evaporation Chamber and Base Plate209
Evaporation Source209
Evaporation Procedure211
Cleaning Surface to be Plated213
Plating by Sputtering214
Sputtering Procedure214
Notes on Cathode215
Cleaning Glass Surfaces for Sputtering216
Electroplating216
Preparation of Metal Surfaces for Electroplating217
Plating Solutions220
XI. Purification of Mercury228
Filtration228
Chemical Cleaning228
Oxidation with Air230
Distillation231
Single Distillation231
Triple Distillation232
XII. Fractional Distillation235
Terminology235
Methods of Distillation237
Continuous Distillations237
Batch Distillations237
Factors to be considered in Designing Distillation Equipment238
Efficiency of Separation Desired238
Rate of Distillation238
Temperature Range to be Covered239
Material to be Fractionated239
Constructional Features239
Still Pot239
Column239
Packing240
Still Head240
Thermometer241
Lagging or Insulation241
Column Packing245
Glass Cylinders246
Raschig Rings246
Solid Packing246

Spiral Packing246
Ground Glass Fused to the Inner Wall of the Rectifying Tube248
Metal Helices249
Glass Helices250
Packing Supports250
Packing Glass Helices.252
Stedman Packing253
Chain Packing253
Widmer Column253
Vigreux Column254
Concentric-Tube Column255
Empty Tube Columns258
Oldershaw Perforated Plate Columns259
Variables Effecting Operating Characteristics261
Diameter261
Column Height262
Holdup262
Pressure Drop262
Vapor Velocity263
Distillation Rate263
Water in Material to be Distilled263
Preflooding the Column at the Start264
Evaluation of Fractionating Columns265
Choice of a Binary Test Mixture266
Carbon Tetrachloride and Benzene266
n-Heptane-methylcyclohexane269
Methods for Determining Theoretical Plates269
Graphic Method269
Tabular Method271
Algebraic Method271
Distillation under Reduced Pressure275
Disadvantages275
Choice of Columns276
Auxiliary Equipment279
Preliminary Operational Procedure282
Degassing the Sample282
Adjusting Boil-up Rate283
Elimination of Bumping283
Molecular Distillation.284
Azeotropic Distillation284
Use of a Chaser286
Low-Temperature Distillations287
General Descriptions of Fractionating Equipment289
Fractionating Column289
Still Heads295

Boiling Kettles302
Fraction Cutters307
Care and Use of a Refractometer309
Description310
Care of the Instrument314
Method of Reading315
Work Involving Transparent and Viscous Liquids315
Temperature Control316
XIII. High Vacuum.318
History318
High Vacuum Systems319
Kinetic Vacuum Systems319
Static Vacuum System319
A Simple Static System320
Vacuum Equipment321
Backing Pumps321
Mercury Diffusion Pumps321
Heaters332
Lagging333
Oil Diffusion Pumps333
Vapor Traps341
Measurement of Pressure347
Discharge Tube347
McLeod Gage349
Bourdon Gages358
Pirani Gages362
Ionization Gages363
Knudsen Gage363
Evacuation of Glass Vessels363
Evacuation of Unsilvered Vessels364
Glass Baking during Evacuation365
Sealing of Evacuated Vessels366
Effect of High Temperature on Silvered Surfaces366
Notes on Evacuation Practices367
Detection of Leaks367
Tesla Coil368
Discharge Tube368
Leak Detector369
Testing Tungsten-Glass Seals369
Cutoffs371
Toepler Pumps371
Pump Operation373
Filing Manometers375
Concentric-Tube Manometers375
Standard U-Type Manometers377

XIV. Metal Working	.378
Setting Up a Machine Lathe	.378
Setting Up a Bench Lathe	.378
Readjusting Shims	.379
Testing the Leveling of the Lathe	.379
Belts for the Lathe Drive	.380
Oiling the Lathe	.382
Spindle Speeds	.382
Principal Operating Parts of the Lathe Carriage and Apron	.382
Micrometer Collars	.384
Fundamental Lathe Operations	.384
Drilling Center Holes between Centers	.384
Testing and Drawing Center Points	.385
Drilling Operations	.386
Removing a Broken Center Drill	.387
Lathe Work Mounted between Centers	.387
Procedure for Mounting Work between Center	.390
Lathe Work Mounted in Chunks	.390
Boring	.397
Tapping on a Lathe	.399
Cutting off Stock on a Lathe	.400
Lathe Tool Bits	.405
Grinding Lathe Tools	.408
General Notes on Lathe Turning	.409
Filing and Polishing	.410
Hardening and Tempering Lathe Tools	.410
Casehardening.	.411
Annealing Tool Steel	.411
Annealing Brass	.412
Spot Welding of Metals	.412
Technique	.413
Soldering	.416
Soft Solders	.416
Hard Soldering	.417
Aluminum Solder	.418
Glass Solders	.419
Tinning Glass and Ceramics Preparatory to Soldering	.419
XV. Electrical Heaters	.422
Designing Coil Units	.422
Ohm's Law	.422
Cold and Hot Resistance	.423
Heating Element Design	.423
Winding Coils.	.434
Useful Life Expectancy of Chromel A	.437

XVI. Miscellaneous Equipment and Procedure439
Chromatography439
Partition Chromatography439
Adsorption Chromatography440
Ion-Exchange or Displacement Chromatography440
Chromatographic Equipment441
Crystallization.446
Extraction with Solvents447
Discontinuous Extraction448
Multiple Extraction448
Continuous Extraction448
Liquid-Liquid Extractions449
Filtration451
Freezing and Melting Point Temperatures452
Lyophilization455
Mixing.457
Sublimation459
Viscometry461
Density463
Removal of Frozen Stopcocks.464
Rust Preventive465
Preparation of Ground Glass465
Etching Glass465
Miscellaneous Tables467
Index471