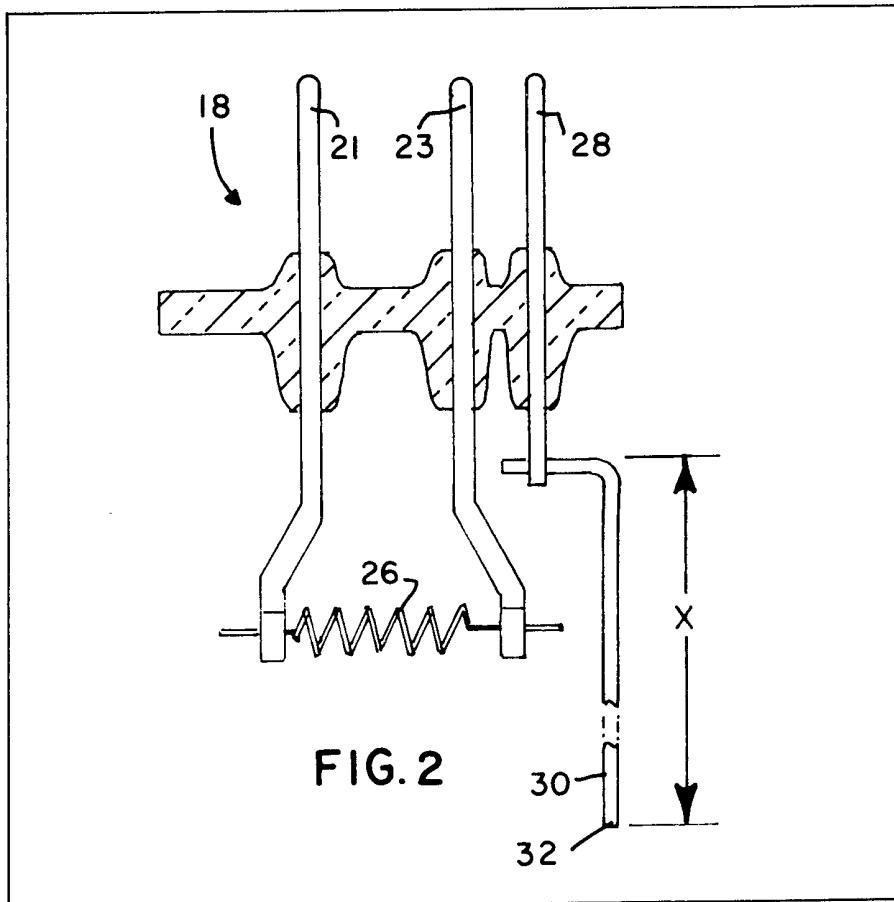


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(54) Lead-in mount for discharge lamps

(57) A sealing closure means or mount 18 for discharge lamps includes three lead-in wires 21, 23, 28 wherein two of the lead-in wires 21, 23 support an electron emissive electrode 26 therebetween and the third 28 supports a wire starting aid 30 having a length  $x$  substantially equal to the arc length of the lamps. The starting aid is internal of the lamp, and the closure mount 18 may seal an end of a straight or a circular fluorescent lamp. Instead of having a circular, disc-like shape as shown, the mount 18 may be of conventional flare and press configuration.



