

NATIONAL AEROSPACE STANDARD

AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC., 1725 DE SALES STREET, N. W., WASHINGTON 6, D. C.

FED SUP CLASS
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1. SCOPE

- 1.1 Scope: - Materials covered under this specification shall be suitable for use as a temporary protective coating primarily for surfaces of metal parts, during fabrication, assembly, or transfer from one location to another.

2. APPLICABLE DOCUMENTS

- 2.1 The following specification and standards of issue on the date of the purchase order, form a part of this specification to the extent specified herein:

Fed. Test Method STD 141 Paint, Varnish, Lacquer, and Related Materials, Methods of Inspection, Sampling and Testing

QQ-A-287 Aluminum Alloy Plate and Sheet, Alclad 7075

3. REQUIREMENTS

- 3.1 Materials: - Ingredient materials used in the manufacture of this product shall be of high quality and entirely suitable for the intended use. Not more than 5% by weight of organic solvent shall be permitted.
- 3.2 Toxicity: - The material shall contain no substance known to be toxic, such as benzene or chlorinated solvents, under normal conditions of use.
- 3.3 Appearance: - The film produced by the material shall be clean, transparent and homogenous.
- 3.4 Odor: - The material shall contain no noxious odors and the odor shall be normal for the resin solution used.
- 3.5 Color: - The color shall be non-fading, in a primary color shade as specified on the purchase order, which shall show only a slight bleaching, discoloration or other evidence of color breakdown when tested as specified in paragraph 4.3.12.

② Inactive For Design
After 29 Dec. 1981
NO Superseding Standard

List of Active Sheets

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CUSTODIAN: AEROSPACE RESEARCH AND TESTING COMMITTEE

PROCUREMENT
SPECIFICATION
NONETITLE
COATING - PROTECTIVE, TEMPORARY, WATER
REDUCIBLE, CHEMICAL SOLUTION REMOVABLECLASSIFICATION
SPECIFICATIONNAS 1614
Sheet 1 of 6

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3.6 Application: - The material shall be a free working product applicable in one coat, with acceptable leveling and coating properties, when applied using conventional spray, dip, brush, or roll coating equipment.

3.7 Thinning: - The material shall be water reducible, if thinning is required, to obtain optimum working consistency.

3.8 Drying Time: - The material shall dry, under normal conditions of $75^{\circ}\text{F} \pm 2^{\circ}\text{F}$ temperature and $50 \pm 15\%$ relative humidity, in accordance with the following schedule when tested in conformance with the requirements of paragraph 4.3.3.

Dust Free	-	10 minutes (max.)
Tack Free	-	30 minutes (max.)
Dry to Stack	-	120 minutes (max.)
Full Cure	-	48 hours (max.)

3.9 Surface Appearance: - The material, upon drying, shall be free from blushing, streaks, blisters, coarse particles, or other irregularities of surface.

3.10 Package Stability: - The material shall retain all its properties for one year when stored at $65 - 100^{\circ}\text{F}$ in a closed-metal friction lid container. The container shall be lined with a suitable coating to prevent deterioration and subsequent contamination of the contents.

3.11 Non-Volatile Content: - The non-volatile content shall be determined for each type of coating and shall be reported by the supplier. Once determined the non-volatile content shall not vary by more than $\pm 2\%$ of the qualified product as determined by the test method specified in paragraph 4.3.4.

3.12 Film Properties: -

3.12.1 Thickness: - Coatings shall perform satisfactorily at 0.5 mils to .8 mils dry film thickness.

3.12.2 Metal Anchorage: - Coatings shall not indicate any loss of adhesion or separation from the metal substrate when tested as specified in Paragraph 4.3.5.

3.12.3 Heat Resistance: - The properties of the coating shall remain unchanged after exposure to a temperature of $210 \pm 5^{\circ}\text{F}$ for 14 days.

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