

TEMPORARY PROTECTIVE COATINGS

PART NUMBER NONE

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

Attached is the current revision to this STANDARD OVERHAUL PRACTICES MANUAL

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STANDARD OVERHAUL PRACTICES MANUAL

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A = Added, R = Revised, D = Deleted, O = Overflow

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All revisions to this manual will be accompanied by transmittal sheet bearing the revision number. Enter the revision number in numerical order, together with the revision date, the date filed and the initials of the person filing.

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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- A. The data in this subject comes from Boeing Process Specification BAC5034 which superseded BAC5835.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



TEMPOR	ARY PROTECTIVE COATING	CLASSIFICATION	RECOMMENDED MATERIALS
1-71	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 300T, V17209 Leeder 305N, V17209 Leeder 305N, V17209 Leeder 305N, V17209 Leeder 314N, V17209 Leeder 315T, V17209 Leeder 315T, V17209 Leeder 321-N transparent, alkaline removable, V17209 Scotch 471, V76381 Scotch 472, V76381 Tec 243-4F7, V25227 Tec 243-4F7G, 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)



TEMPOR F	ARY PROTECTIVE COATING (RECOMMENDED MATERIALS	
Removable	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)



TEMPOR	ARY PROTECTIVE COAT	ING CLASSIFICATION	RECOMMENDED MATERIALS
Type 1: Protec- tive 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)

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TEMPORA	ARY PROTECTIVE COATING	RECOMMENDED MATERIALS	
Type 2: Non- adherent Films and Sheet Coverings		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 Grade C: Waterproof, Light Stable, Fire Resistant	Polyethylene sheet, carbon-filled, 0.006 inch minimum thickness Polyethylene sheet, purple, self-extinguishing per ASTM D568, V61177
	Class 2: Indoor/Limited Outdoor	Grade A: Water Resistant Grade B: Water Resistant, Vapor Phase Inhibitor	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 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)

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TEMPORA	ARY PROTECTIVE COATING	CLASSIFICATION	RECOMMENDED MATERIALS
Type 3: Preserva- tives	1	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)

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TEMPOR	ARY 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 855, V76381

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



TEMPORA	ARY PROTECTIVE COATING	G CLASSIFICATION	RECOMMENDED MATERIALS
Type 4: Pressure- Sensitive Adhesive	Class 3: Manufacturing Aid	Riveting	Arlon 180, V29246 Scotch 685, V76381 ST 440, V4P100
Tapes		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 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)



TEMPORA	ARY PROTECTIVE	COATING	CLASSIFICATION	RECOMMENDED MATERIALS
	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



•	T CCUNT	R HEATED		STORAGE	GE AND MANUFAC	STORAGE AND MANUFACTURE	1 1	INCOVERED OUTDOOR	L91* NO	TRAN	TRANSPORTATION	ON *E13 *E63
•	1120°F	MAXIM	UM)	ŭ	ED OUTDOO	OUTDOOR *E103	ONCOVER		OK % L01		WILES	OR BEYOND
	s N S	EK ITHS	6 MONTHS OR MORE *[2]	LESS THAN 2 WEEKS	2 WEEKS TO 6 MONTHS		LESS THAN 2 WEEKS	2 WEEKS TO 3 MONTHS	3 MONTHS OR MORE *[2]	TO INDOOR		
NON-CLAD ALUMINUM, STEEL OR MAGNESIUM	NONE TYPE	м				TYPE 3 CLASS 1	DO NOT STORE OU (EXCEPT UNMACHI STEEL FORGINGS)	DO NOT STORE OUTDOORS (EXCEPT UNMACHINED RAW STEEL FORGINGS)	DOORS ED RAW	TYPE 1 0 PLUS TYPE 2 0 0R TYPE 3 0 *C4]	CLASS 1 CLASS 1 CLASS 1	TYPE 1 CLASS PLUS TYPE 2 CLASS OR TYPE 3 CLASS GRADE A PLUS TYPE 2 CLASS
	NONE			NONE OR TYPE CLASS 2 GRADE OTHER NON-HAL CONTAINING CC PREVENTIVE CC	NONE OR TYPE 3 CLASS 2 GRADE A OR OTHER NON-HALOGEN- CONTAINING CORROSION PREVENTIVE COMPOUND	or EN – SS I ON DUND	NONE OR TYPE 3 CLASS 2 GRADE A PLUS TYPE 2 CLA: GRADE A	NONE OR TYPE 3 CLASS 2 GRADE A PLUS TYPE 2 CLASS GRADE A	·	NONE, OF	OR TYPE 2 CLASS 2 CLASS A	CLASS 1, OR
CLAD ALLUMINUM *E31	NONE					TYPE 1 CLASS 1 OR 2, OR TYPE 2 CLASS 2 OR TYPE 3	TYPE 2 CLASS 1	TYPE 1 CLASS 1 OR 2	TYPE 1 CLASS 1	TYPE 2	TYPE 2 CLASS 1 *[12]	[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 S	STORE OUTDOORS	ooors	TYPE 2 (2 CLASS 1 OI	1 OR TYPE 3 CLASS
	TYPE 4 CLASS TYPE 2 CLASS	3.2	PLUS GRADE A	TYPE 4 CTYPE 2 DO NOT 3	CLASS 2 PLUS CLASS 3 GRADE I STORE OUTDOORS	2 PLUS 3 GRADE B OUTDOORS	DO NOT S.	STORE OUTDOORS	ooors	TYPE 4 CLASS 3 CLASS 2	+ CLASS 2 PI 3 GRADE B I 2 GRADE A	2 PLUS TYPE 2 B PLUS TYPE 2 A