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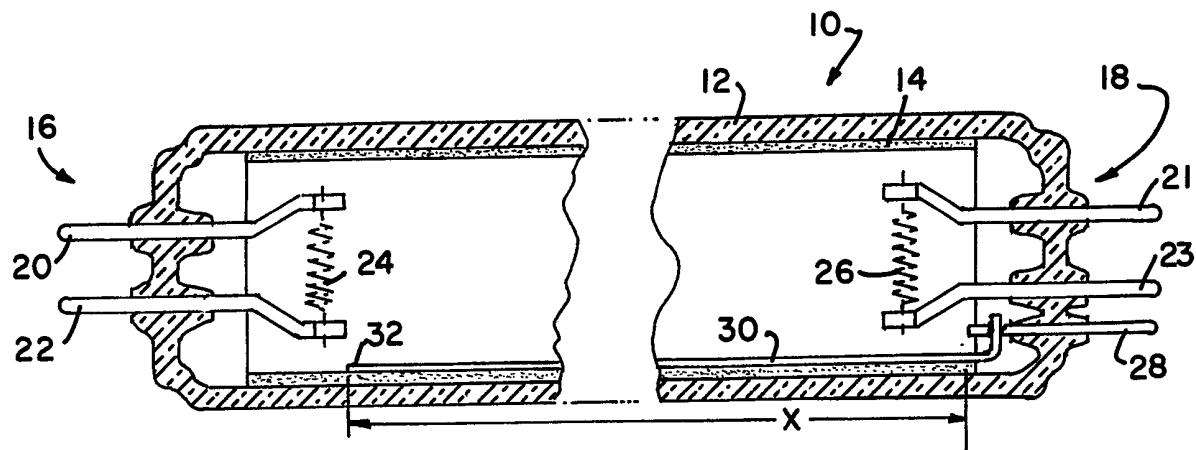


