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**MIL-STD-171E**  
**23 JUNE 1989**  
SUPERSEDING  
MIL-STD-171D  
29 FEBRUARY 1980

**DEPARTMENT OF DEFENSE  
MANUFACTURING PROCESS  
STANDARD**

**FINISHING OF METAL AND WOOD  
SURFACES**



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DEPARTMENT OF DEFENSE

Washington, DC 20301

**Finishing of Metal and Wood Surfaces**

**MIL-STD-171E**

1. This Military Standard is approved for use by all Departments and Agencies of the Department of Defense.

2. Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Director, U.S. Army Laboratory Command, Materials Technology Laboratory, ATTN: SLCMT-MEE, Watertown, MA 02172-0001 by using the Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

## FOREWORD

The purpose of this standard is to establish finish system codes which link or cross reference specific specification information for finishing and otherwise treating metal and wood surfaces. It also serves as a general guide to the selection of suitable finishing materials, procedures, and systems. It covers both organic (paint, varnish, and the like) and inorganic (metal plate, phosphatized metal, and the like) coatings. Specialized systems peculiar to individual agencies are covered by drawings, specifications and standards published by those organizations and supplement this standard. Such procurement documents should make direct reference to the applicable specification. For example, MIL-STD-194 covers painting and other finishing of fire-control materiel. Finish system code numbers in the tables shall not be changed in future revisions of this standard, inasmuch as those code numbers should be referenced on drawings, in contracts and in end item specifications. Where a system in a previous edition of MIL-STD-171 has been deleted from the revision, the system to be used as a substitute is noted in the tables.

For convenience in referencing, all procedures, whether they merely clean a surface, deposit a film, or perform some other desirable function, are cataloged as "finishes".

As an example of how to use this standard, assume a part is to be finished with chromated zinc plate 0.001 inch (25 um) thick. Turning to table II, Inorganic Finishes, Plating, we find the designation for this finish to be 1.9.2.1. Hence, the instructions on the drawing would be:

Finish 1.9.2.1 of MIL-STD-171.

In this particular case, it is unnecessary to mention any preliminary steps such as cleaning, because ASTM B633, Coatings of Zinc on Iron and Steel Zinc Plating Electrodeposited referenced in finish 1.9.2.1, provides for this step in these words "It (the basis metal) shall be subjected to such cleaning, pickling, and plating procedures as are necessary to yield deposits as hereinafter specified".

Again, assume the hood of a truck is to be finished with olive drab lustreless lacquer. According to table XIII, this finish is system 20.4. Assume the preparation for painting to be phosphating (finish 5.1.1). The primer would be one conforming to MIL-P-11414 or TT-P-664. The finishing coat would be a lacquer conforming to MIL-L-11195. Hence the instructions on the drawing would be:

Finish 5.1.1 plus 20.4 of MIL-STD-171, Olive Drab No. 34087.

If circumstances make it desirable that parts of an assembly be primed separately and be given final coats after assembly, the instructions might be:

Finish 5.1.1 plus 20.4 of MIL-STD-171, Olive Drab No. 34087  
primed before assembly.

MIL-STD-171E

The subject matter of this standard is arranged in sections as prescribed in MIL-STD-962 as follows:

1. Scope; 2. Referenced Documents; 3. Definitions; 4. General Requirements; 5. Detail Requirements; and an additional section
6. Notes on Inspection.

Section 6 on inspection presumes that the paints have been laboratory tested against the appropriate products specification prior to application. However, inspection to assure that the painting operations are carried out properly is as important as the quality of the paint itself. For example, inspection of surface preparation prior to painting is of major importance. An excellent paint on an improperly prepared surface may fail prematurely. Again, the thickness of a paint coat has a direct bearing on its durability. Thus, the correct thickness of the dry film of "wash primer" (DOD-P-15328) as given in this standard is very important. In addition to these two factors, proper mixing and thinning of the paint, suitable weather at time of painting, uniform application, suitable drying time between coats, and proper handling of painted surfaces, must be carefully observed. Admittedly this type of inspection requires sound judgment derived from long experience.

Compliance with this standard will promote uniformity in the painting and other finishing of military equipment, and will lessen the chances of error and confusion in times of emergency. The net result should be improved protection of military materiel from deterioration.

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## 1. SCOPE

1.1 Scope. This standard establishes and updates general finish codes and serves as a general guide to the selection of suitable materials, procedures, and systems for cleaning, plating, painting and the otherwise finishing of metal and wood surfaces.

1.2 Selection of finishing system. Unless otherwise specified the responsibility for selecting the cleaning method, surface treatment, metal coating, paint system or other finish shall rest with the activity responsible for the end item. The finishing system should be selected from those listed in this document and shall be referenced on drawings, contracts, and item specifications. Finish numbers should be preceded by the word "finish" to avoid possible confusion with paragraph numbers, for example, "finish 5.1.1 plus 20.4". This does not preclude the acceptance of a proven commercial finish selected by the manufacturer, supplier, or contractor and concurred in by the procuring activity. Additional information relative to protective finishes and their selection may be found in MIL-HDBK-132 and the Appendix of this document.

1.3 Conflicts. In the event of conflict between the requirement of this standard and those of specifications or drawings, the requirements of drawings shall have first preference, those of specifications next, and those of this standard last.



## 2. REFERENCED DOCUMENTS

### 2.1 Government documents.

2.1.1 Specifications, standards, and handbooks. The following specifications, standards, and handbooks form a part of this document to the extent specified herein. Unless otherwise specified, the issues of these documents are those listed in the issue of the Department of Defense Index of Specifications and Standards (DODISS) and supplement thereto, cited in the solicitation (see 6.2).

### SPECIFICATIONS

#### FEDERAL

- O-I-501 - Inhibitors, Pickling (for Use with Sulfuric Acid)
- O-T-634 - Trichloroethylene, Technical
- P-C-436 - Cleaning Compound, Alkali, Boiling Vat (Soak) or Hydrosteam
- QQ-C-320 - Chromium Plating (Electrodeposited)
- QQ-N-290 - Nickel Plating (Electrodeposited)
- QQ-P-35 - Passivation Treatments for Corrosion Resisting Steel
- QQ-P-416 - Plating, Cadmium (Electrodeposited)
- QQ-S-365 - Silver Plating, Electrodeposited; General Requirements for
- TT-C-490 - Cleaning Methods and Pretreatment of Ferrous Surfaces for Organic Coatings
- TT-C-494 - Coating Compound, Bituminous, Solvent Type, Acid Resistant
- TT-C-520 - Coating, Compound, Bituminous, Solvent Type, Underbody (for Motor Vehicles)
- TT-E-485 - Enamel, Semi-Gloss, Rust-Inhibiting
- TT-E-489 - Enamel, Alkyd, Gloss, Low VOC Content
- TT-E-515 - Enamel, Alkyd, Lusterless, Quick-Drying
- TT-E-516 - Enamel, Lustreless, Quick-Drying, Styrenated Alkyd Type
- TT-E-522 - Enamel, Phenolic, Lusterless, Outside
- TT-E-527 - Enamel, Alkyd, Lusterless, Low VOC Content
- TT-E-529 - Enamel, Alkyd, Semi-Gloss, Low VOC Content
- TT-E-1593 - Enamel, Silicone Alkyd Copolymer Gloss (for Exterior and Interior Use)
- TT-F-325 - Filler, Engraving, Stamped Marking
- TT-F-336 - Filler, Wood, Paste
- TT-L-20 - Lacquer, Camouflage
- TT-L-58 - Lacquer, Spraying, Clear and Pigmented (General Use)
- TT-L-190 - Linseed Oil, Boiled, (for Use in Organic Coatings)
- TT-L-215 - Linseed Oil, Raw (for Use in Organic Coatings)
- TT-P-28 - Paint, Aluminum, Heat Resisting
- TT-P-320 - Pigment, Aluminum; Powder and Paste, for Paint
- TT-P-662 - Primer Surfacer, Sanding, Lacquer and Enamel Type
- TT-P-664 - Primer Coating, Alkyd, Corrosion-Inhibiting, Lead and Chromate Free, VOC Compliant
- TT-P-1757 - Primer Coating, Zinc Chromate, Low-Moisture-Sensitivity

- TT-S-300 - Shellac, Cut
- TT-V-51 - Varnish; Asphalt
- TT-V-119 - Varnish, Spar, Phenolic Resin
- TT-V-121 - Varnish, Spar, Water-Resisting
- VV-L-800 - Lubricating Oil, General Purpose, Preservative (Water Displacing, Low Temperature)

#### MILITARY

- MIL-P-116 - Preservation, Methods of
- MIL-T-152 - Treatment, Moisture and Fungus-Resistant of Communications, Electronic and Associated Electrical Equipment
- MIL-V-173 - Varnish, Moisture and Fungus Resistant (for the Treatment of Communications, Electronic, and Associated Electrical Equipment)
- MIL-C-450 - Coating Compound, Bituminous, Solvent Type, Black (for Ammunition)
- MIL-P-495 - Finish, Chemical, Black, for Copper Alloys
- MIL-R-3043 - Resin Coating, Unpigmented, for Engine Components and Metal Parts
- MIL-L-3150 - Lubricating Oil, Preservatives, Medium
- MIL-M-3171 - Magnesium Alloy, Processes for Pretreatment and Prevention of Corrosion on
- MIL-W-3688 - Wax Emulsion (Rust Inhibiting)
- MIL-L-3891 - Luminescent Material and Equipment (Nonradioactive)
- MIL-C-4556 - Coating Kit, Epoxy, for Interior of Steel Fuel Tanks
- MIL-W-5044 - Walkway Coating and Matting, Nonslip, Aircraft
- MIL-C-5541 - Chemical Conversion Coatings on Aluminum Alloys
- MIL-P-7962 - Primer Coating, Cellulose Nitrate Modified Alkyd Type Corrosion Inhibiting, Fast Drying, (for Spray Application over Pretreatment Coating)
- MIL-C-8507 - Coating, Wash Primer, Pretreatment (for Metals); Application of
- MIL-A-8625 - Anodic Coatings, for Aluminum and Aluminum Alloys
- MIL-S-8802 - Sealing Compound, Temperature-Resistant, Integral Fuel Tanks and Fuel Cell Cavities, High Adhesion
- MIL-C-8837 - Coating, Cadmium (Vacuum Deposited)
- MIL-C-10578 - Corrosion Removing and Metal Conditioning Compound (Phosphoric Acid Base)
- MIL-T-10727 - Tin Plating; Electrodeposited or Hot-Dipped, for Ferrous and Non-Ferrous Metals
- MIL-S-11030 - Sealing Compound, Non-Curing, Polysulfide Base
- MIL-L-11195 - Lacquer, Lusterless, Hot Spray
- MIL-P-11414 - Primer; Lacquer, Rust-Inhibiting
- MIL-C-11796 - Corrosion Preventive Compound, Petrolatum, Hot Application
- MIL-T-12879 - Treatments, Chemical, Prepaint and Corrosion Inhibitive for Zinc Surfaces
- MIL-L-13762 - Lead Alloy Coating, Hot Dip (for Iron and Steel Parts)
- MIL-L-13808 - Lead Plating (Electrodeposited)
- MIL-I-13857 - Impregnation of Metal Castings

- MIL-C-13924 - Coating, Oxide, Black, for Ferrous Metals
- MIL-F-14072 - Finishes for Ground Electronic Equipment
- MIL-P-14105 - Paint Heat-Resisting (for Steel Surfaces)
- MIL-C-14460 - Corrosion Removing Compound Sodium Hydroxide Base; for Electrolytic or Immersion Application
- MIL-C-14538 - Plating, Black Chromium (Electrodeposited)
- MIL-C-14550 - Copper Plating (Electrodeposited)
- MIL-P-14553 - Primer Coating, Dipping, Automotive
- DOD-P-15328 - Primer (Wash) Pretreatment, Blue (Formula No. 117B) for Metals
- MIL-P-15930 - Primer Coating, Shipboard, Vinyl-Zinc Chromate (Formula No. 120 - for Hot Spray)
- MIL-C-16173 - Corrosion Preventative Compound, Solvent Cutback, Cold Application
- DOD-P-16232 - Phosphate Coatings, Heavy Manganese or Zinc Base (for Ferrous Metals)
- MIL-E-16400 - Electronic, Interior Communication and Navigation Equipment, Naval Ship and Shore, General Specification for
- MIL-P-18264 - Finishes, Organic, Weapons System, Application and Control of
- MIL-P-18317 - Plating, Black Nickel (Electrodeposited) on Brass, Bronze, or Steel
- MIL-L-19538 - Lacquer, Acrylic Nitrocellulose, Camouflage (for Aircraft Use)
- MIL-C-20218 - Chromium Plating, Electro-Deposited, Porous
- MIL-P-22332 - Paint, Priming, Exterior and Interior (for Ammunition)
- MIL-C-22750 - Coating, Epoxy Polyamide
- MIL-T-23142 - Tape, Pressure Sensitive Adhesive, for Dissimilar Metal Separation
- MIL-C-23217 - Coating, Aluminum, Vacuum Deposited
- DoD-P-23236 - Paint Coating Systems, Steel Ship Tank, Fuel and Salt Water Ballast (Metric)
- MIL-P-23377 - Primer Coating, Epoxy Polyamide, Chemical and Solvent Resistant
- MIL-L-23398 - Lubricant, Solid Film, Air-Cured, Corrosion Inhibiting
- DoD-C-24667 - Coating System, Nonskid, for Roll or Spray Application
- MIL-L-25142 - Luminescent Material, Fluorescent
- MIL-C-26074 - Coating, Electroless Nickel, Requirements for
- MIL-P-38336 - Primer Coating, Inorganic, Zinc Dust Pigmented, Self-Curing for Steel Surfaces
- MIL-M-45202 - Magnesium Alloys, Anodic Treatment of
- MIL-G-45204 - Gold Plating (Electrodeposited)
- MIL-P-45209 - Palladium Plating, Electrodeposited
- MIL-L-46010 - Lubricant, Solid Film, Heat Cured, Corrosion Inhibiting
- MIL-I-46058 - Insulating Compound, Electrical (for Coating Printed Circuit Assemblies)
- MIL-R-46085 - Rhodium Plating, Electrodeposited

