

5 **SEALING LIGHTING DEVICE COMPONENT ASSEMBLY**
 WITH SOLDER GLASS PREFORM BY USING INDUCTION HEATING

FIELD OF THE INVENTION

 The present invention relates to processes for sealing and affixing a
10 component assembly to glass envelopes of electrical lighting devices by using
 induction heating. In particular, the present invention relates to a process for sealing
 and affixing a component assembly comprising a solder glass preform and the lamp
 component by using induction heating. The present invention is useful, for example,
 in hermetically sealing and affixing lamp components, such as electrical lead wires
15 and exhaust tubulation, to a low pressure fluorescent discharge lamp envelope having
 phosphor coating already applied thereto.

BACKGROUND OF THE INVENTION

 Electrical lighting devices, including incandescent, fluorescent, high intensity
20 discharge and halogen lamps, as well as cathode ray tubes, usually comprise a
 hermetically sealed glass envelope. Electrodes, incandescent filament, exhaust tubes
 and other components are hermetically sealed and affixed to the glass envelope. The
 electrodes and the incandescent filaments are generally housed within the glass
 envelope. The lead wires of the electrodes must be hermetically sealed with the glass
25 envelope. Beaded leads are traditionally used in these many lighting devices to effect
 the glass-to-metal seals. FIG. 1 shows schematically the design of a traditional
 beaded leads, which consists of three pieces: an inner nickel or tungsten lead **13**, an
 outer stranded nickel lead **11**, and an intermediate tungsten lead **15**. A glass bead **17**
 is hermetically sealed over the middle tungsten lead. For borosilicate lamp
30 applications, the bead is typically made of borosilicate glass as well. Traditionally,
 flame burner technology is used in sealing the bead to the glass envelope. Burners
 provide the necessary heat to soften and fuse the two glass components together to
 form a hermetic seal. Having glass-to-glass contact ensures that the electrical feed-
 through is fully hermetic within the lighting device.

35 A typical fluorescent lamp comprises a glass envelope having an enclosed
 discharge channel. Inside the discharge channel are placed electrodes, mercury,
 getters, phosphor coatings and inert gases. Inert gases and/or mercury vapor sealed

5 inside the channel, excited by electrical energy, emit ultraviolet radiation together with a small amount of visible light. Phosphor particles, usually sized on the micro level, covert the ultraviolet radiation into visible light via the mechanism called fluorescence. As in other lighting applications, the exhaust tube is sealed outside of the glass lamp envelope. Recently, a new generation of fluorescent lamp has been
10 developed especially for use as the backlighting unit for information displays, such as the LCD display and other displays requiring an illumination source. These lamps feature a flat geometry having a convoluted discharge channel enclosed inside. To achieve good lighting efficiency and appealing color, rare-earth tri-phosphors are typically applied onto the internal wall of the discharge channel on these lamp
15 envelopes. As in other fluorescent light devices, getters, electrodes, mercury and inert gases as well as exhaust tubes are to be hermetically sealed with the glass envelope. A method of producing such flat panel lamp envelope is disclosed in U.S. Pat. No. 6,301,932. The glass envelope produced in accordance with this method has a once-piece design, viz., the faceplate and the backplate are sealed together to form an
20 integral lamp body having a convoluted channel. To meet the requirements of many applications, especially those of the portable devices, such as a notebook computer, a handheld computer, and the like, light-weight flat panel backlight unit has been produced. These lamp envelopes may have a very thin substrate with a wall thickness often even below 1 mm.

25 For these flat panel lamp envelopes, especially the one-piece lamp envelope produced in United States Patent No. 6,301,932, electrodes, getters and exhaust tubes are typically sealed with the lamp envelope after the phosphor coating has been applied. Hermetic sealing the electrodes, exhaust tubes and other components to the lamp envelope has been proven to be a challenge. Flame sealing technology suitable
30 for traditional lighting devices has proven to be difficult, if not impossible, to be directly used for these applications in the conventional way. First, the excessive heat generated by the burner flame will soften the glass envelope, causing the thin glass walls to sag and leading to deformation. The serpentine channel geometry requires sealing on a flat surface often of glass thickness less than 1 mm. Though possible,
35 flame working glass components to a flat surface typically results in a deformed seal area, subsequently affecting the overall thickness of the lamp and mechanical

5 strength. Second, these lamp envelopes with large area and complex geometry are very sensitive to temperature differentials. The temperature differentials involved in flame sealing can easily cause them to crack. Third, the phosphor coatings, getter and electrodes are sensitive to high temperature. Exposure of the phosphor coating to a temperature over 600°C will greatly diminish its functionality, lowering light output
10 and subsequent life. Getters, when subjected to high temperature before the channel is evacuated and hermetically sealed, may be activated prematurely, react with the atmosphere in the channel, and thus lose their intended functions. The electrode bells are usually coated with a layer of special emission coating material on its outer surface. When heated to a temperature over 600°C, the coatings will be destroyed or
15 negatively as well. Oftentimes, using direct flame sealing technology in a conventional manner cannot avoid heating the phosphors, getters and electrodes, which are located usually not far from the sealing area. Some natural outcomes, therefore, for example, are destroyed or deteriorated lamp components, lamp dysfunction or shortened lamp life, and reduced lamp brightness uniformity. Fourth,
20 in many lamp applications, the holes to be sealed are much larger than the solder glass bead on a beaded lead wire, making it difficult, if not impossible, to directly seal the beaded lead wire to the glass envelope using conventional flame sealing technology. Finally, using a burner flame can introduce unwanted impurities into the lamp discharge channel such as hydrocarbons, which are detrimental to the lamp
25 brightness, brightness uniformity and lamp life.

Therefore, there is a genuine need of a new approach for sealing the flat panel lamps in place of the conventional direct flame sealing technology, where localized heating can be used to effect a hermetic sealing and affixing lamp components, such as electrode leads and tubulations, without affecting the crucial and sensitive lamp
30 components.

Solder glasses have been used to achieve glass-to-glass or glass-to-metal sealing. Solder glasses can be vitreous or devitrifying. Vitreous solder glasses maintain a glass state after sealing. They are thermoplastic materials which melt and flow at the same temperatures each time they are melted. Devitrifying solder glasses,
35 commonly referred to as frits, are thermosetting, meaning they are no longer in glassy state after sealing, but contains both glassy and crystalline phases. Because of their

5 thermosetting properties, devitrifying solder glasses have many advantages and preferred in many applications against the vitreous ones. Once crystallized, devitrifying solder glasses have a higher modulus of rupture of about $4.2\text{--}5.6 \times 10^{-6}$ $\text{kg}\cdot\text{m}^{-2}$ compared with about $2.1\text{--}3.5 \times 10^{-6}$ $\text{mg}\cdot\text{m}^{-2}$ for its vitreous precursors and counterparts. Moreover, the softening point of the devitrified frits is essentially
10 increased to above the initial softening point of their vitreous precursors. The overall effect would be a seal stronger and more stable at elevated temperatures.