FIG.1

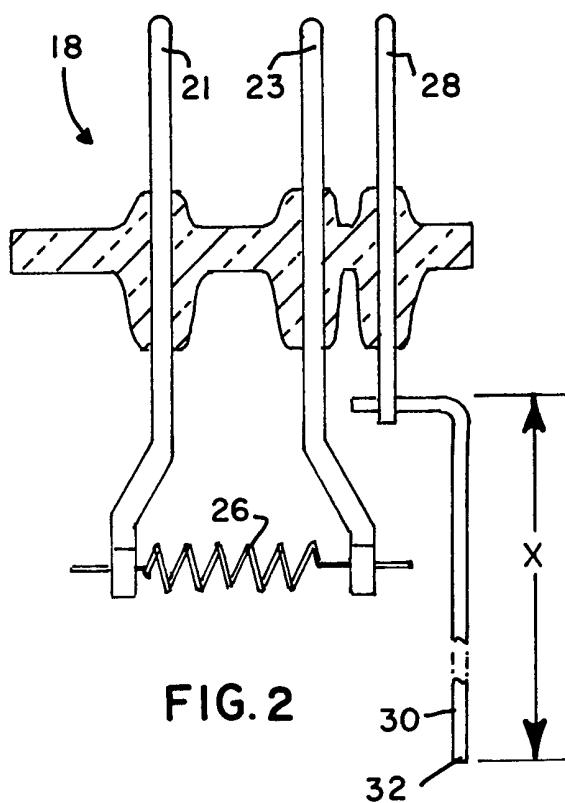


FIG.2

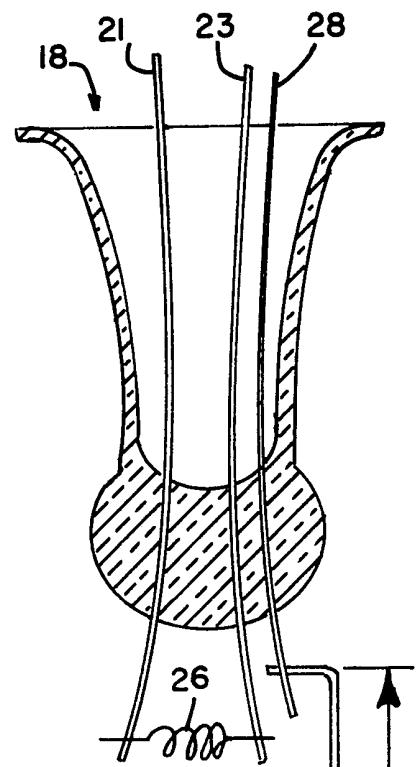


FIG.3

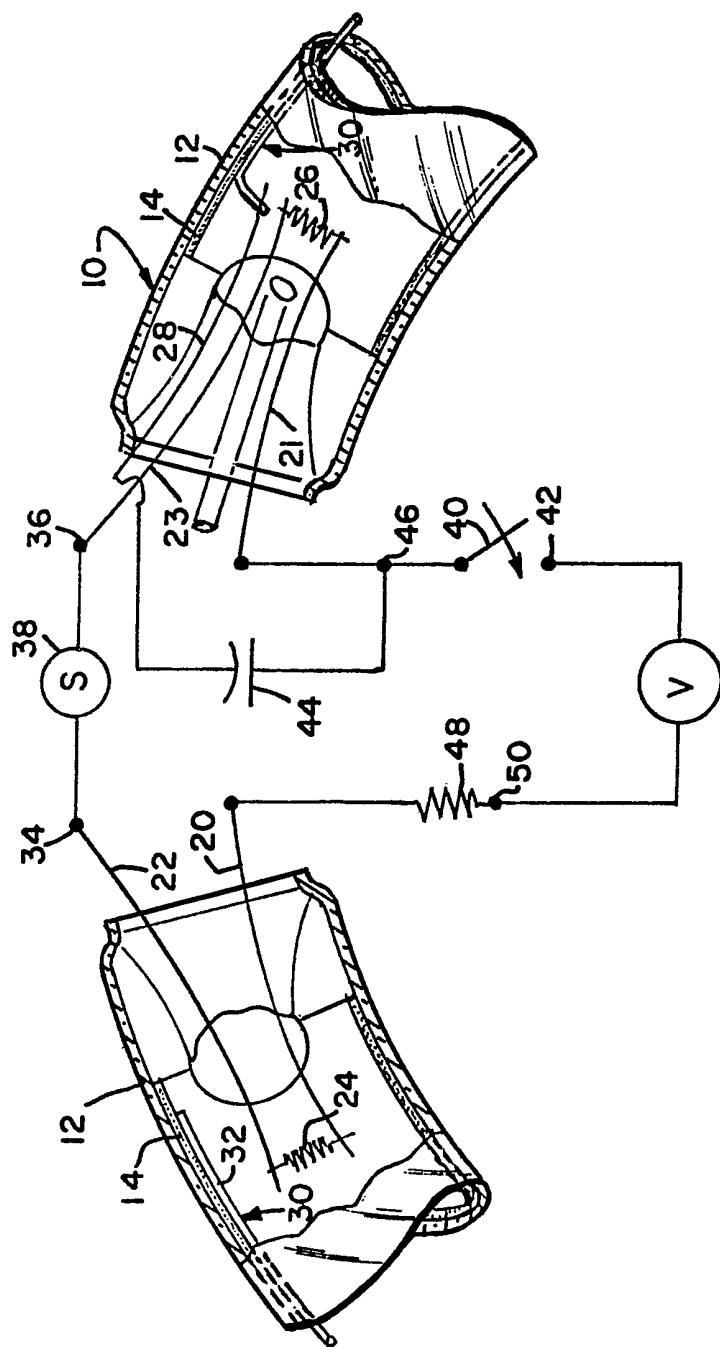


FIG. 4

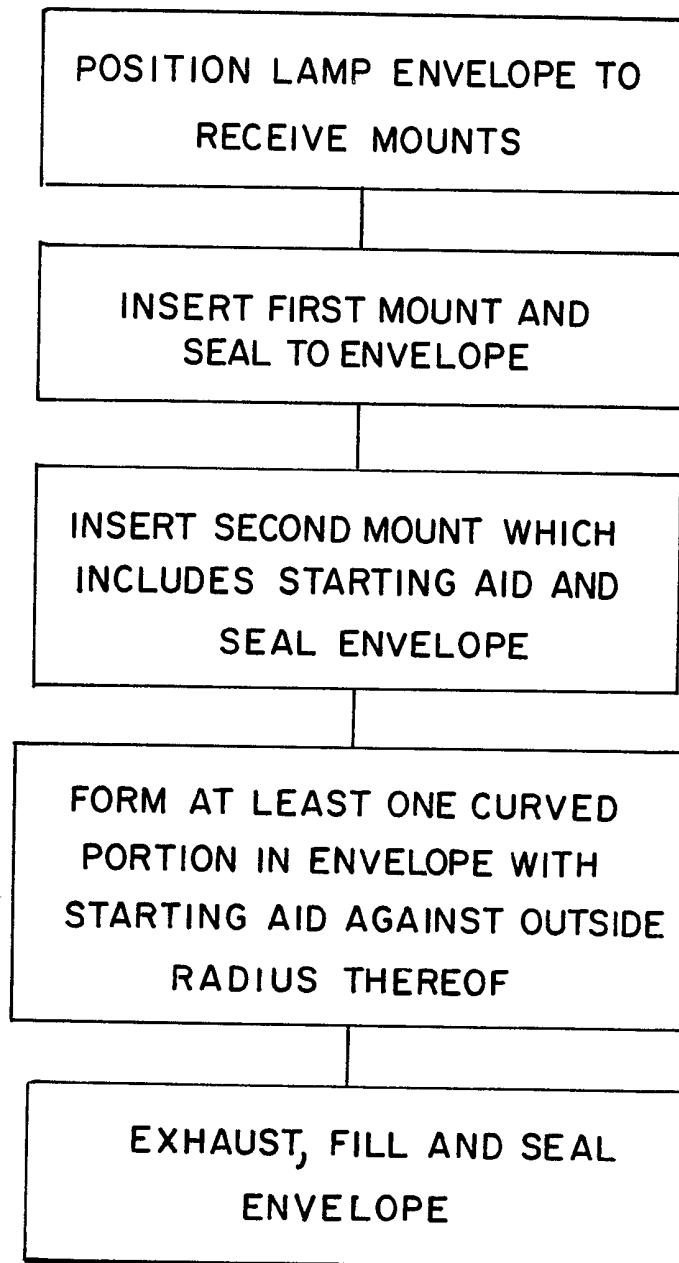


FIG.5

## SPECIFICATION

**Three lead-in mount for discharge lamps including a starting aid**

5 This Application discloses, but does not claim, inventions which are claimed in Application numbers 8136828, 8136829 and 8136830 filed concurrently herewith and assigned to the assignee of this

10 Application. This invention relates to discharge lamps and more particularly to a sealing closure means or mount therefor.

Starting aids for discharge lamps can be characterized by two generic classes, viz. active devices such as pulse generators of one form or another; and passive techniques such as ground planes or probes.

15 Active devices have the disadvantage of being costly; further, they contribute to the size and weight of the ballast package. The active devices also tend to be complex with this complexity adding a negating factor since the reliability is adversely affected.

20 Passive starting aids also can be broken down into two distinct classes. First, there is the external type which comprises ground planes adjacent to or in contact with the exterior bulb wall. Examples of this type of starting aid include external conductive bulb wall coatings or stripes and grounded fixtures. The second class of passive starting aids includes internal conductive stripes or coatings and starting probes.

25 The relative merits of a particular type of passive starting aid depends on the lamp type and the intended market application. For example, the standard F40WT12 lamp relies generally on a grounded fixture to provide the necessary starting function.