- MIL-P-46105 - Primer Coating, Weld-Through, Zinc Rich
- MIL-C-46156 - Corrosion Removing Compound, Sodium Hydroxide Base, for Immersion Application
- MIL-L-46159 - Lacquer, Acrylic, Low Reflective
- MIL-C-46168 - Coating, Aliphatic Polyurethane, Chemical Agent Resistant
- MIL-L-52043 - Lacquer, Semigloss, Cellulose Nitrate
- MIL-E-52891 - Enamel, Lusterless, Zinc Phosphate, Styrenated Alkyd Type
- MIL-P-53022 - Primer, Epoxy Coating, Corrosion Inhibiting, Lead and Chromate Free
- MIL-P-53030 - Primer Coating, Epoxy, Water Reducible, Lead and Chromate Free
- MIL-C-53039 - Coating, Aliphatic Polyurethane, Single Component, Chemical Agent Resistant
- MIL-C-53072 - Chemical Agent Resistant Coating (CARC) System Application Procedures and Quality Control Inspection
- MIL-P-53084 - Primer, Cathodic Electrodeposition, Chemical Agent Resistant
- MIL-N-55392 - Nickel-Carbon, Porous, Electrodeposited, for Camouflage
- MIL-T-81533 - Trichloroethane, 1,1,1 (Methylchloroform) Inhibited Vapor Degreasing
- MIL-C-81562 - Coating, Cadmium and Zinc (Mechanically Deposited)
- MIL-S-81733 - Sealing and Coating Compound, Corrosion Inhibitive
- MIL-P-85582 - Primer Coatings: Epoxy, Waterborne

#### STANDARDS

##### FEDERAL

- FED-STD-141 - Paint, Varnish, Lacquer and Related Materials; Methods of Inspection, Sampling and Testing.
- FED-STD-595 - Colors

##### MILITARY

- MIL-STD-276 - Impregnation of Porous Nonferrous Metal Castings
- MIL-STD-865 - Brush Plating, Electro Deposition
- MIL-STD-962 - Outline of Forms and Instructions for the Preparation of Military Standards and Military Handbooks

#### HANDBOOKS

##### MILITARY

- MIL-HDBK-132 - Protective Finishes
- MIL-HDBK-205 - Phosphatizing and Black Oxide Coating of Ferrous Metals

(Unless otherwise indicated, copies of federal and military specifications, standards, and handbooks are available from the Naval Publications and Forms Center, (ATTN: NPODS), 5801 Tabor Avenue, Philadelphia, PA 19120-5099.)

2.2 Non-Government publications. The following documents form a part of this specification to the extent specified herein. Unless otherwise specified, the issues of the documents which are DoD adopted are those listed in the issue of the DODISS cited in the solicitation. Unless otherwise specified, the issues of documents not listed in the DODISS are the issues of the documents cited in the solicitation (see 6.2).

ASTM (AMERICAN SOCIETY FOR TESTING AND MATERIALS)

ASTM A153 - Zinc Coating (Hot Dip) on Iron and Steel Hardware

ASTM A123 - Zinc (Hot Dip Galvanized) Coatings on Iron and Steel Products

ASTM A380 - Cleaning and Descaling Stainless Steel Parts, Equipment and Systems

ASTM B545 - Electrodeposited Coatings of Tin

ASTM B633 - Zinc on Iron and Steel, Electrodeposited Coatings of

(Copies of ASTM Standards may be obtained from ASTM, 1916 Race Street, Philadelphia, Pennsylvania 19103.)

**3. DEFINITIONS**

**\*NOT APPLICABLE\***

#### 4. GENERAL REQUIREMENTS

4.1 Materials. All materials used shall conform to the requirements of the applicable specifications. Types, classes, grades, etc., shall be specified by the procuring activity. Materials may be subject at any time to such tests of the pertinent specification as the procuring activity shall prescribe to determine compliance with the applicable specification.

4.1.1 Applicable documents. The specifications and standards referenced in this document shall be the issue in effect on the date of invitation for bids. The finish or system requirement in the tables does not indicate the latest document designation as evidenced by the omission of the revision letter following the document number.

4.2 Substitution for specified finishes, processes, or materials. If, because of special conditions of service or design, the contractor considers that a finish, method, or material, other than that specified herein, is necessary or more suitable, such finish, method, or material may be used upon written approval of the contracting officer. Unless otherwise specified, the contractor shall demonstrate the suitability of the proposed substitute by submission of samples, test specimens, test data or other evidence as required by the procuring activity.

4.3 Preparation and cleaning of surfaces. Before any plating, metal conversion or painting, all surfaces shall be free from soils and corrosion; for example, grease, oil, solder flux, welding flux, weld spatter, sand, rust, scale, and all other contaminants that might interfere with the intimate application of the finish. Cleaning shall be done immediately before the finishing operation, or suitable precautions shall be taken to ensure that the surfaces remain clean until they are to be finished. When a cleaning procedure is not specified by the procuring activity or as a part of the pretreatment specification, the supplier shall use any cleaning procedure which will produce a clean surface and not adversely affect the surface being cleaned, or the subsequently applied coating.

4.3.1 Castings. Porous castings may require sealing to assure that they are leakproof, and to prevent bleeding-out of treating chemicals which would cause staining or corrosion of the metal surface and damage to the finishing system. Impregnation or sealing of castings should be accomplished after complete removal of oils, greases, and other surface contaminants, and after machining. Reference should be made to MIL-STD-276 or MIL-I-13857, as applicable.

4.4 Drainage of processing solutions from parts. Where possible, finishing and passivation of parts shall be done prior to fabrication. For example, aluminum sheet to be lap-seamed or riveted should be anodized prior to the joining operation. Where this is not possible the finishing and fabrication of items shall be handled in such a way that processing solutions shall not become trapped within any part of the assemblies such as lock seams, lap joints, spot welds, rivets, bolts or other places where processing solutions will remain on the part.

4.5 Holes and recesses. If a method other than the one specified is necessary in order to attain specified thickness requirements in holes or recesses, such a method may be used upon written approval of the procuring activity. The contractor shall demonstrate that his method or methods produce the required results.

4.6 Rivets, lock bolts, blind rivets and threaded fasteners. Rivets, lock bolts, blind rivets, and threaded fasteners shall be assembled using sealant conforming to MIL-S-81733. Both the fastener and the holes shall be coated with sealant. If the fasteners are dissimilar and can result in a direct contact with magnesium, a washer of 5052 aluminum alloy with a minimum overlap of one-eighth to one-fourth inch shall be used in addition to MIL-S-81733 sealant. Other sealing compounds (MIL-S-11030, and MIL-S-8802) and antiseize compounds shall be used as a substitute for MIL-S-81733 when approved by the procuring activity.

4.7 Compatibility of dissimilar metal couplings. The finishing of metals to be placed in intimate contact when assembled presents a special problem, since dissimilar metal contact results in electrolytic couples which promote corrosion through galvanic action. Table I lists metals and alloys by galvanic potential. To provide corrosion resistance intermetallic couples shall be selected so that there is 0.25 volts or less potential between the two metals or alloys. The proper selection of metals in the design of equipment will result in fewer intermetallic contact problems caused by corrosion at the contact points. For additional information see table I of MIL-E-16400.

4.7.1 Reduction of corrosion at intermetallic contact points. Couples of metals selected as in 4.7 shall be painted in accordance with 5.2.4.2 as a minimum requirement. When base metals intended for intermetallic contact form couples exceeding those permitted in 4.7 they shall be plated with those metals which will reduce the potential difference or they shall be suitably insulated with a nonconducting finish such as zinc chromate primer or other suitable means as specified. Where magnesium is one of the metals of dissimilar metal faying surfaces, the metal shall be separated by use of a vinyl or polyester barrier material (tape) or sealing compound such as MIL-T-23142, MIL-S-11030, MIL-S-8802 or MIL-S-81733.

4.7.1.1 Vinyl tape. Vinyl tape is sometimes used as insulating material and as a means of separating dissimilar metals, however, it is not adequate for separating dissimilar metals where durable and moisture resistant separation is required, i.e., metal parts subject to vibration while fastened together, such as aerospace applications prohibit the use of vinyl electrical insulations.



**TABLE I. Galvanic potentials of metals in sea water.**

	Potential (V) - Relative to saturated calomel electrode @ 25 C
<u>ANODIC END (Less noble, reactive)</u>	
	<u>Volts</u>
Magnesium	-1.80
Magnesium alloys	-1.60
Zinc	-1.10
Zinc - hot dip, galvanized steel	-1.05
Aluminum - cast, other than silicon type	-0.95
Cadmium - plated and chromated	-0.80
Aluminum - wrought, other than copper type	-0.75
Aluminum - cast, silicon type	-0.75
Iron - wrought carbon or low alloy steels gray or malleable cast iron	-0.70
Aluminum - wrought, copper type	-0.60
Steel, stainless - 13% chromium, active	-0.55
Lead - solid or plated, high lead alloys	-0.55
Steel, stainless - 18% chromium, 8% nickel	-0.50
Tin - plate, terneplate, tin-lead solders	-0.50
Chromium - plated	-0.45
Steel, stainless - 13% chromium, passive	-0.45
Brass - yellow, naval, cartridge, muntz metal	-0.40
Brass - red, gilding	-0.35
Copper - solid or plated	-0.30
Nickel - solid or plated, passive	-0.30
Monel	-0.30
Steel, stainless - 18% chromium, 8% nickel, passive	-0.20
Silver, solder	-0.20
Steel, stainless - 18% chromium, 12% nickel 3% molybdenum, passive	-0.20
Titanium, commercial	-0.15
Hastelloy C	-0.10
Silver - solid or plate, high silver alloys	0.0
Rhodium	+0.20
Graphite	+0.25
Gold - solid or plated, high gold alloys	+0.25
Platinum - wrought, high platinum alloys	+0.25
<u>CATHODIC END (More noble, unreactive)</u>	

4.8 Organic vapor, acid or alkaline environment. Unpainted parts of cadmium or zinc base alloys or metal parts plated with cadmium or zinc shall not be used in unventilated assemblies where phenolic or other organic vapors emanating from insulating varnishes, encapsulating compounds or uncured plastic material may contact them. Cadmium and zinc or platings of these metals shall not be used where parts are in contact with acid, unsymmetrical dimethylhydrazine, ammonia or vapors thereof.

4.9 Surfaces not to be painted. Certain surfaces do not require paint for protection, on others paint interferes with their functions. The following are examples of surfaces that should be masked or otherwise protected during painting:

- (a) Machined surfaces that move with respect to each other, such as threads, slides, bearing contacts and gear teeth.
- (b) Electrical parts, such as contacts, relays, bearings, insulators, sockets, plugs, connectors, and terminals. This does not preclude the use of MIL-V-173 varnish or conformal coating in accordance with application requirements of MIL-T-152.
- (c) Plastic and rubber parts such as insulators, mounts, spacers, windshields, etc.
- (d) Lubrication fittings, cups, holes, etc.

4.10 Dressing operations. Filing, sanding or other dressing operations shall not be done on a part or assembly after it has been finished, except as permitted by drawings, other specifications, the contract or by written approval of the contracting officer. If it is necessary to perform one of these procedures after an item is coated, the finish must be completely removed to the substrate in all areas which will reach 400°P (204°C) and above. Where filing or the like is permitted, the affected area shall be refinished in accordance with the finish specified for the part.

4.11 Use of steel wool. Steel wool shall not be used in lieu of emery or garnet abrasives to clean aluminum, magnesium alloy or stainless steel surfaces unless adequate precautions are taken to remove steel contaminants.

4.12 Welding, soldering, and brazing. Unless otherwise specified, welding, soldering and brazing shall not be permitted on an assembly after it has been finished with organic coatings. This restriction does not apply if the finish is MIL-P-46105, Primer Coating; Weld-Through, Zinc Rich, finish 24.1.

## 5. DETAIL REQUIREMENTS

### 5.1 INORGANIC FINISHES

5.1.1 Metallic coatings. Electrodeposited coatings are subject to hydrogen embrittlement. Hydrogen embrittlement during plating may be avoided by the use of vacuum deposited coatings such as MIL-C-8837 or mechanically deposited coatings such as MIL-C-81562 when specified for use. The basis metal shall be substantially free from flaws or defects that will be detrimental to the appearance or performance of the deposited metal. The surface shall be cleaned and coated as required by the detail specification, drawing or contract. The procuring activity shall select the desired finish from those shown in table II, and shall reference it on drawings, in contracts or in item specifications by the number shown in the table. Unless otherwise specified, steel parts Rockwell C-40 or above hardness, shall not be electroplated without a hydrogen embrittlement relief treatment or the specific approval of the procuring activity. These parts may be either vacuum coated with cadmium in accordance with MIL-C-8837 or mechanically coated with cadmium or zinc in accordance with MIL-C-81562. There are specific applications which allow plating of steel parts exceeding HRC 40, e.g., chromium plating for high strength steel landing gear parts; reference should be made to the applicable drawing or item specification for exceptions. The plated coatings listed in table II are applied by the usual or conventional plating techniques. Where in-place plating touch-up, build-up, or repair of metallic parts or surfaces are necessary brush plating techniques may be used. Reference should be made to MIL-STD-865.

