STANDARD OVERHAUL PRACTICES MANUAL

FINISHING MATERIALS

PART NUMBER NONE

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STANDARD OVERHAUL PRACTICES MANUAL

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To: All holders of FINISHING MATERIALS 20-60-02.

Attached is the current revision to this STANDARD OVERHAUL PRACTICES MANUAL

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Location of Change	Description of Change
	NO HIGHLIGHTS

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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.

FINISHING MATERIALS

1. INTRODUCTION

A. Finishing materials identified in the overhaul instructions are in this list.

B. Vendor product names and numbers are given for these finishing materials, along with applicable Boeing, Military or Federal Specification numbers. Refer to SOPM 20-00-00 for a list of all the vendor names and addresses.

Table 1:

NOMENCLATURE	SPECIFICATION	RECOMMENDED MATERIALS
Black Modified Urea, Formaldehyde Thermosetting Plastic		V70849
Black Ethyl Cellulose		No. 24-105-4, V77423
Chemical Films for Aluminum and Aluminum Alloys	MIL-C-5541	*[1]
	BAC 5719	(SOPM 20-43-03)
Coating, Aluminum Pigmented	BMS 10-85	*[1]
Coating, Antiskid Walkway	MIL-W-5044	*[1]
Coating, Antistatic	BMS 10-21, Type 3 (Replaces Type 1)	*[1]
Coating, Nylon	BAC5710, Type 49	Duralon EF-1 (9.6%) Epoxy Primer, and Duralon J.E. Nylon Topcoat, V0813B
Coating, Polyurethane Rain Erosion Resistant	MIL-C-83445, class 1 (Supersedes MIL-C-27315)	Caapcoat C-W4, V60922
	BAC5880	(SOPM 20-44-03)
Coating, Protective – See Protective Coating		
Coating, Resin		PT201, V06341
Coating, Self Lubricated	MIL-B-81934	Kahrlon X1200S, V97613 Karon, V50632
Coating, Suede	BAC5710, Type 35	Nextel Suede 3101, V76381 911-P4 Primer 3101 Component I Base 3101 Component II Catalyst 3101 Component III Catalyst
Coating, Teflon Filled	BMS 10-86, Type 1 or 2	*[1]

NOMENCLATURE	SPECIFICATION	RECOMMENDED MATERIALS
Corrosion Preventives	MIL-C-11796, Classes 1, 1A, 2, 3	*[1]
	MIL-C-16173, Grades 1 thru 5	*[1]
	MIL-C-23411	*[1]
	MIL-P-8585	*[1]
	BMS 10-11, Type 1 Primer with BMS 10-11, Type 2 enamel	*[1]
	BMS 3-23, Type 1 or 2	*[1]
	BMS 3-26, Type 1 or 2	*[1]
	BMS 3-27	*[1]
	BMS 3-29	*[1]
	BMS 3-35	*[1]
	BMS 3-38	*[1]
		Bostik 1007, 70707 Deoxidine 624 Corrosion Inhibiting Primer, V2K010 or V84063 DeSoto High Temperature Polyurethane Primer, V91013 Duralon EF-1 Epoxy Primer, V0813B Rust Veto 260, V73277 Rust Veto 266, V73277 Rust Veto 377, V73277
	BMS 10-79 Primer, with BMS 10-60 Enamel	V85570 *[1]
	BMS 10-100	*[1]
Corrosion Resistant Finish for Integral Fuel Tanks	BMS 10-20, Type 2	454-4-1 Base, V98502 454-4-2 Base, V98502 454-4-5 Base, V98502 10-P1-4 Base, V06367 CA-120 Activator, V98502 CA-109 Activator, V98502 X-395 Activator, V98502 EC-108 Catalyst, V06367 TL-52 Thinner, V98502 TL-132 Thinner, V98502 TR-19 Thinner, V06367 TR-20 Thinner Retarder, V06367

NOMENCLATURE	SPECIFICATION	RECOMMENDED MATERIALS
Decorative Interior Finishes		Hi-Speed Lacquer, V54636 Metallic or Flexible Hi-Speed Lacquers, V81205
	BMS 10-11, Type 2 (textured, flat)	*[1]
	BMS 10-83, Type 1 Primer	*[1]
	BMS 10-83, Type 4 Primer	*[1]
	BMS 10-83, Type 2 Enamel	*[1]
	BMS 10-83, Type 3 Enamel	*[1]
	BMS 10-55, Type 1 and 2	*[1]
Decorative Exterior Finish	BMS 10-72	*[1]
Enamel, Gloss	MIL-E-7729	*[1]
Enamel, Lusterless	TT-E-527 Color No. 27038 (per FED-STD-595)	*[1]
Enamel, polyurethane	BMS 10-97, Type 2	*[1]
Enamel, protective	BMS 10-60 Types 1 and 2	*[1]
Enamel, Black, Semigloss	TT-E-529 Color No. 27038 (per FED-STD-595)	*[1]
Enamel, Clear Baking	BMS 10-78 (Superseded by BAC5755, Type 11)	Sherwin-Williams F63V1 System, V54636
		X75114, V13054
Enamel		Dulux, 83 Series, V18873
Enamel	MIL-E-5556	*[1]
Enamel, White, Nylon Baking (Alkyd)		BA-G8S-1 (PA-1), V07937
Filler		28-C-1, V02463
Glycerin (Glycerol)	O-G-491	*[1]
Intumescent Paint (see also Coating, Fire Resistant Insulative in SOPM 20-60-04)		Ocean No. 477, V61895 *[2] Barnard No. 477 Epoxy, V1H3K8
Kahrlon coating	(SAE AS81934 (Replaces MIL-B-81934)	X1200S, V97613
Karon coating (See also wear resistant finish)	SAE AS81934 (Replaces MIL-B-81934)	V50632
Lacquer, Acid Resistant	BAC5710, Type 54 (Replaces obsolete BMS 10-16)	Rustbond Primer 6C (Gray), V06634 Polyclad 933-1 Topcoat (White or Black), V06634

