

NOTES:

1. DETAIL REQUIREMENTS FOR SURFACE PREPARATION (CLEANING AND PRETREATMENT) TO BARE METAL PRIOR TO PRIMING AND PAINTING.
 - 1.1 ALL SURFACES SHALL BE THOROUGHLY CLEANED SUCH THAT THE BARE METAL SURFACES ARE FREE FROM OIL, GREASE, DIRT, SCALE, RUST, FOREIGN MATTER AND LOOSE WELD SPATTER. THE CLEANING METHOD SHALL BE IN ACCORDANCE WITH ANY METHOD IN TABLE IV OF MIL-STD-171. PARTICULAR CARE MUST BE TAKEN TO REMOVE WELD SLAG AND LOOSE WELD SPATTER FROM WELDS AND ADJACENT AREAS.
 - 1.2 IMMEDIATELY AFTER CLEANING, ANY SOLVENTS OR MOISTURE SHALL BE COMPLETELY REMOVED. THESE CLEAN DRY SURFACES SHALL THEN HAVE A PRETREATMENT APPLIED IN ACCORDANCE WITH MIL-STD-171. FOR STEEL SUBSTRATES THE PRETREATMENT TO USE IS ZINC PHOSPHATE, FINISH NO. 5.1.1, IRON PHOSPHATE, FINISH NO. 5.1.2 OR WASH PRIMER, FINISH NO. 5.2.
 - 1.3 IMMEDIATELY PRIOR TO PRIMING, ALL SURFACES WHICH HAVE BEEN CLEANED AND PRETREATED IN ACCORDANCE WITH PARAGRAPH 1.1 AND 1.2 SHALL BE CHECKED FOR THOROUGH CLEANLINESS. ANY ACCUMULATION OF OIL, GREASE, DUST, RESIDUES FROM THE CLEANING PROCESS OR ANY FOREIGN MATERIAL SHALL BE COMPLETELY REMOVED. THE USE OF SOLVENTS MEETING THE REQUIREMENTS OF TABLE IV, FINISH NO. 4.3 OF MIL-STD-171 IS ACCEPTABLE. THE COMPLETE DRYING OF ANY SOLVENTS OR MOISTURE IS ESSENTIAL.
2. DETAIL REQUIREMENTS FOR APPLICATION OF ANTI-CORROSIVE PRIMER PAINT.
 - 2.1 PRIMER SHALL BE APPLIED ON ALL SURFACES IN ACCORDANCE WITH MANUFACTURERS' INSTRUCTIONS AND PARAGRAPHS 5.2.1 AND 5.2.2 OF MIL-STD-171 (EXCEPT THAT WHEN ACCELERATED DRYING IS EMPLOYED, OVEN TEMPERATURE IS NOT TO EXCEED 200 DEGREES F). MIL-DTL-53022, MIL-DTL-53030, OR MIL-DTL-53084 MAY BE USED ON EITHER FERROUS OR NON-FERROUS MATERIALS.
 - 2.2 ONE COAT OF PRIMER SHALL BE APPLIED AS PROMPTLY AS POSSIBLE AFTER THE SURFACES HAVE BEEN PREPARED AND CLEANED BY THE AFOREMENTIONED PROCEDURES. THE PRIMER SHALL BE DRY TO THE TOUCH IN ACCORDANCE WITH MIL-DTL-53072. ALL EPOXY PRIMERS SHALL BE PROPERLY DRIED BEFORE TOPCOATING. PRIMER DRY FILM THICKNESS SHALL BE APPLIED TO ATTAIN THE 336 HOUR SALT SPRAY REQUIREMENT. RECOMMENDED THICKNESS RANGE IS .0010 TO .0035 INCHES (.0254 TO .0889 MM).
3. DETAIL REQUIREMENTS FOR APPLICATION OF POLYURETHANE TOPCOAT PAINT.
 - 3.1 TOPCOAT SHALL BE APPLIED ON EXTERIOR SURFACES ONLY IN ACCORDANCE WITH MANUFACTURERS' INSTRUCTIONS OR PARAGRAPHS 5.2.1 AND 5.2.2 OF MIL-STD-171. UNLESS OTHERWISE SPECIFIED, THE TOPCOAT COLOR SHALL BE GREEN NO. 383 IN ACCORDANCE WITH MIL-DTL-64159 OR MIL-DTL-53039.
 - 3.2 TOPCOAT DRY FILM THICKNESS OF MIL-DTL-64159 AND MIL-DTL-53039 SHALL BE .0018 TO .0035 INCHES (.0457 TO .0889 MM) TOTAL APPLIED IN TWO COATS. THE SECOND COAT MAY BE APPLIED IN ACCORDANCE WITH MIL-DTL-53072 OR MANUFACTURERS' RECOMMENDATIONS.
 - 3.3 ALL REWORK SHALL BE IN ACCORDANCE WITH PARAGRAPH 3.6.1 OF MIL-DTL-53072.
 - 3.4 ALTERNATE COATINGS MAY BE USED IF APPROVED BY THE CONTRACTING OFFICER.
 4. DETAIL REQUIREMENTS FOR APPLICATION TO PREVIOUSLY PAINTED SUBSTRATES.
 - 4.1 ALL PREVIOUSLY PAINTED SURFACES MUST BE CLEAN AND FREE FROM RUST. WHERE RUST EXISTS, MECHANICAL CLEANING IN ACCORDANCE WITH FINISH NO. 4.1 OF MIL-STD-171 (WIREBRUSH IS ACCEPTABLE) SHALL BE PERFORMED UNTIL BRIGHT METAL IS EXPOSED. ONE COAT OF POLYURETHANE PAINT PER MIL-DTL-64159 OR MIL-DTL-53039 CAN BE APPLIED DIRECTLY OVER EXISTING ENAMEL OR POLYURETHANE COATINGS WITHOUT ANY ADDITIONAL SURFACE PREPARATION EXCEPT CLEANING. IF THE SURFACE IS BROKEN DOWN TO THE SUBSTRATE, THAT AREA MUST BE CLEANED, PRETREATED, PRIMED AND TOPCOATED PER PARAGRAPH 1 THROUGH 3. THE POLYURETHANE COATING SHALL NOT HOWEVER, BE DIRECTLY APPLIED OVER LACQUER. THE LACQUER MUST BE REMOVED DOWN TO THE BARE METAL BEFORE POLYURETHANE COATING IS APPLIED PER PARAGRAPHS 1 THROUGH 3.