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

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[1] *[6]	75 MILES OR BEYOND		TYPE 3 CLASS 1 GRADE A PLUS TYPE 2 CLASS 1 GRADE A	TYPE 1 CLASS 1 OR 2	A 0 R	TYPE 1 CLASS 1 PLUS TYPE 2 CLASS 1	TYPE 2	ASS 1
TRANSPORTATION *E13 *E63	WITHIN 75 MILES		CLASS 1 TYPE 3 CLASS 2 GRADE , PLUS TYPE 2 CLASS GRADE ,	TYPE 1 CLASS 1 OR 2 PLUS TYPE 2 CLASS 1	OR TYPE 2 CLASS 2 CLASS 2 GRADE	TYPE 2 CLASS 1	CLASS 3 PLUS.	TYPE 2 CLASS
TRANS	INDOOR TO TO	INDOOR	TYPE 2 CL OR TYPE 3 CL *[5]	TYPE 2 CLASS 1	NONE OR T	TYPE 2 CLASS 3 GRADE A OR B PLUS TYPE 2 CLASS 1	TYPE 2 CL CLASS 1	TYPE 2 CLASS 3
	UNCOVERED OUTDOOR *[6]	2 WEEKS 3 MONTHS TO OR MORE 3 MONTHS *E21	STORE OUTDOORS	TYPE 1 TYPE 1 CLASS 1 CLASS 1 OR 2 GRADE A	NONE OR TYPE 3 CLASS 2 GRADE A PLUS TYPE 2 CLASS 2 GRADE A	DO NOT STORE OUTDOORS	STORE OUTDOORS	LASS 1
 	UNCOVER	LESS THAN 2 WEEKS	DO NOT	CLASS 1	OR EN- SS I ON DUND	DO NOT	S TON OO	TYPE 2 CLASS
AND MANUFACTURE	UNHEATED OR OUTDOOR *E101	-	TYPE 1 1 OR TYPE 3 CLASS 1	TYPE 1 CLASS 1 OR 2 OR TYPE 3 CLASS 1	NONE OR TYPE 3 CLASS 2 GRADE A OR OTHER NON-HALOGEN- CONTAINING CORROSION PREVENTIVE COMPOUND		_ 8	
STORAGE AND	INDOOR UNHI COVERED OUTD	LESS 2 WEEKS THAN TO 2 WEEKS 6 MONTHS	TYPE 2 TYPE 3 CLASS 1 CLASS 1 TYPE 3 OR 2 CLASS 2 *[5] *[5]	NONE	NONE CLASS OTHER CONTA PREVE	58.1	TYPE 2 CLASS 1 TYPE 2 CLASS 3	TYPE 2 CLASS ?
	HEATED MAXIMUM)	6 MONTHS OR MORE *E23	TYPE 3 TI CLASS 1 CI OR 2 TI *[5]	TYPE 2 N CLASS 1 OR TYPE 3 CLASS 2 *E43		TYPE 2 CLASS		<u> </u>
	INDOOR HEATED (120°F MAXIMUM	1 WEEK TO 6 MONTHS	TYPE 2 CLASS 1 0R TYPE 3 CLASS 2 *E51			TYPE 2 CLASS 3	CLASS 3	
	[] (1]	LESS THAN 1 WEEK	NONE	NOO NE	NOONE	NON	TYPE 2	NONE
	SMALL DETAIL PARTS		UNPROTECTED METAL SURFACES OF NON-CLAD ALUMINUM, STEEL OR MAGNESIUM	UNPROTECTED CLAD ALUMINUM *E3]	TITANIUM ALLOY	METAL SURFACES WITH INORGANIC COATING (EXCEPT DECORATIVE) E.G. ANODIZE OR ALODINE	DECORATIVE INORGANIC SURFACES	PAINTED SURFACES