Solder glasses enable the use of localized heating to effect a hermetic seal. Besides, solder glass can be used to fill in the gaps between a component, such as the bead of a beaded lead wire and tubulations such as the exhaust tube, and the periphery
15 of a larger hole in which the component is to be hermetically sealed. Therefore, they are attractive in sealing the flat panel lamps.

Because an electrical lamp generates heat during its operation, it is desirable to use a low-expansion glass to manufacture glass envelopes. Borosilicate glasses having a coefficient of thermal expansion (CTE) in the range of $30\text{--}45 \times 10^{-7}$ $^{\circ}\text{C}^{-1}$ from
20 0 to 300°C have been used for lighting devices, including flat panel lamp envelopes. However, it has proven to be challenging to find the suitable solder glass and sealing method for sealing the lamp components with the borosilicate lamp envelope.

The present invention, by providing a process for sealing and affixing a component assembly comprising a solder glass preform and the component to be
25 sealed by using induction heating, addresses the concerns outlined above.

SUMMARY OF THE INVENTION

The present invention provides a process for hermetically sealing a component to a lamp envelope of a lighting device made of glass having a CTE C_1 from 0 to
30 300°C , comprising the following steps:

(i) providing a component assembly comprising the component to be sealed with the lamp envelope and a solder glass preform enclosing and bonded to the portion of the component to be hermetically sealed and affixed to the glass lamp envelope, wherein the solder glass of the preform has a before-sealing
35 softening point T_s over 500°C , an after-sealing CTE C_2 from 0 to 300°C in the

- 5 range of $C_1 \pm 10 \times 10^{-7} \text{ }^\circ\text{C}^{-1}$, and is capable of forming a hermetic sealing of the component with the lamp envelope upon being heated to a temperature over its before-sealing softening point T_s ; and
- (ii) attaching the component assembly to the hole of the lamp envelope through which the component is to be sealed and affixed to the lamp envelope;
- 10 (iii) allowing the solder glass preform to proximate the succesor die, which is heated by induction, of an induction heating device to heat the solder glass preform to a temperature higher than the before-sealing softening point T_s of the solder glass to effect a hermetic sealing.

Preferably, the process of the present invention is used for lamp envelopes made of borosilicate glass having a CTE C_1 from 0 to 300°C in the range of $30\text{-}45 \times 10^{-7} \text{ }^\circ\text{C}^{-1}$.

Preferably, according to one embodiment of the present invention, in step (iii), the succesor die does not contact the solder glass preform directly, but is placed over the solder glass preform at a distance less than 5 mm, preferably less than 3 mm, more preferably between 1-2 mm, and the solder glass preform is heated by the radiation emitted from the heated succesor die. Preferably, in this embodiment, the solder glass of the preform as used in the process of present invention is infrared absorbing.

Preferably, the solder glass in the preform used in the process of the present invention is formed from a devitrifying solder glass consisting essentially of a B_2O_3 - SiO_2 - PbO - ZnO glass containing CuO and/or Fe_2O_3 , having a before-sealing softening point in the range of $550\text{-}700^\circ\text{C}$, an after-sealing CTE C_2 from 0 to 300°C in the range of $32\text{-}40 \times 10^{-7} \text{ }^\circ\text{C}^{-1}$ and a devitrifying temperature T_d in the range of $630\text{-}750^\circ\text{C}$. More preferably, the solder glass preform in the component assembly of the present invention is formed from a solder glass consisting essentially, by weight percentage on an oxide basis calculated from the batch, of: 0-2% of Al_2O_3 , 15-25% of B_2O_3 , 1-5% of CuO , 0-5% of Fe_2O_3 , 0-7% of PbO , 10-16% of SiO_2 and 55-65% ZnO , and having a before-sealing softening point in the range of $550\text{-}700^\circ\text{C}$, preferably $600\text{-}650^\circ\text{C}$, an after-sealing CTE C_2 from 0 to 300°C in the range of $32\text{-}40 \times 10^{-7} \text{ }^\circ\text{C}^{-1}$, preferably $34\text{-}38 \times 10^{-7} \text{ }^\circ\text{C}^{-1}$, and a devitrifying temperature T_d in the range of 630-

5 750°C, preferably 650-700°C. Because the solder glass comprises, among others, CuO and/or Fe₂O₃, it has good infrared absorbing ability.

According to one preferred embodiment of the present invention, the component to be hermetically sealed and affixed to the glass envelope is a beaded electrode lead wire. Preferably, the beaded lead wire has an outer lead wire, an inner
10 lead wire, and an intermediate lead wire, and the intermediate lead wire is hermetically sealed with a solder glass bead.

According to another preferred embodiment of the present invention, the component to be hermetically sealed and affixed to the glass envelope is a glass tubulation having a similar CTE to the glass envelope. The tubulation may be an
15 exhaust tube of the glass envelope. Alternatively, according to one embodiment of the present invention, beaded electrode lead wire can be placed inside the tubulation, which, upon prior or further heating, can form a hermetic seal between the tubulation and the bead.

In one embodiment of the present invention, the solder glass preform of the component assembly of the present invention has a shape receivable by or capable of
20 covering the hole of the glass envelope through which the component is to be sealed and affixed.

In one preferred embodiment of the present invention, the solder glass preform has a one-step structure consisting of two integrated parts P_1 and P_2 , wherein P_1 has a
25 smaller cross-sectional size than P_2 and is receivable by the hole through which the component is to be sealed and affixed to the lamp envelope, and P_2 has a larger cross-sectional size capable of covering the hole when P_1 is inserted into and received by the hole.

By heating the solder glass preform in the component assembly of the present invention in a localized manner using the succesor dies of an induction heating
30 device, a hermetic seal between the component and the glass envelope can be effected in a short period of time without causing substantial temperature increase to the adjacent lamp area, thus potential deformation of the lamp envelope, destruction of the phosphor coatings, getters and electrodes are avoided. The present invention is
35 particularly suitable for sealing flat panel lamp envelopes that are sensitive to high

5 temperatures and for which traditional flame sealing technology cannot be used, for example, flat panel lamp envelopes with phosphor coating already applied thereto.

Additional features and advantages of the invention will be set forth in the detailed description which follows, and in part will be readily apparent to those skilled in the art from the description or recognized by practicing the invention as described
10 in the written description and claims hereof, as well as the appended drawings.

