STANDARD OVERHAUL PRACTICES MANUAL

TEMPORARY PROTECTIVE COATINGS

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To: All holders of TEMPORARY PROTECTIVE COATINGS 20-44-02.

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INTRODUCTION

1. General

A. The instructions in this manual tell how to do standard shop procedures during maintenance functions from simple checks and replacement to complete shop-type repair.

B. This manual is divided into separate sections:

(1) Title Page

(2) Transmittal Letter

(3) Highlights

(4) Effective Pages

(5) Contents

(6) Revision Record

(7) Record of Temporary Revisions

(8) Introduction

(9) Procedures

C. Refer to SOPM 20-00-00 for a definition of standard industry practices, vendor names and addresses, and an explanation of the True Position Dimensioning symbols used.

D. The data is general. It is not about all situations or specific installations. Use it as a guide to help you write minimum standards.

E. If the component overhaul instructions are different from the data in this subject, use the component overhaul instructions.

TEMPORARY PROTECTIVE COATINGS

1. INTRODUCTION

A. The data in this subject comes from Boeing Process Specification BAC5034 which superseded BAC5835. The airline has a copy of the Boeing Process Specification Manual.

B. The data is general. It is not about all situations or specific installations. Use it as a guide to help you write minimum standards.

C. This subject tells about specific materials and methods to apply temporary protective coatings. The coatings are in four types: Removable Coatings, Nonadherent Films and Sheet Coverings, Preservatives, and Pressure-Sensitive Adhesive Tapes. These are then put into classes and grades which further specify usages and limitations. Refer to Figure 1 for further details.

D. Refer to SOPM 20-00-00 for a list of all the vendor names and addresses.

2. MATERIALS

A. Temporary Protective Coatings – Figure 1.

B. Removers

(1) For alkaline-removable coatings

(a) Alkasol 27, water-base, V0583B

(b) Cee Bee A-276B Remover, V71361

(c) Leeder 302N, V17209

(d) Leeder 783W, V17209

(e) Spraylat Remover SC1101S, water-base, V87354

(f) Tec 243 or 243P Remover, water-base, V25227

(2) For solvent-removable coatings

(a) Leeder 787W, V17209

(b) Tec 900-I, solvent-base, V25227

(c) Turco 6015, V61102

TEMPORARY PROTECTIVE COATING CLASSIFICATION			RECOMMENDED MATERIALS
Type 1: Removable Coatings	Class 1: Indoor/Outdoor	Grade A: General Purpose	Aztec 534-2, VOA3C8 Aztec 643GC aerosol, VOA3C8 Aztec 643GCS, VOA3C8 Aztec 643GFC blue, VOA3C8 Dapcoat 10066 alkaline removable, V58093 DeSoto Skingard, V91013 Leeder 103T, V17209 Leeder 117T, V17209 Leeder 300T, V17209 Leeder 304N, V17209 Leeder 305N, V17209 Leeder 306N, V17209 Leeder 314N, V17209 Leeder 315T, V17209 Leeder 321-N transparent, alkaline removable, V17209 Scotch 471, V76381 Scotch 472, V76381 Tec 243-4F, V25227 Tec 243-4F7, V25227 Tec 243-4F7G, V25227 Tec 558K, V25227 Tec 556-P, V25227 Tec 556-10, V25227 Tec 556-6625P, V25227 Tec 734-10, V25227 Tec 734-10-12, V25227 Turco 5228C, V61102
		Grade B: Special Purpose	Aztec 524 peelable vinyl caulk, VOA3C8 Aztec 624 peelable vinyl caulk, VOA3C8 Leeder 313N, V17209 Tec 660-2W rubber base, peelable, V25227 Tec 734-10CW, V25227

Temporary Protective Coating Classifications and Materials
Figure 1 (Sheet 1 of 8)

TEMPORARY PROTECTIVE COATING CLASSIFICATION			RECOMMENDED MATERIALS
Type 1: Removable Coatings	Class 2: Indoor/Limited Outdoor	Grade A: General Purpose	BMS 10-52 class 1, peelable *[1] Fuller 175-K-23 brush-on vinyl, peelable, V0361B or V72556 Spraylat TR 5157-1 alkaline removable, V87354
		Grade B: Interiors	Dapcoat 10010, V58093 Pro-Seal peelable (for interior plastic parts only), V83527 Spraylat SC1071, V87354
	Class 3: Indoor Only	Grade A-5514: Prebond Cleaning (BAC5514)	Dapcoat 1001, V58093 Dapcoat 5020 with CA-F (fast) or CA-S (slow) Catalyst, V58093 Organocerams 1-2050, V0194B or V33740 Turcoform 522, V61102

Temporary Protective Coating Classifications and Materials
Figure 1 (Sheet 2 of 8)

TEMPORARY PROTECTIVE COATING CLASSIFICATION			RECOMMENDED MATERIALS
Type 1: Protective Coatings	Class 3: Indoor Only	Grade A-5555 Prebond Cleaning (BAC5514 or 5555)	Adcoat 819R, V1M391 Adcoat 819R-LA, V1M391 Adcoat 820B, V1M391 Adcoat 820NF, V1M391 Adcoat 820R, V1M391 Adcoat 850, V1M391 Dapcoat 5040, V58093 De Soto Skingard, V91013 Scotch Y-335 colored mylar tape, V76381 Turco 5580G, V61102 Turco Form Mask 580-A, peelable, V61102
		Grade B: Chemical Milling or Anodizing	Adcoat 828, V1M391 Adcoat 850, perchloroethylene, V1M391 Adcoat 850, toluene, V1M391 Bostik-Finch 376-49, V98502 Coverlac SC-284X, V87354 Dapcoat 1001, V58093 Dapcoat 10220, V58093 Mask Coat No. 2, V22853, V87468, V92232 Organocerams 1-2020 HS Maskant, V0194B or V33740 Peel-Coat B-100, V56307 Turco 522 Maskant, V61102 Turco 567 Maskant, V61102 Turco 5696, V61102
		Grade C: Chromic Acid Anodizing	Adcoat 850 toluene dip, V1M391 Dapcoat 1200-AB, V58093 Dapcoat 10220, V58093 Turco TFM-522, V61102 Turco 5696, V61102
		Grade D: Sulfuric Acid Anodizing	Dapcoat 10220, V58093

Temporary Protective Coating Classifications and Materials
Figure 1 (Sheet 3 of 8)