REVISION			APPROVED	
LTR.	DESCRIPTION	ENG.	BY	DATE
A	CHANGE PAINT THICKNESS REQUIREMENTS	ZAJICEK	ERNST	87-09-17
B	PRODUCT BASELINE ERR M8K9450	TT	MICHELS	89-04-10
C	NOR M2T4200 / 92-07-20 (ECP M3T4030 / 93-11-02) (ECP M4T3005 / 94-06-02)	SCHULTZ	MICHELS	94-11-02
D	NOR M5T8003 / 95-05-09	SCHULTZ	MICHELS	95-06-07
E	NOR M5T3003 / 95-06-22 (ECP M6R3004) / 96-02-22	SCHULTZ	MICHELS	96-04-11
F	ECP R8T8020 / 98-08-31	BARTOSIAK	MICHELS	99-02-17
G	ECP R05T5076 / 05-03-22	BARTOSIAK	GW/JB/RC	06-02-23
H	ECP R07T2007-040 / 07-12-04	BARTOSIAK	LF/JB	08-09-05
J	ECP R08A2030-017 / 09-01-26	Q. TRAN	LF/PB/JB	09-07-21
K	ECP MI-P-1690R2A1, NOR 9 / 12-06-27	Q. TRAN	FIEFFER	20-01-08

CAD MAINTAINED. CHANGES SHALL BE INCORPORATED BY THE DESIGN ACTIVITY.

