

# TMC SPECIFICATION

NO. S 115

REV:

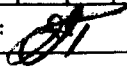
C D

COMPILED: J. C.

CHECKED:



APPD:



SHEET

1

OF

3

TITLE:

SMOOTH GRAY ENAMEL

# TMC SPECIFICATION

NO. S 115

REV: C D

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SHEET 2 OF 3

TITLE: SMOOTH GRAY ENAMEL

I. PURPOSE: The purpose of this specification is to outline the materials and method of applying smooth gray enamel finish.

## II. MATERIALS REQUIRED

- A. Hartex Smooth Epoxy Bake Enamel Semi-Gloss Gray (TMC #162) #1610 - Hartin Corporation
- B. Epoxy Reducer #1488 or equivalent - Hartin Corporation
- C. On all front panels: Gray Bake Primer #1255 - Hartin Corporation

## III. COLOR STANDARD

- A. Munsell notation: 3B 4.53/0.35+, 17844
- B. Finishes will be matched by visual means to the standard color chips made available by TMC Standards Section or MUNSELL COLOR CO.

## IV. SURFACE PREPARATION

- A. Clean Surface of all foreign materials.
- B. Apply zinc chromate primer per specification S-114, and air dry.
- C. On front panels: Apply Bake Primer Surface and bake for 30 minutes.

## V. METHOD OF APPLICATION

- A. Apply by spraying one uniform coat of enamel
- B. Bake: One half(1/2) hour at 300° F.

## VI. APPLICABLE SPECIFICATIONS

- A. S-114 Zinc Chromate Primer
- B. Test Specifications of MIL-E-15090, Type III Class 2 and TT-E-529

## VII. SHIPPING AND MARKING

- A. All finished material shall be shipped in suitable containers to give maximum protection during transit.
- B. All containers shall be plainly marked with the purchase order number, manufacturer's name and TMC Part Number.

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SHEET 3 OF 3

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## VIII. PROPORTIONS OF MATERIAL

- A. Viscosity Reading
- B. Zohn Cup #2
- C. Twenty(20) seconds
- D. 72° F.

IX. GLOSS RANGE: 35° Min. - 45° Max. On flat surfaces, 25° Min. - 45° Max. on bent surfaces.

X. FILM THICKNESS: 1.25 to 1.50 mils of enamel

# REVISION SHEET

THE TECHNICAL MATERIEL CORP.  
MAMARONECK NEW YORK

S-115

MODEL S-115

PROJECT NO. \_\_\_\_\_

DATE	REV.	PAGE	EMN #	DESCRIPTION	CHK.	APP.
2/14/62	A	1	6391	Chg. materials Req. chart from #68397 enamel, Mass & Waldstein Co. #8 Reducer, Mass & Waldstein Co. to TC gray #162 semi-gloss baked enamel, Hartin Corp.	}	6
				On color, chg. gloss from 30 to 40, to 40 to 50.		
				On method of application, chg. item 2 from 10 minutes to half hour.		
		2		On proportions of material, chg. from four part enamel, one part reducer to viscosity reading ZAHN Cup #2, 26 seconds.		
10/26/62	B	1	7579	On "Applicable Spec." Sec., Chg. MIL-P-15090 to MIL-E-15090	}	6
11-4-64	C	ALL	12867	COMPLETELY REVISED		L. Gabel
3/8/65	D	2,3	13657	Revised shts. per EMN		6