TEMPORARY PROTECTIVE COATING CLASSIFICATION			RECOMMENDED MATERIALS
Type 2: Non-adherent Films and Sheet Coverings	Class 1: Indoor/Outdoor	Grade A: Waterproof	MIL-D-10860 QMC Class 1 cotton duck, fire, water, weather and mildew resistant per CCC-C-428 *[1] MIL-P-22035 polyethylene sheet or MIL-P-26692 tubing thicknesses 0.004, 0.006 0.008 inch *[1]
		Grade B: Waterproof, Light Stable	Polyethylene sheet, carbon-filled, 0.006 inch minimum thickness
		Grade C: Waterproof, Light Stable, Fire Resistant	Polyethylene sheet, purple, self-extinguishing per ASTM D568, V61177
	Class 2: Indoor/Limited Outdoor	Grade A: Water Resistant	Greaseproof paper per MIL-B-121 class 1, grade A, type 1 or 2, or MIL-B-131 *[1] Greaseproof bags per MIL-B-117, type 2, class C *[1] Kraft paper, laminated with 0.001 inch polyethylene, 40-pound test
		Grade B: Water Resistant, Vapor Phase Inhibitor	MIL-P-3420 packaging materials, volatile corrosion inhibitor, treated, opaque *[1] Angier 30/50/30 paper, 1 gram coated, creped, V6E915 Angier 30-pound paper, 1 gram coated, flat, V6E915 Orchard 30/50/30 paper, 1 gram coated, creped, V86001
	Class 3: Indoor Only	Grade A: Non-Waterproof	Kraft paper, untreated, oil and wax free, UU-P-268 or MIL-P-17667 *[1]
		Grade B: Non-waterproof, Cushioning	Bubble-Pak, polyethylene (air-pillow plastic) Cushioning, PPP-C-843 *[1] Cushioning, Rubberized Animal Hair Fiberboard or paper, corrugated, single face Kushion Kraft, KK951 Padding, Foam, Flexible

Temporary Protective Coating Classifications and Materials
Figure 1 (Sheet 4 of 8)

TEMPORARY PROTECTIVE COATING CLASSIFICATION			RECOMMENDED MATERIALS
Type 3: Preservatives	Class 1: Indoor/Outdoor	Grade A: Hard Films	MIL-C-11796, class 1 *[1] MIL-C-16173, grade 1 *[1] MIL-P-149, type 2 *[1]
		Grade B: Soft Films	BMS 3-23 *[1]
	Class 2: Indoor/Limited Outdoor	Grade A: Soft Films	MIL-C-11796, class 2 *[1] MIL-C-16173, grade 2 *[1] MIL-C-23411 *[1] MIL-G-23827 grease *[1]
		Grade B: Oils and Greases	MIL-H-6083 hydraulic fluid *[1] MIL-L-7870 oil *[1] MIL-L-21260 *[1]
Type 4: Pressure-Sensitive Adhesive Tapes	Class 1: Indoor/Limited Outdoor	Grade A: Substrate Protection	C-5-X clear plastic, V91757 C-15-X clear plastic, V91757 Protex 1321-D clear mylar, V06929 Protex 8216 clear mylar, V06929 Scotch Y-335 colored mylar, V76381 SPV 214 clear vinyl VS4064 SPV 224 blue vinyl VS4064 Y-10-X clear plastic, V91757
		Grade B: Protective Packaging	Mystik 5863 plastic-coated cloth, V88301 Mystik 7452 aluminum foil, rubber adhesive, V88301 Mystik 7453L aluminum foil, rubber adhesive, V88301 Permacel 662 waterproof cloth, V99742 Polyken 216 plastic-coated cloth, V80769 5HT clear plastic, V67945 90W waterproof cloth, V83334 91B waterproof cloth, V83334

Temporary Protective Coating Classifications and Materials
Figure 1 (Sheet 5 of 8)

TEMPORARY PROTECTIVE COATING CLASSIFICATION			RECOMMENDED MATERIALS
Type 4: Pressure-Sensitive Adhesive Tapes	Class 2: Indoor Only	Grade A: Substrate Protection	Behr-Manning 190 flat paper, V06565 C-4X blue plastic, V91757 Protex 20-series flat paper, V06929 Protex 50 flat paper, V06929 Protex 51AC flat paper, V06929 Protex 501 flat paper, V06929 Scotch Y-340 paper, V76381 Scotch 342 paper, V76381 Scotch 343 paper, V76381 Scotch 347 plastic, V76381 4RM blue plastic, V67945
		Grade B: Protective Packaging	Mystik 6250 high-temp crepe paper, V88301 Mystik 7352 clear polyester, V88301 Mystik 7453L aluminum foil, rubber adhesive, V88301 Permacel 99 clear acetate, V99742 Permacel 672 waterproof cotton cloth, V99742 Permacel 786 moisture resistant crepe, V99742 Permacel 921 plastic, V99742 Polyken 110 sized cloth, V80769 Polyken 114 yellow cloth, V80769 Scotch 200 crepe paper (general masking), V76381 Scotch 232 crepe paper (general masking), V76381 Scotch 481 black vinyl, V76381 Scotch 710 transparent plastic, V76381
	Class 3: Manufacturing Aid	General Masking Up to 250°F	CP-15, V86984 HS 8171 PS, V1E893 Mystik 6241, V88301 Mystik 6324, V88301 Permacel 11, V99742 Permacel 733, V99742 Scotch 213, V76381 Scotch 226, V76381 Scotch 855, V76381

Temporary Protective Coating Classifications and Materials
Figure 1 (Sheet 6 of 8)

TEMPORARY PROTECTIVE COATING CLASSIFICATION			RECOMMENDED MATERIALS
Type 4: Pressure-Sensitive Adhesive Tapes	Class 3: Manufacturing Aid	Riveting	Arlon 180, V29246 Scotch 685, V76381 ST 440, V4P100
		Drill/ Countersinking	American Builtrite 6582, V3S304
		Chemical Processing	Mystik 7452, V88301 Permacel 29, V99742 Scotch 420, V76381 Scotch 425, V76381
		Bonding	Flashbreaker No. 2, V53912 HS 8171 PS, V1E893 Mystik 6325, V88301 Permacel 11, V99742 Permacel 733, V99742 Scotch 855, V76381
		Anodized Surfaces	CP-15, V86984 Mystik 6250, V88301 Mystik 7352, V88301 Mystik 7453, V88301 Permacel 70, V99742 Permacel 72, V99742 Permacel 92, V99742 Permacel 703, V99742 Protex P412, V06929 RM 2642, V62293 Scotch 213, V76381 Scotch 855, V76381
		Titanium Surfaces	Mystik 5863, V88301 Permacel 95, V99742 Scotch 850, V76381 Tuck 90T, V83334

Temporary Protective Coating Classifications and Materials
Figure 1 (Sheet 7 of 8)

TEMPORARY PROTECTIVE COATING CLASSIFICATION			RECOMMENDED MATERIALS
Type 4: Pressure-Sensitive Adhesive Tapes	Class 3: Manufacturing Aid	Freshly-Painted Surfaces	Mystik 6241, V88301 Permacel 705, V99742 Protex 939A, V06929 Scotch YR-239, V76381
		Double-Backed Tapes	DF-69, V86984 Permacel 02, V99742 Permacel 50, V99742 Polyken 105, V80769 Scotch 400, V76381 Scotch 971, V76381
		Exterior Skin Lap Splice Surface Masking	FP-81, V86984 Protex P412, V06929
		Masking for Electrical Bonding	Mactac XD-0946, V17452 Protex 223-5, V06929
		Computer-Cut Paint Premasks	Permacel ST-3000, V99742 Scotch Y-7901, V76381

*[1] Refer to the Qualified Product List of the applicable specification for approved material part numbers and vendors.

