

INCH-POUND

**MIL-C-83019(USAF)  
AMENDMENT 3  
13 January 1995  
SUPERSEDING  
AMENDMENT 2  
20 OCTOBER 1972**

## MILITARY SPECIFICATION

### COATING, POLYURETHANE, FOR PROTECTION OF INTEGRAL FUEL TANK SEALING COMPOUND

This amendment forms a part of MIL-C-83019(USAF) dated 4 November 1968, and is approved for use by the Department of Air Force and is available for use by all Departments and Agencies of the Department of Defense.

PAGE 1

\*Last line: Delete: "MIL-S-7502 Sealing Compound, Integral Fuel Tanks and Required Cell Cavities, High Adhesion, Accelerator"

PAGE 2

\*Line 8 and 9: Delete: "MIL-C-38736(USAF) Cleaning Compound, Solvent, for Use in Integral Fuel Tanks"

\*Under Military: Delete: "MIL-STD-105 Sampling Procedures and Tables for Inspection by Attributes

USAF Bulletin Free Diisocyanate Test Method No. 535"

\*2.2: Add: "SOCIETY OF AUTOMOTIVE ENGINEERS (SAE)

AMS 2629 Fluid, Jet Reference  
AMS 3166 Solvents, Cleaning, for Cleaning Prior to Application of Sealing Compounds

(Application for copies should be addressed to the Society of Automotive Engineers, Inc., 400 Commonwealth Drive, Warrendale, PA 15096.)"

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AMSC N/A

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## PAGE 3

3.2.1: Add: "Material meeting this specification is normally clear. There are instances, however, when a colored material is desired. The use of colored material is permissible providing all requirements of this specification are met. Materials containing a blue dye and a red dye are available"

Table I: Under Viscosity requirement: Delete "15 to 20 seconds" and substitute "15 to 25 seconds", Under Application Life requirement: Delete "30 seconds, Maximum" and substitute "40 seconds, Maximum".

## PAGE 4

\*Table I: Under Requirements, line 13 and 14: Delete: "(MIL-S-7502 Sealant) 3.0% Maximum"

Line 20: Delete: "Free diisocyanate 0.5% Maximum 4.7.12".

## PAGE 5

\*4.4.1, 4.4.1.1: Delete in its entirety and substitute:

"4.4.1 Sampling for inspection. Sampling for quality conformance inspection shall be in accordance with Sampling Plan A, except where otherwise indicated herein. Quality conformance tests are required for all production batches of material.

4.4.1.1 Batch lot. Unless otherwise specified, a batch lot shall consist of all coating material manufactured at one time from one batch, forming a part of one contract or order for delivery.

Add: 4.4.1.2 Sampling Plan A for examination of product. Sampling for filled containers shall be in accordance with table II.

Table II. Sampling Plan A.

Lot Size	Sample Size
1-4	all
5-50	5
51-90	7
91-150	11
151-280	13
281-500	16
501-12,000	19
[acceptance number is zero, (c + 0)]	

## PAGE 6

\*4.4.2, line f: Delete in its entirety.

\*4.6.2, line 5: Delete: "MIL-C-38736(USAF)" and substitute "AMS 3166".

\*4.6.3, line 2: Delete: "MIL-S-7502".

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\*4.6.6, Delete in its entirety and substitute:

"4.6.6 Formuation of jet reference test fluid. The jet reference fluid required for conducting fluid immersion tests shall be as specified in AMS 2629, type 1".

\*4.6.6.1: Delete in its entirety.

PAGE 9

\*4.7.9, line 2: Delete: "MIL-S-7502".

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\*4.7.9, line 7 and 13: Delete: "MIL-S-7502".

\*4.7.12: Delete in its entirety.

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\*Add: "The margins of this amendment are marked with an asterisk or vertical lines to indicate where changes (additions, modifications, corrections, deletions) from the previous amendment were made. This was done as a convenience only and the Government assumes no liability whatsoever for any inaccuracies in these notations. Bidders and contractor are cautioned to evaluate the requirements of this document based on the entire content irrespective of the marginal notations and relationship to the last previous amendment".

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Air Force – 11

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