

MIL-C-18187A(ASG)

14 JANUARY 1965

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22 December 1954

MILITARY SPECIFICATION

COATINGS, PROTECTIVE; APPLICATION TO FABRIC SURFACES OF AIRCRAFT

This specification has been approved by the Department of the Air Force and by the Bureau of Naval Weapons.

1. SCOPE

1.1 This specification covers the detailed requirements and procedures for the application of protective coatings to fabric surfaces of aircraft in order to achieve uniformly taut and aerodynamically smooth exterior finishes of high quality. The finishing process described in this specification is designed to produce suitable protection to fabric-covered aircraft parts. Careful production methods which insure aerodynamically smooth contours are prerequisites to the successful application of dope finishes.

2. APPLICABLE DOCUMENTS

2.1 The following documents of the issue in effect on date of invitation for bids or request for proposal, form a part of this specification to the extent specified herein:

SPECIFICATIONSFederal

TT-L-20

TT-L-32

TT-P-320

UU-T-106

Lacquer, Camouflage

Lacquer, Cellulose Nitrate, Gloss, for Aircraft Use

Pigment, Aluminum, Powder and Paste, for Paint

Tape, Pressure Sensitive Adhesive, Masking Paper

Military

MIL-D-5549

Dope, Cellulose-Acetate-Butyrate, Clear for Aircraft Use

MIL-D-5550

Dope, Cellulose-Acetate-Butyrate, Pigmented, Camouflage

MIL-D-5551

Dope, Cellulose-Acetate-Butyrate, Pigmented, Gloss

MIL-C-5642

Cloth, Cellulose Acetate Butyrate, Predoped Airplane

MIL-C-5646

Cloth, Cotton, Airplane

MIL-C-5654

Cloth, Process for Application of Aircraft Surface

FSC 1500

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MIL-T-6096	Thinner, Cellulose Acetate Butyrate Dope
MIL-T-6097	Thinner, Cellulose Acetate Butyrate Dope Blush Retardin
MIL-F-7179	Finishes and Coatings, General Specification for Protection of Aircraft and Aircraft Parts
MIL-D-7850	Dope; Cellulose-Acetate-Butyrate, First Coat, Fungicidal
MIL-S-15847	Spray Guns and Accessories, Paint and Dope, Aircraft Use
MIL-C-18263	Colors, Exterior, Naval Aircraft, Requirements for

STANDARDSFederal

FED. TEST METHOD STD.

NO. 141

Paint, Varnish, Lacquer, and Related Materials;
Methods of Inspection, Sampling and Testing

(Copies of specifications, standards, drawings, and publications required by suppliers in connection with specific procurement functions should be obtained from the procuring activity or as directed by the contracting officer.)

3. MATERIALS

3.1 General.- Unless otherwise specified, all materials used in the coating of fabric surfaces of aircraft shall conform to the applicable specifications, and as specified in MIL-F-7179. Material shall be subject at any time to such tests as the procuring activity may prescribe to determine compliance with the applicable specification:

<u>Specification</u>	<u>Use and material</u>
MIL-D-7850 } MIL-D-5549 }	Base coats - dope
MIL-D-5551 } MIL-D-5550 }	Insignia and finish coats - dope
TT-P-320	Aluminum pigment for dope
TT-L-20 } TT-L-32 }	Emergency where pigmented dope is not available - lacquer (insignia and markings only)
UU-T-106	Masking surfaces - tape
MIL-T-6096 } MIL-T-6097 }	Thinner for dope
MIL-C-5646	Cloth fabric
MIL-C-5642	Cloth fabric, predoped

3.2 Old dope.- Dope more than 36 months old shall not be used unless one of the following testing procedures has been complied with and the material authorized for use or otherwise determined to be satisfactory.

3.2.1 Old dope, authorization to use.- A 2-quart sample from the overage lot of dope shall be forwarded to the Director, Aeronautical Materials Laboratory, Naval Air Engineering Center (NAEC), Philadelphia, Pa. 19112, with a report stating the following:

Station and manufacturer received from
 Contract number
 Date of manufacture
 Date of storage
 Quantity on hand
 Approximate temperature range in storage

If the laboratory examination indicates the material to be satisfactory, it can be used; if not, it shall be surveyed. Stocks of dope over 36 months old which are authorized for use shall be reported again every 6 months after each previous approval and additional reports and samples forwarded to the NAEC for tests.

