



AEROSPACE MATERIAL SPECIFICATION

AMS1388™**REV. A**

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Superseding AMS1388

Remover, Temporary Coating
Alkaline Type, Water Base

1. SCOPE:

1.1 Form:

This specification covers two types of thickened, water base temporary coating remover in the form of an alkaline liquid.

1.2 Application:

This product has been used typically for removing temporary coatings used for protection of aircraft skins from exposure to processing damage, but usage is not limited to such applications.

1.3 Classification:

Remover conforming to this specification is classified as follows:

Type 1 - Ammoniated

Type 2 - Non-Ammoniated

1.3.1 When a type is not specified, Type 1 remover shall be supplied.

1.4 Safety - Hazardous Materials:

While the materials, methods, applications, and processes described or referenced in this specification may involve the use of hazardous materials, this specification does not address the hazards which may be involved in such use. It is the sole responsibility of the user to ensure familiarity with the safe and proper use of any hazardous materials and to take necessary precautionary measures to ensure the health and safety of all personnel involved.

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2. APPLICABLE DOCUMENTS:

The following publications form a part of this specification to the extent specified herein. The latest issue of SAE publications shall apply. The applicable issue of other publications shall be the issue in effect on the date of the purchase order.

2.1 SAE Publications:

Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001.

AMS 2470 Anodic Treatment of Aluminum Alloys, Chromic Acid Process
AMS 2475 Protective Treatments, Magnesium Alloys
AMS 2825 Material Safety Data Sheets
AMS 4037 Aluminum Alloy Sheet and Plate, 4.4Cu - 1.5Mg - 0.60Mn (2024; -T3 Flat Sheet, -T351 Plate), Solution Heat Treated
AMS 4041 Aluminum Alloy Sheet and Plate, Alclad, 4.4Cu - 1.5Mg - 0.60Mn (Alclad 2024 and 1-1/2% Alclad 2024 -T3 Flat Sheet; 1-1/2% Alclad 2024-T351 Plate)
AMS 4045 Aluminum Alloy Sheet and Plate, 5.6Zn - 2.5Mg - 1.6Cu - 0.23Cr (7075, -T6 Sheet, -T651 Plate), Solution and Precipitation Heat Treated
AMS 4049 Aluminum Alloy Sheet and Plate, Alclad, 5.6Zn - 2.5Mg - 1.6Cu - 0.23Cr (Alclad 7075; -T6 Sheet, -T651 Plate), Solution and Precipitation Heat Treated
AMS 4377 Sheet and Plate, Magnesium Alloy, 3.0Al - 1.0Zn (AZ31B-H24), Cold Rolled, Partially Annealed
AMS 4911 Titanium Alloy Sheet, Strip, and Plate, 6Al - 4V, Annealed
MAM 4911 Titanium Alloy Sheet, Strip, and Plate, 6Al - 4V, Annealed
AMS 5047 Steel Sheet and Strip, 0.08 - 0.13C, Aluminum Killed, Deep Forming Grade

2.2 ASTM Publications:

Available from ASTM, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959.

ASTM D 1193 Reagent Water
ASTM F 483 Total Immersion Corrosion Test for Aircraft Maintenance Chemicals
ASTM F 484 Stress Cracking of Acrylic Plastics in Contact with Liquid or Semi-Liquid Compounds
ASTM F 519 Mechanical Hydrogen Embrittlement Testing of Plating Processes and Aircraft Maintenance Chemicals
ASTM F 1080 Determining the Consistency of Viscous Liquids Using a Consistometer
ASTM F 1104 Preparing Aircraft Cleaning Compounds, Liquid Type, Water Base, for Storage Stability Testing
ASTM F 1110 Sandwich Corrosion Test

2.3 U.S. Government Publications:

Available from DODSSP, Subscription Services Desk, Building 4D, 700 Robbins Avenue, Philadelphia, PA 19111-5094.

MIL-T-23397 Tape, Pressure-Sensitive Adhesive, for Masking During Paint Stripping Operations
MIL-P-25690 Plastic, Sheets and Parts, Modified Acrylic Base, Monolithic, Crack Propagation Resistant

3. TECHNICAL REQUIREMENTS:

3.1 Material:

Composition of the remover shall be optional with the manufacturer, but shall provide a product meeting the requirements of 3.2.

3.2 Properties:

The product shall conform to the following requirements; tests shall be performed in accordance with specified test methods, on the product supplied, at $24\text{ }^{\circ}\text{C} \pm 3$ ($75\text{ }^{\circ}\text{F} \pm 5$) and a relative humidity of $50\% \pm 5$ unless otherwise specified in the applicable test procedure.

3.2.1 Ammonia Content:

3.2.1.1 Type 1: The test strip shall turn red within five seconds, when tested as in 4.5.1.

3.2.1.2 Type 2: The test strip shall show no sign of pink color after 30 seconds, when tested as in 4.5.1.

3.2.2 The product shall be non-toxic, non-corrosive and shall not produce vapors hazardous to personnel when used for its intended purpose in accordance with manufacturer's recommendations.

3.2.3 Consistency: The remover shall flow to a point between 18.0 and 23.0 cm in five minutes, determined in accordance with ASTM F 1080. The remover shall be of such consistency that a smooth, even coating can be applied by brushing, flowing, or spraying onto, and will adhere to, the vertical surface of test panels and surfaces of aircraft for sufficient time for the remover to be effective.

3.2.4 Flammability: Remover shall not continue to burn longer than three seconds after removal of the flame, determined in accordance with 4.5.2.

3.2.5 Effect on Aircraft Surfaces:

3.2.5.1 Sandwich Corrosion: Specimens of AMS 4045 and AMS 4049 aluminum alloy, after testing in accordance with ASTM F 1110, shall not show corrosion worse than that on control panels tested using ASTM D 1193, Type IV, water.