It is to be understood that the foregoing general description and the following detailed description and drawings are merely exemplary of the invention, and are intended to provide an overview or framework to understanding the nature and character of the invention as it is claimed.

15 The accompanying drawings are included to provide a further understanding of the invention, and are incorporated in and constitute a part of this specification.

BRIEF DESCRIPTION OF THE DRAWINGS

In the accompanying drawings,

20 **FIG. 1** is a schematic cross-sectional view of a beaded electrode lead wire consisting of an outer lead, an inner lead and an intermediate lead having a hermetically sealed solder glass bead;

FIG. 2 is a schematic cross-sectional view of a component assembly of the present invention comprising a beaded electrode lead wire and a solder glass preform
25 having a uniform shape receivable by or capable of covering the hole of the lamp envelope through which the assembly is to be sealed and affixed;

FIG. 3 is a schematic cross-sectional view of a component assembly of the present invention comprising a beaded electrode lead wire and a solder glass preform with a one-step structure having two integrated parts P_1 and P_2 , with P_1 being smaller
30 and receivable by the hole through which the assembly is to be sealed and affixed, P_2 being larger and capable of covering the hole when P_1 is inserted into and received by the hole;

FIG. 4 is a schematic cross-sectional view of a component assembly of the present invention comprising a tubulation and a solder glass preform having a shape
35 receivable by or capable of covering the hole of the lamp envelope through which the assembly is to be sealed and affixed;

5 **FIG. 5** is a schematic cross-sectional view of a component assembly of the present invention comprising a tubulation and a solder glass preform with a one-step structure having two integrated parts P_1 and P_2 , with P_1 being smaller and receivable by the hole through which the assembly is to be sealed and affixed, P_2 being larger and capable of covering the hole when P_1 is inserted into and received by the hole;

10 **FIG. 6** is a schematic cross-sectional view of a component assembly of the present invention comprising a tubulation and a solder glass preform having a shape receivable by or capable of covering the hole of the lamp envelope through which the assembly is to be sealed and affixed, wherein a beaded lead wire is inserted and placed into the tubulation;

15 **FIG. 7** is a schematic cross-sectional view of a component assembly of the present invention comprising a tubulation and a solder glass preform with a one-step structure having two integrated parts P_1 and P_2 , with P_1 being smaller and receivable by the hole through which the assembly is to be sealed and affixed, P_2 being larger and capable of covering the hole when P_1 is inserted into and received by the hole, wherein a beaded lead wire is inserted and placed into the tubulation.

20 **FIG. 8** is a schematic top plan view of an apparatus set-up, in which three succceptor dies are used, for sealing the components to a flat panel lamp envelope using the process of the present invention.

25 **FIG. 9** is a schematic side view of an apparatus setup, in which the glass envelope is placed inside a preheating oven, and the succceptor die of the induction device is capable of moving up and down, for sealing the components to a flat panel lamp envelope using the process of the present invention.

DETAILED DESCRIPTION OF THE INVENTION

30 For the purpose of the present invention, a "component assembly" means an assembly containing (i) an electrical lamp component, such as an electrode lead wire, tubulation, and the like, to be sealed and affixed to a glass lamp envelope, and (ii) a solder glass preform. Once hermetically sealed and affixed to the lamp envelope, the component becomes a structural and functional part of the lamp envelope.

35 As described *supra*, hermetic sealing of electrode leads, getters, exhaust tubes, and other lamp components to a flat panel lamp envelope, especially those which a

5 phosphor coating has been applied to, has proven to be a challenge. For a simpler lamp envelope design, such as an incandescent lamp and a tubular fluorescent lamp, the traditional flame sealing method can be conveniently used for hermetic sealing a beaded lead wire as illustrated in **FIG. 1** or an exhaust tubulation to the glass envelope. However, for the reasons detailed *supra*, direct flame sealing in a similar
10 fashion has proven to be difficult, if not impossible, to use in hermetic sealing of flat panel lamp applications. Recently, a new method of producing flat panel lamp envelope has been disclosed in United States Patent No. 6,301,932. The lamp envelope produced in accordance with this method features a one-piece design, viz., the faceplate and the backplate of the lamp are formed into once piece enclosing a
15 convoluted discharge channel inside. For this lamp design, a phosphor coating must be applied onto the internal wall of the discharge channel before the sealing of electrodes, getters and exhaust tubulation. The holes on the glass lamp envelopes for applying phosphor coating as well as for sealing and affixing the electrodes and exhaust tubulations, are typically larger than the solder glass bead of a beaded lead
20 wire. It has been proven that the hermetic sealing of electrodes and exhaust tubulation to this one-piece glass lamp envelope is particularly difficult without deforming the lamp body, destroying or otherwise negatively affecting the crucial components of the lamp, including the getters and the electrode components, the phosphor coating, which is usually formed of a rare-earth tri-phosphor very sensitive
25 to temperature over 600°C.

Electrical lamps generate heat during their normal operation. As such, low-expansion glasses such as borosilicate glasses have been used in lamp applications.

A new component assembly comprising a solder glass preform and the lamp component to be sealed and affixed to the lamp envelope has been recently developed.
30 This new component assembly can be conveniently used for hermetic sealing of a borosilicate glass lamp envelope with phosphor already applied thereto and affixing lamp components such as electrode lead wire and exhaust tubulations to the lamp envelope, by using localized heating provided by the succesor die of an induction heating device.

35 Solder glass has been in use to realize glass-to-glass and glass-to-metal sealing in many years. For example, United States Patent Nos. 4,238,704, 3,127,278,

5 3,975,176 and 3,088,834 all disclosed solder glass compositions for joining glass parts to form a composite glass body. However, the solder glasses and/or method of use thereof disclosed in these references either do not meet the stringent heating conditions as required by a fluorescent flat panel discharge lamp, especially one with phosphor coating already applied, or do not form a hermetic seal under the required
10 sealing conditions. In choosing the right solder glass for a certain application, many technical factors need to be taken into consideration. First and foremost, the CTE of the parts to be sealed and the solder glass during the operational temperature range of the application should match, viz., the CTE differentials should not be too large. Second, the compositions of the parts to be sealed and the solder glass must be
15 compatible such that the rheology of the solder glass when heated to the sealing temperature can effect a tight and hermetic seal when hermeticity is required. Third, the capability of the solder glass to be locally heated at an adequate rate is also a concern when special heating source, such as infrared radiation, is used. Not all solder glasses have the same absorbing ability of infrared radiation. Some solder
20 glasses are not infrared absorbing at all.