3.2.2 Old dope, alternate procedure for.- The following alternate procedure may be followed if preferred:

Acidity determinations shall be made on the dope in question every 6 months in accordance with Fed. Test Method Std. No. 141 in a laboratory approved by the procuring activity. If the acidity is found to be 0.25 percent or over, calculated as acetic acid, the dope shall be surveyed. If below this value, the material may be used, provided the overall age of the dope is not over 48 months, in which case the procedure indicated in 3.2.1 shall be followed. This alternate procedure does not apply to MIL-D-7850 type II.

4. STORAGE

4.1 Deterioration of finishing materials.- When stored for extended periods in a warm place, dopes and other finishing materials are subject to serious deterioration. Storage temperatures should not exceed 80° F for long periods, and may approach, but should not exceed 100° F for shorter periods not exceeding 4 months. All conditions under which dope is stored shall be subject to approval by the procuring activity.

4.2 Fire hazard.- Because of the fire hazard involved, finishing materials shall be stored under conditions approved by the fire prevention and safety authorities concerned. Attention is directed to the following conditions:

When stored in any one fire section, material in shipping containers exceeding on aggregate of 1,000 gallons shall be protected by automatic sprinklers. Ventilation shall be provided equal to a clear opening of at least one-half square inch per cubic foot of room. Storage shall not be on any floor below grade. Containers shall not be placed beneath other goods and must be readily accessible at all times. Spaces underneath benches shall be kept free of storage of any kind

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and accumulations of paper, refuse, and other combustible material. Not over four containers shall be open at any one time in the same fire section which is not protected with automatic sprinklers. The containers which have been opened, but have been closed in essentially the same manner as prior to opening, may be re-stored with other material. No material shall be stored within 2 feet of steampipes, radiators, chimneys, etc. Smoking shall be prohibited and "No Smoking" signs shall be posted in prominent places. Fire pails or extinguishers shall be provided. Additional precautions, depending on the facilities available for storage, shall be taken when applicable.

5. WORKSHOP CONDITIONS

5.1 Doping room.- The room in which doping is performed shall be completely enclosed to exclude dirt and dust and shall not be used for any purpose other than painting, doping, predrying, or fabric covering and patching incident to doping. The room shall be maintained in a clean and neat condition consistent with the best practice for obtaining dust-free finishes. Doping performed in any place outside the doping room shall constitute emergency work, and as such shall be carried on in the presence of and under conditions approved by the procuring activity.

5.2 Atmospheric conditions.- The temperature and relative humidity shall be maintained at that relative adjustment which will permit the best doping conditions. The relative humidity and temperature shall be maintained within the following limits:

Relative humidity percent:		Dry bulb temperature °F:	
Minimum	20	Minimum	70
Desirable	45 to 50	Desirable	75 to 80
Maximum	55	Maximum	100

In rooms especially designed for the application of dope, means shall be provided for humidification when the relative humidity falls below the minimum specified. Likewise, means for dehumidification shall be provided to prevent the relative humidity exceeding the maximum limit. In conjunction with the humidity controls, suitable means for heating and cooling shall be provided to control the temperatures within the specified limits. In general, equipment shall be designed to maintain the desired atmospheric conditions within the dope rooms under all exterior atmospheric conditions. The maximum and minimum conditions may be used only when, due to general outside conditions, the desirable values may not be obtained without undue cost. When humidity control equipment is not available, the relative humidity may be lowered by raising the temperature, provided that the dry bulb temperature does not exceed 100° F, with a wet bulb depression of not less than 12° F, and that, at the first indication of blushing, all doping shall be immediately suspended. Work shall not be resumed until safe temperature-humidity conditions are restored, and only after tests made on sample panels indicate that doping may proceed without encountering blushing. The wet and dry bulb temperatures in the doping room shall be checked hourly.

5.3 Ventilation.- The doping room shall be ventilated by forced draft which shall be capable of effecting at least 15 complete air changes per hour. The air shall be filtered and cooled or heated as may be required to realize the conditions specified in 5.2. In the design of rooms for use as dope shops, provisions shall be made for replacing 100 percent of all exhausted air. The air shall be introduced into the room in such a manner as not to cause turbulence or perceptible air currents. There shall be no appreciable difference in temperature or humidity conditions anywhere in the room. The face velocity of air currents at the entrance to vertical type spray booths shall be 150 feet per minute. For down draft spray booths the velocity at the floor grating shall be 300 feet per minute. Where practicable, water-washed spray booths shall be used. All designs for dope spray rooms or equipment shall be approved by the procuring activity before construction.