5.1.1.1 Stress relief of ferrous alloy. Unless otherwise specified for a particular end item specification or drawing, after forming and hardening, and prior to cleaning and plating, objectionable residual stress in ferrous alloy parts having a hardness greater than Rockwell C-40 shall be relieved by suitable heat treatment. The temperature shall be such that maximum relief is given without hardness being reduced to less than the specified minimum. Stress relief is not necessary where it has been demonstrated that plating has no harmful effect on the plated part. When prestressed wire springs are to be plated, they shall be stress relieved immediately after winding.

5.1.1.2 Embrittlement relief. Unless altered by a specific end item finishing requirement (i.e., DOD-P-16232 etc.) all steel parts having a hardness of Rockwell C-40 and higher shall be baked at  $375 \pm 25$  F ( $191 \pm 14$  C) for three hours or more as soon after plating as practicable. Plated springs or other parts subject to flexure shall not be flexed prior to the baking operations. If the plated part (such as cadmium or zinc plate) is to be given a supplementary surface conversion treatment, such as chromate or phosphate, it should be treated to relieve hydrogen embrittlement before applying the conversion treatment, which could be rendered ineffective by baking.

5.1.2 Conversion coatings. Unless otherwise specified, stress relief and hydrogen embrittlement relief for steel parts HRC 39 and above shall be performed to DoD-P-16232. Hydrogen embrittlement relief treatments above 180 degrees F for zinc phosphate and 240 degrees F for manganese phosphate may adversely effect the corrosion resistance of the coating.

TABLE II. Inorganic finishes, metallic coatings.

Finish No.	Requirements
<u>1.1 Cadmium coatings</u>	
1.1.1	Plating, QQ-P-416, type I, without supplementary treatment
1.1.1.1	Class 1, 0.0005 inch (13 um) thick
1.1.1.2	Class 2, 0.0003 inch (7.6 um) thick
1.1.1.3	Class 3, 0.0002 inch (5.1 um) thick
1.1.2	Plating, QQ-P-416, type II, with supplementary chromate treatment; normal color; not bleached or clear (see 5.1.3.3)
1.1.2.1	Class 1, 0.0005 inch (13 um) thick
1.1.2.2	Class 2, 0.0003 inch (7.6 um) thick
1.1.2.3	Class 3, 0.0002 inch (5.1 um) thick
1.1.3	Plating, QQ-P-416, type III, with supplementary phosphate treatment (see 5.1.3.3)
1.1.3.1	Class 1, 0.0005 inch (13 um) thick
1.1.3.2	Class 2, 0.0003 inch (7.6 um) thick
1.1.3.3	Class 3, 0.0002 inch (5.1 um) thick
1.1.4	Cadmium coating (vacuum deposited), MIL-C-8837, type I, without supplementary treatment
1.1.4.1	Class 1, 0.0005 inch (13 um) thick
1.1.4.2	Class 2, 0.0003 inch (7.6 um) thick
1.1.4.3	Class 3, 0.0002 inch (5.1 um) thick
1.1.5	Cadmium coating (vacuum deposited), MIL-C-8837, type II, with supplementary chromate treatment, normal color, not bleached or clear (see 5.1.3.3)
1.1.5.1	Class 1, 0.0005 inch (13 um) thick
1.1.5.2	Class 2, 0.0003 inch (7.6 um) thick
1.1.5.3	Class 3, 0.0002 inch (5.1 um) thick
1.1.6	Cadmium coating (vacuum deposited), MIL-C-8837, type III, with supplementary phosphate treatment (see 5.1.3.3)
1.1.6.1	Class 1, 0.0005 inch (13 um) thick
1.1.6.2	Class 2, 0.0003 inch (7.6 um) thick
1.1.6.3	Class 3, 0.0002 inch (5.1 um) thick
1.1.7	Cadmium coating, mechanically deposited, MIL-C-81562, thickness and supplementary treatment as specified
<u>1.2 Chromium coatings</u>	
1.2.1	Decorative plating, QQ-C-320, class 1
1.2.1.1	Type I, bright
1.2.1.2	Type II, satin
1.2.2	Engineering plating, QQ-C-320, class 2; thickness and under-coating, if necessary, as specified
1.2.2.1	Class 2a
1.2.2.2	Class 2b
1.2.2.3	Class 2c
1.2.2.4	Class 2d
1.2.2.5	Class 2e

**TABLE II. Inorganic finishes, metallic coatings. (Continued)**

Finish No.	Requirements
1.2.3	Gray, MIL-N-55392
1.2.4	Black, MIL-C-14538
1.2.5	Porous chromium plating, MIL-C-20218
1.3	<u>Lead coatings</u>
1.3.1	Electrodeposited lead, MIL-L-13808, type I, without preliminary copper coatings
1.3.1.1	Class 1, 0.001 inch (25 um) thick
1.3.1.2	Class 2, 0.0005 inch (13 um) thick
1.3.1.3	Class 3, 0.00025 inch (6.4 um) thick
1.3.1.4	0.0015 inch (38 um) thick
1.3.2	Electrodeposited lead, MIL-L-13808, type II, with preliminary copper plating 0.000015 inch (0.38 um) thick
1.3.2.1	Class 1, 0.001 inch (25 um) thick
1.3.2.2	Class 2, 0.0005 inch (13 um) thick
1.3.2.3	Class 3, 0.00025 inch (6.4 um) thick
1.3.2.4	0.0015 inch (38 um) thick
1.3.3	Hot dip lead coating, MIL-L-13762
1.3.3.1	Type I (low tin content)
1.3.3.2	Type II (medium tin content)
1.3.3.3	Type III (high tin content)
1.4	<u>Nickel coatings</u>
1.4.1	Decorative plating, QQ-N-290, class 1; bright or dull finish as specified on drawing
1.4.1.1	Grade C, 0.0010 inch (25 um) thick
1.4.1.2	Grade E, 0.0006 inch (15 um) thick
1.4.1.3	Grade F, 0.0004 inch (10 um) thick
1.4.1.4	Grade G, 0.0002 inch (5 um) thick
1.4.1.5	Use finish 1.4.1.2 (grade E)
1.4.1.6	Use finish 1.4.1.3 (grade F)
1.4.1.7	Use finish 1.4.1.4 (grade G)
1.4.1.8	Use finish 1.4.1.2 (grade E)
1.4.1.9	Use finish 1.4.1.3 (grade F)
1.4.1.10	Use finish 1.4.1.3 (grade F)
1.4.1.11	Grade A, 0.0016 inch (40 um) thick
1.4.1.12	Grade B, 0.0012 inch (30 um) thick
1.4.1.13	Grade D, 0.0008 inch (20 um) thick
1.4.2	Engineering plating, QQ-N-290, class 2, thickness as specified.
1.4.3	Electroless nickel coating, MIL-C-26074
1.4.3.1	Class 1, as coated, no subsequent heat treatment
1.4.3.2	Class 2, steel, copper, nickel, cobalt, titanium-based alloys, and any basis metal not adversely affected by heating as specified for improved hardness

TABLE II. Inorganic finishes, metallic coatings. (Continued)

Finish No.	Requirements
1.4.3.3	Class 3, aluminum alloys non-heat-treatable, and beryllium alloys processed to improve adhesion of the nickel deposit
1.4.3.4	Class 4, aluminum alloys, heat-treatable, process to improve adhesion of the nickel deposit
1.4.4	Black nickel coating, MIL-P-18317 (undercoat as specified)
1.5	Use finish 1.2.4
1.6	Use finish 1.4.4
1.7	<u>Silver coating, QQ-S-365</u>
1.7.1	Type I, grade B, matte
1.7.2	Type II, grade B, semibright
1.7.3	Type III, grade B, bright
1.7.4	Type I, grade A (supplementary treatment), matte
1.7.5	Type II, grade A (supplementary treatment), semibright
1.7.6	Type III, grade A (supplementary treatment), bright
1.8	<u>Tin coatings</u>
1.8.1	Electrodeposited, MIL-T-10727, specifies ASTM B545 for Type I, thickness as specified
1.8.2	Hot-dipped, MIL-T-10727, type II, thickness as specified
1.9	<u>Zinc coatings</u>
1.9.1	Electrodeposited zinc, ASTM B633, type I, as plated without supplementary treatment
1.9.1.1	Class 1, 0.0010 inch (25 um) thick
1.9.1.2	Class 2, 0.0005 inch (13 um) thick
1.9.1.3	Class 3, 0.0002 inch (5.1 um) thick
1.9.2	Electrodeposited zinc, ASTM B633, type II with supplementary chromate treatment; normal color; not bleached or clear (see 5.1.3.3)
1.9.2.1	Class 1, 0.0010 inch (25 um) thick
1.9.2.2	Class 2, 0.0005 inch (13 um) thick
1.9.2.3	Class 3, 0.0002 inch (5.1 um) thick
1.9.3	Electrodeposited zinc, ASTM B633, type IV, with supplementary phosphate treatment (see 5.1.3.3)
1.9.3.1	Class 1, 0.0010 inch (25 um) thick
1.9.3.2	Class 2, 0.0005 inch (13 um) thick
1.9.3.3	Class 3, 0.0002 inch (5.1 um) thick
1.9.4	Zinc, hot-dip galvanizing, ASTM A153 (for hardware)
1.9.4.1	With chromate treatment, finish 6.1.1.2
1.9.4.2	With phosphate treatment, finish 6.1.1.1
1.9.5	Zinc coating, mechanically deposited, MIL-C-81562, thickness and supplementary treatment, as specified
1.10	<u>Copper coating, electrodeposited, MIL-C-14550</u>
1.10.1	Class 1, 0.0010 inch (25 um) thick
1.10.2	Class 2, 0.0005 inch (13 um) thick
1.10.3	Class 3, 0.0002 inch (5.1 um) thick
1.10.4	Class 4, 0.0001 inch (2.5 um) thick

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TABLE II. Inorganic finishes, metallic coatings. (Continued)

Finish No.	Requirements
1.11	<u>Gold coating, electrodeposited, MIL-G-45204</u>
1.11.1	Type I, 99.7 percent gold, minimum; hardness shall be specified
1.11.1.1	Class 1, 0.00005 inch (1.3 um) thick, minimum
1.11.1.2	Class 2, 0.00010 inch (2.5 um) thick, minimum
1.11.1.3	Class 3, 0.00020 inch (5.1 um) thick, minimum
1.11.1.4	Class 4, 0.00030 inch (7.6 um) thick, minimum
1.11.1.5	Class 5, 0.00050 inch (13 um) thick, minimum
1.11.1.6	Class 6, 0.00150 inch (38 um) thick, minimum
1.11.1.7	Class 0, 0.00003 inch (0.76 um) thick, minimum
1.11.1.8	Class 00, 0.00002 inch (0.51 um) thick, minimum
1.11.2	Type II, 99.0 percent gold, minimum; hardness shall be specified
1.11.2.1	Class 1, 0.00005 inch (1.3 um) thick, minimum
1.11.2.2	Class 2, 0.00010 inch (2.5 um) thick, minimum
1.11.2.3	Class 3, 0.00020 inch (5.1 um) thick, minimum
1.11.2.4	Class 4, 0.00030 inch (7.6 um) thick, minimum
1.11.2.5	Class 5, 0.00050 inch (13 um) thick, minimum
1.11.2.6	Class 6, 0.00150 inch (38 um) thick, minimum
1.11.2.7	Class 0, 0.00003 inch (0.76 um) thick, minimum
1.11.2.8	Class 00, 0.00002 inch (0.51 um) thick, minimum
1.11.3	Type III, 99.9 percent gold, minimum
1.11.3.1	Class 1, 0.00005 inch (1.3 um) thick, minimum
1.11.3.2	Class 2, 0.00010 inch (2.5 um) thick, minimum
1.11.3.3	Class 3, 0.00020 inch (5.1 um) thick, minimum
1.11.3.4	Class 4, 0.00030 inch (7.6 um) thick, minimum
1.11.3.5	Class 5, 0.00050 inch (13 um) thick, minimum
1.11.3.6	Class 6, 0.00150 inch (38 um) thick, minimum
1.11.3.7	Class 0, 0.00003 inch (0.76 um) thick, minimum
1.11.3.8	Class 00, 0.00002 inch (0.5 um) thick, minimum
1.12	<u>Aluminum coating</u>
1.12.1	Discontinued: Data to be specified on drawing or in contract
1.12.2	Vacuum deposited aluminum, MIL-C-23217
1.13	<u>Palladium coating</u>
1.13.1	Electrodeposited palladium, MIL-P-45209, thickness as specified
1.14	<u>Rhodium coating</u>
1.14.1	Electrodeposited rhodium, MIL-R-46085
1.14.1.1	Class 1, 0.000002 inch (0.05 um) thick
1.14.1.2	Class 2, 0.000010 inch (0.25 um) thick
1.14.1.3	Class 3, 0.000020 inch (0.51 um) thick
1.14.1.4	Class 4, 0.000100 inch (2.5 um) thick
1.14.1.5	Class 5, 0.000250 inch (6.4 um) thick

General finish requirement headings shall not be specified. The specific finish number(s) only shall be specified. See page iii for the proper method of specifying finishes.

5.1.3 Black oxide finishes. The basis metal shall be substantially free from flaws or defects that will be detrimental to the appearance or performance of the finish. The surface shall be cleaned and chemically finished as required by the detail specification, drawing or contract. The procuring activity shall select the desired finish from those shown in table III, and shall reference it on drawings, in contracts or in item specifications by the number shown in the table.

TABLE III. Inorganic finishes, black oxide.