30 Energy saving, krypton-filled, F34WT12 lamps rely on an internal conductive film applied between the glass and the phosphor. External stripes and coatings have found favour in Europe.

35 However, while the use of starting aids have been recognized as a desirable feature, it has not been heretofore possible to provide lamps with an effective and economical internal starting aid.

40 Accordingly, it is an object of the invention to obviate at least some of the disadvantages of the prior art.

45 It is another object of the invention to provide a simple and economical starting aid.

50 The present invention provides a sealing closure for a discharge lamp, said lamp having a given arc length, said closure comprising: a glass base having an internal surface and an external surface relative to said lamp; first and second lead-in wires sealed in said base and extending on both sides thereof; an electron emitting electrode electrically connected between said first and second lead-in wires adjacent said internal surface; a third lead-in wire sealed in said base and extending on both sides thereof; and a

55 wire starting aid electrically connected to said third lead-in wire adjacent said internal surface, said starting aid having a length substantially equal to said given arc length.

60 The invention is illustrated by way of example in the accompanying drawings, in which;

65 *Figure 1* is sectional view of a lamp employing an internal wire starting aid;

70 *Figures 2 and 3* are sectional views of alternate mount structures;

75 *Figure 4* is a diagrammatic view of a non-linear lamp employing the invention together with the circuitry therefor; and

80 *Figure 5* is a flow diagram of a method of making a lamp.