5.4 Handling equipment.- Work shall be handled through the dope room on specially designed trucks, jigs, or trolleys. All trolleys shall have nonferrous wheels and shall be fitted with hand operated rope type self-locking hoists with nonferrous pulleys. Any switches or other movable parts in any monorail system installed in a dope shop shall be of nonferrous, nonsparking materials.

5.5 Fire prevention.- All electrical equipment of any kind including lights, motors, switches, starter, etc., shall be explosion-proof as approved by the National Fire Underwriters Laboratory for class 1, group D locations. Under no circumstances shall any electric appliance of any kind, including flash lights, be permitted in the doping room unless it has been approved for use in a class 1 group D location and unless it carries the National Fire Underwriters Laboratory label as such. All doping rooms shall be provided with a sprinkler fire protection system.

5.6 Lighting.- It is important that doping operations be carried out in a well-lighted shop. An intensity of 30 foot-candles at a height of 36 inches above the floor is the minimum required. This lighting will be provided by properly spaced incandescent explosion-proof fixtures installed with metal guard or metal frame glass enclosure.

5.7 Floors.- In order to avoid the danger of explosions, all floors in dope rooms shall be constructed of nonsparking materials. This material shall be insoluble in dope thinners and solvents. For this reason, asphalt products such as asphalt block, asphalt tile, etc., shall not be used. The preferred material is a concrete floor finished with a floor topping. This topping shall be composed of material from which a spark cannot be struck by impact, either from the floor material itself or from the conductor embedded in the flooring. The conductor installed in the flooring shall have a high electric conductivity such that any static electricity built up on a person, truck, jig or any other body in contact with the floor will be immediately carried away through the conductor which shall be properly grounded. Floor gratings for down draft booths shall be constructed of steel heavily galvanized to prevent sparking.

5.8 Grounding.- To prevent explosions or fires caused by static discharges, all metal work in the structure shall be grounded. Metal doors shall be grounded by brazing a flexible copper cable across the hinges. Provisions shall be made for discharging static electricity from the body of any person before entering the room by grounding the door pulls at all entrances. All work in the dope room shall be grounded by a flexible cable attached by means of battery clips to the

work at one end and to an approved ground rod connection at the other. Ground rod connections shall be spaced 10 by 10 to 10 by 20 feet on centers depending on the size of the room. An approved ground rod connection is shown by figure 1.

5.9 Dope storage and circulating systems.- All dope storage and circulating systems shall be housed in a separate enclosure separated from the dope room by a fire wall or open space. Material, when stored out of doors, shall not be permitted to rest directly on the ground.

5.10 Existing dope shops.- Nothing in this specification shall be construed as authorization for changes in any existing dope shop, dope room, or doping equipment without prior approval of the procuring activity.

6. APPARATUS

6.1 Brushes.- It is recommended that brushes used for applying dope be of the flat style, 5 or 6 inches wide, with the bristles set in rubber and bound in metal. Brushes shall be cleaned each day after use with the applicable thinner.

6.2 Spray equipment.- Spray guns and accessories shall conform to MIL-S-15847. All lines shall be blown out at least twice a day, or oftener if necessary, to avoid possible contamination of the dope coats.