The component assembly used in the process of the present invention comprises the component, such as the electrode lead wire, to be sealed with the lamp envelope and a solder glass preform enclosing and bonded to the portion of the component to be hermetically sealed and affixed to the glass lamp envelope. The
25 lamp component assembly is particularly suitable for lamp envelopes made of borosilicate glass having a CTE C_1 in the range of $30-45 \times 10^{-7} \text{ }^\circ\text{C}^{-1}$. However, it should be noted that the sealing method of the present invention by using induction heating are applicable for lamp envelopes having a different glass composition. The solder preform enclosing the component to be sealed has an after-sealing CTE C_2 in
30 the range of $C_1 \pm 10 \times 10^{-7} \text{ }^\circ\text{C}^{-1}$ and is capable of forming a hermetic seal after being heated to a temperature over its before-sealing softening point T_s .

The solder glass of the preform used in the process in accordance with the present invention can be either vitreous solder glass or devitrifying solder glass. A vitreous solder glass maintains glassy state after being sealed. Its before-sealing
35 softening temperature T_s and after-sealing softening temperature T_s' are substantially the same because there is no phase changes during the softening and sealing process.

5 However, a devitrifying solder glass undergoes phase changes at least partially during the softening and sealing process, resulting in crystalline phases in the original glassy phase. Therefore, the after-sealing softening temperature T_s' for a devitrifying solder glass is higher than its before-sealing softening temperature T_s . Regardless of whether the solder glass is vitreous or devitrifying, the sealing temperature thereof must be
10 higher than its before-sealing softening temperature T_s in order to effect a good hermetic sealing between the lamp component and the lamp envelope. Typically, when a devitrifying solder glass is used, it is heated to a temperature above its devitrifying temperature T_d in order to obtain a good and durable seal.

For a borosilicate glass envelope having a CTE C_1 in the range from 30-
15 $45 \times 10^{-7} \text{ } ^\circ\text{C}^{-1}$, a preferred solder glass of the preform of the component assembly used in the process of the present invention consists essentially of a devitrifying B_2O_3 - SiO_2 - PbO - ZnO solder glass containing CuO and/or Fe_2O_3 , having a before-sealing softening point T_s in the range of 550-700°C, an after-sealing CTE C_2 from 0 to 300°C in the range of 32 - $40 \times 10^{-7} \text{ } ^\circ\text{C}^{-1}$ and a devitrifying temperature T_d in the range of
20 630-750°C. More preferably, the solder glass of the preform of the component assembly of the present invention consists essentially, expressed in terms of weight percentage on an oxide basis calculated from the batch material, of: 0-2% of Al_2O_3 , 15-25% of B_2O_3 , 1-5% of CuO , 0-5% of Fe_2O_3 , 0-7% of PbO , 10-16% of SiO_2 and 55-65% ZnO , and has a before-sealing softening temperature T_s in the range from
25 550-700°C, preferably 600-650°C, an after-sealing CTE C_2 from 0 to 300°C in the range of 32 - $40 \times 10^{-7} \text{ } ^\circ\text{C}^{-1}$, preferably 34 - $38 \times 10^{-7} \text{ } ^\circ\text{C}^{-1}$ and a devitrifying temperature in the range of 630-750°C, preferably 650-700°C. These solder glasses ensure a CTE match with the substrate glass of the lamp envelope. Moreover, the rheology of the solder glass when heated to a temperature above its devitrifying temperature and
30 composition compatibility with the substrate glass of the lamp envelope permit the forming of a hermetic seal between the component to be sealed and the glass lamp envelope. These preferred solder glasses have good infrared absorbing abilities because they contain CuO and/or Fe_2O_3 . However, for the present invention process using induction heating, infrared-absorbing ability is not required. Therefore, other
35 solder glasses may be used for the present invention as well.

5 A non-limiting example of the borosilicate glass for the glass envelope consists of, expressed in terms of weight percentage on an oxide basis calculated from the batch materials, 77.4% SiO₂, 15.4% B₂O₃, 1.9% Al₂O₃ and 5.3% Na₂O, and has a CTE of approximately $38 \times 10^{-7} \text{ }^{\circ}\text{C}^{-1}$ from 0 to 300°C.

10 In one embodiment of the present invention, the component to be sealed to the glass lamp envelope in the component assembly of the present invention is an electrode lead wire. The resulted component assembly is thus a lead wire assembly to be sealed to the glass envelope. The cross-sectional view of a typical electrode lead wire for use in electrode lighting devices is schematically illustrated in **FIG. 1**. This lead wire has three parts: a stranded nickel outer lead for connection with power
15 source, an intermediate tungsten lead **15**, and an inner nickel or tungsten lead **13**. The intermediate tungsten lead **15** is hermetically sealed by a solder glass bead when supplied by the manufacturer. The glass bead can be made of NONEX[®], a clear soda lead borosilicate glass for tungsten sealing, having a CTE of about $36.0 \times 10^{-7} \text{ }^{\circ}\text{C}^{-1}$ from 0 to 300°C.

20 In conventional lighting devices, such as incandescent lamps and simple tubular fluorescent lamps, the glass bead enclosing the intermediate tungsten lead is directly sealed to the glass lamp envelope using, for example, flame sealing technology. However, for reasons enumerated *supra*, this technology is not directly
25 applicable for flat panel lamps, especially those having phosphor coatings applied thereto before sealing of the electrode wires. In the present invention, flame sealing is no longer required for sealing the component assembly to a flat panel lamp envelope. The solder glass preform encloses and bonds to the bead of the beaded electrode lead wire. Upon being heated to a temperature over its before-sealing softening
30 temperature T_s , and/or over its devitrifying temperature when a devitrifying solder glass is used, a hermetic sealing between the solder glass preform and the glass bead on the tungsten intermediate lead wire is effected. The bonding between beaded electrode lead wire and the solder glass preform in the component assembly of the present invention does not have to be as strong and hermetic as the seal obtained after the sealing procedure. The bonding between the solder glass preform and the beaded
35 lead wire before sealing, indeed, may be porous and discontinuous. A mechanical bonding between the solder glass preform and the bead of the lead wire to a certain

5 extent is convenient for down-stream sealing process in that the lead wire and the electrodes welded thereto will not move about because of the bonding, thus a precise seal can be realized. Electrode bells, not shown in the drawings, are usually welded to the end of the inner nickel or tungsten lead, inserted through the hole of the lamp envelope before sealing the beaded lead assembly to the lamp envelope.