Finish No.	Requirements
3.1	Discontinued
3.2	Black oxide for copper alloys, MIL-P-495
3.3	Black oxide for iron and steel, MIL-C-13924
3.3.1	Class 1, alkaline oxidizing process (for wrought iron, plain carbon, low alloy steels).
3.3.1.1	Class 1 with MIL-C-16173, Grade 3 supplementary oil treatment
3.3.2	Class 2, alkaline-chromate oxidizing process
3.3.2.1	Class 2 with MIL-C-16173, Grade 3 supplementary oil treatment
3.3.3	Class 3, fused salt oxidizing process
3.3.3.1	Class 3 with MIL-C-16173, Grade 3 supplementary oil treatment
3.3.4	Class 4, alkaline oxidizing process

General finish requirement headings shall not be specified. The specific finish number(s) only shall be specified. See page iii for the proper method of specifying finishes.

5.1.4 Metal treatments, other than metal deposition or black oxide.

5.1.4.1 Steel, noncorrosion-resistant. Prior to being painted, surfaces of noncorrosion-resistant steel (and iron) shall be cleaned and, unless otherwise specified, shall be pretreated. The cleaning shall leave the surface substantially free from oil, grease, dirt, scale, rust, and other foreign matter. Mechanical cleaning (finish 4.1) shall be used only where contamination from the process will not harm the surface being cleaned or any adjacent ones. The procuring activity shall select the method of cleaning from table IV (only if the pretreatment specification does not contain a cleaning requirement) and shall reference it on drawings, in contracts, or in item specifications by the number shown in the table. Porous castings may require sealing to assure that they are leakproof and would be required to prevent bleeding-out of treating chemical which would cause staining or corrosion of the metal surface and damage to the finishing system. Impregnation or sealing should be accomplished after preparation as in 4.3.1.



TABLE IV. Cleaning methods<sup>1/</sup>

Finish No.	Requirements
4.1	Abrasive blasting
4.2	Hot alkaline cleaning
4.3	Solvent cleaning (immersion or spray)
4.4	Phosphoric acid cleaning (alcoholic, detergent or solvent type with detergent) MIL-C-10578
4.5	Use finish 4.4
4.6	Emulsion cleaning
4.7	Alkaline derusting (MIL-C-46156 or MIL-C-14460)
4.8	Acid pickling
4.8.1	Sulfuric acid pickling. Immerse the part in a solution consisting of 5 volumes of sulfuric acid (66 Baume or 1.84 Sp Gr), 95 volumes of water, and nonfoaming liquid inhibitor, O-1-501, type B, class A, as directed by manufacturer of inhibitor, at a temperature of 170 - 180 F (77 - 82 C). After removal of scale (indicated by a uniform gray color), remove part from solution, allow to drain, and then rinse in fresh circulating water at 170 - 180 F (77 - 82 C). Immerse for 2 to 5 minutes in solution of 1 ounce (28 g) of sodium dichromate and 3/4 ounce (21 g) of phosphoric acid (75% grade) per gallon (3.8 l) of water, at 190 to 205 F (88 - 96 C). Discard rinsing bath when combined sulfuric acid and iron sulfate reaches 2 grams per gallon. After surfaces are thoroughly dry, treat and/or paint as soon as possible. (Note: Where the steel parts will be used under stress cleaning by acid pickling is not recommended because of hydrogen embrittlement. Acid pickling is also not recommended prior to phosphating.
4.8.2	Acid pickling - other methods as specified in detail on drawing or in contract
4.9	Hot alkaline cleaning, nonetching, for nonferrous (and ferrous) metals. Use P-C-436 material in accordance with specification
4.10	Vapor degreasing, using solvent conforming to O-T-634, type II or MIL-T-81533

General finish requirement headings shall not be specified. The specific finish number(s) only shall be specified. See page iii for the proper method of specifying finishes.

<sup>1/</sup>Additional details on cleaning methods and procedures may be found in MIL-HDBK-132, MIL-HDBK-205, MIL-P-116, and TT-C-490.

TABLE V. Surface treatments and finishes for iron and steel.  
(including corrosion-resisting steel ores)

Finish No.	Requirements
Finishes for iron and low-alloy steels	
*5.1	Light phosphate paint base coatings
5.1.1	Zinc phosphate base, TT-C-490, type I
5.1.2	Iron phosphate base, TT-C-490, type II or IV
5.2	Pretreatment coating, TT-C-490, type III (wash primer)
*5.3	Heavy phosphate coatings
*5.3.1	Manganese phosphate base, DOD-P-16232, type M
5.3.1.1	Class 1, supplementary preservative treatment or coating, as specified.
5.3.1.2	Class 2, supplementary treatment with lubricating oil conforming to MIL-L-3150
5.3.1.3	Class 3, with no supplementary treatment
5.3.1.4	Class 4, Chemically converted (may be dyed to color as specified) with no supplementary coating or supplementary coating as specified
*5.3.2	Zinc phosphate base, DOD-P-16232, type Z
5.3.2.1	Class 1, supplementary preservative treatment or coating, as specified
5.3.2.2	Class 2, supplementary treatment with preservative conforming to MIL-C-16173, grade 3 or MIL-L-3150 (as alternate for very small parts)
5.3.2.3	Class 3, with no supplementary treatment
5.3.2.4	Class 4, Chemically converted (may be dyed to color as specified) with no supplementary coating or supplementary coating as specified.
5.3.3	Specify finish 5.3.2.1, 5.3.2.2, or 5.3.2.3 as applicable
5.3.4	Use finish 5.3.2.4
Finishes for corrosion-resisting steels	
*5.4	Corrosion-resisting steel not to be painted
5.4.1	Clean and passivate, QQ-P-35 (clean ASTM A380)
5.4.2	Discontinued: Use Finish 5.4.1
*5.5	Corrosion-resisting steel to be painted
5.5.1	Cleaning, passivation, and pretreatment coating Clean and passivate, QQ-P-35 (clean ASTM A380) Surfaces to be painted shall be treated with a wash primer conforming to DOD-P-15328

\*General finish requirement headings shall not be specified. The specific finish number(s) only shall be specified. See page iii for the proper method of specifying finishes.

5.1.4.1.1 Surface treatments for noncorrosion resistant steel. Immediately after cleaning, solvents and moisture, if any, shall be completely removed. Unless otherwise specified in the contract or order, the contractor may select the method of removal. Unless otherwise specified, the surfaces shall receive one of the treatments listed in table V immediately after removal of solvents and moisture. Unless otherwise specified, high strength steel parts (Rockwell C40 or higher) shall not be cleaned, phosphated, pickled or wash primed (finish 5.2) with acid containing materials without the specific approval of the procuring activity. The procuring activity shall select the treatment and shall reference it on drawings, in contracts or in item specifications by the number shown in the table.

5.1.4.2 Steel corrosion-resisting. Surfaces of corrosion resisting steel shall be thoroughly cleaned and treated by one or more of the finishes listed in table V. The procuring activity shall select the finish and shall reference it on drawings, in contracts, or in item specifications by the number shown in the tables.

5.1.4.3 Zinc and cadmium. Surfaces of zinc and cadmium shall be cleaned by degreasing (finish 4.10) or as otherwise specified. Prior to being painted, any surfaces without the supplementary treatments described in table II under finishes 1.1 or 1.9 shall be given one or more of the surface treatments in table VI. The procuring activity shall select the cleaning method (unless cleaning is specified in the pretreatment specification) and the finish shall be referenced on drawings, in contracts or in item specifications by the numbers shown in the tables.

TABLE VI. Surface treatments for zinc and cadmium

Finish No.	Requirements
*6.1	Phosphate and chromate treatments, MIL-T-12879
*6.1.1	Type I, prepaint treatment
6.1.1.1	Class 1, phosphate
6.1.1.2	Class 2, chromate
6.1.2	Type II, chromate final finish
6.2	Use Finish 5.1.1, light zinc phosphate coating
6.3	Use Finish 5.2, pretreatment coating
*6.4	Phosphoric acid conditioner, MIL-C-10578
6.4.1	Type I, wash-off
6.4.2	Type II, wipe-off

\*General finish requirement headings shall not be specified. The specific finish number(s) only shall be specified. See page iii for the proper method of specifying finishes.

5.1.4.4 Aluminum and aluminum alloy. Surfaces of aluminum or aluminum alloy shall be cleaned by vapor-degreasing (finish 4.10), nonetching alkaline cleaner (finish 4.9), or as otherwise specified (e.g., non-metallic abrasive blasting). They shall then be given immediately one or more of the treatments specified in table VII. The procuring activity shall select the cleaning method (unless cleaning is covered in the treatment specifications of table VII) and the treatment, and shall reference them on drawings, in contracts, or in item specifications by the numbers shown in the tables.

TABLE VII. Surface treatments and finishes for aluminum

Finish No.	Requirements
7.1	Anodic film, chromic-acid, MIL-A-8625, type I
7.1.1	Class 1, nondyed
7.1.2	Class 2, dyed, color to be specified
7.1.3	Anodic film, chromic-acid, MIL-A-8625, type IB (10W voltage process, 20V)
7.2	Anodic film, sulfuric acid, MIL-A-8625, type II
7.2.1	Class 1, nondyed
7.2.2	Class 2, dyed, color to be specified
7.3	Chemical film, chromate, MIL-C-5541
7.3.1	Class 1A, for maximum protection against corrosion, painted or unpainted
7.3.2	Discontinued: Use finish 7.3.1
7.3.3	Class 3, for protection against corrosion where low electrical resistance is required
7.4	Use finish 5.2, pretreatment coating
7.5	Hard anodic coating, MIL-A-8625, type III, thickness $0.002 \pm 0.0002$ inch ( $50.8 \pm 5$ um) unless otherwise specified.
7.5.1	Class 1, nondyed
7.5.2	Class 2, dyed, color to be specified
7.6 thru 7.9	Discontinued: Use finish 7.5

General finish requirement headings shall not be specified. The specific finish number(s) only shall be specified. See page iii for the proper method of specifying finishes.

5.1.4.5 Magnesium alloy. Surfaces of magnesium alloy shall be cleaned by vapor degreasing (finish 4.10), nonetching alkaline cleaner (finish 4.9), or as otherwise specified (e.g., non-metallic abrasive blasting). They shall then be immediately given one or more of the treatments specified in table VIII. Finish 8.1.2 is very corrosion resistant but is a hard, brittle coating and subject to chipping, cracking or spalling, therefore is recommended only for rigid parts. The procuring activity shall select the finish and shall reference it on drawings, in contracts, or in item specifications by the number shown in the table. Finish 8.6 is used for touch-up applications or where dimensional tolerance must be maintained.

5.1.4.6 Copper and copper alloy. Surfaces of copper, brass, and bronze shall be cleaned by vapor-degreasing (finish 4.10), or as otherwise specified. Surfaces that are to be painted shall be acid-etched (finish 4.4) or sandblasted (finish 4.1) just prior to being painted. The thickness of metal removed by blasting should not exceed 0.005 inch (130 um). The procuring activity shall reference the amount on drawings. The procuring activity shall select the method of cleaning (unless cleaning is covered in the treatment specifications of table IX) and pretreatment coating, and shall reference them on drawings, in contracts, or in item specifications by numbers shown in tables IV and IX. None of the primers listed in paragraph 5.2.3 should be applied directly over the acid-etched copper without first listing the pretreatment primer conforming to DOD-P-15328.

**TABLE VIII. Surface treatments for magnesium alloy**

Finish No.	Requirements
8.1	Anodic treatments, MIL-M-45202
8.1.1	Type I, class C, light coating
8.1.2	Type II, heavy coating
8.1.2.1	Class A, grade 3
8.1.2.2	Class D
8.2	Chrome pickle, MIL-M-3171, type I
8.3	Discontinued: Use finish 8.4
8.4	Dichromate treatment, MIL-M-3171, type III
8.5	Galvanic anodizing, MIL-M-3171, type IV
8.6	Chromic acid brush-on treatment, MIL-M-3171, type VI
8.7	Pretreatment coating, DOD-P-15328 with 50 percent of specified phosphoric acid
8.8	Fluoride anodizing process plus corrosion preventive treatment (for castings), MIL-M-3171, type VII
8.9	Chromate treatment, MIL-M-3171, type VIII

General finish requirement headings shall not be specified. The specific finish number(s) only shall be specified. See page iii for the proper method of specifying finishes.

**TABLE IX. Surface treatments for copper and copper alloys**

Finish No.	Requirements
9.1	Phosphoric acid conditioner, use finish 6.4
9.2	Abrasive blasting, use finish 4.1
9.3	Black oxide, use finish 3.2

5.1.4.7 Terneplate. Surfaces of terneplate shall be cleaned by vapor degreasing (finish 4.10), or as otherwise specified. Surfaces that are to be painted shall then be given one of the treatments described in table X. The procuring activity shall select the method of cleaning (unless cleaning is covered in the pretreatment specification of table X) and the treatment, and shall reference them on drawings, in contracts, or in item specifications by the numbers shown in the tables.

**TABLE X. Surface treatments for terneplate**

Finish No.	Requirements
10.1	Discontinued: Data to be specified on drawings or in the contract
10.2	Discontinued: Data to be specified on drawings or in the contract
10.3	Pretreatment coating, use finish 5.2
10.4	Discontinued: Data to be specified on drawings or in the contract

5.1.4.8 Tin. Surfaces of tin plate that are to be painted shall be cleaned by vapor degreasing (finish 4.10), or as otherwise specified. Hot-dip tin plate needs no other pretreatment. Tin plate, electrodeposited from an alkaline stannate bath shall be treated according to finish 11.2. The procuring activity shall reference the method of cleaning and the pretreatment on drawings, in contracts or in item specification by the numbers shown in tables IV and XI.