Temporary Protective Coating Classifications and Materials
Figure 1 (Sheet 8 of 8)

3. SELECTION

A. Generally, parts must have temporary protection during overhaul processes, and during storage and transportation.

B. When you move parts or put them in storage, use temporary protection per Figure 2.

NOTE: Figure 2 specifies minimum protection. Temporary protection applied for a given environment can stay on the parts for less severe conditions.

C. During overhaul processes, you can use these materials:

(1) Forming, shearing – Type 1, class 1, grade A; or Type 4, class 1, grade A

(2) Machining or riveting – Type 1, class 1 or 2, grade A

(3) Prebond cleaning – Type 1, class 3, grade A

(4) Chemical milling or plating – Type 1, class 3, grade B

(5) Chromic Acid Anodizing – Type 1, class 3, grade C

(6) Sulfuric Acid Anodizing – Type 1, class 3, grade D

(7) Painting, bonding, or sealing – Type 4, class 3

RAW MATERIAL	STORAGE AND MANUFACTURE									TRANSPORTATION *[1] *[6]		
	INDOOR HEATED (120°F MAXIMUM)			INDOOR UNHEATED OR COVERED OUTDOOR *[10]			UNCOVERED OUTDOOR *[6]			INDOOR TO OUTDOOR TO INDOOR	WITHIN 75 MILES	75 MILES OR BEYOND
	LESS THAN 1 WEEK	1 WEEK TO 6 MONTHS	6 MONTHS OR MORE *[2]	LESS THAN 2 WEEKS	2 WEEKS TO 6 MONTHS	6 MONTHS OR MORE *[2]	LESS THAN 2 WEEKS	2 WEEKS TO 3 MONTHS	3 MONTHS OR MORE *[2]			
NON-CLAD ALUMINUM, STEEL OR MAGNESIUM	NONE	TYPE 3				TYPE 3 CLASS 1	DO NOT STORE OUTDOORS (EXCEPT UNMACHINED RAW STEEL FORGINGS)			TYPE 1 CLASS 1 PLUS TYPE 2 CLASS 1 OR TYPE 3 CLASS 1 *[4]	TYPE 1 CLASS 1 PLUS TYPE 2 CLASS 1 OR TYPE 3 CLASS 2 GRADE A PLUS TYPE 2 CLASS 1 *[12]	
TITANIUM ALLOY	NONE			NONE OR TYPE 3 CLASS 2 GRADE A OR OTHER NON-HALOGEN-CONTAINING CORROSION PREVENTIVE COMPOUND			NONE OR TYPE 3 CLASS 2 GRADE A PLUS TYPE 2 CLASS GRADE A			NONE, OR TYPE 2 CLASS 1, OR TYPE 2 CLASS 2 GRADE A		
CLAD ALLUMINUM *[3]	NONE					TYPE 1 CLASS 1 OR 2, OR TYPE 2 CLASS 2 OR TYPE 3 CLASS 2	TYPE 2 CLASS 1	TYPE 1 CLASS 1 OR 2	TYPE 1 CLASS 1	TYPE 2 CLASS 1 *[12]		
STAINLESS STEEL (14% CR MINIMUM)	NONE	TYPE 2 CLASS 1 TYPE 3 CLASS 2		NONE	TYPE 2 CLASS 1 TYPE 3 CLASS 2	TYPE 1 CLASS 1 OR TYPE 2 CLASS 1 OR 2	DO NOT STORE OUTDOORS			TYPE 2 CLASS 1 OR TYPE 3 CLASS 2		
ACRYLIC PLASTIC SHEET	TYPE 4 CLASS 2 PLUS TYPE 2 CLASS 3 GRADE A			TYPE 4 CLASS 2 PLUS TYPE 2 CLASS 3 GRADE B DO NOT STORE OUTDOORS			DO NOT STORE OUTDOORS			TYPE 4 CLASS 2 PLUS TYPE 2 CLASS 3 GRADE B PLUS TYPE 2 CLASS 2 GRADE A		

Temporary Protective Coating Selection Table
Figure 2 (Sheet 1 of 7)

SMALL DETAIL PARTS	STORAGE AND MANUFACTURE								TRANSPORTATION *[1] *[6]		
	INDOOR HEATED (120°F MAXIMUM)			INDOOR UNHEATED OR COVERED OUTDOOR *[10]			UNCOVERED OUTDOOR *[6]		INDOOR TO OUTDOOR TO INDOOR	WITHIN 75 MILES	75 MILES OR BEYOND
	LESS THAN 1 WEEK	1 WEEK TO 6 MONTHS	6 MONTHS OR MORE *[2]	LESS THAN 2 WEEKS	2 WEEKS TO 6 MONTHS	6 MONTHS OR MORE *[2]	LESS THAN 2 WEEKS	2 WEEKS TO 3 MONTHS	3 MONTHS OR MORE *[2]			
UNPROTECTED METAL SURFACES OF NON-CLAD ALUMINUM, STEEL OR MAGNESIUM	NONE	TYPE 2 CLASS 1 OR TYPE 3 CLASS 2 *[5]	TYPE 3 CLASS 1 OR 2 *[5]	TYPE 2 CLASS 1 OR TYPE 3 CLASS 2 *[5]	TYPE 3 CLASS 1 OR 2 *[5]	TYPE 1 OR TYPE 3 CLASS 1	DO NOT STORE OUTDOORS			TYPE 2 CLASS 1 OR TYPE 3 CLASS 2 *[5]	TYPE 1 CLASS 1 OR 2 PLUS TYPE 2 CLASS 1	TYPE 3 CLASS 1 GRADE A PLUS TYPE 2 CLASS 1 GRADE A
UNPROTECTED CLAD ALUMINUM *[3]	NONE	TYPE 2 CLASS 1 OR TYPE 3 CLASS 2 *[4]		NONE		TYPE 1 CLASS 1 OR 2 OR TYPE 3 CLASS 1	TYPE 2 CLASS 1	TYPE 1 CLASS 1 OR 2	TYPE 1 CLASS 1 GRADE A	TYPE 2 CLASS 1	TYPE 1 CLASS 1 OR 2 PLUS TYPE 2 CLASS 1	TYPE 1 CLASS 1 OR 2
TITANIUM ALLOY	NONE			NONE OR TYPE 3 CLASS 2 GRADE A OR OTHER NON-HALOGEN-CONTAINING CORROSION PREVENTIVE COMPOUND			NONE OR TYPE 3 CLASS 2 GRADE A PLUS TYPE 2 CLASS 2 GRADE A			NONE OR TYPE 2 CLASS 1 OR TYPE 2 CLASS 2 GRADE A		
METAL SURFACES WITH INORGANIC COATING (EXCEPT DECORATIVE) E.G. ANODIZE OR ALODINE	NONE	TYPE 2 CLASS 3	TYPE 2 CLASS 1				DO NOT STORE OUTDOORS			TYPE 2 CLASS 3 GRADE A OR B PLUS TYPE 2 CLASS 1	TYPE 2 CLASS 1	TYPE 1 CLASS 1 PLUS TYPE 2 CLASS 1
DECORATIVE INORGANIC SURFACES	TYPE 2 CLASS 3			TYPE 2 CLASS 1 TYPE 2 CLASS 3			DO NOT STORE OUTDOORS			TYPE 2 CLASS 3 PLUS TYPE 2 CLASS 1		
PAINTED SURFACES	NONE			TYPE 2 CLASS 1			TYPE 2 CLASS 1			TYPE 2 CLASS 3	TYPE 2 CLASS 1	

