

DATE 12-28-55
SH. 1 OF 1

TMC SPECIFICATION NO. S- 254

COMPILED BY
W.D.C.

TITLE: RCAF Grey Wrinkle Enamel

JOB

APPROVED

I PURPOSE:

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

II FINAL COLOR:

Medium Grey Wrinkle, 1-110 as per Canadian Government Specifications Board Schedule of Standard Paint Colors, 1-GP-12a 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 iniform 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.