10 **FIG. 2** illustrates schematically the cross-sectional view of a component assembly comprising a beaded electrode lead wire and a solder glass preform **19** according to the present invention. As shown in this figure, the glass bead **17** over the intermediate tungsten lead **15** of the beaded electrode lead wire is bonded to the solder glass preform **19**. As can be appreciated, the bonding between **17** and **19** may be
15 porous and/or discontinuous and not as intimate as is indicated in this figure. As illustrated in this figure, the solder glass preform in this embodiment has a uniform shape receivable by or capable of covering the hole of the lamp envelope through which the assembly is to be sealed to the lamp envelope. Before sealing of the assembly to the glass envelope, getters are placed into the discharge channel of the
20 lamp envelope and an electrode bell is welded onto the lower end of the inner lead wire **13**. Subsequently, the electrode and inner lead wire **13** are inserted into the discharge channel through the hole, and the solder glass preform **19** is placed into and received by the hole or placed atop to cover the hole. Preferably, the top plan view of the solder glass preform should take the same form of the hole so that it can be
25 received by the hole, and a size substantially the same of the hole so that no substantial gap remains between the solder glass preform and the periphery of the hole. For example and for the purpose of illustration only, where the hole is circular, the solder glass preform is advantageously cylindrical. Or, the solder glass perform may have a size larger than the hole, so that the hole can be covered when the perform is placed atop. After localized heating is applied to the solder glass preform, and the
30 solder glass is heated to a temperature above its before-sealing softening temperature T_s , a hermetic seal is effected across the hole.

FIG. 3 illustrates schematically the cross-sectional view of another component assembly of the present invention comprising a beaded lead wire and a solder glass
35 preform. In this figure, the glass bead **17** over the intermediate lead **15** is bonded to a solder glass preform **21**, which has a one-step structure. The one-step structure

5 consists of two integrated parts P_1 and P_2 having different cross-sectional size, with P_2 large than P_1 . P_1 advantageously has a shape and size receivable by the hole through which the beaded lead is to be sealed and affixed. The size and shape of P_2 , however, should be chosen such that when P_1 is inserted into the hole, P_2 can cover the periphery of the hole. **FIG. 3** is a preferred design of the beaded lead wire solder glass preform assembly of the present invention. Compared to the design of **FIG. 2**,
10 the one-step structure of **FIG. 3** reduces or prevents the movements of the electrode lead wire with respect to the hole periphery during the sealing process, thus a more precise sealing of the electrode wire centered in the hole can be achieved. It has been found that off-center sealing of the lead wire may lead to cracking of the glass
15 envelope and/or gross leak.

In another embodiment of the present invention, the component to be sealed with the glass envelope in the component assembly is a borosilicate glass tubulation having a CTE C_3 in the range of $C_1 \pm 10 \times 10^{-7}$. **FIGS. 4** and **5** illustrate the cross-sectional view of this embodiment, where **23** represents the cross-sectional view of
20 the glass tubulation. This tubulation may serve as an exhaust tubulation of the lamp envelope. Likewise, two designs of the solder glass preform for this embodiment have been contemplated and illustrated in **FIGS. 4** and **5**, respectively. The solder glass preform **19** in **FIG. 4** has a uniform shape and size receivable by or capable of covering the hole of the glass envelope through which the tubulation is to be sealed and affixed. The solder glass preform **21** in **FIG. 5** has a one-step structure
25 substantially the same as in **FIG. 3**. Similarly, the **FIG. 5** design is a preferred embodiment of the present invention where the component is a tubulation. Compared to the design of **FIG. 4**, the one-step structure of **FIG. 5** reduces or prevents the movements of the tubulation with respect to the hole periphery during the sealing process, thus a more precise sealing of the tubulation can be achieved. Where the
30 tubulation to be sealed to the lamp envelope is an exhaust tubulation, it is usually sealed to a separate hole other than the holes for sealing and affixing electrode lead wires. After the getters have been placed inside the discharge channel, the electrode lead wires and the exhaust tubes all hermetically sealed, the channel evacuated
35 through the exhaust tubulation, mercury and inert gas added to the channel, the exhaust tubulation may be collapsed using flame heating or other heating means to

5 obtain a final discharge lamp setup without substantial heating of the crucial and sensitive lamp components. Because the exhaust tubulation is farther from the essentially lamp components than the solder glass preform, flame sealing, when care is exercised, can be used to collapse the exhaust tube without destroying or deforming the lamp envelope. Flame sealing, though also used, is not directly applied to the
10 glass envelope here.

The tubulations illustrated in **FIGS. 4** and **5** may be used for sealing an electrode to the glass envelope, in addition to being used as an exhaust tubulation. **FIGS. 6** and **7** illustrate schematically the cross-sectional views of two designs of component assembly comprising a borosilicate glass tubulation, a solder glass
15 preform and a beaded electrode lead wire. Likewise, the **FIG. 7** design has a solder glass preform featuring a one-step structure and represents a preferred embodiment in the present invention. Compared to the **FIG. 6** design, the one-step structure of **FIG. 7** reduces or prevents the movement of the tubulation **23** with respect to the periphery of the hole through which the tubulation is to be sealed during the process of sealing, thus a more precise sealing of the tubulation can be achieved.
20

In the component assemblies illustrated in **FIGS. 6** and **7**, a beaded electrode lead wire is inserted into the tubulation to be sealed to the glass lamp envelope before the sealing of the tubulation. The glass bead **17** may have already been hermetically sealed to the tubulation **23** by, for example, flame sealing process, prior to the sealing
25 of the tubulation to the glass lamp envelope. In this scenario, a hermetic seal of the beaded electrode lead wire is obtained when the tubulation **23** is hermetically sealed to the glass lamp envelope. Or alternatively, the beaded electrode lead wire may be inserted into the tubulation **23** without a hermetic sealing therebetween before the tubulation is hermetically sealed to the glass lamp envelope. After sealing the
30 tubulation to the lamp envelope by locally heating the solder glass preforms **19** and **21**, hermetic sealing between the glass bead **17** and tubulation **23** can be done using further heating. Again, flame sealing may be used if care is taken given the longer distance between the flame sealing location and the crucial and sensitive components of the lamp envelope.

35 Various methods of making solder glass preform are known to one of skill in the art. Both vitreous and devitrifying solder glasses are available in power form in a

5 variety of particle distributions that are designed to meet the needs of specific applications. Vitreous solder glasses can be formed into rods for the preparation of sealing frames. Devitrifying solder glasses, however, cannot be formed into rods for sealing frames because of its tendency to crystallize during the redraw process. For both types of solder glasses, they can be dry-pressed, with or without the use of
10 organic binders, to form sealing collars of various desired shapes and configurations for use in, for example, tubulation seals. Or alternatively, they can be extruded and sintered to form sealing strips of desired shapes and designs. Holes for receiving the lamp component, such as the beaded lead wire and the tubulations, can be formed directly during the dry-pressing and/or extruding process, or drilled thereafter.