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

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*[6]	75 MILES OR BEYOND		YPE 2	TYPE 3 CLASS 1 PLUS TYPE 2 CLASS 1	OR	TYPE 2 CLASS 3 PLUS TYPE 2 CLASS 1	TYPE 2	2 TYPE 2	
TRANSPORTATION *E13	WITHIN 7		STORAGE, PLUS TYPE	TYPE 2 TY CLASS 2 CI OR PI TYPE 3 TY CLASS 2 CI PLUS TYPE 2 CLASS 1	OR TYPE 2 CLASS 1 2 CLASS 2 GRADE A	TYPE 2 TY CLASS 1 CL PL TY	STORAGE, PLUS T'	TYPE 1 CLASS GRADE B PLUS CLASS 1	s 1
TRANSPO	INDOOR TO TO	TO TO INDOOR	SAME AS STC CLASS 1	TYPE 2 CLASS 1 OR TYPE 3 CLASS 2	NONE OR TYP TYPE 2 CLAS	TYPE 2 CLASS 3	SAME AS STC CLASS 1	TYPE 1 CLASS 2 GRADE B	TYPE 2 CLASS
	UNCOVERED OUTDOOR *E63	UP TO 2 WEEKS 3 MONTHS 2 WEEKS TO OR MORE 3 MONTHS *[2]	DO NOT STORE OUTDOORS	DO NOT STORE OUTDOORS	LDE A NONE OR TYPE 3 LINING CLASS 2 GRADE A NUND PLUS TYPE 2 CLASS 2 GRADE A	DO NOT STORE OUTDOORS	DO NOT STORE OUTDOORS	STORE UNHEATED INDOORS, COVERED OUTDOORS, COVERED OUTDOORS	DO NOT STORE OUTDOORS
STORAGE AND MANUFACTURE	INDOOR UNHEATED OR COVERED OUTDOOR *E101	UP TO 2 WEEKS 6 MONTHS 2 WEEKS TO OR MORE 6 MONTHS *C21	SAME AS AT LEFT. DO NOT STORE OUTDOORS	TYPE 2 TYPE 3 CLASS 1 IC CLASS 1 CLASS 1 CLASS 1 CLASS 2 CLASS 2	NONE OR TYPE 3 CLASS 2 GRADE A OR OTHER NON-HALOGEN-CONTAINING CORROSION PREVENTIVE COMPOUND	TYPE 2 CLASS 3 TYPE 2 CLASS 3 CLASS 3 PLUS TYPE 2 CLASS 3 CLASS 1	SAME AS AT LEFT DO NOT STORE OUTDOORS	DONOT STORE UNHEATED INDOO OR UNCOVERED OUTDOORS	CLASS 1 CLASS 1 TYPE 3 CLASS 2 CLASS 2
	HEATED IAXIMUM)	K 6 MONTHS OR MORE HS *[2]	2 OR 2 GRADE B CLASS 3	TYPE 3 CLASS 1 GRADE A		TYPE 2 CLASS 3 PLUS TYPE 2 CLASS 1		1 TYPE 2 2 CLASS 1 B	TYPE 3 CLASS 1 GRADE A
	INDOOR HEATED (120°F MAXIMUM)	UP TO 1 WEEK 1 WEEK 6 MONTHS	TYPE 4 CLASS 2 TYPE 1 CLASS 2 PLUS TYPE 2 CL GRADE B	NONE TYPE 2 CLASS 1 OR TYPE 3 CLASS 2	NONE	TYPE 2 CLASS 3	TYPE 2 CLASS 2 GRADE A OR TYPE 1 CLASS 2 GRADE PLUS TYPE 2 CLASS 3 GRADE B	TYPE 2 TYPE 1 CLASS 3 CLASS GRADE	NONE
	SMALL ASSEMBLIES	*C 5]	ACRYLIC PLASTIC	UNPROTECTED METAL SURFACES OF NON-CLAD ALUMINUM OR STEEL *[4]	TITANIUM ALLOY ASSEMBLIES	DECORATIVE ANODIZED SURFACES	GLASS WINDOWS (REF 20-70-01)	DECORATIVE INTERIOR SURFACES	PLATED SURFACES EXCLUDING PLATED RIVETS