Temporary Protective Coating Selection Table
Figure 2 (Sheet 2 of 7)

SMALL ASSEMBLIES *[5]	STORAGE AND MANUFACTURE								TRANSPORTATION *[1] *[6]		
	INDOOR HEATED (120°F MAXIMUM)			INDOOR UNHEATED OR COVERED OUTDOOR *[10]			UNCOVERED OUTDOOR *[6]		INDOOR TO OUTDOOR TO INDOOR	WITHIN 75 MILES	75 MILES OR BEYOND
	UP TO 1 WEEK	1 WEEK TO 6 MONTHS	6 MONTHS OR MORE *[2]	UP TO 2 WEEKS	2 WEEKS TO 6 MONTHS	6 MONTHS OR MORE *[2]	UP TO 2 WEEKS	2 WEEKS TO 3 MONTHS	3 MONTHS OR MORE *[2]			
ACRYLIC PLASTIC	TYPE 4 CLASS 2 OR TYPE 1 CLASS 2 GRADE B PLUS TYPE 2 CLASS 3 GRADE B			SAME AS AT LEFT. DO NOT STORE OUTDOORS			DO NOT STORE OUTDOORS			SAME AS STORAGE, PLUS TYPE 2 CLASS 1		
UNPROTECTED METAL SURFACES OF NON-CLAD ALUMINUM OR STEEL *[4]	NONE	TYPE 2 CLASS 1 OR TYPE 3 CLASS 2	TYPE 3 CLASS 1 GRADE A	TYPE 2 CLASS 1 OR TYPE 3 CLASS 2	TYPE 3 CLASS 1		DO NOT STORE OUTDOORS			TYPE 2 CLASS 1 OR TYPE 3 CLASS 2	TYPE 2 CLASS 2 OR TYPE 3 CLASS 2 PLUS TYPE 2 CLASS 1	TYPE 3 CLASS 1 PLUS TYPE 2 CLASS 1
TITANIUM ALLOY ASSEMBLIES	NONE			NONE OR TYPE 3 CLASS 2 GRADE A OR OTHER NON-HALOGEN-CONTAINING CORROSION PREVENTIVE COMPOUND			NONE OR TYPE 3 CLASS 2 GRADE A PLUS TYPE 2 CLASS 2 GRADE A			NONE OR TYPE 2 CLASS 1 OR TYPE 2 CLASS 2 GRADE A		
DECORATIVE ANODIZED SURFACES	TYPE 2 CLASS 3	TYPE 2 CLASS 3 PLUS TYPE 2 CLASS 1		TYPE 2 CLASS 3	TYPE 2 CLASS 3 PLUS TYPE 2 CLASS 1		DO NOT STORE OUTDOORS			TYPE 2 CLASS 3	TYPE 2 CLASS 1	TYPE 2 CLASS 3 PLUS TYPE 2 CLASS 1
GLASS WINDOWS (REF 20-70-01)	TYPE 2 CLASS 2 GRADE A OR TYPE 1 CLASS 2 GRADE B PLUS TYPE 2 CLASS 3 GRADE B			SAME AS AT LEFT DO NOT STORE OUTDOORS			DO NOT STORE OUTDOORS			SAME AS STORAGE, PLUS TYPE 2 CLASS 1		
DECORATIVE INTERIOR SURFACES	TYPE 2 CLASS 3	TYPE 1 CLASS 2 GRADE B	TYPE 2 CLASS 1	DONOT STORE UNHEATED INDOORS, COVERED OUTDOORS OR UNCOVERED OUTDOORS			DONOT STORE UNHEATED INDOORS, COVERED OUTDOORS,			TYPE 1 CLASS 2 GRADE B	TYPE 1 CLASS 2 GRADE B PLUS TYPE 2 CLASS 1	
PLATED SURFACES EXCLUDING PLATED RIVETS	NONE		TYPE 3 CLASS 1 GRADE A	TYPE 2 CLASS 1 TYPE 3 CLASS 2	TYPE 3 CLASS 1		DO NOT STORE OUTDOORS			TYPE 2 CLASS 1		

Temporary Protective Coating Selection Table
Figure 2 (Sheet 3 of 7)