15 Afterwards, the component is inserted into the hole to form the component-solder glass preform assembly of the present invention. Mechanical bonding to a certain extent between the component and the solder glass preform is desired for the convenience of down-stream processes, and can be effected by sintering the whole assembly at a temperature lower than the before-sealing softening temperature T_s of the solder glass. Where organic binders are added to the solder glass in forming the preform, sintering temperature and time should be enough to substantially eliminate them from the preform in order that hazardous organic impurities will not be
20 introduced into the discharge channel of the lamp envelope after sealing. For example, in an preferred embodiment of the present invention, devitrifying solder glass power, with a small amount of ethanol added, is first pressed into a desired
25 shape, such as the cylindrical shape and the one-step shape described, *supra*. A hole is then drilled through the preform, through which the beaded electrode lead wire or a glass tubulation is then inserted. Subsequently, sintering of the solder glass preform is carried out, whereby the ethanol is eliminated, and a bonding between the solder
30 glass preform and the component is obtained. The thus prepared component assembly of the present invention is ready for sealing with the glass lamp envelope. Typically, especially for the glass envelope with one-piece design, the sealing of the component assembly of the present invention to the lamp envelope is carried out after the phosphor coating has been applied and the getters are placed into the discharge
35 channel. Additional lamp components, such as the electrode bells, and the like, are

5 welded to the end of the inner lead of the beaded electrode lead before sealing the assembly to the lamp envelope.

As described, *supra*, for flat panel lamp envelopes, especially those which have phosphor coatings already applied, localized heating in sealing the electrode leads and exhaust tubulations to the lamp envelope is desired in order to avoid
10 destroying the heat-sensitive components of the lamp, such as the phosphor coating, getters, and/or deforming the lamp envelope *per se*. The component-solder glass preform assembly used in the present invention makes it possible to use localized heating in sealing the components. When sealing the component assembly to the glass envelope, localized heating source is applied mainly to the solder glass preform.
15 Pressure is optionally applied to the preform where necessary. Preferably, within a short period of time, the solder glass is brought to a temperature over its sealing temperature T_s , where it softens, optionally flows, and/or devitrifies if a devitrifying solder glass is used, to form a hermetic seal between the component and the glass lamp envelope. To avoid excessive heat transfer to the nearby lamp components,
20 such as phosphor coating, getters and the like, it is desired that the sealing time is controlled under 5 minutes, preferably under 3 minutes, more preferably under 1 minute, most preferably within seconds. Optionally, a shield, a reflector and/or a heat-absorbing cover material may be used to shield the rest of the lamp envelope to prevent it from being heated excessively by the heating source used for sealing. Once
25 a hermetic seal is effected, the heating source is removed from the component assembly, and the glass envelope with the seal is allowed to slowly cool down to room temperature. The solder glass hardens during the cooling process to form a strong and hermetic seal.

The present inventors contemplated using induction heating to provide the
30 localized heating. Induction heating involves placing an electrical conductor in a alternating magnetic field. The alternating magnetic field is produced by circulating an alternating current through the induction coil that acts as the primary winding of a simple transformer. The electrical conductor, usually metal, which is to be heated, is placed into the magnetic field and acts as the secondary winding or succeptor. The
35 electric current generated within the succeptor by the alternating magnetic field can heat up the succeptor. By shaping the coil properly, the heat can be localized or

5 spread throughout the conductor. Depending on the heat pattern desired of the conductor, the induction coil can be of a single turn or of many turns. Appreciable heat loss may occur in the induction coil from the relatively high currents and the high effective resistance to the current. Where the heat loss is substantial, the induction coil can be cooled by water or other means. Induction heating has a number of salient advantages. For example, it is possible to localize the heat to the surface of the 10 succesor. In addition, there is no electric connection between the power source and the succesor, and the succesor can be heated extremely quickly, with a rate of 10-1000°C per second without heating up the surrounding atmosphere, many times those possible by conventional heating means such as flame heating and/or infrared heating. 15 This highly concentrated, fast heating and easily adjustable technique suits the need of the sealing a low pressure fluorescent lamp very well. A metal succesor die connected to the end of the succesor, when allowed to contact the solder glass preform and the sealing area, can transfer the heat generated to the solder glass, soften it to effect a hermetic seal within a very short period time. However, it is preferred 20 that the succesor, heated to a high temperature dies does not contact the glass preform directly to heat the solder glass preform. Where the die does not contact the solder glass preform directly, several problems can be avoided. First, the die will be less prone to contaminate the solder glass preform. Second, the die will not stick to the solder glass preform during the operation, reducing the cleaning work of the die. 25 When the die is held at a close proximity to the preform, the radiation generated by the high-temperature die, including infrared, ultraviolet and other radiation, can heat up the preform very quickly to the sealing temperature. Advantageously, the distance between the die and the glass preform is controlled automatically within 5 mm, preferably within 3 mm, more preferably between 1 and 2 mm. Accordingly, the 30 solder glass of the preform in accordance with the process of the present invention is advantageously infrared absorbing, so that it can be heated up quickly without heating up the adjacent lamp area.

The succesor can be made of metals such as iron, stainless steel, platinum where a clean seal is required, and the like. A metal with a high melting temperature 35 and good resistance to oxidation in the air at a temperature below about 1200°C is preferred for prolonged use. Advantageously, the die has a size and shape that can

5 effect an effective and quick heating of the solder glass preform without heating up the surrounding glass lamp envelope. Dies with contoured inner surface to focus the radiations to the glass preform are advantageously used. The design of the die should avoid contact between the die and adjacent lamp envelope area, such as the outer wall of the discharge channel. For example, the die may have a hole or slot through which
10 the lamp component, such as an electrode lead wire or an exhaust tubulation, can be inserted and received. It is contemplated that (i) more than one succceptor may be placed into a single induction coil, or (ii) more than one succceptor die may be connected to a succceptor in a single induction coil, or (iii) more than one induction coils may be used, where necessary, to heat and seal multiple locations and/or
15 components to a glass lamp envelope.