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

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	OND						~	-
113 *[6]	75 MILES OR BEYOND		CLASS 1	488 1	TYPE 1 CLASS 1 GRADE A OR B		TYPE 3 CLASS 1 OR TYPE CLASS 1 PLUS TYPE 2, CLASS 1	TYPE 3 CLASS 1 OR TYPE CLASS 1 OR 2, TYPE 2 CLASS 1
TRANSPORTATION *E11 *E61	WITHIN 75 MILES		TYPE 2 CL/	TYPE 2 CLASS	ASS 1		TYPE 1 CLASS 1 PLUS TYPE 2 CLASS 1	TYPE 2 CLASS 1 OR TYPE 1 CLASS 1 OR 2
TRANS	INDOOR		TYPE 2 CLASS 3	NONE	TYPE 2 CLASS 1		TYPE 2 CLASS 3 PLUS TYPE 2 CLASS 1, OR TYPE 1 CLASS 1	TYPE 2 CLASS 3 PLUS TYPE 2 CLASS 1 CLASS 1
	UNCOVERED OUTDOOR *E6J	2 WEEKS 3 MONTHS TO OR MORE 3 MONTHS *E21	STORE OUTDOORS	STORE OUTDOORS	DO NOT STORE OUTDOORS		DO NOT STORE OUTDOORS	DO NOT STORE OUTDOORS
	COVERED C	UP TO 2 WE 2 WE 3 MO		DO NOT STORE	NOT STORE		NOT STORE	NOT STORE
SE SE	Ν		DO NOT	00	00		04	00
AND MANUFACTURE	red or R *E103	6 MONTHS OR MORE *E23			TYPE 1 CLASS 1 GRADE A OR B		TYPE 1 CLASS 1 OR TYPE 2 CLASS 1 OR TYPE 3 CLASS 2	
	INDOOR UNHEATED OR COVERED OUTDOOR *[10]	2 WEEKS TO 6 MONTHS	2 CLASS 1	LASS 1			TYPE 3 CLASS 1 GRADE A PLUS TYPE 2 CLASS 1	TYPE 3 CLASS 1 OR TYPE 1 CLASS 1 OR 2
STORAGE	INDO COVERE	UP TO 2 WEEKS	TYPE 2 (TYPE 2 CLASS 1			TYPE 3 CLASS 1 GRADE A OR TYPE 3 CLASS 2 GRADE A	TYPE 2 CLASS 1 0R TYPE 3 CLASS 2 0R TYPE 1 CLASS 1
	TED MUM)	6 MONTHS OR MORE *[2]		TYPE 2 CLASS 1			TYPE 3 CLASS 1 OR TYPE 1 CLASS 1 GRADE 1	TYPE 1 CLASS 1 OR 2 OR TYPE 2 CLASS 1
	INDOOR HEATED (120°F MAXIMUM)	1 WEEK TO 6 MONTHS		TYPE 2 CLASS 3			TYPE 2 CLASS 1 TYPE 3 CLASS 1 OR 2, OR 2, OR 2, CLASS 1 GRADE A	
	IP (12	UP TO 1 WEEK	NONE	NONE	NONE		NON	NONE
	SMALL ASSEMBLIES *E53		PAINTED SURFACES	ENTIRE SMALL ASSEMBLY	FLAME SPRAYED FIBERGLASS (UNPROTECTED)	LARGE ASSEMBLIES	UNPROTECTED SURFACES OF NON-CLAD ALUMINUM (E.G. WING SKIN) OR STEEL (E.G., TRUCK BEAM)	UNPROTECTED CLAD ALUMINUM (E.G., BODY SKIN)

