

SECTION 20

PAINTING

TABLE OF CONTENTS

Page

PAINTING	20-1
ENMAR 2TH SERIES LACQUER	20-1
Preparation	20-1
Mixture and Application of Primer	20-1
Preparation of Lacquer Colors	20-1
Application of Lacquer Colors	20-1
ENMAR 82A SERIES VINYL	20-1
Initial Preparation	20-1

Mixture and Application of Primer	20-2
Preparation of Vinyl Colors	20-2
Application of Vinyl Colors	20-2
NO-VISIBILITY PAINT	20-3
Materials	20-3
Mixing	20-3
Surface Preparation	20-3
Application	20-3
FIBERGLAS SPEED PAINTING	20-3

20-1. PAINTING an airplane requires little special equipment. The average shop will have the compressor, spray gun and clean place to work required for a good paint job. Ordinarily, painting involves three basic steps. They are:

1. Cleaning - Washing down the aircraft thoroughly to remove all oil, grease, and dirt.
2. Priming - Applying one priming coat before painting with vinyl and an extra intermediate priming coat before painting with lacquer.
3. Painting - Applying three or more coats of final paint, then adding decorative stripes.

20-2. PROCEDURE FOR PAINTING WITH ENMAR 2TH SERIES LACQUER.

20-3. PREPARATION. Thoroughly clean all surfaces, baysed and to be painted, with 309# GUMMER. Extreme care should be taken to remove all lint, grease, wax, etc. Mask off strips areas to be painted carefully - use that all tapes are firmly adhered to metal to prevent ragged edges. Cover "A" wrapping paper and thinner proof soaking tape should be used to cover the Fiberglas area. This will prevent damage from solvent and thinner vapors. (Newspapers will not provide adequate protection.)

20-4. MIXTURE AND APPLICATION OF PRIMER.

NOTE

845x EX2015 primer only in quantities required for use within six hours and then only in stain-less steel bucket provided.

- a. Mix EX2015 primer and EX2015C reducer in a 1-1 ratio and stir thoroughly.
- b. Apply EX2015 primer in a well broken up, wet, even coat.
- c. Mix EX2414 yellow lacquer primer and MIL-T-5694A thinner in equal parts.

- d. Apply two well broken up, wet, even coats of lacquer primer over the EX2015 as an intermediate coat.

20-5. PREPARATION OF 2TH LACQUER COLORS.

- a. Thoroughly stir and mix in original container to make sure all pigments are in solution.
- b. Thin required amount of lacquer color with T-1664 thinner in a 1:1 ratio. Mix thoroughly and strain into cup before using.

NOTE

T-1664A is faster drying than T-1664B. The former is primarily for lacquer, although the "B" may be mixed with the "A" to slow down the drying time if desired.

20-6. APPLICATION OF 2TH LACQUER COLORS.

Apply three well broken, wet, even coats of lacquer color. Air pressure at the gun should not exceed 40 pounds. At all times, keep gun from 6 to 8 inches from the work and perpendicular to surfaces being painted. DO NOT PAINT WITH ARCING MOTION. Keep paint room around 75 to 80°F. Burn down with T-1411 thinner to give smooth, even surfaces free from overspray.

20-7. PROCEDURE FOR PAINTING WITH ENMAR 82 SERIES VINYL.

NOTE

82A and 83 are interchangeable, although 82A has better flow characteristics.

20-8. INITIAL PREPARATION. Thoroughly clean all surfaces and seams with 309# lacquer thinner. Extreme care should be taken to assure that no oil seepage occurs from seams, splices or rivet heads. All bugs and foreign matter should be removed from

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Table of Contents Cessna 100 Series Service Manual 53 62 63507

1. Understanding the eBook Cessna 100 Series Service Manual 53 62 63507
 - The Rise of Digital Reading Cessna 100 Series Service Manual 53 62 63507
 - Advantages of eBooks Over Traditional Books
2. Identifying Cessna 100 Series Service Manual 53 62 63507
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Cessna 100 Series Service Manual 53 62 63507
 - User-Friendly Interface
4. Exploring eBook Recommendations from Cessna 100 Series Service Manual 53 62 63507
 - Personalized Recommendations
 - Cessna 100 Series Service Manual 53 62 63507 User Reviews and Ratings
 - Cessna 100 Series Service Manual 53 62 63507 and Bestseller Lists

5. Accessing Cessna 100 Series Service Manual 53 62 63507 Free and Paid eBooks
 - Cessna 100 Series Service Manual 53 62 63507 Public Domain eBooks
 - Cessna 100 Series Service Manual 53 62 63507 eBook Subscription Services
 - Cessna 100 Series Service Manual 53 62 63507 Budget-Friendly Options
6. Navigating Cessna 100 Series Service Manual 53 62 63507 eBook Formats
 - ePub, PDF, MOBI, and More
 - Cessna 100 Series Service Manual 53 62 63507 Compatibility with Devices
 - Cessna 100 Series Service Manual 53 62 63507 Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Cessna 100 Series Service Manual 53 62 63507
 - Highlighting and Note-Taking Cessna 100 Series Service Manual 53 62 63507
 - Interactive Elements Cessna 100 Series Service Manual 53 62 63507
8. Staying Engaged with Cessna 100 Series Service Manual 53 62 63507
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Cessna 100 Series Service Manual 53 62 63507
9. Balancing eBooks and Physical Books Cessna 100 Series Service Manual 53 62 63507
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Cessna 100 Series Service Manual 53 62 63507
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Cessna 100 Series Service Manual 53 62 63507
 - Setting Reading Goals Cessna 100 Series Service Manual 53 62 63507
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Cessna 100 Series Service Manual 53 62 63507
 - Fact-Checking eBook Content of Cessna 100 Series Service Manual 53 62 63507
 - Distinguishing Credible Sources
13. Promoting Lifelong Learning

- Utilizing eBooks for Skill Development
- Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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introduction à l évaluation 07 les fondamentaux 08 Évaluation d obligations 09

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