SMALL ASSEMBLIES *[5]	STORAGE AND MANUFACTURE									TRANSPORTATION *[1] *[6]		
	INDOOR HEATED (120°F MAXIMUM)			INDOOR UNHEATED OR COVERED OUTDOOR *[10]			UNCOVERED OUTDOOR *[6]			INDOOR TO OUTDOOR TO INDOOR	WITHIN 75 MILES	75 MILES OR BEYOND
	UP TO 1 WEEK	1 WEEK TO 6 MONTHS	6 MONTHS OR MORE *[2]	UP TO 2 WEEKS	2 WEEKS TO 6 MONTHS	6 MONTHS OR MORE *[2]	UP TO 2 WEEKS	2 WEEKS TO 3 MONTHS	3 MONTHS OR MORE *[2]			
PAINTED SURFACES	NONE			TYPE 2 CLASS 1			DO NOT STORE OUTDOORS			TYPE 2 CLASS 3	TYPE 2 CLASS 1	
ENTIRE SMALL ASSEMBLY	NONE	TYPE 2 CLASS 3	TYPE 2 CLASS 1	TYPE 2 CLASS 1			DO NOT STORE OUTDOORS			NONE	TYPE 2 CLASS 1	
FLAME SPRAYED FIBERGLASS (UNPROTECTED)	NONE					TYPE 1 CLASS 1 GRADE A OR B	DO NOT STORE OUTDOORS			TYPE 2 CLASS 1		TYPE 1 CLASS 1 GRADE A OR B
LARGE ASSEMBLIES												
UNPROTECTED SURFACES OF NON-CLAD ALUMINUM (E.G. WING SKIN) OR STEEL (E.G., TRUCK BEAM)	NONE	TYPE 2 CLASS 1 TYPE 3 CLASS 1 OR 2, OR TYPE 1 CLASS 1 GRADE A *[4]	TYPE 3 CLASS 1 OR TYPE 1 CLASS 1 GRADE 1	TYPE 3 CLASS 1 GRADE A OR TYPE 3 CLASS 2 GRADE A	TYPE 3 CLASS 1 GRADE A PLUS TYPE 2 CLASS 1	TYPE 1 CLASS 1 OR TYPE 2 CLASS 1 OR TYPE 3 CLASS 2	DO NOT STORE OUTDOORS			TYPE 2 CLASS 3 PLUS TYPE 2 CLASS 1, OR TYPE 1 CLASS 1 GRADE A	TYPE 1 CLASS 1 PLUS TYPE 2 CLASS 1	TYPE 3 CLASS 1 OR TYPE 1 CLASS 1 PLUS TYPE 2, CLASS 1 *[11]
UNPROTECTED CLAD ALUMINUM (E.G., BODY SKIN)	NONE	TYPE 1 CLASS 1 OR 2 OR TYPE 2 CLASS 1	TYPE 2 CLASS 1 OR TYPE 3 CLASS 2 OR TYPE 1 CLASS 1 OR 2	TYPE 3 CLASS 1 OR TYPE 1 CLASS 1 OR 2			DO NOT STORE OUTDOORS			TYPE 2 CLASS 3 PLUS TYPE 2 CLASS 1 OR TYPE 1 CLASS 1 OR 2	TYPE 2 CLASS 1 OR TYPE 1 CLASS 1 OR 2	TYPE 3 CLASS 1 OR TYPE 1 CLASS 1 OR 2, TYPE 2 CLASS 1 *[11]

Temporary Protective Coating Selection Table
Figure 2 (Sheet 4 of 7)

LARGE ASSEMBLIES	STORAGE AND MANUFACTURE								TRANSPORTATION *[1] *[6]		
	INDOOR HEATED (120°F MAXIMUM)			INDOOR UNHEATED OR COVERED OUTDOOR *[10]			UNCOVERED OUTDOOR *[6]		INDOOR TO OUTDOOR TO INDOOR	WITHIN 75 MILES	75 MILES OR BEYOND
	UP TO 1 WEEK	1 WEEK TO 6 MONTHS	6 MONTHS OR MORE *[2]	UP TO 2 WEEKS	2 WEEKS TO 6 MONTHS	6 MONTHS OR MORE *[2]	UP TO 2 WEEKS	2 WEEKS TO 3 MONTHS	3 MONTHS OR MORE *[2]			
METAL SURFACES WITH BMS 5-89 INCLUDING AREAS COVERED WITH TAPE	NONE			TYPE 2 CLASS 2			TYPE 2 CLASS 1 GRADE B		DO NOT STORE OUTDOORS	TYPE 2 CLASS 1 GRADE B		
METAL SURFACES WITH SEALANT (E.G., WING PANELS)	NONE			TYPE 2 CLASS 1			TYPE 2 CLASS 1. IF OVER 2 WEEKS, COVER SEALANT WITH TYPE 1 CLASS 3 GRADE A			TYPE 2 CLASS 1		TYPE 1 CLASS 3 GRADE A ON SEALANT PLUS TYPE 2 CLASS 1 GRADE B OVER ALL
METAL SURFACES WITH ORGANIC COATINGS OTHER THAN BMS 5-89 OR SEALANT	NONE			TYPE 2 CLASS 1			TYPE 2 CLASS 1. IF PART SIZES MAKES THIS UNECONOMICAL, RIG PARTS TO PREVENT WATER ENTRAPMENT			TYPE 2 CLASS 1 GRADE B		
UNPROTECTED ALCLAD PERFORATED ACOUSTICAL ALUMINUM	NONE	TYPE 2 CLASS 1 GRADE B					DO NOT STORE OUTDOORS			TYPE 2 CLASS 1 GRADE B OR TYPE 2 CLASS 1 OR 3	TYPE 1 CLASS 1 GRADE B OR TYPE 2 CLASS 1	TYPE 1 CLASS 1 GRADE B PLUS TYPE 2 CLASS 1
PRIMED BUT NOT ENAMELED COMPOSITE HARDWARE DETAIL PARTS AND ASSEMBLIES	NONE			*[8]		TYPE 2 CLASS 1 GRADE B	NOT FOR EXPOSURE UP TO 4 WEEKS. DO NOT STORE OUTDOORS UNCOVERED LONGER THAN 4 WEEKS. *[7]			NONE		DO NOT TRANSPORT UNCOVERED *[7]
VEHICLE SECTIONS	NONE	TYPE 1 CLASS 1 OR 2	NONE	TYPE 1 CLASS 1 OR TYPE 1 CLASS 2 GRADE A		TYPE 1 CLASS 1 OR 2 GRADE A	TYPE 1 CLASS 1 OR 2 GRADE A	TYPE 1 CLASS 1 OR TYPE 1 CLASS 1	TYPE 1 CLASS 1 OVER ENDS TO AVOID ENTRY OF WATER	TYPE 1 CLASS 1		TYPE 1 CLASS 1 OR 2 GRADE A

Temporary Protective Coating Selection Table
Figure 2 (Sheet 5 of 7)