7. PROCEDURE

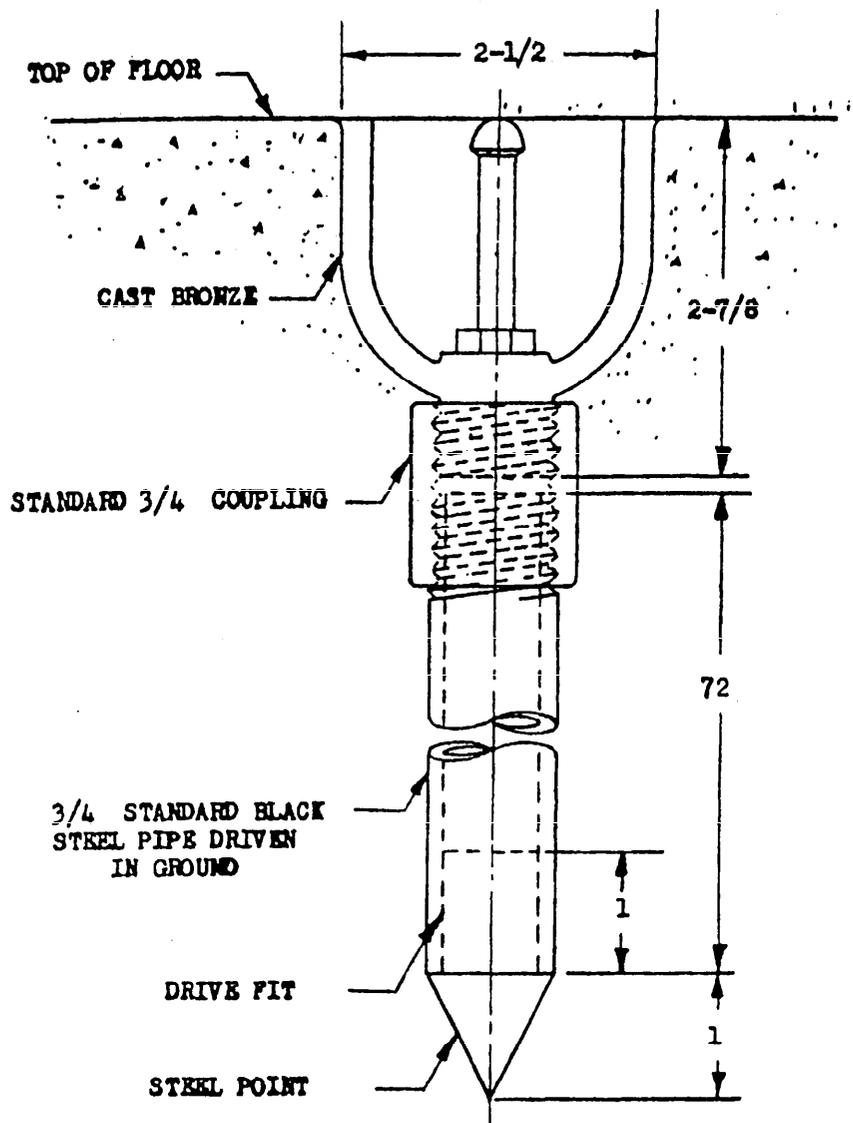
7.1 Conditioning of fabric surface.-

7.1.1 Moisture content.- Fabric surfaces, before being doped, must be at the optimum moisture content. Fabric surfaces, after being covered and before being doped, shall be exposed to an atmosphere as described in 5.2 for approximately 4 hours to achieve this condition.

7.2 Preparation of material.-

7.2.1 Thinning.- All specifications for product materials specify that thinning directions be given on the label. When thinning directions are not supplied with the product, the material shall be thinned with the applicable thinner until suitable brushing or spraying properties are obtained. The proper working viscosity for spraying corresponds to approximately 40 to 60 seconds as determined with a No. 4 Ford cup for dope and is usually attained by adding one part of thinner to three parts of dope by volume. The thinning of dopes influences the drying time and tautening properties, and it is highly essential that the thinning be done properly. The exact amount of thinner to be used for each shop set-up cannot definitely be specified since it depends upon the characteristics of the dope, the atmospheric conditions, the spraying equipment, the operator, and the type of thinner employed. It must, therefore, be determined on experimental panels for the conditions which prevail locally at the time of application of the dope. Constant agitation of the thinned dope shall be maintained during spraying operation.

7.2.2 Blush retarding thinner.- The antiblush characteristics of the latest dopes and standard thinners may be improved with the use of blush retarding thinner, MIL-T-6097, under the conditions specified in 9.4. Use of blush-retarder should, however, be kept to a minimum, because of the undesirable properties accompanying the use of this thinner.



DIMENSIONS IN INCHES

FIGURE 1. Grounding connection for paint and dope shop

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7.3 Application of dope.

7.3.1 Doping of fabric.- Successive coats of clear dope shall be applied on fabric covered parts until a film is obtained to produce a uniformly taut and smooth surface. By definition, a single coat of dope shall be applied by a cross coat. Under normal conditions this result should be accomplished with four coats of clear dope, two brush coats and two spray coats, the complete clear dope film weighing not more than 2.75 ounces and not less than 2.25 ounces per square yard. Pigmented dope shall be applied by spray gun over the clear dope. Pigmented dope shall be applied equal to 2.00 ounces minimum per square yard of surface which under normal conditions should be accomplished with two coats. An additional coat shall be applied to upper surfaces of horizontal air foils. This additional coat is required due to the deleterious effect of sunlight and moisture and, for carrier-based planes, the added exposure to exhaust gases, soot deposits, and stack heat which is more pronounced on upper surfaces. Colors shall be used for doped fabric surfaces in accordance with the requirements of MIL-C-18263.