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

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_	ı		1	- ~ ~ 		. ~		
[1] *[6]	75 MILES OR BEYOND		ø.		CLASS 1 GRADE	TYPE 1 CLASS 1 GRADE B PLUS TYPE CLASS 1	DO NOT TRANSPORT UNCOVERED *E73	TYPE 1 CLASS 1 OR 2 GRADE A
TRANSPORTATION *E13 *E63	WITHIN 75 MILES		2 CLASS 1 GRADE	-	2	TYPE 1 CLASS 1 GRADE B OR TYPE 2 CLASS 1		TYPE 1 CLASS 1
TRANSF	INDOOR TO TO	TO TO INDOOR	ТҮРЕ	TYPE 2 CLASS	TYPE 2 CLASS 1	TYPE 2 CLASS 1 GRADE B OR TYPE 2 CLASS 1	NONE	TYPE 2 CLASS 1 OVER ENDS TO AVOID ENTRY OF WATER
	00R *E6]	3 MONTHS OR MORE S *E23	DO NOT STORE OUTDOORS	IF OVER SEALANT SS 3	IF PART S IG PARTS R	TDOORS	NOT FOR EXPOSURE UP TO 4 WEEKS. DO NOT STORE OUTDOORS UNCOVERED LONGEI THAN 4 WEEKS. *[7]	CLASS 1
	UNCOVERED OUTDOOR	2 WEEKS TO 3 MONTHS	CLASS 1	TYPE 2 CLASS 1. IF OV 2 WEEKS, COVER SEALANT WITH TYPE 1 CLASS 3 GRADE A	TYPE 2 CLASS 1. I SIZES MAKES THIS UNECONOMICAL, RIG TO PREVENT WATER ENTRAPMENT	DO NOT STORE OUTDOORS	NOT FOR EXPOSURE UP TO 4 WEEKS. DO NOT STORE OUTDOORS UNCOVERED LON THAN 4 WEEKS. *[7]	TYPE 1 OR TYPE CLASS 2
E E	UNCOV	S UP TO	TYPE 2 GRADE B	TYPE 2 2 WEEKS WITH TY GRADE A	TYPE 2 CLA SIZES MAKE UNECONOMIC TO PREVENT ENTRAPMENT	DO NOT		TYPE 1 CLASS 1 OR 2 OR TYPE 2 CLASS 1
AND MANUFACTURE	UNHEATED OR OUTDOOR *E101	6 MONTHS OR MORE S *[2]					TYPE 2 CLASS 1 GRADE B	TYPE 1 CLASS 1 OR 2 GRADE A
AGE AND M		2 WEEKS TO 6 MONTHS	2 CLASS 2		CLASS 1		[8] *	TYPE 1 CLASS 1 OR TYPE 1 CLASS 2 GRADE A
STORAGE	INDOOR	UP TO 2 WEEKS	TYPE 2	7	TYPE 2	GRADE B		NONE
	HEATED IAXIMUM)	6 MONTHS OR MORE *E23				2 CLASS 1 G		TYPE 1 CLASS 1 OR 2
	INDOOR HEATED (120°F MAXIMUM)	1 WEEK TO 6 MONTHS				TYPE 2		
	II (1)	UP TO 1 WEEK	NONE			NONE		NONE
	LARGE ASSEMBLIES		METAL SURFACES WITH BMS 5-89 INCLUDING AREAS COVERED WITH TAPE	METAL SURFACES WITH SEALANT (E.G., WING PANELS)	METAL SURFACES WITH ORGANIC COATINGS OTHER THAN BMS 5-89 OR SEALANT	UNPROTECTED ALCLAD PERFORATED ACOUSTICAL ALUMINUM	PRIMED BUT NOT ENAMELED COMPOSITE HARDWARE DETAIL PARTS AND ASSEMBLIES	VEHICLE SECTIONS

