APPENDIX A. Finish Codes

SECTION D. NON-CORROSION RESISTANT STEEL ALLOYS

CODE	APPLICABLE FINISH

D473 **ALLOY STEEL - (CADMIUM PLATE OR IVD ALUMINUM) PRIMER AND 16NXXXX FINISH**
HEAT TREAT RANGE: 220 – 240 KSI

A CADMIUM PLATE PER 122 OR IVD ALUMINUM TREAT PER 516 ALL SURFACES.
B PRIME ONE COAT ALL SURFACES PER 201.
C FINISH EXTERIOR EXPOSED SURFACE AFTER ASSEMBLY PER DRAWING 16N0001.
D TOUCH UP AS REQUIRED PER 307 AND 345.

D474 **ALLOY STEEL-(CAD PLATE OR IVD ALUM) AMS-C-27725 FUEL TANK COATING & WHT ACRYLIC LACQ/WHT URETHANE**
HEAT TREAT RANGE - 220 KSI OR GREATER

A CADMIUM PLATE PER 123 OR IVD ALUMINUM TREAT PER 516 ALL SURFACES.
B APPLY AMS-C-27725 COATING ON SPECIFIED FAYING SURFACES AND SURFACES EXPOSED TO FUEL PER 221.
C PRIME REMAINING SURFACES WITH ONE COAT OF PRIMER PER 202.
D PAINT PRIMED SURFACES WITH EITHER WHITE ACRYLIC LACQUER OR WHITE URETHANE COATING PER 294 (OR 296).
E TOUCH UP AS REQUIRED PER 371 AND 372.

D475 **ALLOY STEEL - (CADMIUM PLATE OR IVD ALUMINUM) PRIMER**
HEAT TREAT RANGE - 180 KSI OR LESS

A CADMIUM PLATE PER 120 OR IVD ALUMINUM TREAT PER 516 ALL SURFACES.
B PRIME ALL SURFACES PER 201.
C TOUCH UP AS REQUIRED PER 307.

D476 **ALLOY STEEL - (CADMIUM PLATE OR IVD ALUMINUM) AND WHITE URETHANE**
HEAT TREAT RANGE: 180 - 220 KSI

A CADMIUM PLATE PER 121 EXCEPT 10 NICKEL STEEL (HY 180), OR IVD ALUMINUM TREAT PER 516 - ALL SURFACES.
B PRIME ONE COAT ALL SURFACES PER 201.
C PAINT PRIMED AREAS WITH WHITE URETHANE COATING PER 223 (OR 274).
D TOUCH UP AS REQUIRED PER 312.

D701 **ALLOY STEEL TUBE - (CADMIUM PLATE OR IVD ALUM.) PRIMER AND BLACK EPOXY ENAMEL/BLACK URETHANE**
HEAT TREAT RANGE: 180 – 220 KSI

A CADMIUM PLATE PER 153 OR IVD ALUMINUM TREAT PER 517 TUBE OUTSIDE AND THREADS.
B PRIME ONE COAT ON EXTERIOR SURFACES SPECIFIED FOR BLACK COLOR PER 202.
C PAINT SPECIFIED AREAS WITH BLACK EPOXY ENAMEL OR BLACK URETHANE PER 213.
D TEMPORARY CORROSION PROTECTION FOR INTERIOR OF THE TUBE REQUIRED FOR LONG DELAYS BETWEEN CADMIUM PLATING TUBE EXTERIOR AND PAINTING TUBE INSIDE, PER 250.
E CLEAN TUBE INSIDE, EXCEPT THREADS, PER 156.
F PRIME TWO COATS ON INTERIOR OF TUBE EXCEPT THREADS PER 205.
G TOUCH UP AS REQUIRED PER 346.