FIGS. 8 and 9 illustrate a design of apparatus setup for the process of the present invention. Referring to **FIG. 8**, three succceptor dies **49** connected to three succceptors, heated by induction coils **51**, are placed at a short distance less than 5 mm over three solder glass preforms simultaneously. The glass lamp envelope is shown
20 as **45** in **FIG. 8**. Once the induction coil is powered to generate the alternating magnetic field, a current is induced in the succceptor, whereby the succceptor and the die are heated up very quickly. Thus, in a single heating cycle, the sealing of two electrodes at both ends of the discharge channel and an exhaust tubulation in the middle can be effected. **FIG. 9** is a side view of the apparatus setup shown in **FIG. 8**,
25 with an additional heating chamber, comprised of the insulation elements **41** and heating elements **43**, housing the lamp envelope **45**. The succceptor die **49**, as shown in **FIG. 9**, can move up and down. Thus, the die is first lowered down from an upper position to proximate but not directly contact the solder glass preform **47**. The die may have been heated to a high temperature before being allowed to proximate the solder glass preform. Or alternatively, the die can also be heated very quickly to a
30 high temperature by turning on the power source of the induction coils after it comes into close proximity with the solder glass preform. Either way, the solder glass preform can be heated to a temperature around 800-900°C from about 580°C within a very short period of time, such as below 1 minute, advantageously below 30 seconds, whereby a hermetic seal is achieved. Experiments showed that such heating can be
35 effected within 15 seconds. This is surprisingly fast compared with other heating

5 methods. Once a hermetic seal is accomplished, the die can be lifted up away from the solder glass preform, with or without turning off the power source of the induction coils, so that no excessive heat unnecessary for the sealing process is transferred to the solder glass preform, then to the neighboring lamp components such as the phosphor coating, getters and electrode bells. The sealing process of the present
10 invention is particularly suitable for sealing electrodes and tubulations to a flat panel lamp envelope having phosphor coatings applied prior to sealing thereof. Because of the close proximity between the die and the solder glass preform, radiation from the die is substantially directed to the preform only, and the sensitive lamp components nearby are not affected. The sealing process of the present invention is fast and
15 effective. Moreover, it is contemplated that the induction equipment used in the present invention process can be used to activate getters inside the discharge channel after the lamp is sealed, if the getters can be activated by radio frequency magnetic wave.

During the sealing process of the component assembly to the lamp envelope, it
20 is desired to reduce the temperature differential between the glass envelope and the solder glass preform being sealed. If the sealing temperature is excessively higher than the substrate of the lamp envelope, there is a risk of cracking during the sealing process. Therefore, preheating of the lamp envelope is desired before the sealing of the component assembly thereto. The preheating is advantageously carried out in a
25 oven, where the lamp envelope, including the phosphor coating applied thereto, is brought to a higher temperature safe to the phosphor coatings. For lamps using rare-earth tri-phosphor coatings, this temperature should be below 600°C, preferably between about 500-585°C, so that a minimal temperature differential is obtained between the sealing temperature and the substrate temperature without harming the
30 phosphor coatings. The relatively low expansion of borosilicate glass represents an advantage during this process, rendering the glass substrate less prone to cracking in sealing. An oven with programmed temperature profile can be advantageously used for the sealing and the subsequent slow cooling processes. **FIG. 9** illustrates an embodiment of the present invention where a heating chamber, defined by the
35 insulation materials **41** and containing the heating elements **43**, is used.

5 The following example further illustrates the present invention. It is to be understood that following example is for illustration only and is not meant to limit the claimed invention in any way.

EXAMPLE

10 In this example, a beaded electrode lead-solder glass preform assembly as illustrated in **FIG. 2** was prepared and sealed to a one-piece borosilicate glass flat panel lamp envelope.

 A devitrifying solder glass power from SEM-COM Company, Toledo, OH, product name SCC-7, which has an approximate CTE from 0 to 300°C of $35 \times 10^{-7} \text{°C}^{-1}$,
15 an approximate before-sealing softening point of 632°C and an approximate devitrifying temperature T_d of 670°C was used in this example. A beaded lead as illustrated in **FIG. 1** was used to form the assembly. The lead had a stranded nickel outer lead **11**, a tungsten intermediate lead **15** hermetically sealed with a Nonex[®] solder glass **17**, and a nickel inner lead **13**. The beaded lead wire is commercially
20 available from The Fredericks Company, Huntington Valley, PA.

 1.0 gram of the solder glass power was mixed with a drop of ethanol, filled into a pressing die, pressed into disk shape to produce a greenish cylindrical preform having a diameter of 12.8 mm and a thickness of 3.2 mm. The preform was pre-sintered at 590°C for half an hour. Afterwards, a hole was drilled in the center of the
25 disk which had a size just enough to suspend the bead **17** of the lead wire shown in **FIG. 1**. The beaded lead wire was then inserted into the hole and placed in a manner such that the bead **17** was centered within the disk. The resulted assembly was then sintered at 620°C for half an hour, whereby the bead **17** was bonded to the disk, though not forming an intimate and hermetic seal. An electrode was then welded to
30 the inner lead **13**. Thus an electrode-solder glass preform assembly was finalized.

 The glass lamp envelope used in this example was manufactured using the method described in United States Patent No. 6,301,932 and had a one-piece design. Rare-earth tri-phosphor coating was applied to the internal wall of the discharge channel of the lamp envelope. The glass of the lamp envelope had a composition
35 consisting essentially, by weight on an oxide basis calculated from the batch material,

5 of 77.4% SiO₂, 15.4% B₂O₃, 1.9% Al₂O₃ and 5.3% Na₂O, and had a CTE from 0 to 300°C of approximately $38 \times 10^{-7} \text{°C}^{-1}$. Three holes of about 6 mm in radius were drilled and to be sealed with electrodes and/or tubulations. The lamp envelope was placed into an oven and preheated to about 580°C before sealing of the electrode assembly.

10 The electrode-solder glass preform assembly prepared above was inserted into one of the holes of the preheated lamp envelope after getters were placed into the discharge channel. The solder glass preform was placed on top of the hole with the lead wire in the center of the hole. A susceptor die heated by induction was then placed over the solder glass preform at a distance between about 1-2 mm. The solder
15 glass preform softened and devitrified as a result and a hermetic seal was obtained within 15 seconds. Subsequently, the susceptor die was removed from above the solder glass preform and the lamp envelope was slowly cooled to room temperature. Further testing showed that the sealing was hermetic, and the phosphor coating and getters were not destroyed because of the sealing. No cracking on the lamp envelope
20 was observed. Optical microscopic examinations showed that the desired glass/crystalline phases in the solder glass could be achieved within seconds using the present invention process.

It will be apparent to those skilled in the art that various modifications and alterations can be made to the present invention without departing from the scope and
25 spirit of the invention. Thus, it is intended that the present invention cover the modifications and variations of this invention provided they come within the scope of the appended claims and their equivalents.

