

DATE 9/27/54

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COMPILED BY  
EAM Jr

TMC SPECIFICATION NO. S -220 **A**

TITLE: RCAF Gray Semi-Gloss Enamel finish

JOB 170

APPROVED 

I PURPOSE:

To outline the materials and methods of finishing metal to the color required.

II FINAL COLOR:

~~Gray~~ 50152010 as per Canadian Government Specifications Board Schedule of Standard Paint Colors, 1-GP-12e and amends.

III MATERIALS REQUIRED:

A. Zinc Chromate Primer-

1. No SV319 Wash Primer of Maas & Waldstein Co, or equal.
2. No. FC320 Reducer of Maas & Waldstein Co., or equal.
3. Lacquer Thinner, of any standard manufacturer.
4. No. 2106-77A Enamel of Eastern Lacquer Co or equal.
5. No. 902 Thinner of Eastern Lacquer Co or any good grade Tolual.

IV PROCEDURE:

- A. Clean surface of bare metal of all foreign materials.
- B. Apply zinc chromate primer, consisting of four parts primer, one part reducer, thinned if necessary with lacquer thinner. CAUTION: Mix only enough primer for one days' operation.
- C. Apply by spraying one uniform coat of mixed primer and air dry for 15 to 30 minutes before applying final finish. NOTE: If only part of the surface is to be finally finished and all surfaces are primed, the unfinished primed surface will change color from greenish-yellow to brownish-green after baking.
- D. ENAMEL- Apply by spraying one uniform coat of enamel. Bake for one hour at 250°F, one half hour at 275°F or ten minutes at 300°F.

V. APPLICABLE SPECIFICATIONS: MIL Spec P-15328 (Primer)  
MIL Spec P-15090 Type III Class 2

VI. MARKING AND SHIPPING: All finished items shall be shipped in suitable containers to insure maximum protection during transit, after marking with TMC Purchase Order No, part number, and manufacturer's name and applicable reference numbers.

