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Revised
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AERONAUTICAL MATERIAL SPECIFICATION

Society of Automotive Engineers, Inc.
29 West 39th Street
New York City

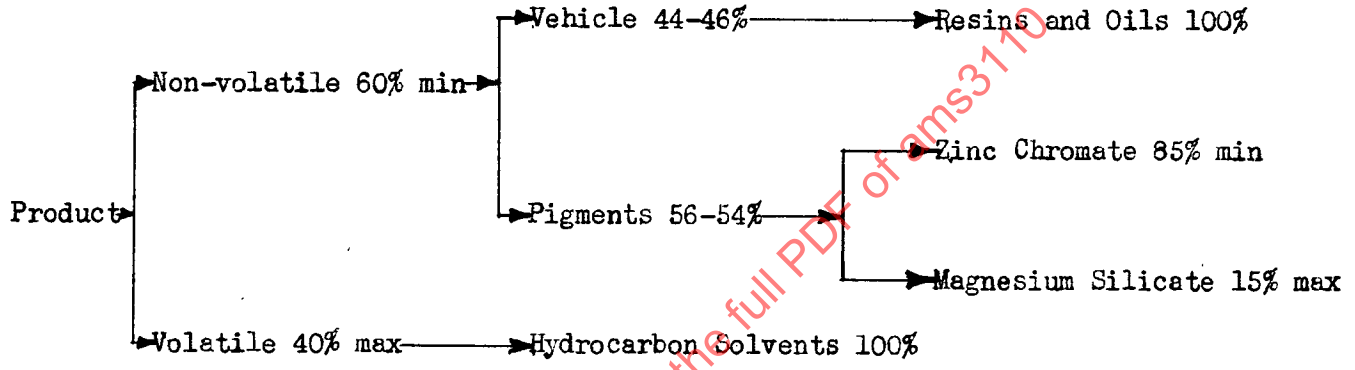
AMS
3110

PRIMER, ZINC CHROMATE

1. ACKNOWLEDGMENT: A vendor must mention this specification number and its last revision in all quotations and when acknowledging purchase orders.

2. USE: For general use on metal surfaces before enameling.

3. COMPOSITION (by weight):



4. COMPOUNDING: (a)The zinc chromate primer shall be equal in working properties and service performance to a product compounded in accordance with the following formula on the basis of a 100-gallon yield:

Zinc Chromate, Imperial or equivalent	295 lb
Magnesium Silicate, Fibrous	52 "
Reduced Congo Copal (40% heat loss)	26 "
Rezyl 113 or equivalent (60% in Xylene)	34 gal
Bakelite 3962 (50% in Toluene)	21 "
Xylene	32 "
Lead Napthenate (12% metal)	1/2 "
Cobalt Napthenate (6% metal)	1/8 "
Stabilizing Ingredient	2% max

(b)The component ingredients shall be intimately assembled and processed as required to produce a product which is stable and not subject to abnormal change with age in a sealed container.

(c)To reduce to suitable working viscosity, add one and one-half parts of thinner, AMS 3180, to one part of package material.

5. QUALITY: The finished product shall be uniform, homogeneous and free from bubbles. Its color shall be yellow, characteristic of the pigment, with no noticeably greener cast than is apparent in the average standard formula. There shall be no trace of grit, rough particles or separation of pigments. Skinning shall be absent in a one-quarter filled closed container after forty-eight hours.

6. PHYSICAL PROPERTIES: Coarse particles shall not exceed 0.1 per cent by weight retained on a No. 325 screen. The moisture content shall not exceed 0.4% by weight. The viscosity at 77°F shall be not less than one-half poise absolute when reduced one volume of material to one volume of toluene. The weight per gallon at 77°F shall be not less than 10.0 lb. When reduced one volume of material to three volumes of toluene and allowed to set 24 hours in a glass graduate, there shall be no indication of distinct layer separation.