APPENDIX A. Finish Codes

SECTION A. ALUMINUM ALLOYS

CODE	APPLICABLE FINISH
A913	**WHITE URETHANE (ACCOUNTS FOR PREVIOUSLY PAINTED SURFACES) 2000 AND 7000 SERIES ALUMINUM ALLOYS**
	A FOR UNFINISHED PARTS, PROCEED AS FOLLOWS (FOR PREVIOUSLY PRIMED OR PAINTED PARTS, START WITH STEP E).
	B ANODIZE ALL SURFACES PER 111.
	C PRIME ONE COAT ALL SURFACES EXCEPT EXPOSED SURFACES OF LUBRICATION FITTINGS AND BUSHINGS PER 202.
	D PAINT PRIMED SURFACES PER STEP H.
	E SCUFF SAND PREVIOUSLY PRIMED OR PAINTED PARTS USING 320 GRIT ABRASIVE TO REMOVE SURFACE GLOSS.
	F WIPE SURFACES WITH CLEAN CHEESE CLOTH MOISTENED WITH MIL-C-38736 OR FMS-2004 CLEANER.
	G APPLY A THIN COAT OF MIL-PRF-23377 PRIMER OR MIL-PRF-85582 VOC COMPLIANT EPOXY PRIMER TO ALL SURFACES EXCEPT THE EXPOSED SURFACES OF LUBRICATION FITTINGS AND BUSHINGS.
	H PAINT PRIMED SURFACES WITH WHITE URETHANE PER 222.
	I TOUCH UP AS REQUIRED PER 237.
A914	**ORANGE URETHANE. FOR FS-X/F-2 INSTRUMENTATION ONLY. ALL ALUMINUM ALLOYS.**
	A CHEM FILM ALL SURFACES PER 105.
	B PRIME ONE COAT ALL SURFACES PER 201.
	C PAINT ALL SURFACES WITH MIL-C-83286 OR MIL-C-85285 URETHANE COATING, COLOR NO. 12197 PER FED-STD-595. TOPCOAT MAY BE DELAYED TO A SUBSEQUENT ASSEMBLY LEVEL.
	D TOUCH UP AS REQUIRED PER 242 USING AN ADDITIONAL TOPCOAT OF MIL-C-83286 OR MIL-C-85285 URETHANE COATING, COLOR NO. 12197 PER FED-STD-595.
A915	**P6096-2 ON SPECIFIED INTERIOR SURFACES. TOPCOAT APPLIED AFTER ASSEMBLY. (FOR FS-X/F-2 PARTS)**
	A ANODIZE ALL SURFACES PER 111.
	B PRIME ONE COAT ALL SURFACES PER 201.
	C PAINT SPECIFIED INTERIOR SURFACES WITH P6096-2 FLAT BLACK URETHANE PER 217.
	D TOUCH UP AS REQUIRED PER 242 AND 241.
A921	**IVD ALUMINUM COATING OR CADMIUM PLATING OF ALUMINUM ALLOYS (SPECIAL ELECTRICAL BONDING APPLICATION)**
	A CLEAN ALL SURFACES PER FPS-3001 PARA. 3.1.1(A)
	B IVD ALUMINUM TREAT ALL SURFACES PER MIL-C-83488 TYPE II, CLASS 3, OR VACUUM CADMIUM PLATE PER MIL-C-8837, TYPE II, CLASS 2.
	NOTE: DO NOT USE WITHOUT MATERIALS AND PROCESSES ENGINEERING APPROVAL.