85 For a better understanding of the present invention, together with other and further objects, advantages and capabilities thereof, reference is made to the following disclosure and appended Claims taken in conjunction with the above-described drawings.

90 Referring now to the drawings with greater particularity, there is shown in *Figure 1* a discharge lamp 10 comprising a tubular glass envelope 12 having a layer of phosphor 14 on the interior surface thereof. Sealing closure means 16 and 18 close the ends of the envelope 12. An arc generating and sustaining medium which includes mercury fills the sealed envelope 12 which can have been evacuated and filled by any known technique.

95 The sealing closure means 16 and 18 have lead-in wires 20 and 22 and 21 and 23, respectively, sealed therein and have electrodes 24 and 26 electrically connected thereto and supported thereby. Conventionally, one or both of the sealing closure means is provided with an exhaust tubulation which is not shown in the instant drawings.

100 One of the sealing closure means, e.g., 18, has a third lead-in wire 28 sealed therein and extending internally and externally of envelope 12. A wire starting aid 30 is electrically connected to the internal end of lead-in 28 and has the major portion of its length contiguous with the phosphor coating 14. Starting aid 30 has a length "x" which is substantially equal to the arc length of lamp 10. Preferably, the aid 30 has its free end 32 terminate adjacent the opposite electrode, in this case, electrode 24. The starting aid 30 is constructed from a material which is substantially inert with respect to the mercury environment of the lamp, such as, e.g., nickel or nickel-plated steel.

105 110 The sealing closure means 16 and 18, which preferably are identical except for the third lead-in wire 28, can be of any desired form. In *Figure 2* is illustrated a sealing closure means 18 having a circular, disc-like format while *Figure 3* illustrates a conventional flare and press configuration. In either case, the means 18 contain the lead-in wires 21 and 23 which support the electrode 26 and the lead-in wire 28 which connects and supports the wire starting aid 30.

115 120 The wire starting aid 30 has additional advantages when employed in non-linear lamps such as the circular configuration shown partially in *Figure 4*. Herein, the lamp 10 is formed so that the wire starting aid 30 lies along the outside diameter of the envelope 12 when it is held in place by the tension imparted thereto by the rolling process.

125 Lamps 10 are constructed by positioning envelope 12, having phosphor coating 14 on the interior surface thereof, in a manner to receive the sealing closure means or mounts. If the overall length of

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lamp 10 is small; i.e., 12 inches or less, the envelope 12 may be positioned horizontally; however, the preferred orientation is vertical, particularly for larger sizes.

5 With the envelope 12 vertically arrayed, mount 16 is inserted into the lower end of the envelope and sealed therein. Mount 18, having the long, wire starting aid attached thereto, is then inserted into the upper end of envelope 12 and sealed thereto. If the 10 final lamp is to remain a linear type, final processing such as exhausting and filling can now be consummated. If the lamp is to be a non-linear type, e.g., circular, the curved portions are formed by conventional techniques; however, the lamp orientation 15 through the forming process must insure that the wire starting aid 30 lies against the outside radius. After forming, the non-linear lamp is exhausted and filled by conventional techniques.

For operation, this lamp is particularly suited to 20 applications where no starting aid is provided by the ballast, such as the resistive ballast shown in Figure 4. Herein, a supply voltage  $V$ , which is preferably 120 V A.C., 60Hz, is applied to the terminals 34 and 36 of starter 38, which is a conventional glo-starter operating 25 in conventional fashion, when switch 40 is closed. When the starter 38 is conducting, the lamp electrodes 24 and 26 will reach thermionic emission temperature and a substantial space charge will surround them. When the starter 38 opens the 30 preheat circuit and when the instantaneous polarity of the supply voltage is positive at node 42, capacitor 44 will charge positive at node 46. The charging path comprises the wire starting aid 30, the ballast resistor 48, and the supply voltage  $V$ . Starting aid 30 35 is coupled to the electrode 24 by the electron space charge developed during the preheat phase. The voltage developed across capacitor 44 will depend upon the value of the capacitor, the space charge at electrode 24, and the proximity of electrode 24 to the 40 starting aid wire 30. When the supply voltage  $V$  reverses polarity on the next half cycle such that the supply voltage is positive at node 50 and before the starter 38 recloses, the voltage of capacitor 44 will add to the supply voltage in a voltage multiplier 45 manner. This combined voltage will appear across the gap separating electrode 24 and the wire starting aid 30. The polarity of this voltage is such that the electrode 24 will be positive with respect to the starting aid 30. Without the added voltage of capacitor 44, the voltage available is not sufficient to 50 initiate the cold cathode discharge from starting aid 30. This discharge is necessary in order for the wire 30 to function as a lamp starting aid.

