

SECTION 20

PAINTING

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20-1. PAINTING an airplane requires little special equipment. The average shop will have the compressor, spray gun and clean place to work required for a good paint job. Ordinarily, painting involves three basic steps. They are:

1. Cleaning - Washing down the aircraft thoroughly to remove all oil, grease, and dirt.
2. Priming - Applying one priming coat before painting with vinyl and an extra intermediate priming coat before painting with lacquer.
3. Painting - Applying three or more coats of final paint, then adding decorative stripes.

20-2. PROCEDURE FOR PAINTING WITH ENMAR 2TH SERIES LACQUER.

20-3. PREPARATION. Thoroughly clean all surfaces, baysed and to be painted, with 309# GUMMER. Extreme care should be taken to remove all linters, grease, bugs, etc. Mask off strips areas to be painted carefully, - use that all tapes are firmly adhered to metal to prevent ragged edges. Class "A" wrapping paper and thinner proof soaking tape should be used to cover the Plexiglas area. This will prevent damage from solvent and thinner vapors. (Newspapers will not provide adequate protection.)

20-4. MIXTURE AND APPLICATION OF PRIMER.

NOTE

845x EX2018 primer only in quantities required for use within six hours and then only in stain-less steel bucket provided.

- a. Mix EX2018 primer and EX2018C reducer in a 1-1 ratio and stir thoroughly.
- b. Apply EX2018 primer in a well broken up, wet, even coat.
- c. Mix EX2414 yellow lacquer primer and MIL-T-5694A thinner in equal parts.

- d. Apply two well broken up, wet, even coats of lacquer primer over the EX2018 as an intermediate coat.

20-5. PREPARATION OF 2TH LACQUER COLORS.

- a. Thoroughly stir and mix in original container to make sure all pigments are in solution.
- b. Thin required amount of lacquer color with T-1066A thinner in a 1:1 ratio. Mix thoroughly and strain into cup before using.

NOTE

T-1066A is faster drying than T-1066B. The former is primarily for lacquer, although the "B" may be mixed with the "A" to slow down the drying time if desired.

20-6. APPLICATION OF 2TH LACQUER COLORS.

Apply three well broken, wet, even coats of lacquer color. Air pressure at the gun should not exceed 40 pounds. At all times, keep gun from 6 to 8 inches from the work and perpendicular to surfaces being painted. DO NOT PAINT WITH ARCING MOTION. Keep paint room around 75 to 80°F. Burn down with T-1411 thinner to give smooth, even surfaces free from overspray.

20-7. PROCEDURE FOR PAINTING WITH ENMAR 82 SERIES VINYL.

NOTE

82A and 83 are interchangeable, although 82A has better flow characteristics.

20-8. INITIAL PREPARATION. Thoroughly clean all surfaces and seams with 309# lacquer thinner. Extreme care should be taken to assure that no oil seepage occurs from seams, splices or rivet heads. All bugs and foreign matter should be removed from

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