- 4.2 WHERE VENDOR PARTS ARE SUPPLIED TO THE PRIME ORIGINAL EQUIPMENT MANUFACTURER (OEM) ALREADY ENAMEL PAINTED, THE PRIME OEM WILL HAVE TO REPAINT PER PARAGRAPH 4.1 BY APPLYING DIRECTLY OVER THE EXISTING ENAMEL COATING. IF THE VENDOR PARTS ARRIVE JUST ENAMEL PRIMED (WHICH IS PREFERABLE), WITH SPECIFICATION PRIMERS SUCH AS TT-P-1757 OR SSPP PAINT 25, THEN THE POLYURETHANE PAINT PER PARAGRAPH 4.1 WILL BE APPLIED DIRECTLY OVER PRIMED SURFACES. IF THE ENAMELS ON THE VENDOR PARTS ARE OF A COMMERCIAL OR UNKNOWN TYPE THEY MUST BE TESTED BEFORE THE POLYURETHANE CAN BE APPLIED. THIS ENTAILS APPLYING POLYURETHANE PAINT TO A SMALL AREA OF THE PART AND OBSERVING FOR A PERIOD OF 15 MINUTES FOR ANY DEFECTS SUCH AS BLISTERING, DELAMINATION OR BLEEDING. IF NONE ARE OBSERVED, THE REMAINDER OF THE PARTS CAN BE PAINTED. IF THERE IS A DEFECT, THE PARTS MUST BE CLEANED, PRETREATED, PRIMED AND TOPCOATED AS PREVIOUSLY DESCRIBED FOR BARE SUBSTRATES IN PARAGRAPH 1 THROUGH 3.

5. TESTING.

- 5.1 PALLETS AND/OR ADAPTERS FINISHED IN ACCORDANCE WITH PARAGRAPH 2, 3, AND 4 AS APPLICABLE SHALL BE TESTED FOR PAINT ADHESION USING ACTUAL PRODUCTION ITEMS.
- 5.2 THE PRIMER AND TOPCOAT SHALL BE ADHESION TESTED IN ACCORDANCE WITH PARAGRAPH 4.2.7.2 OF TT-C-490.
- 5.3 THE PRIMER AND TOPCOAT SHALL BE TESTED IAW PARAGRAPH 4.2.8 OF TT-C-490.
- 5.4 MIL-DTL-53072, PARAGRAPH 4.2.3.7 APPLIES.

DISTRIBUTION STATEMENT A.

APPROVED FOR PUBLIC RELEASE;
DISTRIBUTION IS UNLIMITED.

		ACV00067	M232 MACS	UNLESS OTHERWISE NOTED DIMENSIONS ARE IN INCHES TOLERANCES: <table style="font-size: small;"> <tr> <td>.XX</td> <td>XXX</td> <td>1/16</td> <td>FRACTIONS</td> <td>125</td> </tr> <tr> <td>±.01</td> <td>±.005</td> <td>±0'15"</td> <td></td> <td>±1/64</td> </tr> </table> REMOVE ALL BURRS AND SHARP EDGES 0.010 R OR CHAMFER MAX.	.XX	XXX	1/16	FRACTIONS	125	±.01	±.005	±0'15"		±1/64	DATE 86-05-09	DESIGN ACTIVITY U.S. ARMY COMBINED ARMS SUPPORT COMMAND DEFENSE AMMUNITION CENTER MCALESTER, OKLAHOMA 74501-9053
.XX	XXX	1/16	FRACTIONS		125											
±.01	±.005	±0'15"			±1/64											
		ACV00124	40MM		DFTSMN. CHECKER PROJ. ENGR DH KD ZAJICEK	SJMAG-DEV T. J. MICHELS CHIEF, SUPPLY ENGINEERING DIV.	CHEMICAL AGENT RESISTANT COATING (CARC) FINISHING REQUIREMENTS FOR METAL PALLETS AND/OR PALLET ADAPTERS									
		ACV00134	150MM HWZR		SUBMITTED W. F. ERNST CHIEF, LOGISTICS ENGINEERING OFFICE APPROVED BY ORDER OF COMMANDING GENERAL U.S. ARMY MATERIAL COMMAND											
		ACV00155	HYDRA													
		ACV00156	HYDRA													
		ACV00300	M231 MACS													
AC200000414	VOLCANO	ACV00681	EXCALIBUR													
AC200000501	120MM TANK	ACV00811	120MM													
ACV00053	25MM	ACV00833	HYDRA													
NEXT ASSEMBLY	USED ON	NEXT ASSEMBLY	USED ON													
APPLICATION (CONT.)		APPLICATION														

JOHN L. BYRD, JR.
U.S. ARMY
DEFENSE AMMUNITION CENTER AND SCHOOL

SIZE	CAGE	DRAWING No.	REV.
C	28620	AC200000423	K
SCALE	NONE	UNIT WT	SHEET 1 OF 1