

DWG NO
1741AS829
SH
9

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
B	REDRAWN, 11 SHEETS WAS 15;	1/14/80	[Signature]

I. PAINING PROCEDURES

1. PROCEDURE FOR EXPOSED FERROUS METAL SURFACES.

1.1 MASK ALL SURFACES NOT TO BE PAINTED. (SEE PARAGRAPH B.3, B.9, B.10 AND B.11).

1.2 BLAST SURFACES TO BE PAINTED TO "NEAR WHITE" PER STEEL STRUCTURES PAINT COUNCIL SPECIFICATION NO. 10 (SSPC-SP-10).

ITEMS SUCH AS SHEET METAL ENCLOSURES, WHICH MAY BE DAMAGED BY BLASTING, SHALL BE PREPARED USING ALTERNATIVE METHODS SUCH AS: POWER WIRE BRUSH, SANDING, OR MILD ACID BATH.

1.3 APPLY TWO (2) COATS OF EPOXY PRIMER PER MIL-P-53022, TYPE II TO PREPARED SURFACES. FOLLOW THE MANUFACTURER'S INSTRUCTIONS FOR PREPARING AND SPRAYING THE PRIMER. EACH COAT SHALL BE 1.0 TO 1.5 MILS THICKNESS.

1.4 APPLY TWO (2) COATS OF POLYURETHANE TOP COAT PER MIL-C-85285, TYPE II TO PRIMERED SURFACES. FOLLOW THE MANUFACTURER'S INSTRUCTIONS FOR PREPARING AND SPRAYING THE TOP COATS. EACH COAT SHALL BE 1.7 TO 2.5 MILS THICKNESS. THE COLOR IS GLOSS WHITE (COLOR NO. 17925 OF FED-STD-595).

1.5 TOTAL THICKNESS OF PAINT SHOULD BE BETWEEN 5.4 AND 8.0 MILS.

2. PROCEDURES FOR EXPOSED NON-FERROUS SURFACES.

2.1 MASK ALL SURFACES NOT TO BE PAINTED (SEE PARA. B.3, B.9, B.10, AND B.11).

2.2 REMOVE ANY OIL OR GREASE FROM SURFACES TO BE COATED WITH SOLVENT USING CLEAN LINT FREE CLOTH.

2.3 ROUGHEN SURFACES USING SANDPAPER WITH APPROXIMATELY 100 GRIT.

CONTRACT NO: N00019-86-C-0028	 LAKE SHORE INC. AN OLDENBURG GROUP COMPANY IRON MOUNTAIN, MI. 49801 DWG. NO. 2A1-03004	SIZE A	CAGE CODE 30003	DWG NO 1741AS829	REV B
		SCALE NONE	WT -	LBS	SHEET 9 OF 11