

MIL-STD-171D
CHANGE NOTICE 3
17 December 1985

MILITARY STANDARD
FINISHING OF METAL AND WOOD SURFACES

To all holders of MIL-STD-171D.

1. Make pen and ink changes or add new paragraphs to the following pages:

Page 27

Section 5, paragraph 5.2.3 Film thickness. Insert the phrase, "unless otherwise specified," at the beginning of the first sentence as follows:

"5.2.3 Film thickness. Unless otherwise specified, the thickness of the dry paint film for one coat application shall be as follows:"

Additional primers and top coats need to be added for chemical agent resistant coatings (CARC). Add the following paints:

<u>Specification</u>	<u>Thickness in mils</u>
Primers:	
MIL-P-53022	1.0-1.5
MIL-P-52192	1.0-1.5
MIL-P-53030	1.0-1.5
Top coats:	
MIL-C-22750	1.4-1.8
MIL-C-46168	1.8 min
MIL-C-53039	1.8 min
All other top coats, clear or opaque	0.8-1.2

The last subparagraph in this section should be highlighted for emphasis. Insert "NOTE" in the left margin, at the beginning of the subparagraph as a reminder of the film thickness requirement for multiple coats of paint.

/AREA MFPP/

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Section 5, paragraph 5.2.4.1 Wood. Add another sentence. The revised paragraph will now read as follows:

"5.2.4.1 Wood. Wood in contact with metal shall be painted according to finish 26.3 (table XVIII). The metal surface shall receive two coats of an appropriate primer. For camouflage/chemical agent resistant coatings (CARC), see the appropriate finish in table XIII."

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Section 2, paragraph 5.2.7.1; delete and rewrite paragraph as follows:

"5.2.7.1 Color for Army. Unless otherwise specified, all new materiel and materiel undergoing depot overhaul, shall be painted with Chemical Agent Resistant Coatings (CARC) conforming to MIL-C-46168 or MIL-C-53039 in color 383 green for exterior and with CARC conforming to MIL-C-22750 in the selected color for interiors. For exteriors, when other colors are used, they shall be CARC conforming to MIL-C-46168 or MIL-C-53039 and will usually be color 383 brown and black. Other colors of CARC conforming to MIL-C-46168 or MIL-C-53039 may be used for exteriors of items having special requirements, e.g., Arctic or Desert use, ammunition, aircraft, etc. An item of materiel painted with a three color pattern identifies the coating as CARC. The acceptance of the coating shall not be based specifically on color (see 6.10.)"

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Section 5, paragraph 5.3.1 shall be expanded as follows:

"5.3.1 Priming paint for aluminum.

5.3.1.1 Conventional primers. Primers meeting TT-P-1757, MIL-P-15930 or MIL-P-23377 shall be used in tables XIII, XIV, XV, and XVI in lieu of TT-E-485, TT-P-636, TT-P-664, and MIL-P-11414 in priming aluminum. In mixed metal assemblies with aluminum, finish 5.2 shall be specified as a pretreatment prior to application of these primers. Primer MIL-P-15930 shall not be used under baking finishes where the baking temperature exceeds 250°F (121°C) or as a primer for a lacquer topcoat. When MIL-P-23377 is used, the contractor shall determine that the topcoat demonstrates adequate compatibility and adhesion to the primer.

5.3.1.2 Chemical agent resistant coatings (CARC) primers. MIL-P-23377, MIL-P-53022, or MIL-P-53030 shall be used on aluminum materials prior to the application of the CARC topcoat. MIL-P-23377 (type 1), MIL-P-53022 or MIL-P-53030 shall be used when both ferrous and nonferrous materials are present in the same assembly."

Section 5, paragraph 5.3.2 Priming paint for magnesium. Delete and rewrite paragraph as follows:

"5.3.2 Priming paint for magnesium (conventional and CARC). Unless otherwise specified, epoxy primer meeting MIL-P-23377, MIL-P-53022 or MIL-P-53030 shall be used in tables XIII, XIV, XV, and XVI in lieu of TT-E-485, TT-P-636, TT-P-664 and MIL-P-11414 in priming magnesium. Unless otherwise specified, DOD-P-15328 (finish 8.7) shall be specified as a minimum pretreatment prior to application of primer and the phosphoric acid content for this pretreatment coating is reduced to 50 percent of that required by DoD-P-15328. Zinc chromate primers meeting TT-P-1757 or MIL-P-15930 may be substituted for MIL-P-23377 when approved by the procuring activity. When MIL-P-53022, MIL-P-53030 or MIL-P-23377 is used, the contractor shall determine that the topcoat demonstrates adequate adhesion to the primer."

Page 30

Section 5, paragraph 5.3.5 Application of camouflage paint. Delete and rewrite paragraph as follows:

"5.3.5 Application of CARC/camouflage topcoat paint. Unless otherwise specified 383 green paint shall be applied over the specified primer at a minimum dry film thickness of 1.8 mils to achieve optimum infrared camouflage characteristic. An application of 0.8-1.2 mils dry, which is the normal thickness for a paint topcoat, will only provide visual camouflage. Chemical agent resistance can be achieved with a 0.8-1.2 mil coating. In summary, the 1.8 mil minimum requirement provides visual and infrared camouflage as well as chemical agent resistance. Texture and type of substrate may cause a variation in color. The acceptance of the coating shall not be based specifically on color (see 6.10)."

Pages 31 and 32

Section 5, table XIII, finishes 20.19, 20.20, 20.21, and 20.23 are obsolete for Army use as of 1 October 1985 and are notated by footnote 7 as follows:

Finish No

20.19^{7/}
20.20^{7/}
20.21^{7/}
20.23^{7/}

^{7/}Obsolete for Army use as of 1 October 1985.

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Section 5, table XVIII, Paint finishes for wood. Add additional finishes for numbers 26.4, 26.5, 27.9, and 28.6 as follows:

<u>Finish No</u>	<u>First coat</u>	<u>Top coat(s)</u>	<u>Remarks</u>
26.4	MIL-P-23377 or MIL-P-53022 or MIL-P-53030	MIL-C-46168 or MIL-C-53039	Camouflage/CARC
26.5	MIL-P-23377 or MIL-P-53022 or MIL-P-53030	MIL-C-22750	CARC
27.9	MIL-P-23377 or MIL-P-53022 or MIL-P-53030	MIL-C-22750	CARC
28.6	MIL-P-23377 or MIL-P-53022 or MIL-P-53030	MIL-C-22750	CARC

2. Retain this NOTICE and insert before Table of Contents.

3. Holders of MIL-STD-171D will verify that page changes indicated herein have been entered. This notice will be retained as a check sheet. This issuance is a separate publication. Each notice is to be retained by stocking points until the Military Standard is completely revised or cancelled.

Custodians:

Army -- MR
Navy -- SH
Air Force -- 20

Preparing activity:

Army -- MR

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Review interest:

Army -- GL, ME, MI, AR, ER, MD, EA, AV
Air Force -- 70, 99

User interest:

Army -- AT, AV, AL
Navy -- OS