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

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				STORA	STORAGE AND MANUFACTURE	NUFACTURE				TRANSPO	TRANSPORTATION *E11 *E61	13 *[6]
LARGE DETAIL PARTS	IN (12	INDOOR HEATED (120°F MAXIMUM)	TED MUM)	INDOOR	INDOOR UNHEATED OR OVERED OUTDOOR *[10]	ED OR * *[10]	UNCOVEF	UNCOVERED OUTDOOR *[6]	OR *[6]	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]	TO TO INDOOR		
METAL SURFACES WITH INORGANIC COATINGS (NON- DECORATIVE) E.G. ANODIZE OR ALODINE	NONE	TYPE 2	2 CLASS 3	TYPE 2 CLASS 1	CLASS 1	TYPE 1 CLASS 2 GRADE A *[9]	TYPE 2 CLASS GRADE A *[9]	*E91		TYPE 2 CLASS	2 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	TYPE 2 (PLUS TYF	2 CLASS 3 GRADE A TYPE 2 CLASS 1	RADE A S 1	DO NOT S	DO NOT STORE OUTDOORS	DOORS	TYPE 2 CLASS TYPE 2 CLASS	S 3 GRADE A PLUS	A PLUS
METAL SURFACES WITH ORGANIC COATINGS (E.G. PRIMERS OR PAINTS) EXCEPT BMS 5-89	NONE			TYPE 2 (2 CLASS 1		TYPE 2 C SIZE MAK ICAL, RI WATER EN	TYPE 2 CLASS 1. IF PART SIZE MAKES THIS UNECONOM ICAL, RIG TO PREVENT WATER ENTRAPMENT	IF PART	TYPE 2 CLASS	د د	
METAL SURFACES WITH BMS 5-89 INCLUDING AREAS COVERED WITH TAPE	NONE			TYPE 2 (CLASS 1		TYPE 2 CLASS GRADE B	-	DO NOT STORE OUTDOORS	TYPE 2 CLAS	CLASS 1 GRADE I	Ф
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	DO NOT STORE	TORE OUT	OUTDOORS	TYPE 2 CLASS TYPE 3 CLASS	s 1 or s 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.



		AVE	AVERAGE DRYING TIME AT 72° F *[1]	IME AT 72° F	*[1]		RE FILM (1 M	RECOMMENDED DRY FILM THICKNESS (MILS) (1 MIL = 0.001 INCH)	RY MILS) :NCH)
COATING TYPE AND GRADE	THINNER	DUST FREE	TO APPLY 2ND COAT	TO HANDLE	FOR MAXIMUM HARDNESS	RECOMMENDED ACCELERATION CURE	FOR RIVETING *E7]	FOR USAGE AS NOTED	FOR OUTDOOR EXPOSURE
			HINOLES —		(HOURS)				*[2] *[6]
CLASS 1 GRADE A									
LEEDER 103T MEK OR LEEDER 117T 10 PERC TEC 734-10 BY VOLU TEC 734-10-12 MAXIMUM	MEK OR MIBK 10 PERCENT BY VOLUME MAXIMUM	10	2	20-30	12	I	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		1	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*E10J	* [6]*	1–2	1-2	1–2 *[18]
AZTEC 534-2	NONE	15	IMMEDIATELY	30	7/2	NONE	NR	GENERAL 3-5	NR
DESOTO SKINGARD	NONE	09	-	240 (4HRS)	168 (7 DAYS)	*E18]	NR	2.0-2.5	NR
LEEDER 312N	NONE	-	20	20	9	*[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)



