

Coded Note Number: LI075

Revision: **C006**

Date: **January 20, 2017**

Title: **Paint Coating of Components previously requiring Low Temperature Wire Spray Aluminum**

This revision history is provided for convenience and does not alleviate the supplier's responsibility with understanding and complying with the full coded note.

Bolded font indicates changed/added content.

[Text deleted] inserted in the document indicates the removal of content.

[This revision is an entire re-write from previous METAL SPRAY COATING PROCEDURE IAW MIL-STD-2138 FOR APPROVAL]

- 1. All items, previously wire spray aluminum coated, to a lead design yard approved wire spray aluminum procedure, prior to this change, are acceptable as is.**
- 2. The following items shall not be painted - component marking data, label plates, keyways, machined surfaces, O-ring grooves, seating surfaces, alignment pins and holes, threaded holes, bolt holes, fasteners/including threaded portions and non-ferrous material.**
- 3. After production testing, thoroughly clean external surfaces to be painted in accordance with SSPC-SP 10 (near-white blast clean).**
- 4. External surfaces shall receive one coat of green epoxy primer, formula 150, MIL-DTL-24441/29, TY-IV at 4 - 6 mils dry film thickness and one top coat of chlorinated alkyd enamel, formula 124, MIL-DTL-24607 at 1.5 - 2.0 mils dry film thickness.**
- 5. The above paint requirements are based on all components being carbon steel.**
- 6. Paint shall not be applied within 7/8-inch of weld prep.**
- 7. Paint shall be fully cured in accordance with manufacturer's instructions prior to shipment.**
- 8. Where only a localized area or spot requires repainting, removal of old paint shall be carried back around the edges to intact and adhering paint. The edges of the remaining paint shall be flared to present a smooth appearance. These areas shall be cleaned and repainted with all coats required for the areas.**