



AEROSPACE MATERIAL SPECIFICATION

AMS2510™**REV. F**

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Superseding AMS2510E

Engine Gray Finishing
Low Baking

RATIONALE

AMS2510F stabilizes this document because this document contains mature technology that is not expected to change, and thus no further revisions are anticipated.

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1. SCOPE:

1.1 Purpose: This specification covers the engineering requirements for finishing aircraft parts and assemblies with an engine gray enamel.

1.2 Application: Primarily for parts and assemblies operating in service up to 350°F (175°C).

2. APPLICABLE DOCUMENTS: The following publication form a part of this specification to the extent specified herein. The latest issue of Aerospace Material Specifications (AMS) shall apply. The applicable issue of other documents shall be as specified in AMS 2350.

2.1 SAE Publications: Available from Society of Automotive Engineers, Inc., 400 Commonwealth Drive, Warrendale, PA 15096.

2.1.1 Aerospace Material Specifications:

AMS 2350 - Standard and Test Methods

AMS2400 - Cadmium Plating

AMS2470 - Anodic Treatment of Aluminum Alloys, Chromic Acid Process

AMS 2471 - Anodic Treatment of Aluminum Alloys, Sulfuric Acid Process, Undyed Coating

AMS 2475 - Protective Treatments, Magnesium Base Alloys

AMS 2480 - Phosphate Treatment, Paint Base

AMS 3110 - Primer, Zinc Chromate

AMS 3125 - Enamel, Glycexyl Phthdate, Engine Gray Baking

2.2 U.S. Government Publications: Available from Commanding Officer, Naval Publications and Forms Center, 5801 Tabor Avenue, Philadelphia, PA 19120.

2.2.1 Military Standards:

MIL-STD-794 - Parts and Equipment, Procedures for Packaging and Packing of

3. TECHNICAL REQUIREMENTS:

3.1 Preparation: Parts and assemblies, before being painted, shall be prepared as follows; elapsed time between preparatory treatments and priming shall be as short as practicable:

3.1.1 Aluminum and Aluminum Alloys: Both wrought and cast parts shall be anodized in accordance with AMS 2470 or AMS 2471.