TABLE XI. Surface treatments for tin plate

Finish No.	Requirements
11.1	Discontinued: Specify cleaning by finish number in table IV
11.2	Acid etch. Immerse for 5 minutes in hot [160 - 180 F (71 - 82 C)] aqueous solution maintained at pH 2 to pH 3 by the addition of a solution containing equal parts by weight of phosphoric acid and chromic acid.
11.3	Pretreatment coating, use finish 5.2

5.1.4.9 Titanium and titanium alloy. Surfaces of titanium and titanium alloy shall be cleaned by vapor degreasing (finish 4.10), or as otherwise specified. Caution should be exercised in the use of chlorinated vapor degreasing solvents as they can cause stress corrosion cracking of titanium alloys. Surfaces that are to be painted shall then be sandblasted (finish 4.1). When sandblasting is not feasible, the clean surface shall receive finish 5.2, pretreatment coating. The procuring activity shall select the method of cleaning and the pretreatment, and shall reference them on drawings, in contracts, or in item specifications by the numbers shown in tables IV and XII.

TABLE XII. Surface treatments for titanium and titanium alloy

Finish No.	Requirements
12.1	Abrasive blasting, use finish 4.1
12.2	Pretreatment coating, use finish 5.2

## 5.2 Organic finishes.

5.2.1 General painting guidelines. Painting shall be done in clean, dry, well-ventilated spaces. It is preferred that the air temperature be between 60 and 90°F (16 and 32°C) and the relative humidity not over 65 percent. Painting should not be done when the temperature is below 50°F (10°C) or when the humidity is above 85 percent. Materials shall be thoroughly mixed and there shall be no settling or separation of ingredients during painting.

Unless specifically directed otherwise, coatings may be applied by any method that will ensure the application of a smooth, uniform, continuous film, free from dried overspray, runs, sags, blisters, orange peel, or other imperfections.

Unless otherwise specified, for bake type coatings, ample flash off time should be allowed before exposing the coats of paint to a temperature of 200°F (93°C) for 45 minutes. Freshly painted materiel shall not be exposed to conditions that will harm the paint. Pretreatment coating DOD-P-15328 (finish 5.2) shall be applied either in accordance with that specification or in accordance with MIL-C-8507. Prior to painting magnesium alloy, first apply one of the finishes 8.1 through 8.6 or 8.9. A surface sealing coating can then be applied. MIL-M-3171 cites a surface coating resin, baking type epoxy sealer.

When pretreatment coating DOD-P-15328 (finish 5.2) is applied to magnesium alloy, its phosphoric acid content shall be reduced to 50 percent of that specified in DOD-P-15328. Additional data on the application of finishes can be found in MIL-HDBK-132 and MIL-F-18264.

5.2.1.1 Previously painted surfaces. Prior to the application of paint to equipment previously painted, the surfaces shall be thoroughly cleaned. If solvent is used it shall be oil free. All loose paint shall be removed. When touching up damaged areas or applying a CARC topcoat to an existing CARC topcoat, the procedure to be followed depends upon the type and condition of the existing finish. Items previously coated with alkyds, lacquers or vinyls must be stripped down to the epoxy primer if present, or to the substrate if not. For rework, polyurethane and epoxy topcoats can only be applied over previously painted epoxy or polyurethane topcoats. When it is necessary to remove the old paint it may be done with solvent-type paint remover, by abrasive blasting (finish 4.1) or other mechanical means. Care shall be used to remove residual remover and solvent from crevices and pockets. Finish 4.1 should be used only where contamination from the process will not harm the surface being cleaned or any adjacent parts. Regardless of the method, no harmful residue shall be left on the surface.

5.2.2 Painting schedule. The first, or priming coat of paint shall be applied as promptly as possible (preferably on the same day but, in any event, within 24 hours) after the surface has been prepared for painting. This requirement shall apply particularly to metal parts that have received a surface treatment.

Each coat of paint shall be dry before the application of a succeeding coat. For example, under good conditions, 24 hours is sufficient for air-drying paint, such as that conforming to TT-E-485, or TT-E-529; 15 minutes for lustreless enamel conforming to TT-E-516; 10 minutes for lacquer conforming to MIL-L-11195. In no case shall the time allowed for drying be less than that specified for the recoating or self-lifting test (if specified) in the applicable specification. For application of Chemical Agent Resistant Coatings (CARC), see MIL-C-53072.

5.2.2.1 Unassembled parts. When circumstances make it desirable, primers and intermediate coats may be applied to unassembled parts of an assembly, the final coat being applied after assembly. Prior to application of final coat, all damage to previously applied paint shall be repaired and all soils deposited on the surface during the assembly shall be removed with a cleaner which will not damage the primer or leave an oil deposit.

5.2.3 Film thickness. Unless otherwise specified, the thickness of the dry paint film or one coat application shall be as follows:

<u>Specification</u>	<u>Thickness in mils</u>
Pretreatment coating:	
DOD-P-15328	0.3-0.5
Primers:	
TT-E-485	0.8-1.2
TT-P-664	1.0-1.5
TT-P-1757	0.4-0.6
MIL-P-11414	0.6-0.8
MIL-P-14553	0.4-0.6
MIL-P-15930	0.4-0.6
MIL-P-23377 <sup>1/</sup>	0.8-1.2
MIL-P-46105	2.0-3.0
MIL-P-53022	1.0-1.5
MIL-P-53030	1.0-1.5
MIL-P-53084	0.8-1.2
MIL-P-85582	0.8-1.2
Primer surfacers:	
TT-P-662	0.8-1.2
Other primers (unless otherwise specified)	0.8-1.2
Top coats:	
MIL-C-22750	1.3-1.7
MIL-C-46168	1.8 min
MIL-C-53039	1.8 min
All other top coats, clear or opaque	0.8-1.2

<sup>1/</sup>Except for aircraft, film thickness shall be 0.6-0.9 mils.

NOTE: Where multiple coats are designated in the tables for finishes the dry film thickness shall be multiplied proportionally. One coat shall be applied by a minimum of one double or cross pass of spray gun. One coat shall not be construed as one pass of the spray gun.



5.2.3.1 Film thickness for camouflage. Where camouflage top coats are used, a minimum of 1.8 mils dry film thickness shall be applied. Normally two spray coats of 0.9 mil each will obtain this minimum film thickness, but with proper care to avert runs, sags or other defects, one coat may suffice.

5.2.4 Faying surfaces.

5.2.4.1 Wood. Wood in contact with metal shall be painted according to finish 26.3 (table XVIII). The metal surface shall receive two coats of an appropriate primer.

5.2.4.2 Metal. All metallic faying surfaces, whether of similar or dissimilar metals shall receive at least two coats of an appropriate primer except at slip fits as mentioned below. Extra protection for dissimilar metals may be provided with sheet or tape. After joining is complete and prior to topcoating, fillet seal all joints where moisture could enter from the top or horizontal with sealant MIL-S-81733. At slip fits or press fits, coating with one of the primers listed above, and assembling while wet, affords some protection. However, such treatments cannot take the place of proper sealing and painting of the joints.

5.2.5 Adhesion. All paint finishes shall show good adhesion to substrates and to other paint coatings when tested to the applicable paint specification.

5.2.6 Appearance. All paint systems shall have uniform and satisfactory hiding power, color, gloss, and smoothness.

5.2.7 Color. When a paint specification provides for more than one color, the procuring activity shall select the color and reference it on drawings, in contracts or in item specifications by number in Fed. Std. No. 595.

5.2.7.1 Color for Army. Unless otherwise specified, all new materiel and materiel undergoing depot overhaul, shall be painted with Chemical Agent Resistant Coatings (CARC) conforming to MIL-C-46168 or MIL-C-53039 in color Green 383 for exterior and with CARC conforming to MIL-C-22750 in the selected color for interiors. CARC painted equipment will be stencilled with the acronym "CARC" followed by the year of application. It must be located near the data plate and applied against a camouflage green or brown background, if pattern painted. For exteriors, when other colors are used, they shall be CARC conforming to MIL-C-46168 or MIL-C-53039 and will usually be color Brown 383 and Black. Other colors of CARC conforming to MIL-C-46168 or MIL-C-53039 may be used for exteriors of items having special requirements, e.g., Arctic or Desert use, ammunition, aircraft, etc. An item of materiel painted with a three color pattern identifies the coating as CARC. The acceptance of the coating shall not be based on a specific visual color match (see 6.10.)

5.2.8 Corrosion resistance. Unless otherwise specified, all primer coatings shall be capable of passing the salt spray requirements of the applicable paint specification called out for the hardware item.

5.3 Paint finishes for metals. Tables XIII, XIV and XV list most of the paint finishes for metals necessary for a wide variety of military equipment. An overwhelming percentage of metallic surfaces that are painted are steel (iron), or aluminum and magnesium, and their alloys. Tables XIII through XVI provide specifically for these metals, but the finishes are also suitable for zinc, cadmium, copper, tin, terne and titanium. In many finishes, aluminum and magnesium, and their alloys require special primers (see 5.3.1 and 5.3.2). Special finishes are listed in table XVI. Acid catalyzed primers and topcoats shall not be utilized on high strength steel parts (Rockwell C 48 or higher) without the specific approval of the procuring activity. The procuring activity shall select the finish and shall reference it on drawings, in specifications or in contracts by the number shown in the tables.

5.3.1 Priming paint for aluminum.

5.3.1.1 Conventional primers. Primers meeting TT-P-1757, MIL-P-15930 or MIL-P-23377 shall be used in tables XIII, XIV, XV, and XVI in lieu of TT-E-485, TT-P-664, and MIL-P-11414 in priming aluminum. In mixed metal assemblies with aluminum, finish 5.2 shall be specified as a pretreatment prior to application of these primers. Primer MIL-P-15930 shall not be used under baking finishes where the baking temperature exceeds 250°F (121°C) or as a primer for a lacquer topcoat. When MIL-P-23377 is used, the contractor shall determine that the topcoat demonstrates adequate compatibility and adhesion to the primer, and that the primer adheres to the substrate.

5.3.1.2 Chemical agent resistant coatings (CARC) primers. MIL-P-53022, MIL-P-53030, or MIL-P-53084 shall be used on pretreated ferrous or non-ferrous metals, or where both ferrous and non-ferrous metals are present in the same assembly, prior to the application of the CARC topcoat. MIL-P-23377 or MIL-P-85582 may be used on pretreated non-ferrous metals or on mixed ferrous and non-ferrous assemblies (Type I only of MIL-P-23377).

5.3.2 Priming paint for magnesium (conventional and CARC). Unless otherwise specified, epoxy primer meeting MIL-P-23377, MIL-P-85582, MIL-P-53022 or MIL-P-53030 shall be used in tables XIII, XIV, XV, and XVI in lieu of TT-E-485, TT-P-664 and MIL-P-11414 in priming magnesium. Unless otherwise specified, DOD-P-15328 (finish 8.7) shall be specified as a minimum pretreatment prior to application of primer and the phosphoric acid content for this pretreatment coating shall be reduced to 50 percent of that required by DOD-P-15328. Zinc chromate primers meeting TT-P-1757 or MIL-P-15930 may be substituted for MIL-P-23377 when approved by the procuring activity. When MIL-P-53022, MIL-P-53030, MIL-P-23377, MIL-P-85582 or MIL-P-53084 is used the contractor shall determine that the topcoat demonstrates adequate adhesion to the primer, and that the primer adheres to the substrate.

5.3.3 Priming paint for dissimilar metal assemblies. The primer used with dissimilar metal assemblies shall be the primer specified for the anodic or less noble member of the assembly. For example, a component composed of magnesium and steel will require the use of primers for magnesium as specified in 5.3.2.

5.3.4 Number of coats of paint, minimum. The number of coats indicated under remarks in the following tables includes primer (if used), for example, finish 20.4 consists of one (1) coat of primer plus one (1) coat of topcoat. The coating thicknesses shall be as specified in 5.2.3.

5.3.5 Application of CARC/camouflage systems. Unless otherwise specified Green 383 paint shall be applied over the specified primer at a minimum dry film thickness of 1.8 mils to achieve optimum infrared camouflage characteristics. An application of 0.8-1.2 mils dry, which is the normal thickness for a paint topcoat, will only provide visual camouflage. In summary, the 1.8 mil minimum requirement provides visual and infrared camouflage as well as chemical agent resistance. Texture and type of substrate may cause a variation in appearance. The acceptance of the coating shall not be based specifically on color (see 6.10.)

5.3.5.1 Primer. Primer requirements include thickness, adhesion and corrosion resistance for carbon and low alloy steels. See tests in Section 6.

5.3.5.2 Top coat. Top coat requirements include thickness, adhesion and "degree of cure" for all substrate material. See tests in Section 6.

