

MIL-T-21595D
AMENDMENT 2
25 September 1986
SUPERSEDING
AMENDMENT 1
22 June 1984

MILITARY SPECIFICATION

TAPES, PRESSURE-SENSITIVE ADHESIVE, MASKING, NON-STAINING,
FOR AIRCRAFT PAINTING APPLICATIONS

This amendment forms a part of Military Specification MIL-T-21595D, dated 31 March 1982, and is approved for use by all Departments and Agencies of the Department of Defense.

PAGE 1

Add: "1.2.1 Part number. Specification part numbers for items described in this specification will be formulated as shown in 6.1.4.1."

PAGE 2

*2.1.1 Add the following entry under FEDERAL.

"CCC-C-440	Cloth, Cheesecloth, Cotton, Bleached and Unbleached"
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*2.1.1 Add the following entries under MILITARY.

"MIL-A-9962	Abrasive Mats, Non-Woven, Non-Metallic
"MIL-C-81706	Chemical Conversion Materials for Coating Aluminum and Aluminum Alloys"

PAGE 3

3.3.2, 1st sentence, line 1: Delete and substitute, "Tape widths shall be 1/2, 3/4, 1, 1-1/2, 2, 3-inches."

PAGE 4

TABLE I, last entry, requirement column, 3rd line: Delete "1/64" and substitute "3/64."

AMSC N/A

FSC 7510

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*4.6.3.1 Delete in its entirety and add the following:

"4.6.3.1 Test panels. Test panels measuring 12x12x0.020 inches shall be cut from aluminum alloy sheets conforming to QQ-A-250/5 and deburred. Each panel shall then be treated as follows:

a. Abrade with abrasive mat (MIL-A-9962, Grade A) which has been soaked with deionized water by manually rubbing the mat back and forth parallel to the one dimension until the entire surface is water break free.

b. Immediately wipe the panel clean and completely dry with cotton cheesecloth (CCC-C-440, Class 1).

c. Within 4 hours, immerse the panel in the MIL-C-81706 conversion coating solution for three minutes, taking care that panels do not touch each other or the sides of the tank.

d. Rinse thoroughly with deionized water (temperature $75^{\circ} \pm 5^{\circ}\text{F}$) for one minute.

e. Allow panels to dry in an upright position.

Panels which require painting shall be prepared as follows: Prime each panel MIL-P-85582 epoxy primer to a dry film thickness of .0006 - .0009 inches and allow to cure for 2 hours. MIL-P-85582 shall be mixed and thinned in accordance with the manufacturer's recommendations. Spray each panel with one coat of white polyurethane paint conforming to MIL-C-83286. MIL-C-83286 paint shall be mixed and thinned as specified in MIL-C-83286. Air dry for 15 minutes and apply a second coat of white polyurethane paint to achieve a dry film thickness of .002 inches.

4.6.3.2.1, fourth sentence, line 6: Delete and replace with the following: "Draw an arc having a radius of 7 inches on the panel connecting the two marks."

4.6.3.3, first sentence, line 2, after "blue": Add "or other contrasting color of."

4.6.3.3, second sentence, line 4: Delete "insignia blue."

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*4.6.4.2 Delete in its entirety and add the following:

"4.6.4.2 Bare aluminum panel test. Using unpainted panels that have been prepared in accordance to 4.6.3.1 up to and including subparagraph e, perform all procedures, tests and evaluations specified in 4.6.4.1.1."

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6.1.4, line 3: Delete "Type of application." and substitute "TABLE III. Type of application."

Add:

"6.1.4.1 Definitive specification part number. The specification part number is a definitive part number which will be formulated to identify each type of item covered by this specification. The part number will be formulated by selecting from the requirements the options available in this specification as follows:

Definitive specification number: M21595 X

Military specification number

Type designator (see 6.1.4.1.1)"

Add:

"6.1.4.1.1 Type designator. A one position field used to designate the required type (see table IV).

TABLE IV. Type designator.

Type designator	Remarks
A	Type I (Paper, creped)
B	Type II (Paper, flat)
C	Type III (Plastic)"

*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 contractors are cautioned to evaluate the requirements of this document based on the entire content of the specification irrespective of the marginal notations and relationship to the last previous amendment.

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Custodians:

Army - MR
Navy - AS
Air Force - 99

Preparing activity:

Navy - AS
(Project No. 7510-0342)

Review activities:

Army - EA

User activities:

Army - AR
Navy - MC