7.3.2 Position of panels during doping.- Panels should be horizontal during application of dope, if practicable. If a vertical position is necessary, care shall be taken to apply the dope in a continuous film and to prevent the dope from running along the bottom edge.

7.3.3 Drying time between successive coats.- Drying time will vary with temperature and humidity. Under good atmospheric conditions, not less than 30 minutes shall be allowed between individual coats, and under unfavorable conditions, this time must be extended. Under all conditions, sufficient time shall elapse between coats to allow the surface to become dry to touch. Unless the dope is properly thinned, drying time will be unduly retarded.

7.3.4 Predoped fabric.- Predoped cellulose acetate butyrate fabric conforming to MIL-C-5642 may be used in place of regular grade A fabric of MIL-C-5646 on aircraft. This material has been prepared by applying a doctor-bladed dope coating to fabric conforming to MIL-C-5646 under controlled manufacturing conditions. The resulting predoped fabric provides a smoother surface for subsequent doping due to the fact that the doctor-blading process smooths down the surface lint. Predoped fabric will have received fungicidal treatment and therefore no mildew proofing of the subsequently applied dope will be required. The color of the doped surface of the cloth is a light transparent red for purposes of ready identification.

7.3.4.1 Predoped fabric, precautions in the use of.- All procedures and methods of doping in this specification apply to the finishing of predoped fabric unless specific exception is made. It is necessary that the first and second coats of clear dope be applied to predoped fabric as specified in 7.3.6 and 7.3.8 respectively. Due to the fact that predoped fabric is more rigid and less porous, caution must be taken to ensure that all air bubbles or pockets between tapes and fabrics are smoothed out. This can be done with a wooden scraper, working entrapped air toward the open edges.

7.3.5 Mildew-proofing.- Dope conforming to MIL-D-7850 shall be applied as the first coat on all fabric used on aircraft, except as stated in 7.3.5.2. MIL-D-7850 dope is tinted purple for ready identification of this dope and of fabric so treated. It is available in two forms, type I, a liquid dope ready for use, and type II, a paste for use in preparing fungicidal dope. Prepare by mixing 4 ounces by weight of the type II paste with 1 gallon of clear package dope

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conforming to MIL-D-5549. The paste is readily incorporated in the clear dope by hand mixing. Slightly faster dispersion is secured if a small amount of MIL-T-6096 thinner is added to the paste after weighing and prior to its addition to the clear dope. First coat fungicidal dope prepared in this manner and MIL-D-7850 type I dope shall be considered for the purpose of coding and marking described in section 10.

7.3.5.1 Fungicidal dope.- Dope conforming to MIL-D-7850 shall be used only as a first coat on MIL-C-5646 aircraft fabric and in no case shall it be used for any subsequent coats. Precautions shall be taken to thoroughly mix MIL-D-7850 dope just prior to use to ensure against nonuniformity caused by settling of the fungicidal agent.

7.3.5.2 Predoped fabric.- When predoped fabric conforming to MIL-C-5642 is used, the above first coat fungicidal procedure shall be eliminated since this fabric has already been mildew-proofed. However, successive coats of MIL-D-5549 clear dope must be applied in such manner that the weight requirements of 7.3.1 are met.

7.3.6 First coat application.- The first coat shall be applied with a brush. It should be spread on the surfaces as uniformly as possible and thoroughly worked into the fabric. Clear or fungicidal dope will normally require some thinning for first coat application to ensure uniform spreading and wetting of the fabric surface. Care should be taken not to work the dope through the fabric to the extent that an excessive film is formed on the reverse side. In effect, the first coat should be nothing more than a thorough and uniform wetting of the fabric. This coat should be applied quickly, but carefully. The dope should be worked with the warp and with the fill alternately for three or four strokes and any excess material stroked away to avoid piling up or dripping.

7.3.7 Surface tape and reinforcing patches.- Tape and patches shall be applied as described in MIL-C-5654 just prior to or during the application of the second coat of dope, and in no case later than the third coat. In patching completely finished fabric, the edges to be patched shall be scraped free from all old dope all the way down to the cloth. A reasonable amount of cleaned spacing around the edges shall be allowed for proper patching.