LARGE DETAIL PARTS	STORAGE AND MANUFACTURE									TRANSPORTATION *[1] *[6]		
	INDOOR HEATED (120°F MAXIMUM)			INDOOR UNHEATED OR COVERED OUTDOOR *[10]			UNCOVERED OUTDOOR *[6]			INDOOR TO OUTDOOR TO INDOOR	WITHIN 75 MILES	75 MILES OR BEYOND
	UP TO 1 WEEK	1 WEEK TO 6 MONTHS	6 MONTHS OR MORE *[2]	UP TO 2 WEEKS	2 WEEKS TO 6 MONTHS	6 MONTHS OR MORE *[2]	UP TO 2 WEEKS	2 WEEKS TO 3 MONTHS	3 MONTHS OR MORE *[2]			
METAL SURFACES WITH INORGANIC COATINGS (NON-DECORATIVE) E.G. ANODIZE OR ALODINE	NONE	TYPE 2 CLASS 3		TYPE 2 CLASS 1		TYPE 1 CLASS 2 GRADE A *[9]	TYPE 2 CLASS 2 GRADE A *[9]			TYPE 2 CLASS 1		TYPE 1 CLASS 1 PLUS TYPE 2 CLASS 1
METAL SURFACES WITH DECORATIVE INORGANIC COATINGS E.G. COLORED ANODIZE	TYPE 2 CLASS 3 GRADE A PLUS TYPE 2 CLASS 1			TYPE 2 CLASS 3 GRADE A PLUS TYPE 2 CLASS 1			DO NOT STORE OUTDOORS			TYPE 2 CLASS 3 GRADE A PLUS TYPE 2 CLASS 1		
METAL SURFACES WITH ORGANIC COATINGS (E.G. PRIMERS OR PAINTS) EXCEPT BMS 5-89	NONE			TYPE 2 CLASS 1			TYPE 2 CLASS 1. IF PART SIZE MAKES THIS UNECONOMICAL, RIG TO PREVENT WATER ENTRAPMENT			TYPE 2 CLASS 1		
METAL SURFACES WITH BMS 5-89 INCLUDING AREAS COVERED WITH TAPE	NONE			TYPE 2 CLASS 1			TYPE 2 CLASS 1 GRADE B		DO NOT STORE OUTDOORS	TYPE 2 CLASS 1 GRADE B		
UNPROTECTED METAL SURFACES OF NONCLAD ALUMINUM STEEL OR MAGNESIUM	NONE	TYPE 2 CLASS 1 OR TYPE 3 CLASS 2	TYPE 3 CLASS 1	TYPE 3 CLASS 1 OR TYPE 3 CLASS 2	TYPE 3 CLASS 1		TYPE 1 CLASS 2 GRADE B OR TYPE 3 CLASS 1			TYPE 2 CLASS 1 OR TYPE 3 CLASS 2		TYPE 3 CLASS 1 PLUS TYPE 2 CLASS 1

Temporary Protective Coating Selection Table
Figure 2 (Sheet 6 of 7)

*[1] Transportation means continuous movement, loading and unloading. Delays over 48 hours long are considered storage.

*[2] Removal of coating at 1-year intervals for complete examination is necessary. Reapply coating or use material as necessary.

*[3] For protection against abrasion use Type 1 or Type 2 Class 1. If stored indoors more than six months, use type 2.

*[4] For durations longer than one week, examine Type 3 Class 2 coating and substrate. Reapply or touch up coating as needed.

*[5] A small assembly is one that can be carried by one person.

*[6] Durations of uncovered outdoor exposures and transportation exposures to outdoor environments are additive (cumulative).

*[7] Primed composite hardware shall be protected by waterproof covers plus Type 2 Class 1 Grade B or the original wooden shipping boxes. When shipping containers have been opened or damaged, cover container with Type 2 Class 1 Grade A.

*[8] No protection required for indoor unheated storage. For covered outdoor storage, protect parts and assemblies from direct sunlight. If necessary, cover with Type 2 Class 1 Grade B.

*[9] Remove coating at six month intervals for examination of substrate. Reapply to continue storage.

*[10] Indoor unheated and covered outdoor storage must prevent exposure of surfaces to sunlight and rain.

*[11] Intercontinental surface transportation requires waterproof protection. Use Type 1, Class 1, Grade B, and Type 2, Class 1, Grade A.

*[12] Raw aluminum stock (bare and clad) shipped overseas must be protected against moisture. Use Type 3, Class 1 or 2, Grade B, and Type 2, Class 1 or 2, Grade A.

Temporary Protective Coating Selection Table
Figure 2 (Sheet 7 of 7)

4. APPLICATION

A. Type 1

(1) Make sure the surfaces to be protected are clean.

(2) Apply by dip, brush, spray methods, as appropriate. See Figure 3 for film thickness and cure recommendations.

(3) When you use peelable materials, cover all openings to prevent coating removal by wind.

B. Types 2, 3, 4

(1) Make sure the surfaces of the part or assembly are clean and painted, primed, plated, or otherwise protected against corrosion.

(2) Wrap the part or assembly in the applicable covering.

(3) Tape the covering securely, with masking tape or equivalent. Do not apply the tape to the surface of the part or assembly.

(4) Attach Type 2 materials to prevent abrasion of underlying substrate or coatings. Tie or otherwise attach the edges of the covering so it will not billow or become unfastened in the wind. Attach the covering to prevent the entry of animal life or unwanted matter. Allow for air circulation.

COATING TYPE AND GRADE	THINNER	AVERAGE DRYING TIME AT 72° F *[1]				RECOMMENDED ACCELERATION CURE	RECOMMENDED DRY FILM THICKNESS (MILS) (1 MIL = 0.001 INCH)		
		DUST FREE	TO APPLY 2ND COAT	TO HANDLE	FOR MAXIMUM HARDNESS (HOURS)		FOR RIVETING *[7]	FOR USAGE AS NOTED	FOR OUTDOOR EXPOSURE *[2] *[6]
		MINUTES							
CLASS 1 GRADE A									
LEEDER 103T LEEDER 117T TEC 734-10 TEC 734-10-12	MEK OR MIBK 10 PERCENT BY VOLUME MAXIMUM	10	2	20-30	12	---	1.5-3.0	GENERAL 3-5 FLAME SPRAY 5-8	3-5
LEEDER 300T TEC 556-P TEC 556-6625F	NONE	10	10	50	24	4 HR. AT 140-160°F	1.5-3.0	GENERAL 1.5-3 CHEMICAL 2 MIN.	1.5-3
LEEDER 314N LEEDER 315T TEC 556-10 TEC 558K	NONE	10	10	50	24	4 HR. AT 140-160°F	1.5-3.0	GENERAL 1.5-3	1.5-3
TURCO 5228C	NONE	10	2	20-30	12	---	---	3-5	3-5
LEEDER 304N TEC 243-4F	NONE	30	2	30	30	10-15 MIN. AT 120-140°F	1-3 (PREF: 1-1.5)	1-3 (PREF: 1-1.5)	1-3 (PREF: 1-1.5)
LEEDER 305N TEC 243-4F7	NONE	20	2	20	10	30 MIN. AT 120-140°F	1-3 (PREF: 1-1.5)	1-3 (PREF: 1-1.5)	1-3 (PREF: 1-1.5)
LEEDER 306N TEC 243-4F7G	NONE	--	20	20	6*[10]	*[9]	1-2	1-2	1-2 *[18]
AZTEC 534-2	NONE	15	IMMEDIATELY	30	3/4	NONE	NR	GENERAL 3-5	NR
DESOTO SKINGARD	NONE	60	--	240 (4HRS)	168 (7 DAYS)	*[18]	NR	2.0-2.5	NR
LEEDER 312N	NONE	--	20	20	6	*[15]	0.8-1.5	0.8-1.5	0.8-1.5 *[16]

