

MILITARY SPECIFICATION

REMOVER, PAINT, TANK TYPE; FOR AIRCRAFT WHEELS,
LANDING GEAR COMPONENTS, AND OTHER AIRCRAFT AND AGE COMPONENTS

This amendment forms a part of Military Specification
MIL-R-83936B (USAF), 13 January 1977.

PAGE 1

Under Specifications, Federal, delete "QQ-P-416 Plating, Cadmium (Electro-deposited)"

PAGE 2

Under Specifications, Military, add "MIL-S-5002 Surface Treatments and Inorganic Coatings for Metal Surfaces of Weapon Systems"

PAGE 2

Under Standards, Military, add "MIL-STD-870 Cadmium Plating, Low Embrittlement, Electrodeposition"

PAGE 3

Add new paragraph as follows:

"3.7 Materials. Recycled and recovered raw materials should be used to the maximum extent possible in lieu of virgin raw materials as long as these materials do not jeopardize the intended use and fully comply with all contract requirements. Materials used shall be free from defects which would adversely affect the performance or maintainability of individual components or the overall assembly. Materials not specified herein shall be of the same quality used for the intended purpose in commercial practice. None of the above shall be interpreted to mean that the use of used or rebuilt products will be allowed.

PAGE 4

In Table I, under "Requirement" for Paint Removal Performance, delete the words "shall not remove MIL-A-8625" and add in their place "of two out of three panels".

PAGE 6

Paragraph 4.6.2 Viscosity, on the second line of the first sentence delete the words "77±2°F (25 ± 1°C) or at".

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PAGE 6

Paragraph 4.6.3 Corrosion, on the first line delete the words "1 x 2 inches (2.54 cm x 5.08cm)" and substitute "2 x 4 inches (5.08cm x 10.16cm)". On the seventh line delete the words "100°F (38°C) or at". On the tenth and eleventh lines delete the words "(Light brushing may be used if necessary to remove difficult residue)". On the twelfth line delete the words "air dried" and substitute the following words: "MEK, or chloroform, oven dried at 375°F for one hour, desiccated for one-half hour,".

PAGE 6

Paragraph 4.6.4.2 Painting of Test Panels, on the fourth line after #17875 add "or #16473".

PAGE 6

Paragraph 4.6.4.3 Paint removal procedure, in the first sentence on the third line delete all words after the word "remover" and add the following: ", which shall be brought up to the manufacturers recommended temperature in an oven prior to immersing the test panels; the test panels shall remain in the remover in the oven for a period of 30 minutes".

PAGE 7

Delete Table II and NOTE and substitute the following:

<u>METAL</u>	<u>SPECIFICATION</u>	<u>SURFACE TREATMENT</u>	<u>WT CHANGE</u>
Aluminum	QQ-A-250/4	As Received	±4.0 mg.
Aluminum	QQ-A-250/4	MIL-A-8625 Type II, Clas I 1900-2100 MG/Sq. FT.	-4.0mg.
Magnesium	QQ-M-44 (AZ31B-H24)	MIL-M-3171 Type III	±20.0 mg
Steel	MIL-S-7952	As Received	± 4.0 mg
Steel	MIL-S-7952	MIL-STD-870 Type II, Class I (Cad. Plate)	±5.0 MG/IN ²

NOTE: All panels shall be cleaned/degreased with MEK, acetone, or chloroform, oven dried at 375°F for 1 hour, and desiccated for 1/2 hour prior to surface treatment and/or testing. Panels shall be sheared/cut prior to surface treatment.

PAGE 7

Under Table III, Steel, MIL-S-7962, delete "QQ-P-416, Type II, Class II" and substitute "MIL-STD-870, Type II, Class I". Also, delete the NOTE and substitute the following: "NOTE: All panels shall be sheared/cut prior to surface treatment. All panels shall be cleaned/degreased with MEK, acetone, or chloroform prior to surface treatment and painting".

PAGE 8

Under Table IV, on the first line of the paragraph after the word "applied" add the words "to both sides of the test panel".

Page 8

Para 4.6.5, Hydrogen embrittlement, Delete in its entirety and substitute the following: "Hydrogen embrittlement - Test specimens shall be prepared as specified in MIL-S-5002, Section 4, with the exception that the cadmium plating is in accordance with MIL-STD-870. The plated test specimens will then be immersed in the active phase of the paint remover maintained at the manufacturers recommended temperature for a period of four hours, then rinsed and dried. The test specimens will then be subjected to test procedures as specified in MIL-S-5002, Section 4 for a period of 200 hours. Any tensile failure of the test specimen during the 200 hour test period will be cause for rejection due to hydrogen embrittlement."

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Delete Figure 1 in its entirety.

Page 10.

Delete Table V in its entirety.

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