The cold cathode discharge from starting aid 30 to 55 electrode 24 will create a free charge comprised of electrons and positive mercury ions. Present understanding of the starting aid mechanism is that preferential ambipolar diffusion of this charge is accomplished by the presence of the negative 60 charged wire 30. In the region close to the wire 30, the envelope wall will acquire a positive charge due to the electrostatic attraction force of the wire 30. The dipole field established by this charge is significantly greater than that that could be generated by 65 an external wire or stripe since the dipole separation

in the latter case is substantially larger, resulting in a lower field strength.

The effect of this dipole is that additional ionization occurs close to the envelope wall which in turn 70 extends the dipole field further along the wire 30. This is analogous to the process which takes place between the negatively charged inner envelope wall and the positively charged outer wall with an external lamp starting aid. In this manner a conducting sheath is established along the bulb wall to a point where the axial lamp field is sufficient to start the lamp. In this regard the value of capacitor 44 is critical with regard to a minimum threshold value. This value must be greater than 0.1uf; otherwise, a 80 substantial voltage loss will occur during the polarity reversal of the supply voltage  $V$ . Laboratory measurements have indicated that this effect is probably caused by a capacitor discharge current resulting from space charge absorption at electrode 24 when 85 the supply voltage polarity reverses and becomes positive at electrode 24.

The wire starting aid 30 described herein is superior to all previous designs. Compared to internal conductive coatings or stripes, the wire starting 90 aid is superior due to the ease of manufacture and the lower cost. Further, it is readily adaptable to non-linear lamps.

In the linear or straight line lamps the wire starting aid offers improved performance due to improved 95 optical transmission as well as superior lumen maintenance.

Compared to external starting aids, superior performance is realized because of the increased electric field strength associated with the inner wire. It is 100 also better from a cost and manufacturing standpoint since additional steps would be required in the application of an external starting aid to a finished lamp. From an aesthetic consideration, the present invention offers an additional advantage in that 105 external starting aids require some form of electrical insulation in situations where electrical connection is required at some point in the circuit. The present invention is practically invisible in the finished lamp.

## 110 CLAIMS

1. A sealing closure for a discharge lamp, said lamp having a given arc length, said closure comprising: a glass base having an internal surface and 115 an external surface relative to said lamp; first and second lead-in wires sealed in said base and extending on both sides thereof; an electron emitting electrode electrically connected between said first and second lead-in wires adjacent said internal surface; a third lead-in wire sealed in said base and extending on both sides thereof; and a wire starting aid electrically connected to said third lead-in wire adjacent said internal surface, said starting aid having a length substantially equal to said given arc 120 length.
2. A sealing closure as claimed in Claim 1, wherein said sealing closure has a longitudinal axis and said third lead-in wire extends substantially parallel to said longitudinal axis, said wire starting aid having its electrically connected end formed to 130

extend, for a short distance, normal to said longitudinal axis, the remainder of said wire starting aid extending substantially parallel to said longitudinal axis.

5 3. A sealing closure as claimed in Claim 2, wherein said wire starting aid is fabricated from nickel or nickel-plated steel.

4. A sealing closure as claimed in Claim 2, wherein said wire starting aid is formed from a 10 material that is substantially inert with respect to mercury vapour.

5. A sealing closure for a discharge lamp, substantially as described herein with reference to Figure 2 of the accompanying drawings.

15 6. The features as herein described, or their equivalents, in any novel selection.

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