5 What is claimed is:

1. A process for hermetically sealing a component to a lamp envelope of a lighting device made of glass having a CTE C_1 from 0 to 300°C, comprising the following steps:

- 10 (i) providing a component assembly comprising the component to be sealed with the lamp envelope and a solder glass preform enclosing and bonded to the portion of the component to be hermetically sealed and affixed to the glass lamp envelope, wherein solder glass of the preform has a before-sealing softening point T_s over 500°C, an after-sealing CTE C_2 from 0 to 300°C in the
15 range of $C_1 \pm 10 \times 10^{-7} \text{ }^\circ\text{C}^{-1}$, and is capable of forming a hermetic sealing of the component with the lamp envelope upon being heated to a temperature over its before-sealing softening point T_s ;
- (ii) attaching the component assembly to the hole of the lamp envelope through which the component is to be sealed and affixed to the lamp envelope; and
- 20 (iii) allowing the solder glass preform to proximate the succesor die, which is heated by induction, of an induction heating device to heat the solder glass preform to a temperature higher than the before-sealing softening point T_s of the solder glass to effect a hermetic sealing.

25 2. A process in accordance with claim 1, wherein in step (iii), (a) the die does not contact the solder glass preform directly; (b) the distance between the succesor die and the solder glass preform when the preform is heated is less than 5 mm, and (c) the solder glass preform is heated by the radiation emitted from the heated succesor die.

30 3. A process in accordance with claim 2, wherein the distance between the succesor die and the solder glass preform when the preform is heated is less than 3 mm.

 4. A process in accordance with claim 3, wherein the distance between the
35 succesor die and the solder glass preform when the preform is heated is between 1 and 2 mm.

5

5. A process in accordance with claim 2, wherein the solder glass of the preform is infrared absorbing.

10

6. A process in accordance with claim 1, wherein the glass envelope is made of borosilicate glass having a CTE C_1 in the range of $30-45 \times 10^{-7} \text{°C}^{-1}$ from 0 to 300°C, and a phosphor coating has been applied to the glass envelope before sealing thereof.

15

7. A process in accordance with claim 6, wherein the solder glass preform is formed from a devitrifying solder glass consisting essentially of a B_2O_3 - SiO_2 - PbO - ZnO glass containing CuO and/or Fe_2O_3 , having a before-sealing softening point in the range of 550-700°C, an after-sealing CTE C_2 from 0 to 300°C in the range of $32-40 \times 10^{-7} \text{°C}^{-1}$ and a devitrifying temperature T_d in the range of 630-750°C.

20

8. A process in accordance with claim 7, wherein the solder glass preform is formed from a solder glass consisting essentially, by weight percentage on an oxide basis, of: 0-2% of Al_2O_3 , 15-25% of B_2O_3 , 1-5% of CuO , 0-5% of Fe_2O_3 , 0-7% of PbO , 10-16% of SiO_2 and 55-65% ZnO , and having a before-sealing softening point in the range of 600-650°C, an after-sealing CTE C_2 from 0 to 300°C in the range of $34-38 \times 10^{-7} \text{°C}^{-1}$ and a devitrifying temperature T_d in the range of 650-700°C.

25

30

9. A process in accordance with claim 1, wherein the glass envelope is made of a borosilicate glass having approximately the following composition, expressed in terms of weight percentage on an oxide basis calculated from the glass batch: 77.4% SiO_2 , 15.4% B_2O_3 , 1.9% Al_2O_3 and 5.3% Na_2O , and has a CTE of approximately $38 \times 10^{-7} \text{°C}^{-1}$ from 0 to 300°C.

10. A process in accordance with claim 6, wherein the glass envelope is preheated to a temperature below 600°C before step (iii).

5 11. A process in accordance with claim 10, wherein the glass envelope is preheated to a temperature between about 550-585°C before step (iii).

12. A process in accordance with claim 1, wherein the component to be sealed and affixed to the glass envelope is a beaded electrode lead wire.

10

13. A process in accordance with claim 12, wherein the beaded electrode lead wire has an inner lead, an outer lead and an intermediate lead, and the intermediate lead has a hermetically sealed solder glass bead therewith.

15 14. A process in accordance with claim 13, wherein the solder glass bead of the beaded lead wire is bonded and attached to the solder glass preform by sintering at a temperature lower than the before-sealing softening temperature T_s of the solder glass preform.

20 15. A process in accordance with claim 14, wherein the solder glass preform has a shape directly receivable by or capable of covering the hole of the glass envelope through which the solder glass preform beaded electrode wire assembly is to be sealed and affixed to the lamp envelope.

25 16. A process in accordance with claim 15, wherein the solder glass preform enclosing part the lead wire consists of two integrated parts P_1 and P_2 having different cross-sectional sizes, P_1 has a smaller cross-sectional size receivable by the hole of the lamp envelope through which the component assembly is to be sealed and affixed, and part P_2 has a larger cross-sectional size capable of covering the hole when P_1 is
30 inserted into and received by the hole.

17. A process in accordance with claim 6, wherein the component to be sealed and affixed is a borosilicate glass tubulation having a CTE C_3 in the range of $C_1 \pm 10 \times 10^{-7} \text{ } ^\circ\text{C}^{-1}$.

35

5 18. A process in accordance with claim 17, wherein the tubulation is bonded to the solder glass preform by sintering at a temperature below the before-sealing softening temperature T_s of the solder glass of the preform.

10 19. A process in accordance with claim 18, wherein the component enclosed by the solder glass preform is to be affixed to the lamp envelope as an exhaust tubulation.

15 20. A process in accordance with claim 18, wherein the solder glass preform enclosing the tubulation has a shape receivable by or capable of covering the hole of the lamp envelope through which the component assembly is to be sealed and affixed.

20 21. A process in accordance with claim 18, wherein the solder glass preform enclosing the tubulation consists of two integrated parts P_1 and P_2 having different cross-sectional sizes, P_1 has a smaller cross-sectional size receivable by the hole of the lamp envelope through which the component assembly is to be sealed and affixed, and part P_2 has a larger cross-sectional size capable of covering the hole when P_1 is inserted into and received by the hole.

25 22. A process in accordance with claim 20 or 21, wherein the component assembly to be sealed and affixed to the lamp envelope further comprises a beaded electrode lead wire placed inside the tubulation, the beaded lead wire and the tubulation are chosen and placed in a manner such that upon prior or further heating of the tubulation, a hermetic seal can be effected between the beaded lead wire and the tubulation without causing substantial heating to the glass envelope to which the assembly is to be sealed and affixed.

30 23. A process in accordance with claim 1, wherein step (iii) is carried out in less than 5 minutes.

35 24. A process in accordance with claim 16, wherein step (iii) is carried out in less than 3 minutes.

- 5 25. A process in accordance with claim 17, wherein step (iii) is carried out in less than 1 minute.
26. A process in accordance with claim 18, wherein step (iii) is carried out in less than 30 seconds.