

DATE 12/17/59

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COMPILED BY

TMC SPECIFICATION NO. S-471

TITLE: USIA PAINT SPECIFICATION

JOB

APPROVED

Ref: NObsr-81106

PURPOSE:

To outline the material and methods of finishing metal to the color required for equipment supplied to the Department of the Navy for use in the CONSOLIDATED EAST COAST FACILITIES project.

EQUIPMENT FACES: Cabinets, doors, exteriors, panels, etc.

Final Color: OPEX CONTINENTAL ELECTRONICS #400 GRAY	Gauge Reading
Primer-Surfacer M. Gray P2A20	40
Opex Mix. Black L3B-31253	68 1/2
Opex Mix. White L3W-31001	100

To each gallon of the above add as much aluminum bronze powder Venus Extra Brilliant as can be put on the lid of a quart can. (This is an unusual formula in that it calls for Opex Primer Surfacer and dry bronze powder, but it makes a perfect match for the finish required).

PROCEDURE:

- A. Cle an 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.
- 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.

TRIM:

Final Color: OPEX CONTINENTAL ELECTRONICS #500 BLUE GRAY	Gauge Reading
Opex Primer-Surfacer - M. Gray P2A20	20
Opex Mix. Prus. Blue - L3L-31044	27
Opex Mix. Ind. Oxide - L3R-31245	52
Opex Mix. Carb. Black- L3B-31253	72
Opex Mix. White - L3W-31001	94
Opex Mix. P.T..Blue - L3L-31244	98
Opex Mix. P. Maroon - L3M-31254	100

INTERIOR, PANELS, etc.

Sherwin-Williams - F-92AA11, which meets Federal Specification #595, issued March 1, 1956, superseding Federal Specification TT-G-595, dated January 12, 1950, color #26307.

REF: Sherwin-Williams Company, 1801 W. Pleasant Valley Road,
Cleveland 34, Ohio.

ATTN: Mr. Joseph A. Stewart.