Type 1 Coating Application and Cure
Figure 3 (Sheet 1 of 7)

COATING TYPE AND GRADE	THINNER	AVERAGE DRYING TIME AT 72° F *[1] MINUTES				RECOMMENDED ACCELERATION CURE	RECOMMENDED DRY FILM THICKNESS (MILS) (1 MIL = 0.001 INCH)		
		DUST FREE	TO APPLY 2ND COAT	TO HANDLE	FOR MAXIMUM HARDNESS (HOURS)		FOR RIVETING *[7]	FOR USAGE AS NOTED	FOR OUTDOOR EXPOSURE *[2] *[6]
DAP 10066	NONE	--	--	20	6*[10]	*[10]	0.8-1.5	0.8-1.5	0.8-1.5 *[14]
AZTEC 643GC	NONE	--	--	20	6	*[10]	0.8-1.5	0.8-1.5	0.8-1.5 *[8]
AZTEC 643GCS	NONE	--	--	--	2	--	--	1 MIN.	1 MIN.
AZTEC 643GFC	NONE	--	--	20	6	*[10]	0.8-1.5	0.8-1.5	NR
CLASS 1 GRADE B									
LEEDER 313N TEC 660-2W	NONE	30	30	120	12	--	NR	GENERAL 5-10	5-10
TEC 734-10CW	NONE	10	2	20-30	12	--	NR	GENERAL 3-5 FLAME SPRAY 3-5	3-5
CLASS 2 GRADE A									
BMS 10-52 CLASS 1	*[4]	30	2	60	48	--	1.5-3.0	GENERAL 2.5-4	3 MIN.
FULLER 175-K-23	NONE	30	2	60	48	--	1.5-3.0	GENERAL 2.5-4	3 MIN.
TR 5157-1	WATER	30	2	30-60	24-48	10 MIN. AT 100°F	1.0-1.5	GENERAL 1-3 *[5]	1-3 *[5]
CLASS 2 GRADE B									
SC 1071	WATER	30	30	60	8	--	NR	GENERAL 3-5	1-3

Type 1 Coating Application and Cure
Figure 3 (Sheet 2 of 7)

COATING TYPE AND GRADE	THINNER	AVERAGE DRYING TIME AT 72° F *[1] MINUTES				RECOMMENDED ACCELERATION CURE	RECOMMENDED DRY FILM THICKNESS (MILS) (1 MIL = 0.001 INCH)		
		DUST FREE	TO APPLY 2ND COAT	TO HANDLE	FOR MAXIMUM HARDNESS (HOURS)		FOR RIVETING *[7]	FOR USAGE AS NOTED	FOR OUTDOOR EXPOSURE *[2] *[6]
DAP 10010	WATER	60	60	240	16	--	NR	6 MIN.	NR
PRO-SEAL	NONE	--	--	60	8	--	NR	GENERAL 5-7	NR
CLASS 3 GRADE A-5514									
DAP 5020, ORG. 1-2050	NONE	30-45	15	1000 (16.7 HR)	24	3 HR AT 140-160°F	NR	PREBOND: 4 MIN. (DAP) 8 MIN. (ORG)	NR
DAP 1001	NONE	15	15	15	48	3 HR AT 140-160°F	NR	6.5 MIN.	NR
TURCO 522	XYLENE OR TOLUENE	30-45	*[3]	240 (4 HR)	24	—	NR	6 MIN.	NR
CLASS 3 GRADE A-5555									
DAP 5040	NONE	30-45	—	1000 (16.7 HR)	24	3 HR AT 140-160°	NR	PREBOND 7 MIN.	NR
ADCOAT 820B, NF OR F	TORLUENE	30-45	3	1000 (16.7 HR)	24	3 HR AT 140-160°	NR	PREBOND 8 MIN.	NR
ADCOAT 819R	PERCHLORO-ETHYLENE/ TOLUENE 1:1	30-45	3	1000 (16.7 HR)	24	3 HR AT 140-160°	NR	PREBOND 8 MIN.	NR
ADCOAT 850	NONE	90	30	240 (4HR)	24	3 HR AT 140-160°	NR	PREBOND FORMING 6 MIN. CHEM MILL 8 MIN.	NR

Type 1 Coating Application and Cure
Figure 3 (Sheet 3 of 7)

COATING TYPE AND GRADE	THINNER	AVERAGE DRYING TIME AT 72° F *[1]				RECOMMENDED ACCELERATION CURE	RECOMMENDED DRY FILM THICKNESS (MILS) (1 MIL = 0.001 INCH)		
		DUST FREE	TO APPLY 2ND COAT	TO HANDLE	FOR MAXIMUM HARDNESS (HOURS)		FOR RIVETING *[7]	FOR USAGE AS NOTED	FOR OUTDOOR EXPOSURE *[2] *[6]
		MINUTES							
ADCOAT 819R-LA	PERCHLORO-ETHYLENE/ TOLUENE 1:1	—	30-45	1000 (16.7 HR)	24	3 HR AT 140-160°F	NR	2 MIN.	NR
DESOTO SKINGARD	NONE	60	--	240 (4 HRS)	168 (7 DAYS)	*[18]	NR	2.0-2.5	NR
TURCO 5580G	TURCO 5580-66	—	--	240 AT 60°F (4 HRS) AFTER TACK-FREE	—	AFTER TACK-FREE, 30 MIN. AT 175-225°F	NR	5-8	NR
CLASS 3 GRADE B									
TURCO 522, 567, OR ORG 1-2020	XYLENE OR TOULENE	30-45	*[3]	240 (4 HRS)	24	—	NR	CHEM MILL 7 MIN.	NR
DAP 1001	NONE	15	15	15	48	3 HR. AT 140-160°F	NR	6.5 MIN	NR
DAPCOAT 10220	WATER	120-180	120-180	360	48	*[19]	NR	CHEM MILL, PLATING 12 MIN.	NR
MASK NO. 2, TURCO 5696	NONE	1	--	1	1	NONE	NR	PLATING 10 APPROX.	NR
BOSTIK 376-49	TURCO THINNER NO. 4 UP TO 25 PERCENT BY VOLUME	30-45	--	240 (4 HRS)	24	1/2 HR. AT 175-225°F	NR	PLATING 5-8	NR
ADCOAT 828, SC 284X	TOLUENE	30-45	*[3]	240 (4 HRS)	24	1/2-2 HR. UP TO 225°F	NR	CHEM MILL 7 MIN.	NR
ADCOAT 850	TOLUENE	15-20	10	120	24	*[11]	NR	CHEM MILL 8 MIN.	NR