NOMENCLATURE	SPECIFICATION	RECOMMENDED MATERIALS
Lacquer, Camouflage	A-A-3164	*[1]
	MIL-L-6805 (Superseded by TT-L-20a)	*[1]
	TT-L-20a (Superseded by A-A-3164)	*[1]
Lacquer, Flat		Sherwin-Williams Hi-Speed Flat, V54636
Lacquer, Flexible Vinyl Marhyde		V42400
Lacquer, Gloss Acrylic		KC9000 Series, V0360B
Lacquer, Cellulose Nitrate	A-A-3165 MIL-L-7128 TT-L-32 (Superseded by A-A-3165)	*[1] *[1] *[1]
Lacquer, Special Hi-Speed Semigloss		R7KP74, V54636 R7KP41, V54636 R7KB29, V54636
Paint, Fluorescent Red-Orange		Zynolyte 1419, V25461
Pickling Agents		ACP Deoxidizer No. 2, V2K010 or V84063
Chromic Acid	O-C-303	*[1]
Hydrofluoric Acid	O-H-795	*[1]
Nitric Acid	O-A-88	*[1]
Sulfuric Acid	O-A-809	*[1]
Plating Processes		
Chromium (or Chrome) Plate	AMS-QQ-C-320	*[1]
Cadmium Plate	AMS-QQ-P-416	*[1]
Zinc Plate	ASTM B633 (Replaces QQ-Z-325)	*[1]
Nickel Plate (Electrodeposited)	AMS-QQ-N-290	*[1]
	BMS 10-36 (Superseded by BAC5746)	*[1]
Nickel Plate (Electroless)	AMS-C-26074 (Replaces MIL-N-26074)	*[1]
Thin Dense Chrome Plating		V1Y388 V34618 V9A398

NOMENCLATURE	SPECIFICATION	RECOMMENDED MATERIALS
Plating Materials	A-A-51126	Cadmium Anodes
		Cadalyte Maintenance Compound, V18873
		Cadalyte Brightener, V18873
	QQ-Q-671	Carbonate Remover Wes-X-150, V25003
	O-S-571	Sodium Carbonate
	MIL-S-11171	Sodium Cyanide *[1]
	MIL-A-18001 (Replaces QQ-Z-285)	Zinc Anodes
		Zinc Cyanide
		Zinc Dust #122, V1F136 Unichrome Compound CR-204, V76323 Unichrome 110, V76323 Unichrome Dip Compound #65 and #67, V73623 Unichrome 210A, V76323
Primers		DC 1200 (Silicone Primer, red tint), V71984 DC 1204, V71984 E61WC40, V54636 PR 1903, V83574 SS-4004, V30221
	BMS 10-11, Type 1 BMS 10-79, Type 2 or 3 BMS 10-97, Type 1 BMS 10-103, Type 1	*[1] *[1] *[1] *[1]
Primer, Adhesive (See SOPM 20-60-04)		
Primer, Aluminized Epoxy		463-6-4 System, V33564 or V98502 463-6-4 Base X-301 Catalyst TL-52 Thinner 519-001 System, V85570 519-001 Base 910-098 Catalyst
Primer, Sealant (See SOPM 20-60-04)		

NOMENCLATURE	SPECIFICATION	RECOMMENDED MATERIALS
Primer, zinc chromate	TT-P-1757	*[1]
Protective Coating		Nycote 4-30, 7-11, 88, V05803
Protective Coatings, Temporary		(See SOPM 20-44-02)
Protective Coating, Inorganic, Heat, Weather and Oil Resistant	BMS 14-4, Type 1	Sermetel W, V58913
	BMS 14-4, Type 2	Sermetel No. 249, V58913 Sermetel No. 273, V58913 (Catalyst)
	BMS 14-4, Type 3	Sermetel No. 984 Part 1, V58913 Sermetel No. 984 Part 2, V58913 Sermetel No. 985 Part 1, V58913 Sermetel No. 985 Part 2, V58913 Sermetel No. 985 Part 3, V58913
	BMS 14-4, Type 4 (Brown)	Sermetel 1273M Primer, V58913 Sermetel 1274 Topcoat (brown) V58913, or Sermetel 1279 Topcoat (black), V58913
Protective Finish (BMS 3-11 Resistant) Clear Skydrol Resistant Topcoating NOTE: This system supersedes Nycote 88 for BMS 3-11 resistant finishes only	BAC5710, Type 41	683-3-2 Base, V3EDW5 683-3-9 Base, V3EDW5 683-3-20 Base, V3EDW5 X-310A Catalyst, V3EDW5
Protective Finish		Nycote 88, V05803
Protective Wax		GMC 1212, V09402 Kerey Wax, V54785 or V89138
Sealer, Acrylic Bonding		AS-900, V81205
Surfacers		Dual Purpose No. 4 glazing putty, V71191 Duratite Surfacing Putty (white and other colors), V58093 8-W-5, V02463 Epocast 156, V99384
Abrasion Resistant Finish	BAC5710, Type 39	Tereco 155, V17359 *[2] Part A Base Part B Catalyst
Varnish, Moisture and Fungus Resistant	MIL-V-173	*[1]
		Rudd 85-173, V02958
Velvet Finish		Alkyd Enamel Type 110-C10, V76381
Wear Resistant Finish		Kahrlon X1200S, V97613 Karon H TFE, V50632

NOMENCLATURE	SPECIFICATION	RECOMMENDED MATERIALS
Wrinkle Finish		89-B-907, V72556

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

*[2] New supply not available.