		AVE	AVERAGE DRYING TIME AT 72° F *E13	IME AT 72° F	*[1]		RE FILM (1 M	RECOMMENDED DRY FILM THICKNESS (MILS) (1 MIL = 0.001 INCH)	DRY (MILS) INCH)
COATING TYPE AND GRADE	THINNER	DUST FREE	TO APPLY ZND COAT MINUTES	T0 HANDLE	FOR MAXIMUM HARDNESS	RECOMMENDED ACCELERATION CURE	FOR RIVETING *[7]	FOR USAGE AS NOTED	FOR OUTDOOR EXPOSURE
	!				(HOURS)			T	*[2] *[6]
DAP 10066	NONE	-	-	20	6*L10J	*L 10 J	0.8-1.5	0.8-1.5	0.8-1.5 *[14]
AZTEC 643GC	NONE	-	-	20	9	*E 10∃	0.8-1.5	0.8-1.5	0.8-1.5 *E8]
AZTEC 643GCS	NONE				2			1 MIN.	1 MIN.
AZTEC 643GFC	NONE			20	9	*[10]	0.8-1.5	0.8-1.5	NR
CLASS 1 GRADE B									
LEEDER 313N TEC 660-2W	NONE	30	30	120	12	1	NR	GENERAL 5-10	5–10
TEC 734-10CW	NONE	10	5	20–30	12		NR	GENERAL 3-5 FLAME SPRAY 3-5	3–5
CLASS 2 GRADE A									
BMS 10-52 CLASS 1	" [7]	30	2	09	87	-	1.5-3.0	GENERAL 2.5-4	3 MIN.
FULLER 175-K-23	NONE	30	2	09	87	-	1.5-3.0	GENERAL 2.5-4	3 MIN.
TR 5157-1	WATER	30	2	30–60	87-77	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	09	∞	-	NR	GENERAL 3-5	1–3

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

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r ILS) ICH)	FOR OUTDOOR EXPOSURE	*[2] *[6]	NR R	N.		N N	NR R	NR		NR	NR	α α	NR
RECOMMENDED DRY FILM THICKNESS (MILS) (1 MIL = 0.001 INCH)	FOR USAGE AS NOTED		6 MIN.	GENERAL 5-7		PREBOND: 4 MIN. (DAP) 8 MIN. (ORG)	6.5 MIN.	6 MIN.		PREBOND 7 MIN.	PREBOND 8 MIN.	PREBOND 8 MIN.	PREBOND FORMING 6 MIN. CHEM MILL 8 MIN.
FILM (1	FOR RIVETING *E7]		NR	NR		NR	NR	NR		NR	NR	an R	NR
	RECOMMENDED ACCELERATION CURE		1			3 HR AT 140-160°F	3 HR AT 140-160°F	I		3 HR AT 140-160°	3 HR AT 140-160°	3 HR AT 140-160°	3 HR AT 140–160°
*[1]	FOR MAXIMUM HARDNESS	(HOURS)	16	_®		54	87	57		54	57	54	54
IIME AT 72° F	TO HANDLE		240	09		1000 (16.7 HR)	15	240 (4 HR)		1000 (16.7 HR)	1000 (16.7 HR)	1000 (16.7 HR)	240 (4HR)
AVERAGE DRYING TIME AT 72° F *E13	TO APPLY 2ND COAT MINITES		09			15	15	*[3]		l	3	23	30
AVE	DUST FREE	,	09			30–45	15	30–45		30–45	30–45	30–45	06
	THINNER		WATER	NONE		NONE	NONE	XYLENE OR TOLUENE		NONE	TORLUENE	PERCHLORO- ETHYLENE/ TOLUENE 1:1	NONE
	COATING TYPE AND GRADE		DAP 10010	PRO-SEAL	CLASS 3 GRADE A-5514	DAP 5020, ORG. 1-2050	DAP 1001	TURCO 522	CLASS 3 GRADE A-5555	DAP 5040	ADCOAT 820B, NF OR F	ADCOAT 819R	ADCOAT 850