Type 1 Coating Application and Cure
Figure 3 (Sheet 4 of 7)

COATING TYPE AND GRADE	THINNER	AVERAGE DRYING TIME AT 72° F *[1]				RECOMMENDED ACCELERATION CURE	RECOMMENDED DRY FILM THICKNESS (MILS) (1 MIL = 0.001 INCH)		
		DUST FREE	TO APPLY 2ND COAT	TO HANDLE	FOR MAXIMUM HARDNESS (HOURS)		FOR RIVETING *[7]	FOR USAGE AS NOTED	FOR OUTDOOR EXPOSURE *[2] *[6]
		MINUTES							
ADCOAT 850	PERCHLORO-ETHYLENE	15-20	10	120	24	*[12]	NR	CHEM MILL 8 MIN.	NR
PEELCOAT B-100	NONE	1	--	1	1	NONE	NR	PLATING 10 APPROX	NR
CLASS 3 GRADE C									
ADCOAT 850	TOLUENE	15-20	10	120	24	*[11]	NR	ANODIZING 4-9	NR
ADCOAT 850	PERCHLORO-ETHYLENE	15-20	10	120	24	*[12]	NR	ANODIZING 4-9	NR
ADCOAT 850 TOLUENE DIP DAP 1200-AB TURCO TFM-522 TURCO 5696	TOLUENE OR ETHYLENE	—	20	60	8	1/2 HR. AT 175-225°F	NR	*[13]	NR
DAPCOAT 10220	WATER	120-180	120-180	360	48	*[19]	NR	CHROMIC ACID ANODIZE 10 MIN.	NR
CLASS 3 GRADE D									
DAPCOAT 10220	WATER	120-180	120-180	360	48	*[19]	NR	SULFURIC ACID ANODIZE 10 MIN.	NR

Type 1 Coating Application and Cure
Figure 3 (Sheet 5 of 7)

NR Not recommended.

*[1] Drying times are average for lowest film thickness recommendations. Lower temperature and heavier film thicknesses will require longer times.

*[2] See Fig. 2 for outdoor exposure limitations and recommendations. Runs and sags are allowed in coatings used for storage protection.

*[3] Twenty minutes at 80°F or above between first and second coats. 30-45 minutes between each succeeding coat.

*[4] Fuller 75-C-1 thinner, or MEK (1/4 part by volume maximum) or MIBK (1/4 part by volume maximum) with cyclohexanone (3.66 fluid ounces per gallon maximum).

*[5] When necessary, overcoating and overspray of one alkaline removable coating with another is allowed.

*[6] Apply coating to bared areas. Additional coating over entire assembly is not required for shipment.

*[7] Apply by spraying (air or airless) to achieve a uniform dry film thickness. The applied coating shall be smooth, transparent, and continuous.

*[8] For outdoor exposure, cure per *[10] followed by 24 hours minimum at 72°F before exposing to outdoor environment.

*[9] Before stacking, cure in accordance with one of these three methods:

(1) 4 hours minimum at 72°F
(2) 15 minutes minimum at 72°F followed by 30 minutes minimum at 90-110°F
(3) 15 minutes minimum at 72°F followed by 15 minutes minimum at 140-150°F

(After oven cure, allow part to reach 72°F before stacking.)

*[10] Before stacking, cure in accordance with one of these two methods:

(1) 6 hours minimum at 72°F
(2) 30 minutes minimum at 72°F followed by 20 minutes minimum at 115-125°F and 20 minutes minimum at 72°F

*[11] Recommended Accelerated Cure:

(1) 10 minutes minimum at 72°F followed by 20 minutes minimum at 115-125°F
(2) 20 minutes minimum at 72°F followed by 10 minutes minimum at 135-145°F
(3) 25 minutes minimum at 72°F followed by 10 minutes minimum at 115-165°F

Type 1 Coating Application and Cure
Figure 3 (Sheet 6 of 7)

WARNING: TOLUENE IS TOXIC AND FLAMMABLE. AVOID BREATHING OF VAPORS AND PROLONGED OR REPEATED SKIN CONTACT. KEEP AWAY FROM HEAT AND OPEN FLAME.

*[12] Recommended Acclerated Cure

(1) 10 minutes minimum at 72°F followed by 20 minutes minimum at 115-125°F
(2) 20 minutes minimum at 72°F followed by 10 minutes minimum at 135-145°F
(3) 25 minutes minimum at 72°F followed by 5 minutes minimum at 155-156°F

WARNING: PERCHLOROETHYLENE IS TOXIC. AVOID BREATHING OF VAPORS AND PROLONGED OR REPEATED SKIN CONTACT.

*[13] Recommended dry film thickness:

(1) Applied by airless spray: 7-12 mils
(2) Applied by dip or flow coat: 9-14 mils

*[14] For outdoor exposure, cure per *[10] followed by 4 days minimum at room temperature before exposing to outdoor environment.

*[15] 30 minutes at 72°F, followed by 20 minutes at 120-150°F, followed by 20 minutes at 72°F

*[16] After the cure, allow 48 hours more time at 72°F before outdoor exposure. (24 hours, for Leeder 306N or Tec 243-4F7G)

*[17] 4 hours minimum after tack free

*[18] 1 hour at 72°F, followed by 1 hour at 200°F or 30 minutes at 240°F

*[19] 14-24 hours at 72°F, followed by 2 hours at 150-160°F or (for Grade B only) 1 hour at 250°F

Type 1 Coating Application and Cure
Figure 3 (Sheet 7 of 7)

5. REMOVAL

A. Alkaline-Removable Coatings (Type 1)

(1) Before applying remover, protect interfaces between lift fittings or similar fixtures and part surfaces from entry of remover solution and rinse water. Entrapment of these fluids may corrode metal surfaces.

(2) Apply remover approximately 0.020 inch thick.

(3) Allow to soak in at least 10 minutes, but do not allow remover to dry. Do not allow remover to contact high strength steels (180 ksi or above). Do not allow remover to contact acrylic plastics longer than 60 minutes.

(4) Pressure wash with water up to 140°F.

(5) If residues remain, repeat application of remover or wipe surfaces with solvent.

B. Peelable Coatings (Type 1)

(1) Break film and peel manually, removing coating in a manner to prevent damage to substrates.

(2) Check surface carefully for residue or particles. Clean as necessary.

C. Hard Films (Type 3, Class 1, Grade A)

(1) Remove compound by soaking in or scrubbing with solvent, and vapor degreasing per 20-30-03.

D. Soft Films, Oils and Greases (Type 3, Class 1, Grade B and Type 3, Class 2)

(1) Solvent clean or vapor degrease per SOPM 20-30-03 or wipe clean.