**TABLE XIII. Lusterless paint finishes for metal surfaces.**

Finish No.	First coat	Topcoat(s)	Remarks
20.1		TT-E-516 or MIL-E-52891	One coat finish for projectiles, grenades, etc.
20.2		MIL-L-11195	
20.3	Discontinued	Use finish 20.4 or 20.5	
20.4	MIL-P-11414 <sup>1</sup> / or TT-P-664	MIL-L-11195	Two coat lacquer finish for automotive and general use
20.5	TT-P-664 <sup>1</sup> / or MIL-P-11414	MIL-E-52891 (for ammunition use)	Two coat lusterless alkyd finish for general use except poor gasoline resistance Determine where finish is to be used and accordingly substitute finish 20.4, 20.8 or 20.9
20.6	Discontinued	Use finish 20.4 or 20.5	
20.7	Discontinued	Use finish 20.8	
20.8	TT-P-664 <sup>1</sup> / or TT-P-664	TT-E-527	Two coat alkyd finish for general use
20.9	TT-P-664 <sup>1</sup> / or TT-P-664	TT-E-515	Quick drying two coat alkyd finish for general use
20.10	MIL-P-11414 <sup>1</sup> / or TT-P-664	TT-P-662 plus MIL-L-11195	Three coat lacquer finish for automotive and general use
20.11	Discontinued	Use finish 20.8	
20.12	Discontinued	Use finish 20.8	
20.13	Discontinued:	Data to be specified on drawing or in contract	
20.14	Discontinued	Use finish 20.9	
20.15	Discontinued	Use finish 1.9.3.3 plus 20.8	
20.16	Discontinued	Use finish 5.3.1.3 plus 20.8	
20.17	Discontinued	Use finish 5.3.2.3 plus 20.8	
20.18	Discontinued:	Data to be specified on drawing or in contract	
20.19	Discontinued	Use finish 20.24	

TABLE XIII. Lusterless paint finishes for metal surfaces. (Continued)

Finish No.	First coat	Topcoat(s)	Remarks
20.20	Discontinued	Use finish 20.24	
20.21	Discontinued	Use finish 20.24	
20.22	Discontinued	Use finish 20.24	
20.23	Discontinued	Use finish 20.24	
20.24	MIL-P-53022 MIL-P-53030 <sup>2/</sup>	MIL-C-46168 or MIL-C-53039	Chemical agent resistant camouflage
20.24.1	Discontinued	Use any combination of primer and top coat(s) in finish 20.24	
20.24.2	Discontinued		•
20.24.3	Discontinued		•
20.24.4	Discontinued		•
20.24.5	Discontinued		•
20.24.6	Discontinued		•

<sup>1/</sup> When these finishes are specified for aluminum or magnesium the primers shall be as specified in paragraph 5.3.1 for aluminum and paragraph 5.3.2 for magnesium.

<sup>2/</sup> MIL-P-23377 (Type I) or MIL-P-85582 may be used on aluminum and non-ferrous metals or when both ferrous and non-ferrous metals are present. MIL-P-53084 may be used on pretreated ferrous or non-ferrous metals, or on assemblies with a mixture of both.

TABLE XIV. Semigloss paint finishes for metal surfaces.

Finish No.	First coat	Topcoat(s)	Remarks
21.1		TT-E-485	One coat finish for ammunition containers, gasoline drums, etc.
21.2	Discontinued	Use finish 21.3	
21.3	TT-P-664	TT-E-529	Two coat alkyd finish for general use
21.4	Discontinued	Use finish 21.5	
21.5	TT-E-485 <sup>1/</sup>	TT-E-485	Two coat alkyd finish for general use
21.6	Discontinued	Use finish 21.3	
21.7	Discontinued		
21.8	Discontinued	Use finish 21.3 or 21.21	
21.9	TT-P-664	TT-E-529 (2 coats)	Two coat alkyd finish for general use
21.10	Discontinued	Use finish 21.9	
21.11	MIL-P-11414 <sup>1/</sup> or TT-P-664	MIL-L-52043	Two coat lacquer finish for automotive materials
21.12	MIL-P-11414 <sup>1/</sup> or TT-P-664	TT-P-662 plus MIL-L-52043	Three coat lacquer finish for automotive materials
21.13	MIL-P-11414 <sup>1/</sup> or TT-P-664	MIL-L-52043 (2 coats)	
21.14	Discontinued		
21.15	Discontinued		
21.16	Discontinued	Use finish 1.9.3.3 plus 21.5 or 21.3	
21.17	Discontinued	Use finish 1.9.3.3 plus 21.9	
21.18	Discontinued	Use finish 21.12	
21.19	TT-P-1757	TT-E-485 (2 coats)	Three coat finish for general use
21.20	MIL-P-14553 (dip and bake) or TT-P-664 (spray and bake)	TT-E-485 or TT-E-529 (baking type)	Two coat baking finish for automotive equipment
21.21	Discontinued		

<sup>1/</sup>When these finishes are specified for aluminum or magnesium the primers shall be as specified in paragraph 5.3.1 for aluminum and paragraph 5.3.2 for magnesium.

TABLE XV. Full gloss paint finishes for metal surfaces.

Finish No.	First coat	Topcoat(s)	Remarks
22.1	Discontinued	Use finish 22.2	
22.2	TT-P-664	TT-E-489	Two coat alkyd finish for general use
22.3	Discontinued		
22.4	Discontinued		
22.5	Discontinued		
22.6	Discontinued	Use finish 24.10	
22.7	Discontinued	Use finish 24.10	
22.8	Discontinued	Use finish 22.2	
22.9	MIL-P-14553 (dip and bake) or TT-P-664 (spray)	TT-E-489 (air dry, VOC compliance)	Two coat alkyd enamel finish
22.10	TT-P-664	TT-E-1593	Two coat silicone-alkyd finish for general exterior use. Outstanding gloss and color retention

1/When these finishes are specified for aluminum or magnesium the primers shall be as specified in paragraph 5.3.1 for aluminum and paragraph 5.3.2 for magnesium.

**TABLE XVI. Special paint finishes for metals.**

Finish No.	Description of coating	Remarks
23.1	Discontinued: Data to be specified on drawing or in contract	
23.2	Discontinued: Data to be specified on drawing or in contract	
23.3	Discontinued: Data to be specified on drawing or in contract	
23.4	Discontinued: Data to be specified on drawing or in contract	
23.5	Discontinued: Data to be specified on drawing or in contract	
24.1	MIL-P-46105, 2-3 mil dry film thickness	Weld through primer
24.2	MIL-C-450	Asphalt coating for painting the interior of ammunition items prior to being filled with explosives. Not suitable as prime coat for painting
24.3	TT-C-520, 1/16 inch minimum dry film thickness	Underbody coating for motor vehicles
24.4	Discontinued: Data to be specified on drawing or in contract	
24.5	TT-P-28 (aluminum) or MIL-P-14105 (colors)	Heat resistant finish for temperatures to 1200°F. MIL-P-14105 is used on exterior of equipment where surfaces exceed 400°F.
24.6	MIL-P-22332	Primer for painting the interior of ammunition items prior to being filled with explosives. It may also be used to prime exterior surfaces
24.7	TT-C-494	Acid resistant asphalt paint for general use
24.8	MIL-C-22750 (1.5 mils min dry film thickness)	Epoxy copcoat resistant to hydraulic fluid spillage
24.9	MIL-P-23377 (2 coats-bake) plus <sup>4/</sup> TT-E-529 (2 coats-baking type)	For magnesium or other metals subject to severe exposure
24.10	TT-V-51 (2 coats)	Two coat acid resistant finish for general use
24.11	Discontinued: Data to be specified on drawing or in contract	
24.12	TT-P-1757 Color Y (2 coats)	For missile use on parts requiring primer only. Apply over pretreatment
24.13	TT-V-119 pigmented with 20 ounces per gallon of TT-P-320, type II, class B, 0.5-0.7 mil dry film thickness	Oil resistant aluminum coating for interior of gear cases or housings



TABLE XVI. Special paint finishes for metals. (Continued)

Finish No.	Description of Coating	Remarks
24.14	MIL-C-4556 (2 coat system, 3.0 mil minimum dry film thickness per coat)	Epoxy coating kit for interior of fuel transportation and storage tanks
24.15	DoD-P-23236 class 3 (3.0-4.0 mil dry film thickness)	Zinc rich primer for steel structures that receive severe exposure to adverse weather, condensing moisture, corrosive atmospheres and marine environments
24.16	MIL-P-38336 (3.0-4.0 mil dry film thickness)	
24.17	MIL-P-23377 <sup>1/</sup> , MIL-C-22750	For protection of areas exposed to chemicals and solvents or for internal surfaces where chemical agent resistant coating is required
24.18	Discontinued	
24.19	Discontinued	
24.20	Discontinued	
*24.21	Discontinued	
24.21.1	Discontinued	
24.21.2	Discontinued	
24.21.3	Discontinued	
*24.22	Discontinued	
24.22.1	Discontinued	
24.22.2	Discontinued	
24.23	Discontinued	
24.24	Discontinued	

\*General finish requirement headings shall not be specified. The specific Finish Number(s) only shall be specified. See page iii for the proper method of specifying finishes.

<sup>1/</sup>MIL-P-23377 (type I) or MIL-P-85582 shall be used on aluminum and nonferrous surface or when both ferrous and nonferrous materials are present. Alternative Coatings of MIL-P-53022 or MIL-P-53030 may also be used on both ferrous and nonferrous materials or when both materials are present in the same assembly.

5.4 Preservative treatments for wood. Preservative treatments are often required for both painted and unpainted material and must be used when specified. A nonpentachlorophenol preservative should be used for this purpose. Caution must be exercised in the use of preservative materials as some water based preservatives might cause objectionable swelling and/or a raised-grain in a high quality end use. When a preservative treatment is specified, the wood surface shall be dry and free from grease and other foreign matter before it is treated. Wood that is to be treated shall not have a moisture content exceeding 20 percent of its oven dry weight. Where

possible, wood parts shall be cut to final dimensions, planed or sanded smooth, and holes, rabbets, and the like, shall be made before treatment. In the event that it becomes necessary to make holes, rabbets, sawcuts, or the like, after treatment, preservative shall be applied liberally to surfaces exposed by these operations. Table XVII lists two treatments.

5.4.1 Preservative identification. The letters "PA" shall be annotated on all wood products subjected to the PQ56 (copper-8-quinolinolate) preservative treatment in accordance with Table XVII. The letters "PB" shall be annotated on all wood products subject to the M-GARD W550 (zinc naphthenate emulsifiable) preservative treatment in accordance with Table XVII.

5.4.2 Presence of Preservative.

5.4.2.1 Presence of PQ56 (copper-8-quinolinolate) preservative. When treated with PQ56, the box shall show evidence of discoloration when tested as specified in 5.4.4.1 and inspected in accordance with 5.4.3.1.

5.4.2.2 Presence of M-GARD W550 (zinc naphthenate emulsifiable) preservative. When treated with M-GARD W550, the box shall show evidence of discoloration when tested as specified in 5.4.4.2 and inspected in accordance with 5.4.3.2.

5.4.3 Inspection for presence of preservation.

5.4.3.1 Presence of PQ56 (copper-8-quinolinolate) preservative. (See 5.4.2.1) Major defect. A sample of 15 boxes shall be selected at random, from each lot, for this test. Four individual boards shall be tested from each box; each board from a different side of the box. The boards shall be tested in accordance with 5.4.4.1. If one board fails to meet the applicable requirement, an additional board may be tested from the box. The failure of two boards to meet the requirements shall constitute the rejection of the box and the lot.

5.4.3.2 Presence of M-GARD W550 (zinc naphthenate emulsifiable) preservative. (See 5.4.2.2), Major defect. A sample of 15 boxes shall be selected at random, from each lot, for this test. Four individual boards shall be tested from each box; each board from a different side. The boards shall be tested in accordance with 5.4.4.2. If one board fails to meet the applicable requirement an additional board may be tested from the box. The failure of two boards to meet the requirements shall constitute the rejection of the box and the lot.

5.4.4 PQ56 (copper-8-quinolinolate)

5.4.4.1 Presence of PQ56 (copper-8-quinolinolate) preservative.

5.4.4.1.1 Primary method.

5.4.4.1.1.1. Materials and equipment. The material and equipment required are as follows:

a. PQ Check (indicator): The formulation contains 10 parts by weight, of sodium diethyldithiocarbamate trihydrate (see 5.4.7) and 90 parts by weight of distilled water.

b. Dropper: An ordinary glass tube eyedropper may be used.

5.4.4.1.1.2 Test procedure. Two drops of PQ Check (indicator) shall be applied to the wood surface at both ends of the board and the middle. An immediate dark brown coloration and the spreading of the drops shall indicate PQ56 treatment.

5.4.4.1.2. Alternate method.

5.4.4.1.2.1 Materials and equipment. The material and equipment required are as follows:

a. Reagent. Dissolve 0.5 grams chrome azurol S concentrate (see 5.4.8) and 5.0 grams sodium acetate in 80 ml of distilled water and then dilute further to 500 mL total with distilled water.

b. Sprayer. A common manual (fly) sprayer type applicator shall be used.

5.4.4.1.2.2 Test procedure. Spray solution over surface of dried wood. A deep blue color reveals the presence of copper (from the copper-8-quinolinolate).\*

5.4.4.2 Presence of M-GARD W550 (zinc naphthenate) emulsifiable preservative.

5.4.4.2.1 Primary method.

5.4.4.2.1.1 Materials and equipment. The materials and equipment required are as follows:

a. Reagent. Dissolve 0.1 grams of dithizone (diphenylthiocarbazone) (see 5.4.9) in 100 mL of chloroform (Note: Solutions should be made up daily).

b. Sprayer. A common manual (fly) sprayer type applicator shall be used.

5.4.4.2.1.2 Test procedure. Spray solution evenly over dried wood. The indicator will turn pink when zinc (M-GARD W550) is present. The pink color fades with light.

5.4.4.2.2 Alternate method.

5.4.4.2.2.1 Materials and equipment. The materials and equipment required are as follows:

a. Reagent. (Stock solutions).

(1) 1 gram of potassium ferricyanide dissolved in 100 mL of distilled water.

(2) 1 gram of potassium iodide dissolved in 100mL of distilled water.

(3) Starch indicator solution. Make a paste of 1 gram of soluble starch in about 5mL of distilled water, add 100mL of distilled water and boil for 1 minute with constant stirring. Cool. Note: This solution is subject to biodegradation and therefore should not be used longer than 3 days before a new batch is prepared.

b. Sprayer. A DeVilbiss No. 30 atomizer or equivalent.

5.4.4.2.2.2 Test procedure. Mix 10mL each of the three stock solutions and pour into the atomizer (sprayer). Spray mixture evenly over surface of dried wood. The solution will cause the treated wood to turn a deep blue instantly while the untreated part will retain its original color.