7.3.8 Second coat.- The second coat shall be applied with a brush, be laid on smoothly, and worked only enough to secure an even spread.

7.3.9 Rubbing.- If roughness appears after the last coat of clear dope or succeeding coats of pigmented dope, the surface should be smoothed by very lightly rubbing with #280 wet or dry sandpaper (avoid excessive pressure) or with doped canvas rubbing pads. These pads are made by applying one coat of dope to clean canvas, allowing it to dry, and cutting fabric to proper size. No other rubbing materials shall be used for this purpose. All fabric covered panels while being sanded, rubbed, or wiped, incident to doping shall be suitably grounded to prevent the accumulation of static electricity.

7.3.10 Third and successive coats.- These coats may be applied by either brush or spray gun and in sufficient number to equal the requirements for weight of clear dope in 7.3.1. When a gun is employed, the correct nozzle setting and spray consistency shall be obtained before starting the actual work.

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7.3.11 Pigmented dope.- Pigmented dope of the proper color, as specified in MIL-C-18263 shall be applied to the fabric surfaces over the clear dope coats. Pigmented dope shall always be applied with a spray gun, and the weight of film shall be as specified in 7.3.1.

7.3.12 Fabric topcoat.- Under no circumstances shall any aircraft fabric surface be finished with clear dope only. The dope shall be applied in such a manner as to produce a uniform and aerodynamically smooth finish over the surface of the fabric.

7.3.13 Deviations in doping.-

7.3.13.1 Use of lacquers.- Lacquer shall not be used as a topcoat on doped fabric surfaces because of the possibility of poor adhesion and embrittlement resulting therefrom. However, in cases of emergency, i.e., where delay would seriously interfere with operation requirements, lacquer may be used when necessary for application of insignia. In addition, the use of lacquers is permitted but not encouraged for identification markings, pigmented dope being preferred for this application. Where lacquers are used for insignia or for markings, they shall be applied over fabric finished with the complete dope scheme as outlined in this specification.

7.3.13.2 Use of enamel.- Enamel shall not be applied on doped fabric surfaces.

7.3.13.3 Use of aluminum dope.- Aluminum dope shall not be used as a sandwich coat between clear and pigmented dope coats or between successive coats of pigmented dope because of the possibility of failure by cleavage at the aluminum layer with corresponding poor adhesion.

7.3.14 Application of insignia and markings.- Dope used for insignia and dope or lacquer used for identification markings may be applied by either brush or spray gun.

7.3.15 Masking.- Adjoining surfaces shall be protected by masking tape when more than one color is used. Plain wrapping paper shall be used in conjunction with the tape for masking large areas.

8. PRECAUTIONS

8.1 Pouring dope on fabric.- Dope shall never be poured on fabric.

8.2 Open dope containers.- Dope shall not be allowed to stand in open containers exposed to the air for more than 1 hour. When not in use, dope dispensing cans or other containers shall be carefully covered to prevent unnecessary evaporation.

8.3 Protection against spray fog.- Operators should wear suitable breathing masks for protection against dope spray fog.

8.4 Location of grommets.- Particular consideration shall be given to proper location of grommets to provide vent and drainage of condensed moisture. Application of grommets shall be in accordance with MIL-C-5654.

9. EVALUATION

9.1 Tautness.- Finished surfaces shall be taut and shall vibrate with a drum-like tone when struck. Tautness meters which measure the deflection of the doped fabric under load, are available and give a quantitative evaluation of the tension of the doped fabric. Method 6281 of Fed. Test Method Std. No. 141 describes tautness measurement procedure for doped fabrics. A deflection of over 0.100 inch indicates that the fabric is not sufficiently taut and should be considered unsatisfactory. The tautening property of dope is a function of both the volatiles and the film base. Improper thinning and insufficient brushing of the first coat to fabric results in poor adhesion of the following coats, tapes, and patches. The speed of tautening may be greatly increased by blowing air inside the wing panels or other confined spaces to remove the heavy solvent vapors which accumulate during the drying period. In such cases the air shall be applied at low velocity, care being exercised to ensure against "pinholing" and straining of wet fabric surfaces.

9.2 Weight of coatings.- The minimum satisfactory weight of clear cellulose acetate butyrate dope coating is 2.25 ounces per square yard of surface, with 2.75 ounces as a maximum weight. The minimum weight of the pigmented dope is 2.00 ounces per square yard, with 2.25 ounces as a maximum weight. Weights should be determined after 72 hours air-dry.