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



r ILS) ICH)	FOR OUTDOOR EXPOSURE	*[2] *[6]	NR P	NR	N N		a a	N.	a a	NR	N.	NR	N.
RECOMMENDED DRY FILM THICKNESS (MILS) (1 MIL = 0.001 INCH)	FOR USAGE AS NOTED	<u>n</u>	2 MIN.	2.0-2.5	5-8		CHEM MILL 7 MIN.	6.5 MIN	CHEM MILL, PLATING 12 MIN.	PLATING 10 APPROX.	PLATING 5-8	CHEM MILL 7 MIN.	CHEM MILL 8 MIN.
FILM (1	FOR RIVETING *[7]		NR	NR	N.		N.	NR	NR N	NR	NR	NR	NR
	RECOMMENDED ACCELERATION CURE		3 HR AT 140-160°F	*E 18]	AFTER TACK- FREE, 30 MIN AT 175-225°F		ı	3 HR. AT 140-160°F	*[19]	NONE	1/2 HR. AT 175-225°F	1/2-2 HR. UP TO 225°F	*[11]
*[1]	FOR MAXIMUM HARDNESS	(HOURS)	54	168 (7 DAYS)			54	85	87	ı	54	57	54
IIME AT 72° F	TO HANDLE		1000 (16.7 HR)	240 (4 HRS)	240 AT 60°F (4 HRS) AFTER TACK- FREE		240 (4 HRS)	15	360	ı	240 (4 HRS)	240 (4 HRS)	120
AVERAGE DRYING TIME AT 72° F *[1]	TO APPLY 2ND COAT MINUTES		30–45				*[3]	15	120–180	-	-	*[3]	10
AVE	DUST FREE		_	09			30-45	15	120–180	ı	30-45	30–45	15–20
	THINNER		PERCHLORO- ETHYLENE/ TOLUENE 1:1	NONE	5580-66		XYLENE OR TOULENE	NONE	WATER	NONE	TURCO THINNER NO. 4 UP TO 25 PERCENT BY VOLUME	TOLUENE	TOLUENE
	COATING TYPE AND GRADE		ADCOAT 819R-LA	DESOTO SKINGARD	TURC0 5580G	CLASS 3 GRADE B	TURCO 522, 567, OR ORG 1-2020	DAP 1001	DAPCOAT 10220 WATER	MASK NO. 2, TURCO 5696	BOSTIK 376-49	ADCOAT 828, SC 284X	ADCOAT 850

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



RECOMMENDED DRY FILM THICKNESS (MILS) (1 MIL = 0.001 INCH)	FOR OUTDOOR EXPOSURE	NR 	N N		N N	N.	Z.	N.		N.
	FOR USAGE AS NOTED E	CHEM MILL 8	PLATING 10 APPROX		ANODIZING 4-9	ANODIZING 4-9	*[13]	CHROMIC ACID ANDDIZE 10 MIN.		SULFURIC ACID NR ANODIZE 10 MIN.
	FOR RIVETING *[7]	NR	NR		NR	NR	N.	N.		N.
	RECOMMENDED ACCELERATION CURE	*[12]	NONE		*[11]	*[12]	1/2 HR. AT 175-225°F	*[19]		*[19]
AVERAGE DRYING TIME AT 72° F *E13	FOR MAXIMUM HARDNESS (HOURS)	54	1		54	54	∞	87		48
	T0 HANDLE	120	1		120	120	09	360		360
	TO APPLY ZND COAT MINUTES	10			10	10	20	120–180		120–180
	DUST FREE	15-20	-		15–20	15–20	I	120–180		120–180
THINNER		PERCHLORO- ETHYLENE	NONE		TOLUENE	PERCHLORO- ETHYLENE	TOLUENE OR ETHYLENE	WATER		WATER
	COATING TYPE AND GRADE	ADCOAT 850	PEELCOAT B-100	CLASS 3 GRADE C	ADCOAT 850	ADCOAT 850	ADCOAT 850 TOLUENE DIP DAP 1200-AB TURCO TFM-522 TURCO 5696	DAPCOAT 10220	CLASS 3 GRADE D	DAPCOAT 10220

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 $72^{\circ}F$ followed by 15 minutes minimum at $140-150^{\circ}F$

(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 $72^{\circ}F$ followed by 20 minutes minimum at $115-125^{\circ}F$
 - (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 $72^{\circ}F$ followed by 10 minutes minimum at $135-145^{\circ}F$
 - (3) 25 minutes minimum at $72^{\circ}F$ followed by 5 minutes minimum at $155-156^{\circ}F$

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.