5.4.5 PQ56. Preservative for the 1.8 percent copper-8-quinolinolate solution, may be obtained from the Chapman Chemical Company, P.O. Box 9158, Memphis, TN 38019 or equivalent facility.

5.4.6 M-GARD W550 (zinc hydronap). Preservative for the 3 percent zinc as metal solution, may be obtained from the Mooney Chemicals, Inc., 2301 Scranton Road, Cleveland, OH 44113-9988 or equivalent facility.

5.4.7 Sodium diethylthiocarbamate trihydrate. This reagent may be obtained from J. T. Baker Chemical Co., Phillipsburg, NJ 08865 or equivalent facility.

5.4.8 Chrome axurol "s". This reagent may be obtained from Eastman Chemical Co., Rochester, NY or equivalent facility.

5.4.9 Dithizone (diphenylthiocarbazone). This reagent may be obtained from Matheson, Coleman and Bell Co., Cincinnati, OH or equivalent facility.

TABLE XVII. Wood preservative treatments.

Finish No.	Requirements
25.1	Discontinued
25.2	<p>Immersion treatment. Dress the wood part to correct cross sectional dimensions. The wood item of the finished wood parts thereof shall be completely immersed for a minimum of one minute in a solution of wood preservative PQ56 reduced with water down to 1.8 percent copper-8-quinolinolate as solution (see 5.4.5) or an emulsion of wood preservative M-GARD W550 (zinc naphthlenate) reduced with water down to 3 percent zinc as metal (see 5.4.6). Alternatively, the wood items or the finished wood parts thereof shall be completely flooded for a minimum of one minute in PQ56 or M-GARD W550 emulsion as to inundate all interior and exterior surfaces (when finished wood parts are dipped). Care shall be exercised to assure complete coverage of all surfaces of the board. After the dip treatment, the items must be air dried (or dried for an appropriate time in a kiln or oven) for a period of 24 hours minimum in a well ventilated area allowing full air circulation around all surfaces of the wood. The wood items must be dried prior to shipment.</p> <p>The treater/manufacturer will be required to obtain and provide all available safety, health and environmental data e.g., Material Safety Data Sheets.</p>
25.3	<p>Surface treatment. Dress the wood part to correct cross sectional dimensions. Apply one liberal coat of preservative solution. Where practical, apply the solution by immersion for not less than one minute. Otherwise brushing or flooding is acceptable. Allow the treated wood to air-dry or kiln-dry before it is painted.</p>

5.5 Paint finishes for wood. Paint finishes for wood are indicated in table XVIII. The treatment of the wood in accordance with one of the systems indicated in table XVII prior to painting provides a more weather resistant finish for exterior exposure and is at the option of the procuring activity. The wood shall not have a moisture content exceeding 20 percent of its oven dry weight. Additional paint finishes for wood are indicated in table XIX.

TABLE XVIII. Paint finishes for wood.

Finish No.	First Coat	Topcoat(s)	Remarks
<b>LUSTERLESS</b>			
26.1	TT-P-664	TT-E-529 plus TT-E-527	Three coat alkyd finish for general use
26.2	Discontinued	Use finish 26.1	
26.3	Discontinued:	Data to be specified on drawing or in contract	
26.4	Discontinued:	Data to be specified on drawing or in contract	
26.5	Discontinued:	Data to be specified on drawing or in contract	
<b>SEMIGLOSS</b>			
27.1	TT-P-664	TT-E-529 (2 coats)	Three coat alkyd finish for general use
27.2	Discontinued	Use finish 27.1	
27.3	TT-E-485 or TT-P-664	TT-E-485 or TT-E-529	Two coat alkyd finish for general use
27.4	Discontinued	Use finish 27.3	
27.5	Discontinued	Use finish 27.3	
27.6	Discontinued	Use finish 27.1	
27.7	Discontinued	Use finish 27.3	
27.8	Discontinued	Use finish 27.1	
27.9	Discontinued:	Data to be specified on drawing or in contract	
<b>FULL GLOSS</b>			
28.1	TT-P-664	TT-E-489	Alkyd finish for general use
28.2	Discontinued		
28.3	TT-P-336 When needed for filling	TT-V-121 (2 coats)	Spar varnish
28.4	Discontinued		
28.5	TT-S-300; specify type and grade	TT-S-300	Shellac varnish
28.6	Discontinued:	Data to be specified on drawing or in contract	

TABLE XIX. Miscellaneous paint finishes for wood.

Finish No.	Requirements
29.1	<u>Stain-varnish-wax.</u> Apply olive-drab stain to bare wood. Let dry. Apply two coats varnish, TT-V-121. Let each coat dry thoroughly. Apply wax, MIL-W-3688. Let dry. Polish with clean, dry cloth.
29.2	<u>Oil-shellac-varnish.</u> Apply linseed oil, TT-L-215, to bare wood. Let stand for 24 hours. Squeegee off excess. Let dry for at least 16 hours. Apply one coat shellac varnish, TT-S-300, type II, grade A. Let dry. Apply two coats varnish, TT-V-121. Let each coat dry thoroughly.
29.3	<u>Oil-shellac-clear lacquer.</u> Apply linseed oil, TT-L-215, to bare wood. Let stand for 24 hours. Squeegee off excess. Let dry at least 16 hours. Apply three coats of shellac varnish, TT-S-300, type I, grade B. Let each coat dry thoroughly, and rub each coat lightly with fine sandpaper. Apply two coats of clear lacquer, TT-L-58. Let dry between coats.
29.4	<u>Oil-shellac-lacquer.</u> Apply linseed oil, TT-L-215, to bare wood. Let stand for 24 hours. Squeegee off excess. Let dry for at least 16 hours. Apply three coats shellac varnish, TT-S-300, type I, grade B. Let each coat dry thoroughly, and rub each coat lightly with fine sandpaper. Apply white lacquer, MIL-L-11195 to a thickness of 2.5 to 3.0 mils, approximately 3 coats, if applied hot, 6 coats if applied cold.
29.5	<u>Preservative-shellac-varnish.</u> Apply finish 25.2 or 25.3 Apply one coat shellac varnish, TT-S-300, type II, grade A. Let dry. Apply one coat varnish, TT-V-121. Let dry.
29.6	<u>Preservative-varnish.</u> Apply finish 25.2 or 25.3. Apply two coats varnish, TT-V-121.
29.7	<u>For wood components of small arms.</u> Apply protective finish, TT-L-190 or, as specified.
29.8	<u>Fire retardant paint.</u> Apply over wood in accordance with finish 25.2, or 25.3

TABLE XX. Miscellaneous finishes not classified.

Finish No.	Requirements
30.1	Filler, graduation, TT-F-325
30.1.1	Type I, crayon type; color as specified; black, deep red, white, translucent white
30.1.2	Type II paste type; color as specified, black, deep red, white, translucent white
30.2 <sub>1</sub> /	Non-skid coating, 1/32 to 1/16 inch dry film thickness, DoD-C-24667, color as specified
30.3 <sub>1</sub> /	Walkway coating and matting, nonslip, MIL-W-5044, type and color as specified
30.4	Coating, luminescent, fluorescent and phosphorescent
30.4.1	Luminescent material, fluorescent, type I, MIL-L-25142
30.4.2	Luminescent material, phosphorescent, type P, form 1, MIL-L-3891
30.4.3	Luminescent material, fluorescent, type P, form 1, MIL-L-3891, color as specified
30.5	MIL-V-173; applied in accordance with MIL-T-152. For moisture and fungus proofing of electronic and associated equipment
30.6	MIL-I-46058, conformal coating for printed wiring boards
30.7	MIL-L-46010, Lubricant, Solid Film, Heat Cured, Corrosion Inhibiting
30.8	MIL-L-23398, Lubricant, Solid Film, Air-Cured (Corrosion Inhibiting)

General finish requirement headings shall not be specified. The specific finish numbers(s) only shall be specified. See page iii for the proper method of specifying finishes.

1/ when non-skid (DoD-C-24667) or walkway coating and matting, nonslip (MIL-W-5044) are required for CARC environments, the sequence of application shall be:

CARC primer/DoD-C-24667 or MIL-W-5044/CARC top coat



## 6. NOTES

(This section contains information of a general or explanatory nature that may be helpful, but is not mandatory.)

6.1 Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the contractor is responsible for the performance of all inspection requirements as specified in the specific document of reference. Except as otherwise specified in the contract or order, the contractor may use his own or any other facilities suitable for the performance of the inspection requirements specified unless disapproved by the Government. The Government reserves the right to perform any of the inspections set forth in the specification where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

6.1.1 Responsibility for compliance. All finishes must meet all requirements specified in sections 3 and 5 of the specific finishing document. The inspections set forth in the specific standardization document shall become a part of the contractor's overall inspection system or quality program. The absence of any inspection requirements in the standard shall not relieve the contractor of his responsibility for assuring that all products or supplies submitted to the Government for acceptance comply with all requirements of the contract.

6.2 General inspection requirements. All equipment being processed shall be inspected at the various stages of cleaning, surface treating, painting, electroplating, and application of other types of finishes and coatings, to ascertain that each process is done in strict accordance with this standard and individual specifications. The inspections and tests covered in this section shall not be considered restrictive. Any condition not in full accord with the applicable drawings and specifications shall be regarded as defective.

6.2.1 Tests. Materials prior to their use, shall be inspected, sampled and tested in accordance with the applicable specification and standard to determine compliance with the requirements of the particular specification. When purchasing camouflage paint, production samples from each lot of paint manufactured shall be forwarded to the laboratory specified in 6.10. The submission of these samples is for validation of the paint for spectral and specular characteristics. With this information, the inspector will have the means, along with the painting procedures, to accept or reject an end product.

6.2.2 Test specimens. When available, test specimens shall be actual production items, or parts of the items. When approved by the contracting officer, coating systems, may be tested on an approved number of test panels of the same metal as, and coated identically and concurrently with, the manufactured parts they represent.

6.3 Condition of surface prior to painting. All surfaces shall be examined just prior to painting to assure that the previously cleaned and pretreated surface is dry and free from soil or contamination of any kind. Poor adhesion of paint shall be construed as evidence of improper cleaning. When poor adhesion is indicated, the entire part shall be stripped and the part shall be refinished.

6.4 Continuity and uniformity of coatings. All coatings, inorganic and organic, shall be visually examined for continuity and uniformity.

6.5 Thickness of coatings. All coatings, inorganic and organic, shall be checked for dry film thickness as required by this standard, the applicable specification or drawing. The correct dry film thickness of pretreatment coating, DOD-P-15328 is very important. Small steel panels prepared with films, too thick, too thin, and correct, may serve as visual color guides for wash primer and zinc chromate primer. Film thickness gages shall be used for other coatings.

6.6 Paint application. The weather and other conditions shall be checked during application of paint for conformance to this standard (see 5.2.1).

6.7 Paint Adhesion. Noncamouflage painted items, or specimen panels shall be examined for adhesion in accordance with TT-C-490 and MIL-P-14072 after the coated items, or specimen panels, have dried for a minimum of 24 hours for quick-drying and baking systems, and for a minimum of 72 hours for all other non-CARC systems; the CARC/camouflage system requires a minimum of 168 hours drying time prior to testing.

6.8 Color. The color of painted surfaces, other than camouflage, shall be checked against the standard color chip representing the specified color in Fed. Std. No. 595 or other standard as furnished by the procuring activity. Color comparisons shall be made using the applicable test method of Fed. Test Method Std. No. 141.

6.9 Hiding power, gloss, and smoothness of paint. The painted surfaces (when dry) shall be checked visually for hiding power, gloss, and smoothness against samples (when available) furnished or approved by the procuring activity.

6.10 Inspection and acceptance of CARC/camouflage painting. The following are inspections that must take place before acceptance can be made on the end item:

(a) Applicators shall obtain a certificate of compliance. Total acceptance of this paint shall be based only upon whether the individual lot of subject paint was approved by the US Army Belvoir RD&E Center, ATTN: STRBE-VO, Fort Belvoir, VA 22060-5606. The acceptance of the color of the paints shall not be based upon a color match to a standard color chip.

(b) Surface cleaning and treatment requirements shall comply with MIL-C-53072.

(c) The CARC/camouflage primer and top coat shall be inspected for conformance with the dry film thicknesses specified in paragraph 4.3.3.3 of MIL-C-53072.

(d) The top coat of the CARC/camouflage system shall be inspected for conformance with the adhesion test specified in paragraph 4.3.3.6 of MIL-C-53072.

(e) The primer used in the CARC/camouflage system shall be inspected for conformance with the corrosion-resistance test specified in paragraph 4.3.3.7 of MIL-C-53072. The test panels shall be tested for dry film thickness prior to the salt spray test. The dry film thickness shall not exceed the maximum limit specified in table V, paragraph 4.3.3.3 of MIL-C-53072.

(f) The top coat of the CARC/camouflage system shall be inspected for its performance in meeting the degree of cure when tested in the solvent wipe test specified in paragraph 4.3.3.2 of MIL-C-53072.

(g) The dry color shall be uniform for each individual part, but not necessarily from part to part.

(h) Upon application, the paint shall not be applied in a dry spray. The paint shall be allowed to flow when applied to the substrate. A dry spray would produce a chalky effect which would allow the paint to be removed just by light rubbing.

(i) Isolated marring and scratching from handling shall be allowed as long as the substrate is not exposed. This slight marring and scratching will not affect the camouflage properties when observed by either visual or photographic means.

**Custodian:**

Army - MR  
Navy - SH  
Air Force - 11

**Preparing activity:**

Army - MR

Project MFFP-0174

**Review interest:**

Army - GL, ME, MI, AR, ER, MD, AV, TA  
Navy - AS  
Air Force - 99

**User interest:**

Army - AL  
Navy - SH, OS, YD

(WP# ID 0268A/DISC 0020A. FOR MTL USE ONLY)

## APPENDIX

Selection of finishes. The finishes should be selected from this standard. The selection of finishes for any particular application should be made in accordance with the following recommendations or as otherwise indicated in this standard. However, final selection shall rest with the activity responsible for the end item.