9.3 Determination of weight of coatings.- The specific weight of film deposited on production samples may be determined by simultaneously spraying small test panels, along with production work. Such panels should have a clear cut area of at least 1 square foot. Having determined the average weight per square foot of the undoped fabric (4.0 to 4.5 oz. per square yard), the weight of the dope deposited can then be found and converted to ounces per square yard. Due to the small differences in weight involved with small panels, precision scales of the balance type should be used. The average results of at least three test panels shall be determined. Weight determinations should be made on any change in production procedure and as frequently as necessary to maintain adequate control of weight of coatings.

9.4 Blushing.- Blushing seriously reduces the tensile strength of the dope film, and is caused by an excessive condensation of moisture under certain unfavorable relationships of the rate of evaporation of the volatile portion of dope to the relative humidity of the surrounding atmosphere. High evaporation rates and high humidity promote blushing. The rate of evaporation is governed principally by the volatile composition, the atmospheric temperature, and the barometric pressure. High temperatures and low pressures produce high evaporation rates. Blushing tendencies are increased if strong currents of air flow over the surfaces during application or immediately thereafter and such air currents should be avoided, except under very dry conditions. See 5.2 on temperature and humidity adjustments and 7.2.2 on use of blush-retarding thinner to avoid blushing.

9.5 Workmanship.- All details for preparation and the application of dope shall be consistent with highest grade workmanship. When an airplane or part is delivered, the protective coatings shall be suitable and satisfactory for service. Any unsatisfactory doping done prior to delivery shall be refinished to the satisfaction of the procuring activity.

9.6 Work done prior to material inspection.- Any doping done before finishing materials are approved will be at the risk of the contractor. If the material fails to meet the specification requirements in any respect, the lot of material, as defined by the applicable specification, shall be subject to rejection. Where material is rejected and doping accomplished on aircraft using such material, the aircraft may be required to be refinished to the satisfaction of the procuring activity. It shall be the duty of the contractor to notify the procuring activity at the first indication of either any defect in material or any unusual detail of procedure likely to result in an inferior finish.

10. IDENTIFICATION

10.1 Dope coding.-

10.1.1 Letters and figures.- Letters and figures shall be applied to the under surfaces of each fabric covered surface, such as fuselages, wings, and control surfaces to designate the number of coats of dope, the specifications for the materials used, date of application, and the activity or contractor finishing the surface. All characters shall be black and white and shall be 1/2 inch in height.

10.1.2 Letters and figures sequence.- The figures indicating the number of coats shall precede the letters and numbers designating the material specifications. The first of these figures shall indicate the number of clear coats, and the second shall indicate the number of pigmented coats. The letters and numbers indicating the specification number of the dope shall follow the figures indicating the number of coats of dope. The figures indicating the date of completion as month, day, and year, shall follow the dope specification number. The letters indicating the finishing activity shall follow the date group. When predoped fabric has been used for covering the surface, the letters PDF will precede the normal doping code. Examples follow:

1MIL-D-7850 3MIL-D-5549 2MIL-D-5551 2-15-45 SD (Indicates 1 coat of fungicidal first coat dope MIL-D-7850, 3 coats clear dope MIL-D-5549, 2 coats pigmented gloss dope MIL-D-5551, finished 15 February 1945 by NORIS, San Diego, Calif.)

PDF 4MIL-D-5549 2MIL-D-5550 3-1-63 NAEC (Indicates predoped fabric, 4 coats clear dope MIL-D-5549, 2 coats camouflage dope MIL-D-5550 finished 1 March 1963 by Naval Air Engineering Center, Philadelphia, Pa.)

10.1.3 Contractors.- Contractors shall be shown by the contractors abbreviation of the firm name.

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10.2 Information.- Information for fabric repair and doping of repaired fabric surfaces of aircraft may be obtained from Handbook T.O. 1-1A-11.

10.3 Data.- Unless otherwise specified in the contract or order, no data are required by this specification or any of the documents referenced in section 2.

Custodians:
Navy - WP
Air Force . (69)

Preparing activity:
Navy - WP

Reviewer activity:
Navy - WP
Air Force - (69)

User activity:

Review/user information is current as of the date of this document. For future coordination of changes to this document, draft circulation should be based on the information in the current Federal Supply Classification Listing of DoD Standardization Documents.