Exposure classification. For application of finishes to materiel, surfaces are classified by exposure as follows:

Type I (Exposed). Type I surfaces are areas, either exposed to view when equipment is in operating or traveling conditions or areas not exposed to view but subject to combined direct action of climatic elements. Climatic elements include temperature extremes, humidity extremes, rain, hail, snow, sleet, salt laden air, industrial atmospheres, direct solar radiation, dust and scouring action of wind-blown sand.

CARC coatings. It should be noted that the Department of the Army has mandated that CARC will be the specified finish for all painted combat materiel, based on both chemical agent resistance and improved durability. The material developer or design engineer should specify the CARC paints wherever there is the possibility that the exterior surface may be exposed to combat.

Type II (Sheltered). Type II surfaces are not exposed to view during equipment operation and not subject to direct action of rain, hail, snow, sleet, direct solar radiation, and sand. For interior use for surfaces not identified for possible use in combat zones.

APPENDIX A. Finish selection.

Class of part	Applicable finish recommendations			
	Conditions affecting finish selection	Type Cleaning	Paint finishes	Gloss
		expose and pretreatment	Lusterless	Semigloss
				Gloss

FABRICATED FROM FERROUS ALLOYS OTHER THAN CORROSION-RESISTING STEEL

1. Massive structural parts and assemblies, such as the bodies of trucks, semitrailers, tanks and vans, special purpose vehicles and vans of all types, large brackets, gussets, and assembly hardware	a. Vat pretreatment is practical	I 5.1.1	20.24	21.3, 21.5, 22.2 or 21.11, 22.3
	b. Vat pretreatment is not practical	I 4.1 or 4.4 plus 5.2		21.19 or 21.21
	c. Parts which have a prior zinc coating and require painting	I 6.1.1.1 or 6.1.1.2 plus 5.2		
2. Large bolts, nuts, washers, and similar type hardware for assembly of massive structures	a. Parts will require painting after assembly	I 1.1.2.3	Same as 1 - assembly	Finish after assembly
	b. Parts will not require painting after assembly	I	1.9.4	
3. Lesser structural parts and assemblies such as racks, cases, castings, housings, panels brackets, etc.	a. Vat treatment is practical	I 5.1.1		
	b. Vat treatment is not practical	I 4.1 or 4.4 plus 5.2	Same as 1	
4. Ground rods, stakes, ground plates, etc.	Parts will be used in contact with soil	I 1.9.4		

APPENDIX A. Finish selection. (Continued)

Class of part	Conditions affecting finish selection	Type	Applicable finish recommendations		
			Cleaning and pretreatment	Lusterless Semigloss	Paint finishes Gloss
5. a. Inside open hollow members		I	4.4	21.1 - Fill and drain	
b. Inside closed hollow members		I	MIL-C-11796 class 1		
6. Small hardware (except threaded parts) such as hinges, fasteners, catches, handles, etc.	a. Parts will be exposed to view when assembled in equipment	I	5.1.1 or (4.1 or 4.4 plus 5.2)		
	b. Parts will not be exposed to view when assembled in equipment	I	5.1.1; 4.1 or 4.4 plus 5.2; 1.1.2.3 or 1.9.4.1	Same as 1 - Finish after assembly	
	c. Parts will be painted after assembly	I	1.2.1.1, 1.9.2.2 or 1.9.4.1		
	d. Parts will be in view when assembled and cannot be painted	I	1.4.1.2 (Matte finish) or 1.2.3		
7. Screws, holes, nuts washers and small specialty parts	a. Prior to assembly in equipment	I	1.1.2.3		
	b. After assembly in equipment (parts were plated with cadmium or zinc	I	6.1.1.1 or 6.1.1.2 plus 5.2	Same as 1 - Finish after assembly	

APPENDIX A. Finish selection. (Continued)

Class of part	Conditions affecting finish selection	Applicable finish recommendations			
		Type	Cleaning and pretreatment	Paint finishes	Gloss
c. Parts will not be exposed to view after assembly	I	1.1.2.1 or 1.9.4.1	Same as 1	Finish after assembly	
		1.4.1.2 (matte finish) or 1.2.3			
d. Parts will be exposed to view after assembly. Not painted	I	1.1.2.1 or 1.9.4.1	Same as 1	Finish after assembly	
		1.4.1.2 (matte finish) or 1.2.3			
8. Any type of part except threaded part	I or II	1.2.2 or 1.4.2			
9. Hardware such as hinges, catches, clamps, clips, screws, bolts, nuts, washers, etc.	II	1.2.2 or 1.4.2			
		30.7 or 30.8	None		
		1.4.1.3 or 1.2.2			
b. Parts will not be subjected to temperatures in excess of 160 F	II	1.4.1.3 or 1.2.2			
c. Parts will be in contact with uncured phenolics or subjected to phenolic vapors (see 4.8)	II	1.2.2 or 1.4.2			

APPENDIX A. Finish selection. (Continued)

Class of part	Conditions affecting finish selection	Type exposure	Applicable finish recommendations			
			Cleaning	and pretreatment	Lusterless	Gloss
10. Wearing parts lubricated in service	a. Parts will be oiled or greased but not during operation	II	5.3.1.3			Paint finishes
	b. Parts will be splash or force-feed lubricated in operation	II	5.3.1.3			Semigloss
11. Sliding wearing surfaces such as guide rails, etc., requiring electrical conductivity	Parts cannot be lubricated	II	1.4.1.3 or 1.4.1.3 plus 1.2.2 (1.0 mil thick)			
	a. Parts cannot be lubricated and will not be subjected to high temperature	II	1.1.2.2			
12. Gears, cams, slides, etc.	b. Parts cannot be lubricated and will be subjected to high bearing pressure	II	1.4.1.3 or 1.4.1.3 plus 1.2.2 (1.0 mil thick)			
	An electrical conductive dissimilar metal contact is required	II				Any plate providing a permissible couple per table I



APPENDIX A. Finish selection. (Continued)

Class of part	Conditions affecting finish selection	Type exposure	Applicable finish recommendations			
			Cleaning and pretreatment	Lusterless	Semigloss	Gloss
14. Hardened steel parts such as coil springs, washers, etc., subject to hydrogen embrittlement	Plating is required for protection due to equipment design	I or II	Any type plating required for exposure plus precautions in paragraphs 5.1.1.1 and 5.1.1.2			
15. Steel small arms parts	Part subjected to temperature in excess of 160 F	I or II	5.3.1.2 or 5.3.2.2			
FABRICATED FROM STAINLESS STEEL OR NICKEL-BASE ALLOYS						
20. Large parts	a. Parts will be exposed to view in assembled equipment	I	5.5.1		Same as 1	20.24
	b. Part will not be exposed to view in assembled equipment	I	5.4.1		No finish required	
21. Small parts	a. Parts will be exposed to view in assembled equipment	I	5.5.1		Same as 1	
	b. Parts will not be exposed to view in assembled equipment	I	5.4.1		No finish required	

APPENDIX A. Finish selection. (Continued)

Class of part	Applicable finish recommendations			
	Conditions affecting finish selection	Type	Cleaning and pretreatment	Paint finishes
	finish selection	exposure	Lusterless	Semigloss
		sure		Gloss
22. Welded or machined parts made of stainless steel		I	5.4.1	
23. Any type parts		II	No finish required	
24. Open hollow members		I or II	4.4	21.1 - Fill and drain
25. Closed hollow members		I or II	MIL-C-11796 Class 1	

FABRICATED FROM ALUMINUM-BASE ALLOYS (For applicable primers see paragraph 5.3.1)

30. Massive structural parts and assemblies, brackets, gussets, and hardware assemblies	a. Vat pretreatment is practical	I	7.1.1 or 7.2.1	20.24	21.3, 21.5	22.2
	b. Vat pretreatment is not practical	I	7.3 or 5.2		21.11 or 21.19	22.3
31. Lesser structural parts and assemblies such as racks, cases, castings, housings, panels, brackets, etc.	a. Vat pretreatment is practical	I	7.1.1 or 7.2.1	Same as 30 after assembly		
	b. Vat pretreatment is not practical	I	7.3 or 5.2			

APPENDIX A. Finish selection. (Continued)

Class of part	Conditions affecting finish selection	Type exposure	Applicable finish recommendations		
			Cleaning and pretreatment	Lusterless	Paint finishes
				Semigloss	Gloss
32. Small hardware such as hinges, fasteners, catches, handles, screws, nuts, bolts, washers, etc.	a. Parts will be exposed to view when assembled in the equipment	I	7.1.1, 7.2.1 or 7.3		
	b. Parts will not be exposed to view when assembled in equipment	I	7.1.1 or 7.2.1		Same as 30 after assembly
33. Internal structural parts such as chassis, brackets, inside of panels, clamps, clips, hinges, etc.	a. None	II	7.1.1, 7.2.1 or 7.3	Same as 30	
	b. RF electrical conducting surface as required	II	7.3.3	None	
34. Open hollow members	a. A nonconducting surface is required	II	7.1.1 or 7.2.1	Same as 30	
	b. Plating is required for contact with dissimilar metals	II	Any plate providing a permanent couple per table I		
35. Closed hollow members		I or II	4.4	Fill with primer and drain	
		I or II	MIL-C-11796, class I		
36. Parts requiring high wear resistance such as gears, cams, slides, etc.	a. Parts will be subjected to high bearing pressure	II	7.5	None	
			30.8	None	

APPENDIX A. Finish selection. (Continued)

Class of part	Applicable finish recommendations			
	Conditions affecting finish selection	Type exposure pretreatment	Cleaning and lusterless	Paint finishes Semigloss Gloss
PARTS FABRICATED FROM MAGNESIUM-BASE ALLOYS (For applicable primers see paragraph 5.3.2)				
40. All parts fabricated from alloys other than "M" alloys	a. Where vat passivation is practical	I or II 8.1.1 plus 8.7	20.24	21.3, 21.5, 22.2 21.11 or 22.3 21.21
	b. Where vat passivation is not practical	I or II 8.6 plus 8.7		
41. All parts except those subject to flexing		I or II 8.1.2 plus 8.7	Same as 40	
42. All parts fabricated from "M" alloys		I or II (8.1.1 or 8.4) plus 8.7	Same as 40	
43. Open hollow members		I or II 4.4	Fill with primer TT-P-1757 or MIL-P-23377 and drain	
44. Closed hollow members		I or II MIL-C-11796, class 1		
45. For magnesium alloys subject to severe exposure (seashore, etc.). Paint system may also be used on steel and aluminum	I	8.1.1 plus 8.7	20.24	
	II	8.1.1 plus 8.7		24.9

APPENDIX A. Finish selection. (Continued)

Class of part	Applicable finish recommendations				
	Type	Cleaning	Paint finishes	Gloss	
Conditions affecting finish selection	expo- sure	pretreatment	Lusterless	Semigloss	
FABRICATED FROM WOOD					
50. All wood surfaces otherwise specified	a. Where vacuum-soak treatment is practical	I or II 25.2 or 25.3	26.1	27.1	28.1
	b. Where vacuum-soak treatment is not practical				
51. Varnished surfaces		I or II			29.6
52. Panel trucks, trailers, semi-trailers, etc.		I or II 25.2 or 25.3			Same as 50

APPENDIX A. Finish selection. (Continued)

Class of part	Conditions affecting finish selection	Type Exposure	Applicable finish recommendations	
			Cleaning and pretreatment	Paint finishes
OTHER APPLICATIONS				
60.	Crankcase sealer for cast iron housings of clutch, transmission, differential, final drive, and brakes	II	<u>I/</u>	MIL-R-3043 or 24.13
61.	Components subject to high temperatures (400 to 1000 F)	I	<u>I/</u>	24.5
62.	Storage battery areas	II	<u>I/</u>	24.2 or 24.10
63.	Areas subject to spillage of hydraulic fluid	I or II	<u>I/</u>	24.8
64.	Wrinkle finish	II	<u>I/</u>	23.1
65.	Inclosed surfaces subject to spot or roll welding	II	<u>I/</u>	24.1
66.	Parts subject to spillage of red fuming nitric acid	I or II	Steel: 4.3 Aluminum: 7.3	24.4
67.	Coating for interior of ammunition items in contact with explosives	II	<u>I/</u>	24.2, 24.6 or 24.7

Cleaning and pretreatment shall be as applicable to basis metal.

### STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

<b>1. DOCUMENT NUMBER</b> MIL-STD-171E		<b>2. DOCUMENT TITLE</b> FINISHING OF METAL AND WOOD SURFACES	
<b>3a. NAME OF SUBMITTING ORGANIZATION</b>		<b>4. TYPE OF ORGANIZATION (Mark one)</b>	
<b>3b. ADDRESS (Street, City, State, ZIP Code)</b>		<input type="checkbox"/> VENDOR	
		<input type="checkbox"/> USER	
		<input type="checkbox"/> MANUFACTURER	
		<input type="checkbox"/> OTHER (Specify): _____	
<b>5. PROBLEM AREAS</b>			
a. Paragraph Number and Wording:			
b. Recommended Wording:			
c. Reason/Rationale for Recommendation:			
<b>6. REMARKS</b>			
<b>7a. NAME OF SUBMITTER (Last, First, MI) - Optional</b>		<b>8. WORK TELEPHONE NUMBER (Include Area Code) - Optional</b>	
<b>9. MAILING ADDRESS (Street, City, State, ZIP Code) - Optional</b>		<b>8. DATE OF SUBMISSION (YYMMDD)</b>	